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KENNAMETAL®



MASTER CATALOG 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–H28.

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 2000+ 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 Authorized Kennametal Distributor.

Visit us at **kennametal.com**.

POWERED BY NOVO™

Volume II • Rotating Tools

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

Rotating Tools

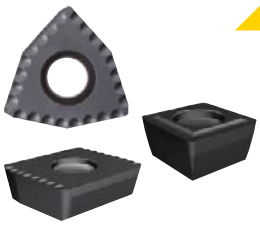
Introduction ..... **ii–xi**
Services and Support ..... **xiv**
Holemaking **F1–K220**
Holemaking Introduction F2–F10
Solid Carbide Drills G1–G145
Modular Drills H1–H133
Combination Tools I1–I30
Indexable Drills J1–J117
Hole Finishing K1–K220
Tapping **L1–M216**
Tapping Introduction L2–L19
Spiral-Point/Left-Hand Spiral-Flute Taps M1–M41
Spiral-Flute Taps M42–M104
Straight-Flute Taps M106–M134
Forming Taps M136–M148
Pipe Taps M150–M158
Solid Carbide Thread Mills M160–M177
Technical Information M178–M216
Solid End Milling **N1–Q47**
Solid End Milling Introduction N2–N3
Duo-Lock Modular Milling O1–O57
High-Performance Solid Carbide End Mills P1–P171
General Purpose Solid Carbide End Mills Q1–Q47
Indexable Milling **R1–X37**
Indexable Milling Introduction R2–R21
Face Milling S1–S126
Shoulder Milling T1–T136
Slot Milling U1–U41
Copy Milling V1–V159
Thread Milling W1–W55
Technical Information • Recommended Starting Speeds X1–X37
Ordering Information **Y2–Y237**
Index by Order Number Y2–Y102
Index by Catalog Number Y103–Y201
Global Contacts Y202–Y203
Icon Legend Y204–Y208
Material Overview Y210–Y211
Workpiece Material Overview Listing Y212–Y237

Turning Tools • See Volume I

Turning **A1–E71**
ISO/ANSI Turning B1–B410
Grooving and Cut-Off C1–C204
Threading D1–D105
Application Specific E1–E71

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 .551–2.125" (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 centering 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.

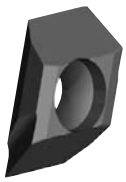




COUNTERFIX MICRO

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.

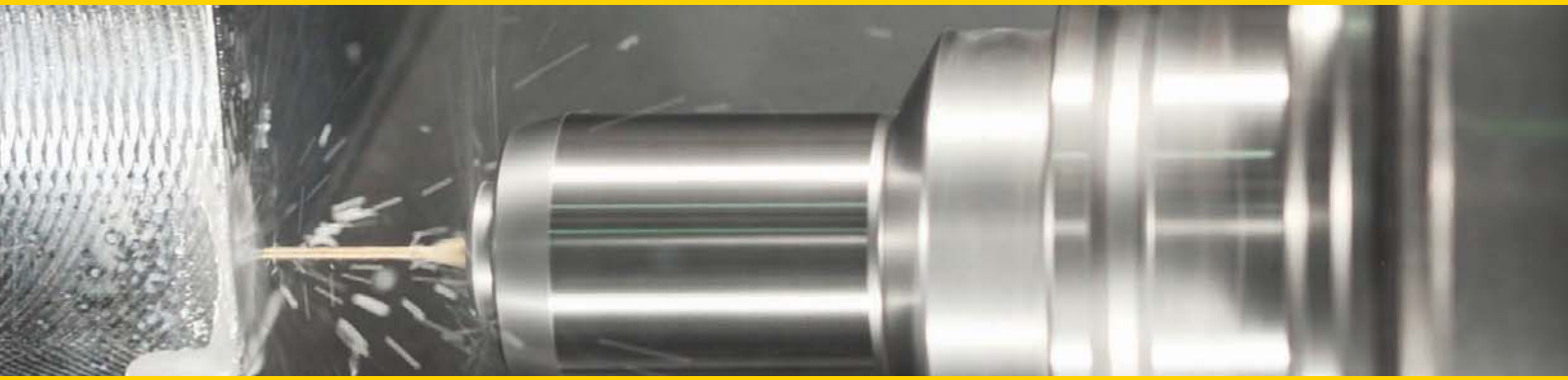
The all-new B21_SGL series solid carbide drills are designed specifically for stainless steel applications, offering high performance and long tool life in high-temperature alloys and regular steel, also.

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 .5512–1.6732" (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 optimized geometries and PVD coatings capable of tapping a wide range of ductile materials, such as stainless steels, carbon and alloy steels, cast aluminum, 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 mulitpurpose taps enable blind-hole tapping with tension/compression holders without sizing problems due to over-feeding. The versatility of GOtap taps means 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 3.300 SFM.



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 aluminum 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™

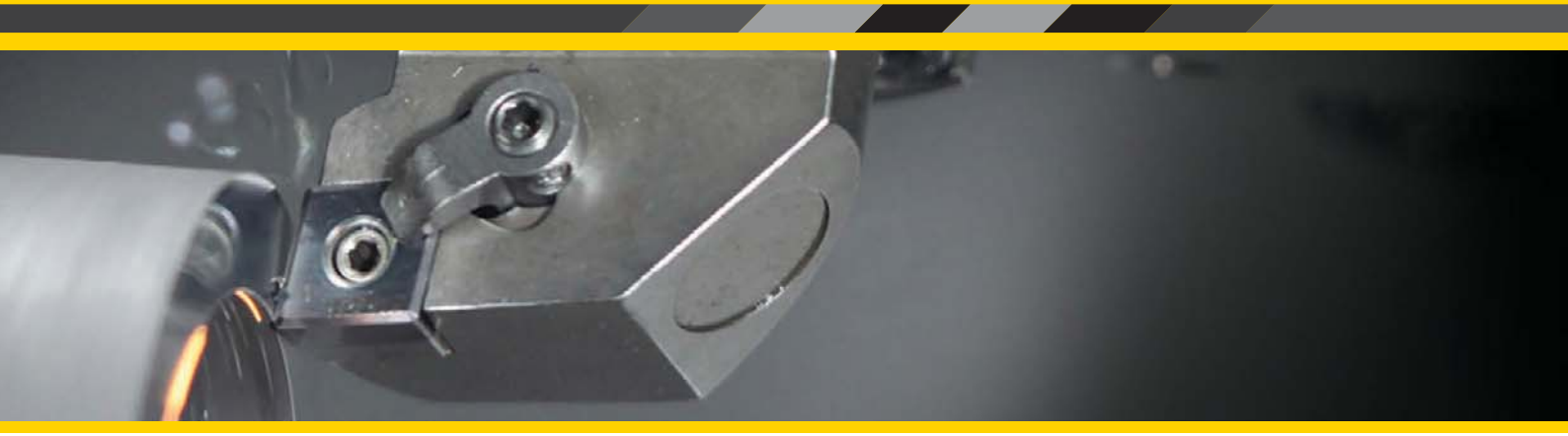
BEYOND™ DRIVE™

See section B (Volume I) for more details.

Beyond™ Drive™ ISO turning inserts provide up to 50% improved insert edge utilization. The advanced surface treatment reduces coating stress and improves coating adhesion. The bronze outer layer simplifies wear detection and increases insert utilization. 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 minimize insert edge wear in turning, grooving, and cut-off operations in a wide range of materials and applications.



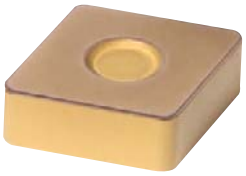
beyond™ DRIVE™



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 gray 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 adapters 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 ADAPTER ADVISOR

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

Let the NOVO Machine Adapter 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 Adapter 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 adapter after another. Now, NOVO applications make it easy.

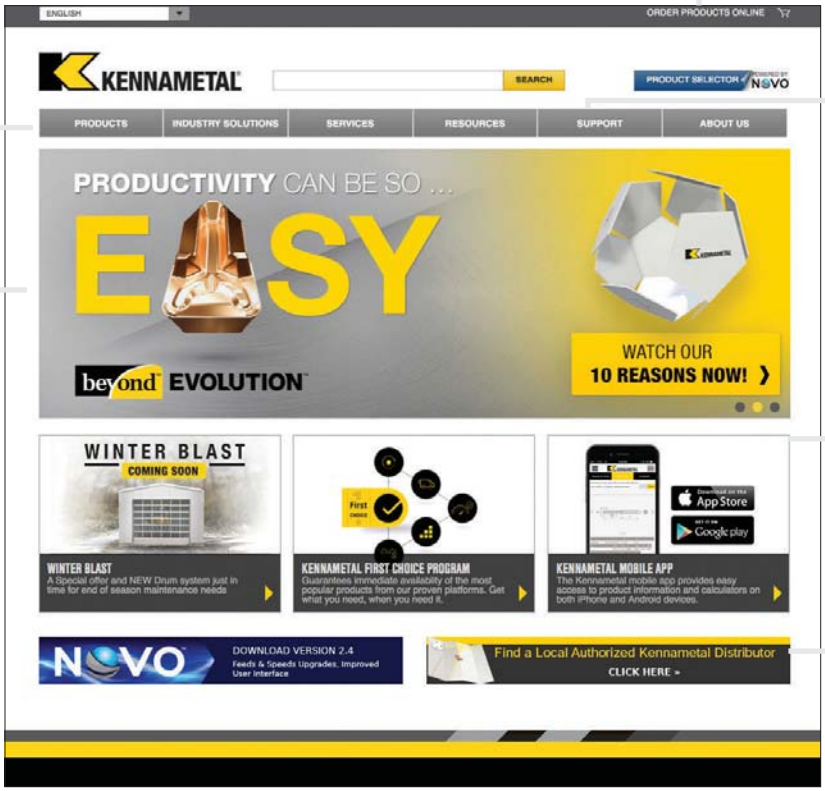
Kennametal on the Web

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 catalogs.



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 AUTHORIZED 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 catalog 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 optimization. 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 catalog 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 maximizes every shift. **kennametal.com/novo**



Holemaking

Holemaking Introduction F2–F10

Solid Carbide Drills G1–G145

Modular Drills H1–H133

Combination Tools I1–I30

Indexable Drills J1–J117

Hole Finishing K1–K220



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 Authorized Kennametal Distributor, or visit **kennametal.com**.

SOLID CARBIDE DRILLS

See Section G for more details.

GOdrill™
3F 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 Customized 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

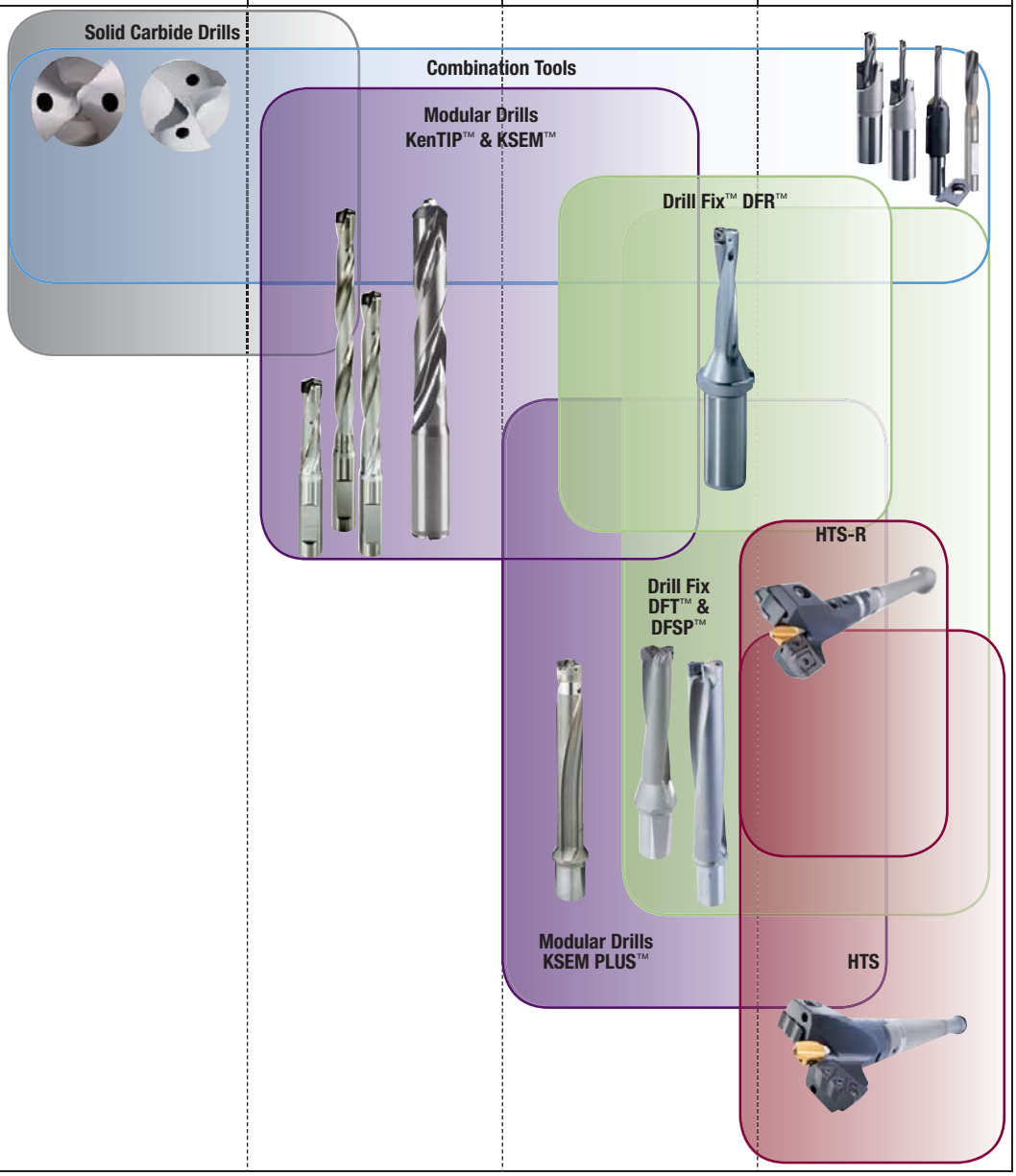
- Material and application-specific solutions.
- Maximum metal removal rates and repeatability.
- Standardized design platforms for special tools based on “proven solutions” for individual optimizations and combination tools.

Control of Total Tooling Costs

- High tool utilization 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)

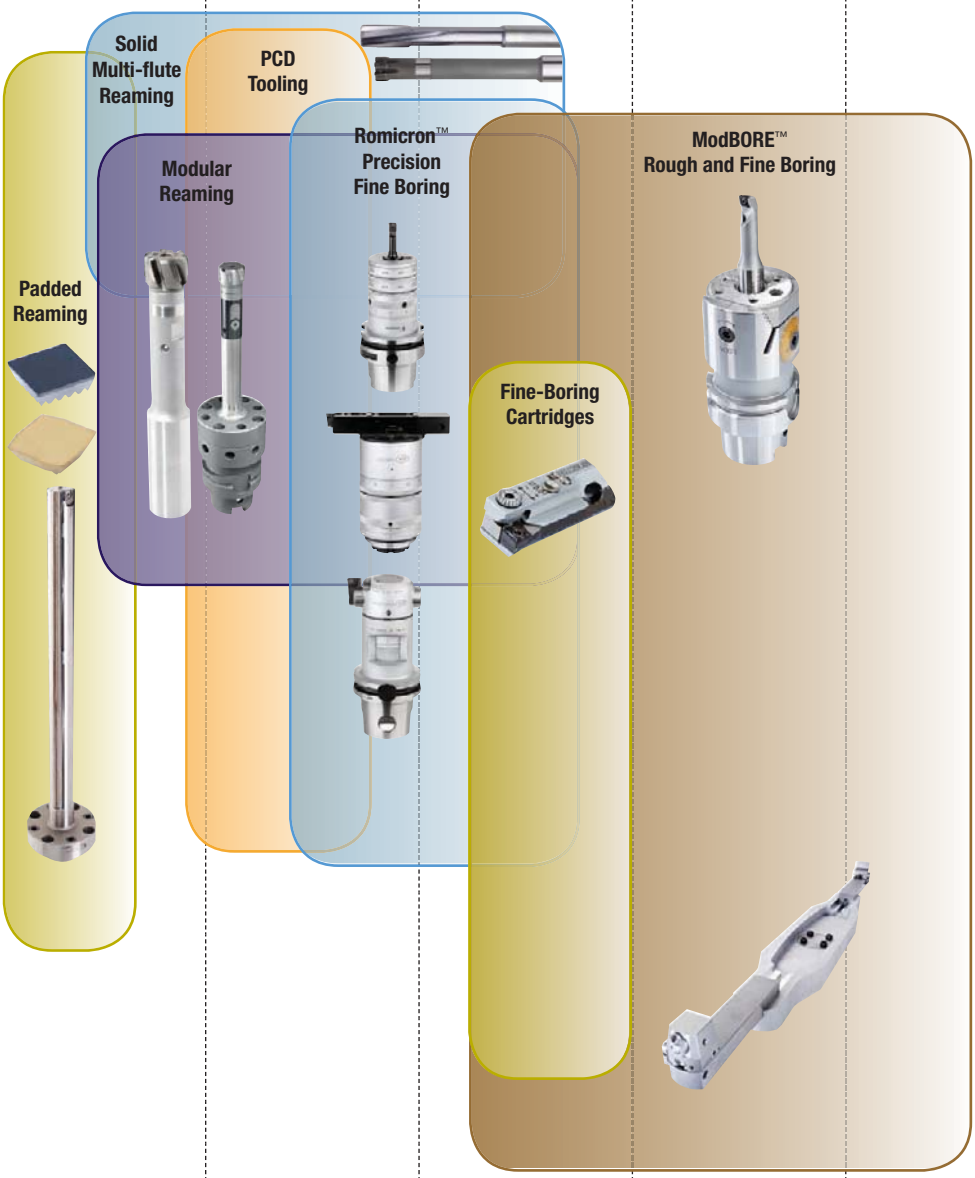
Select the Correct Holemaking Solution for Your Application *(continued)*

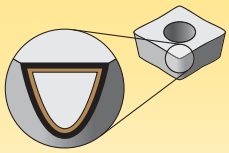
Optimized Purchase

- 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					





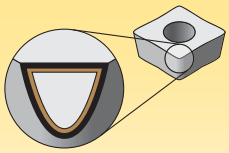
Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

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									
		S									
		C									
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									
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 aluminum alloys. Due to its high wear-resistance, this grade is also applicable for cast iron machining at low to medium speeds.	K									
		N									
		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									
		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									
		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									
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									
		M									
		S									



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M	Stainless Steel
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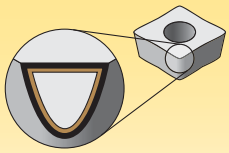
wear resistance ← → toughness

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	■	■							



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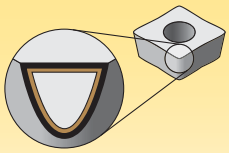
wear resistance ⟷ toughness

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 optimized 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-centering inserts in most materials. The highly wear-resistant TiCN coating combined with a tough carbide substrate are perfectly suited to help with pre-centering 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.

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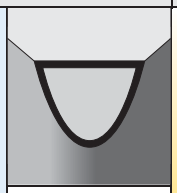
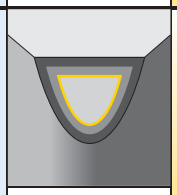
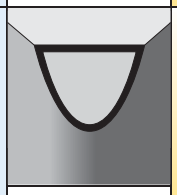
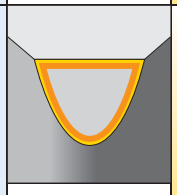
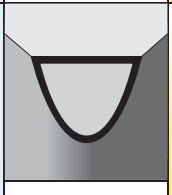
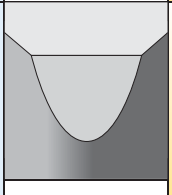
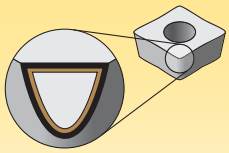
wear resistance ◄——► **toughness**

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 aluminum, titanium, and non-ferrous materials.	N									
			S									

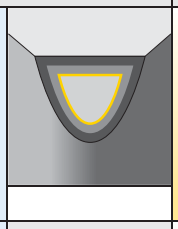
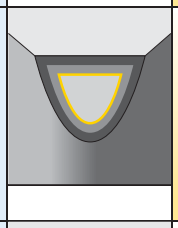
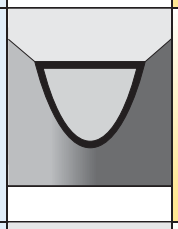
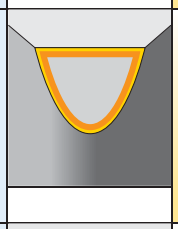
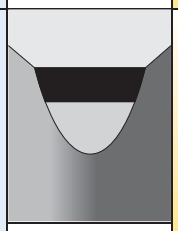


Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

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

wear resistance ⟷ **toughness**

Indexable Drill Grades

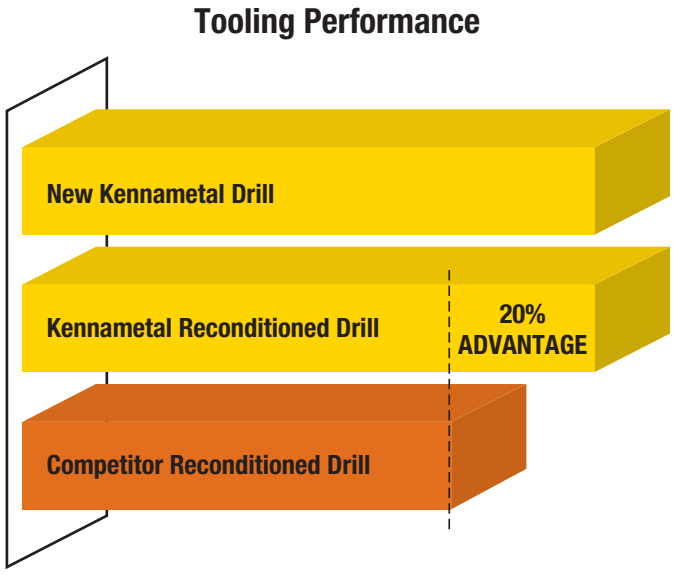
Coating	Grade Description		05	10	15	20	25	30	35	40	45
KCPK10 	**Composition:** Advanced CVD TiCN-Al_2O_3 coating combined with a cobalt-enriched carbide substrate. **Application:** The KCPK10 grade offers a balanced combination of deformation resistance and edge toughness leading to outstanding abrasion 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 aluminum alloys, MMCs, carbon fiber reinforced plastics, and other abrasive non-ferrous materials.	N			■	■	■				
		C	■	■							

Why Reconditioning?

Reconditioning Services

Our Reconditioning Services optimize 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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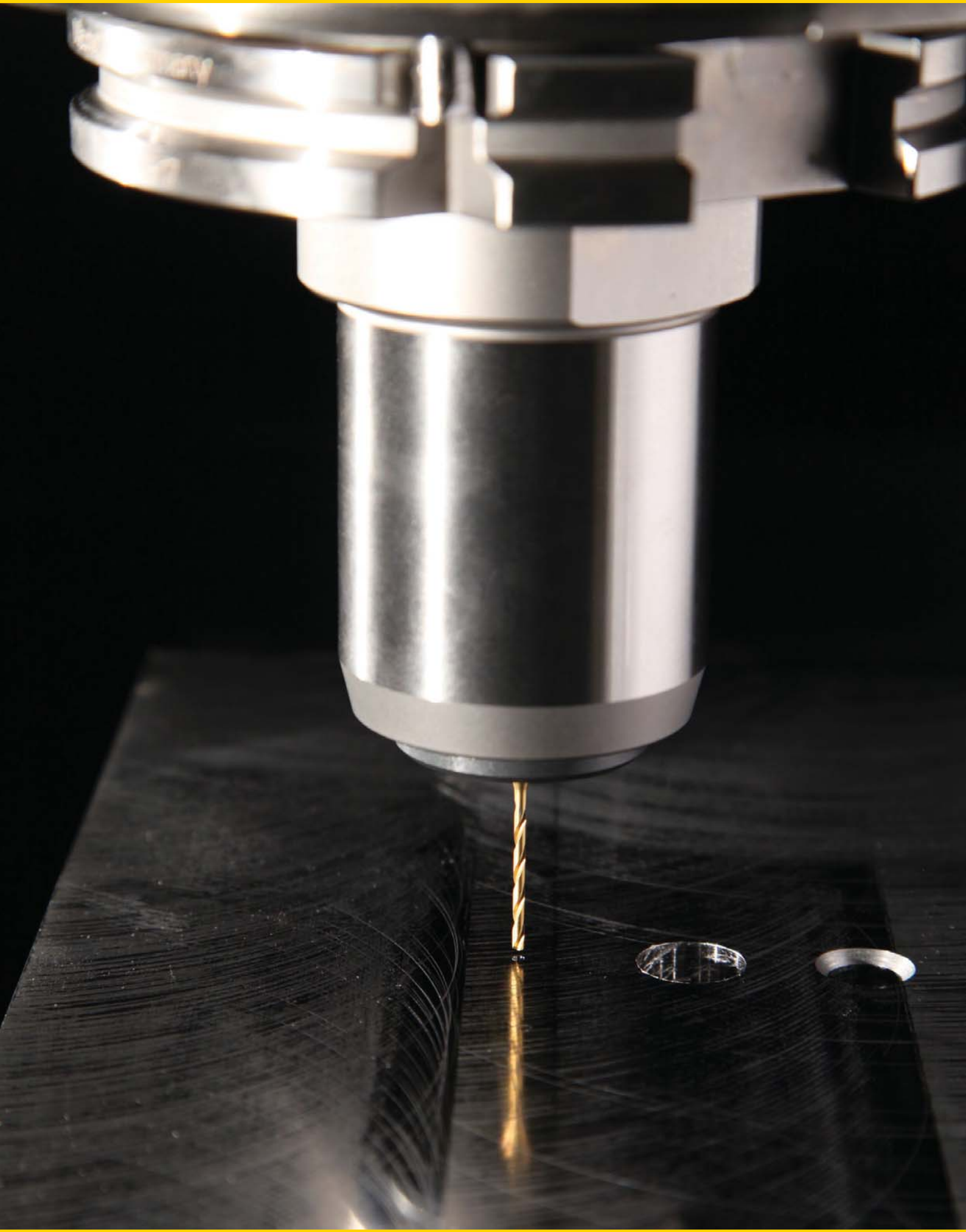


Solid Carbide Drills

Tool Selection Guide G2–G3

Solid Carbide Drills Dimension Tables and Recommendation Chart Foldout

GOdrill • Multiple Materials G6–G21

3F Drills • High Metal Removal Rates G22–G26

SGL Beyond Drills • Stainless Steel G28–G34

HP Beyond Drills • Steel G36–G49

YPC Beyond Drills • Iron Materials G50–G56

SE 4-Margin Drills • Steel G57–G59

HP Beyond 4-Margin, Long-Length Drills G60–G65

Deep-Hole Drills • Steel, Cast Iron, Stainless Steel, High-Temperature Alloys, and Non-Ferrous G66–G79

HPS Beyond Drills • Aluminum Machining G80–G85

Y-TECH Drills • Difficult-to-Machine Materials G86–G91

TX Drills • Close Tolerance Holes G92–G96

SPF Drills • CFRP G98–G101

DAL Drills • CFRP-Stacks G102–G107

Flat-Bottom Drills G108–G115

HP Beyond Step Drills G116–G120

KMH Drills • Hard Materials G122–G127

Kenna Universal Drills G128–G142

NC Spot Drills G144–G145

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
	**3F 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 can be optimized 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	■	■			■			■			□	□		■		□	■	□			G22
3,0–25,0	.1181–1.00	1.5–8 x	■	■			■			■			□	□	■		□	□	■	□			G36
3,0–25,0	.1181–1.00	1.5–5 x	■	■			■			■			□	□				□	■	□			G98
3,0–25,0	.1181–1.00	1.5–5 x	■	■			■	□		■			□	□	■		□	□	■	□			G102
2,5–20,0	.0984–.7874	1.5–8 x	■				■			■			□		■		□	□	■	□			G122
3,0–25,0	.1181–1.00	1.5–8 x	■	■			■	■		■			□	□	□		■	■	■	■			G128
6,0–20,0 6,0–20,0	.2362–.7874 .2362–.7874	1 x D 1 x D	■ ■																				G144

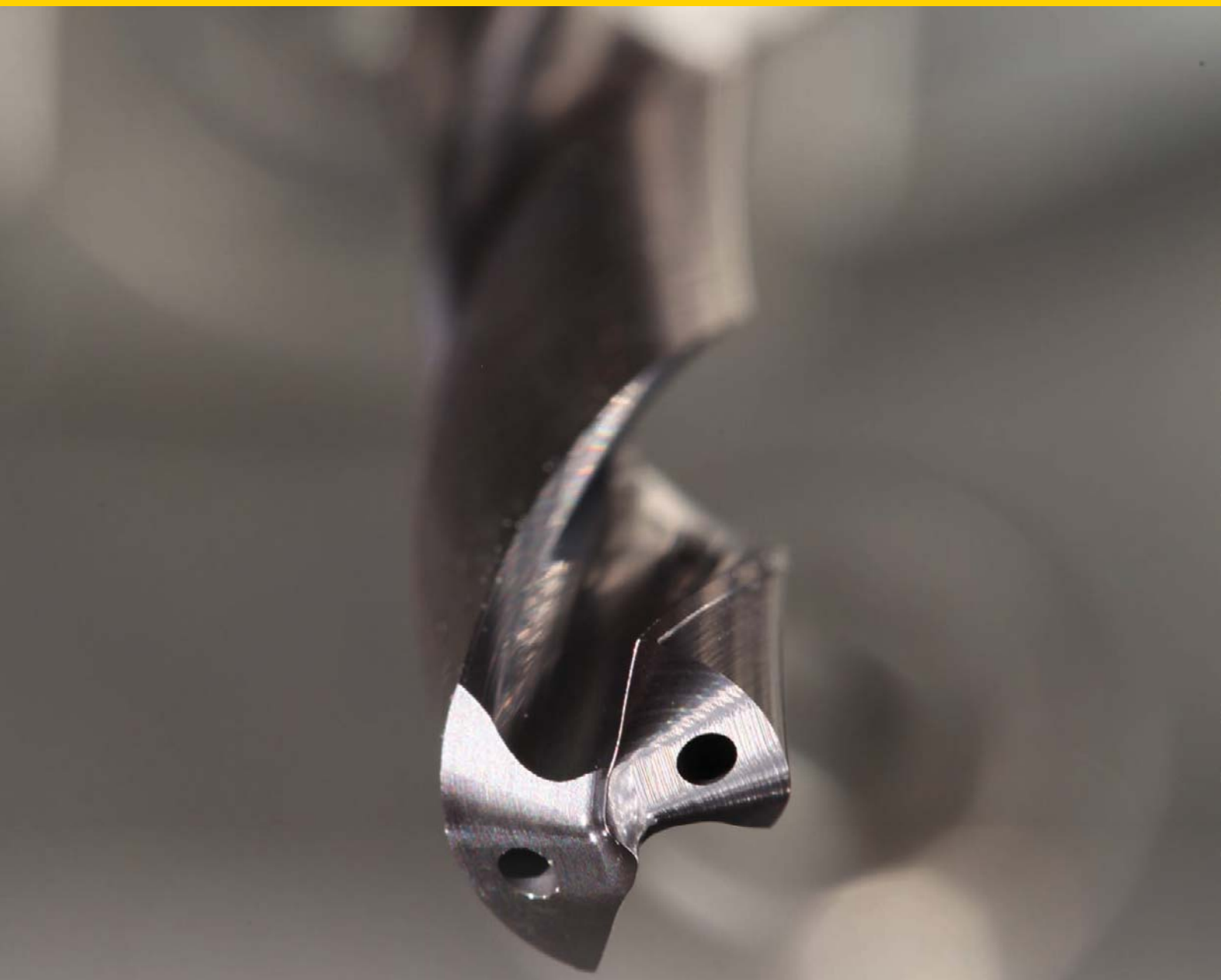
custom solution range			■ standard □ custom solution capabilities																				
diameter range																							
D1 mm	D1 in	drilling depth																					page(s)
min-max	min-max																						
1,0–20,0	.0394–.7874	1.5–12 x			■	■	■			■			□	□				□	■	■	□		G14
3,0–25,0	.1181–1.00	1.5–8 x			■	■	■			■			□	□	■		□	□	■	□			G28
3,0–25,0	.1181–1.00	1.5–5 x			■	■	■			■			□	□	■		□	□	■	□			G36
3,0–25,0	.1181–1.00	1.5–8 x			■	■	■	■		■			□	□		■		■	■	□			G50
3,0–25,0	.1181–1.00	1.5–12 x			■	■	■	■		■			□	□	□		■	□	■	□			G57
3,0–25,0	.1181–.7874	1.5–12 x			■	■	■	■		■			□	□	□		■	□	■	□			G60
2,4–16,0 2,4–16,0 2,4–16,0	.0938–.6299 .0938–.6299 .0938–.6299	500mm 500mm 500mm			■ ■ ■	■ ■ ■	■ ■ ■	■ ■ ■		■ ■ ■					□ □ □		■ ■ ■	□ □ □	■ ■ ■	□ □ □			G66
3,0–25,0	.1181–.7874	3–8 x			■	■	■						□	□	■		□	□	■	□			G80
3,0–25,0	.1181–1.00	1.5–8 x			■	■	■	■		■			□	□		■		□	■	□			G86
3,0–25,0	.1181–1.00	1.5–12 x			■	■	■	■	■	■	■		□	□	□		■	□	■	□			G92
3,0–25,0	.1181–1.00	1.5–5 x			■	■	■	□		■			□	□	■		□	□	■	□			G102
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			■ ■ ■	■ ■ ■	■ ■ ■	■ ■ ■	■ ■ ■		■ ■ ■	■ ■ ■	□ □ □	□ □ □	□ □ □		■ ■ ■	■ ■ ■	■ ■ ■	□ □ □			G108
3,0–25,0	.1181–1.00	1.5–8 x			■	■	■						■	■	■		□	□	■	□			G116
3,0–20,0	.1181–.7874	1.5–12 x			■		■	□		■			□	□	■		□	□	■	□			G122
2,4–25,0	.1181–1.00	1.5–12 x			■	■	■	■		■			□	□	□		■	□	■	■			G128

*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 catalog 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 maximizes every shift. **kennametal.com/novo**

Solid Carbide Drills • Recommendation Chart

Material Specific

standard first choice = bold alternate choice = regular simple special = gray	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** B533A	
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 optimization 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 aluminum, 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** B533A				
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 .0394–.7874" (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 utilization 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 or regular lengths conform to DIN 6537.
Drills with long lengths conform to Kennametal factory standard.
Solid Carbide Drills with diameter D1>.787" (not DIN 6537) are also standardized to factory standard.

Dimensions for Kennametal Solid Carbide Drills (B_Series) • Inch

inch 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
.0394	.0551	.1575	1.10	2.28	.28	.20	2.28	.35	.24	2.28	.47	.39	–	–	–
.0552	.0748	.1575	1.10	2.28	.35	.24	2.28	.47	.35	2.28	.71	.59	–	–	–
.0748	.0906	.1575	1.10	2.28	.51	.35	2.28	.71	.55	2.60	1.02	.87	–	–	–
.0906	.1177	.1575	1.10	2.28	.67	.47	2.28	.87	.67	2.60	1.18	.98	–	–	–
.1181	.1476	.2362	1.42	2.44	.79	.55	2.60	1.10	.91	3.07	1.57	1.30	3.07	1.57	1.30
.1477	.1870	.2362	1.42	2.60	.94	.67	2.91	1.42	1.14	3.43	1.93	1.61	3.43	1.93	1.61
.1870	.2362	.2362	1.42	2.60	1.10	.79	3.23	1.73	1.38	3.70	2.20	1.89	3.70	2.20	1.89
.2363	.2756	.3150	1.42	3.11	1.34	.94	3.58	2.09	1.69	4.13	2.64	2.24	4.13	2.64	2.24
.2756	.3150	.3150	1.42	3.11	1.61	1.14	3.58	2.09	1.69	4.33	2.83	2.40	4.76	3.23	2.52
.3150	.3937	.3937	1.57	3.50	1.85	1.38	4.06	2.40	1.93	4.80	3.15	2.68	5.71	4.02	3.15
.3937	.4724	.4724	1.77	4.02	2.17	1.57	4.65	2.80	2.20	5.55	3.70	3.11	6.69	4.80	3.78
.4725	.5512	.5512	1.77	4.21	2.36	1.69	4.88	3.03	2.36	6.10	4.25	3.58	7.48	5.59	4.41
.5512	.6299	.6299	1.89	4.53	2.56	1.77	5.24	3.27	2.48	6.73	4.76	3.98	8.39	6.38	5.04
.6300	.7087	.7087	1.89	4.84	2.87	2.01	5.63	3.66	2.80	7.28	5.32	4.45	9.13	7.13	5.67
.7087	.7874	.7874	1.97	5.16	3.11	2.17	6.02	3.98	3.03	7.87	5.83	4.88	10.00	7.91	6.30
.7874	.8661	.7874	1.97	5.55	3.39	2.36	6.57	4.41	3.35	8.54	6.38	5.35	10.79	8.70	6.93
.8662	.9843	.9843	2.20	6.02	3.74	2.56	7.24	4.96	3.86	9.37	7.09	5.91	12.20	9.88	7.87

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

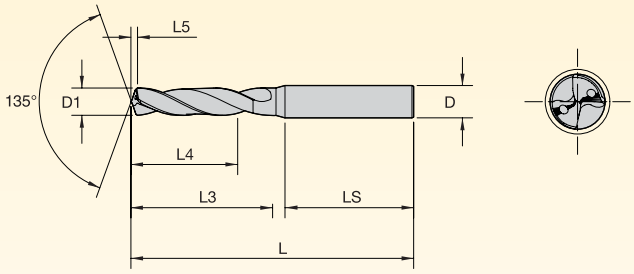
Shank designs to DIN 6535



Form HE,
2° angle
Design F



Form HA,
straight round
Design A

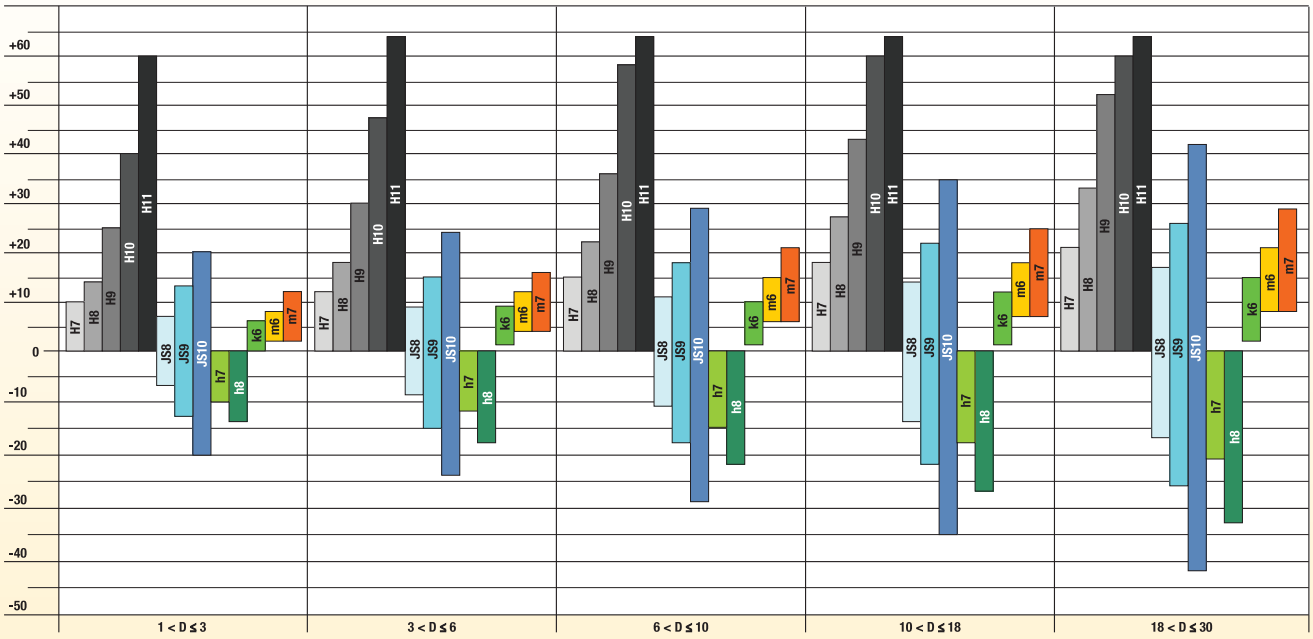


Holemaking Drilling Portfolio • Diameter Tolerances

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 ≤ .1181" (3mm)
	h7	JS9	JS8	B04*CPG, B05*CPG ≥ .1181" (3mm)
3F	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.

KENNAMETAL®

GOdrill™

For Multiple Materials

Primary Application

The GOdrill platform addresses drilling operations in a diameter range of 1–20mm (.0394–.7874") 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 utilization 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 (.0394").

CPG Point

- Optimized gashing design for microdrilling ensures free flow of chips in the center of the drill.
- Excellent centering 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.

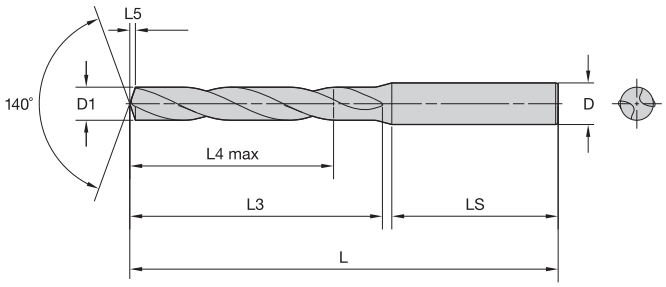


KC7325™ Grade

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 utilize the tool's full tool life capacity.

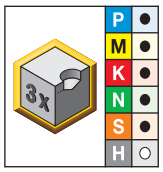


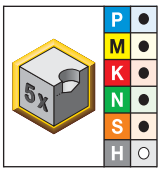




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B041A/B042A • ~3 x D/~5 x D



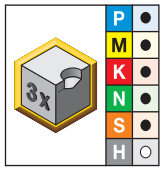


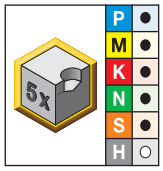
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	in	fraction	wire size	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	3/64	–	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	5/64	–	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	3/32	–	0,4	28	4
B041A02400CPG	B042A02400CPG	2,400	.0945	–	–	0,4	28	4
B041A02439CPG	B042A02439CPG	2,439	.0960	–	41	0,4	28	4
B041A02489CPG	B042A02489CPG	2,489	.0980	–	40	0,4	28	4
B041A02500CPG	B042A02500CPG	2,500	.0984	–	–	0,4	28	4
B041A02578CPG	B042A02578CPG	2,578	.1015	–	38	0,4	28	4
B041A02600CPG	B042A02600CPG	2,600	.1024	–	–	0,4	28	4
B041A02642CPG	B042A02642CPG	2,642	.1040	–	37	0,4	28	4
B041A02700CPG	B042A02700CPG	2,700	.1063	–	–	0,4	28	4

(continued)

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



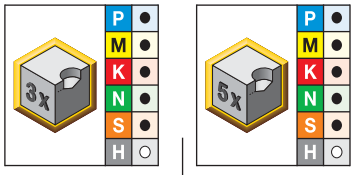


● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	in	fraction	wire size	L5	LS	D
B041A02705CPG	B042A02705CPG	2,705	.1065	–	36	0,4	28	4
B041A02779CPG	B042A02779CPG	2,779	.1094	7/64	–	0,4	28	4
B041A02800CPG	B042A02800CPG	2,800	.1102	–	–	0,5	28	4
B041A02820CPG	B042A02820CPG	2,820	.1110	–	34	0,5	28	4
B041A02870CPG	B042A02870CPG	2,870	.1130	–	33	0,5	28	4
B041A02900CPG	B042A02900CPG	2,900	.1142	–	–	0,5	28	4
B041A02947CPG	B042A02947CPG	2,947	.1160	–	32	0,5	28	4
B041A03000CPG	B042A03000CPG	3,000	.1181	–	–	0,5	36	6
B041A03048CPG	B042A03048CPG	3,048	.1200	–	31	0,5	36	6
B041A03100CPG	B042A03100CPG	3,100	.1220	–	–	0,5	36	6
B041A03175CPG	B042A03175CPG	3,175	.1250	1/8	–	0,5	36	6
B041A03200CPG	B042A03200CPG	3,200	.1260	–	–	0,5	36	6
B041A03264CPG	B042A03264CPG	3,264	.1285	–	30	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	–	29	0,6	36	6
B041A03500CPG	B042A03500CPG	3,500	.1378	–	–	0,6	36	6
B041A03571CPG	B042A03571CPG	3,571	.1406	9/64	–	0,6	36	6
B041A03600CPG	B042A03600CPG	3,600	.1417	–	–	0,6	36	6
B041A03658CPG	B042A03658CPG	3,658	.1440	–	27	0,6	36	6
B041A03700CPG	B042A03700CPG	3,700	.1457	–	–	0,6	36	6
B041A03734CPG	B042A03734CPG	3,734	.1470	–	26	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	5/32	–	0,7	36	6
B041A04000CPG	B042A04000CPG	4,000	.1575	–	–	0,7	36	6
B041A04039CPG	B042A04039CPG	4,039	.1590	–	21	0,7	36	6
B041A04090CPG	B042A04090CPG	4,090	.1610	–	20	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	–	19	0,7	36	6
B041A04300CPG	B042A04300CPG	4,300	.1693	–	–	0,7	36	6
B041A04366CPG	B042A04366CPG	4,366	.1719	11/64	–	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	–	14	0,8	36	6
B041A04700CPG	B042A04700CPG	4,700	.1850	–	13	0,8	36	6
B041A04763CPG	B042A04763CPG	4,763	.1875	3/16	–	0,8	36	6
B041A04800CPG	B042A04800CPG	4,800	.1890	–	12	0,8	36	6
B041A04852CPG	B042A04852CPG	4,852	.1910	–	11	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	–	7	0,8	36	6
B041A05159CPG	B042A05159CPG	5,159	.2031	13/64	–	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	–	3	0,9	36	6
B041A05500CPG	B042A05500CPG	5,500	.2165	–	–	0,9	36	6
B041A05558CPG	B042A05558CPG	5,558	.2188	7/32	–	0,9	36	6

(continued)

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

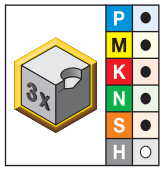


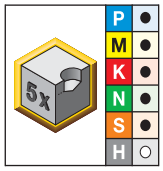
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	in	fraction	wire size	L5	LS	D
B041A05600CPG	B042A05600CPG	5,600	.2205	–	–	0,9	36	6
B041A05616CPG	B042A05616CPG	5,616	.2211	–	2	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	15/64	–	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	1/4	E	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	–	F	1,1	36	8
B041A06600CPG	B042A06600CPG	6,600	.2598	–	–	1,1	36	8
B041A06630CPG	B042A06630CPG	6,630	.2610	–	G	1,1	36	8
B041A06700CPG	B042A06700CPG	6,700	.2638	–	–	1,1	36	8
B041A06746CPG	B042A06746CPG	6,746	.2656	17/64	–	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	9/32	–	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	19/64	–	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	5/16	–	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	21/64	–	1,4	40	10
B041A08400CPG	B042A08400CPG	8,400	.3307	–	–	1,4	40	10
B041A08433CPG	B042A08433CPG	8,433	.3320	–	Q	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	11/32	–	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	23/64	–	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	–	U	1,6	40	10

(continued)

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



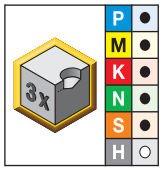


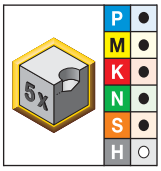
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	in	fraction	wire size	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	3/8	–	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	25/64	–	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	13/32	–	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	27/64	–	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	7/16	–	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	29/64	–	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	15/32	–	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	31/64	–	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	1/2	–	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	33/64	–	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)



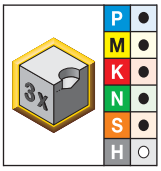


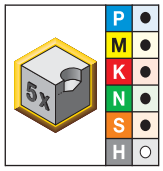
● first choice
○ alternate choice

short • KC7325	long • KC7325	D1 diameter mm	in	fraction	wire size	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	35/64	–	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	9/16	–	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	37/64	–	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	19/32	–	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	39/64	–	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	5/8	–	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	41/64	–	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	21/32	–	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	11/16	–	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	45/64	–	3,1	48	18

(continued)

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



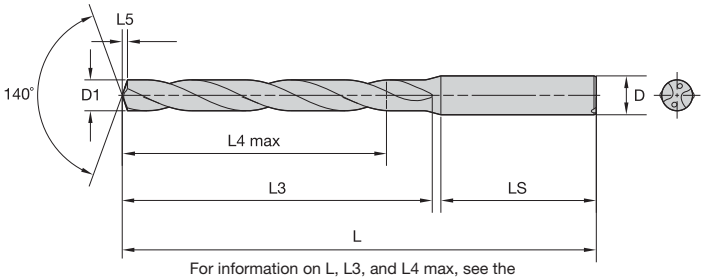


● first choice
○ alternate choice

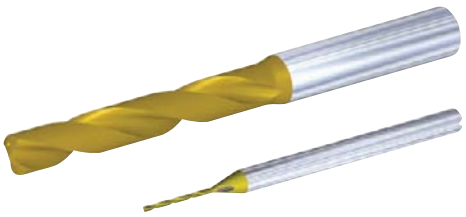
short • KC7325	long • KC7325	D1 diameter mm	in	fraction	wire size	L5	LS	D
B041A17900CPG	B042A17900CPG	17,900	.7047	–	–	3,1	48	18
B041A18000CPG	B042A18000CPG	18,000	.7087	–	–	3,1	48	18
B041A18100CPG	B042A18100CPG	18,100	.7126	–	–	3,1	50	20
B041A18200CPG	B042A18200CPG	18,200	.7165	–	–	3,2	50	20
B041A18258CPG	B042A18258CPG	18,258	.7188	23/32	–	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	47/64	–	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	3/4	–	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.

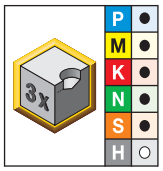


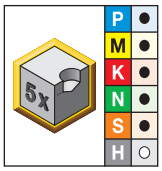


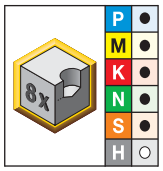
For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.



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





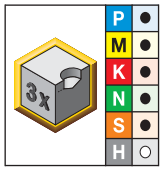


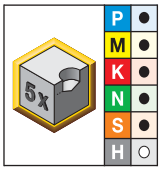
● first choice
○ alternate choice

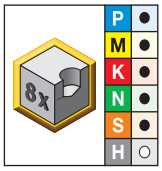
short • KC7325	long • KC7325	extra long • KC7325	D1 diameter mm	in	fraction	wire size	L5	LS	D
–	–	B053A01000CPG	1,000	.0394	–	–	0,1	28	4
–	–	B053A01016CPG	1,016	.0400	–	60	0,1	28	4
–	–	B053A01067CPG	1,067	.0420	–	58	0,2	28	4
–	–	B053A01100CPG	1,100	.0433	–	–	0,2	28	4
–	–	B053A01181CPG	1,181	.0465	–	56	0,2	28	4
–	–	B053A01191CPG	1,191	.0469	3/64	–	0,2	28	4
–	–	B053A01200CPG	1,200	.0472	–	–	0,2	28	4
–	–	B053A01300CPG	1,300	.0512	–	–	0,2	28	4
–	–	B053A01321CPG	1,321	.0520	–	55	0,2	28	4
–	–	B053A01397CPG	1,397	.0550	–	54	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	5/64	–	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	3/32	–	0,4	28	4
B051A02400CPG	B052A02400CPG	B053A02400CPG	2,400	.0945	–	–	0,4	28	4
B051A02439CPG	B052A02439CPG	B053A02439CPG	2,439	.0960	–	41	0,4	28	4
B051A02489CPG	B052A02489CPG	B053A02489CPG	2,489	.0980	–	40	0,4	28	4
B051A02500CPG	B052A02500CPG	B053A02500CPG	2,500	.0984	–	–	0,4	28	4
B051A02578CPG	B052A02578CPG	B053A02578CPG	2,578	.1015	–	38	0,4	28	4
B051A02600CPG	B052A02600CPG	B053A02600CPG	2,600	.1024	–	–	0,4	28	4
B051A02642CPG	B052A02642CPG	B053A02642CPG	2,642	.1040	–	37	0,4	28	4
B051A02700CPG	B052A02700CPG	B053A02700CPG	2,700	.1063	–	–	0,4	28	4
B051A02705CPG	B052A02705CPG	B053A02705CPG	2,705	.1065	–	36	0,4	28	4
B051A02779CPG	B052A02779CPG	B053A02779CPG	2,779	.1094	7/64	–	0,4	28	4
B051A02800CPG	B052A02800CPG	B053A02800CPG	2,800	.1102	–	–	0,5	28	4
B051A02820CPG	B052A02820CPG	B053A02820CPG	2,820	.1110	–	34	0,5	28	4
B051A02870CPG	B052A02870CPG	B053A02870CPG	2,870	.1130	–	33	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)





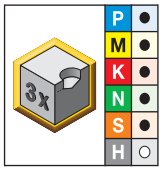


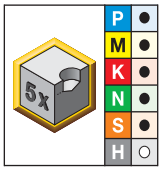
● first choice
○ alternate choice

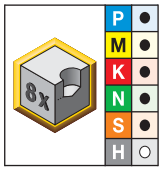
short • KC7325	long • KC7325	extra long • KC7325	D1 diameter mm	in	fraction	wire size	L5	LS	D
B051A02947CPG	B052A02947CPG	B053A02947CPG	2,947	.1160	–	32	0,5	28	4
B051A03000CPG	B052A03000CPG	B053A03000CPG	3,000	.1181	–	–	0,5	36	6
B051A03048CPG	B052A03048CPG	B053A03048CPG	3,048	.1200	–	31	0,5	36	6
B051A03100CPG	B052A03100CPG	B053A03100CPG	3,100	.1220	–	–	0,5	36	6
B051A03175CPG	B052A03175CPG	B053A03175CPG	3,175	.1250	1/8	–	0,5	36	6
B051A03200CPG	B052A03200CPG	B053A03200CPG	3,200	.1260	–	–	0,5	36	6
B051A03264CPG	B052A03264CPG	B053A03264CPG	3,264	.1285	–	30	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	–	29	0,6	36	6
B051A03500CPG	B052A03500CPG	B053A03500CPG	3,500	.1378	–	–	0,6	36	6
B051A03571CPG	B052A03571CPG	B053A03571CPG	3,571	.1406	9/64	–	0,6	36	6
B051A03600CPG	B052A03600CPG	B053A03600CPG	3,600	.1417	–	–	0,6	36	6
B051A03658CPG	B052A03658CPG	B053A03658CPG	3,658	.1440	–	27	0,6	36	6
B051A03700CPG	B052A03700CPG	B053A03700CPG	3,700	.1457	–	–	0,6	36	6
B051A03734CPG	B052A03734CPG	B053A03734CPG	3,734	.1470	–	26	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	5/32	–	0,7	36	6
B051A04000CPG	B052A04000CPG	B053A04000CPG	4,000	.1575	–	–	0,7	36	6
B051A04039CPG	B052A04039CPG	B053A04039CPG	4,039	.1590	–	21	0,7	36	6
B051A04090CPG	B052A04090CPG	B053A04090CPG	4,090	.1610	–	20	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	–	19	0,7	36	6
B051A04300CPG	B052A04300CPG	B053A04300CPG	4,300	.1693	–	–	0,7	36	6
B051A04366CPG	B052A04366CPG	B053A04366CPG	4,366	.1719	11/64	–	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	–	14	0,8	36	6
B051A04700CPG	B052A04700CPG	B053A04700CPG	4,700	.1850	–	13	0,8	36	6
B051A04763CPG	B052A04763CPG	B053A04763CPG	4,763	.1875	3/16	–	0,8	36	6
B051A04800CPG	B052A04800CPG	B053A04800CPG	4,800	.1890	–	12	0,8	36	6
B051A04852CPG	B052A04852CPG	B053A04852CPG	4,852	.1910	–	11	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	–	7	0,8	36	6
B051A05159CPG	B052A05159CPG	B053A05159CPG	5,159	.2031	13/64	–	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	–	3	0,9	36	6
B051A05500CPG	B052A05500CPG	B053A05500CPG	5,500	.2165	–	–	0,9	36	6
B051A05558CPG	B052A05558CPG	B053A05558CPG	5,558	.2188	7/32	–	0,9	36	6
B051A05600CPG	B052A05600CPG	B053A05600CPG	5,600	.2205	–	–	0,9	36	6
B051A05616CPG	B052A05616CPG	B053A05616CPG	5,616	.2211	–	2	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	15/64	–	1,0	36	6

(continued)

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





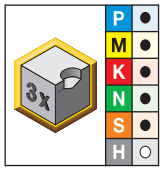


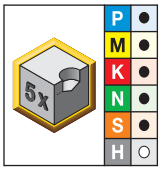
● first choice
○ alternate choice

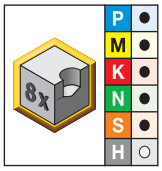
short • KC7325	long • KC7325	extra long • KC7325	D1 diameter mm	in	fraction	wire size	L5	LS	D
B051A06000CPG	B052A06000CPG	B053A06000CPG	6,000	.2362	—	—	1,0	36	6
B051A06100CPG	B052A06100CPG	B053A06100CPG	6,100	.2402	—	—	1,0	36	8
B051A06200CPG	B052A06200CPG	B053A06200CPG	6,200	.2441	—	—	1,0	36	8
B051A06300CPG	B052A06300CPG	B053A06300CPG	6,300	.2480	—	—	1,1	36	8
B051A06350CPG	B052A06350CPG	B053A06350CPG	6,350	.2500	1/4	E	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	—	F	1,1	36	8
B051A06600CPG	B052A06600CPG	B053A06600CPG	6,600	.2598	—	—	1,1	36	8
B051A06630CPG	B052A06630CPG	B053A06630CPG	6,630	.2610	—	G	1,1	36	8
B051A06700CPG	B052A06700CPG	B053A06700CPG	6,700	.2638	—	—	1,1	36	8
B051A06746CPG	B052A06746CPG	B053A06746CPG	6,746	.2656	17/64	—	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	9/32	—	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	19/64	—	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	5/16	—	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	21/64	—	1,4	40	10
B051A08400CPG	B052A08400CPG	B053A08400CPG	8,400	.3307	—	—	1,4	40	10
B051A08433CPG	B052A08433CPG	B053A08433CPG	8,433	.3320	—	Q	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	11/32	—	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	23/64	—	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	—	U	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	3/8	—	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)





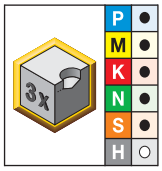


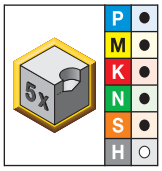
● first choice
○ alternate choice

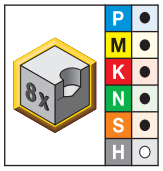
short • KC7325	long • KC7325	extra long • KC7325	D1 diameter mm	in	fraction	wire size	L5	LS	D
B051A09900CPG	B052A09900CPG	B053A09900CPG	9,900	.3898	–	–	1,7	40	10
B051A09921CPG	B052A09921CPG	B053A09921CPG	9,921	.3906	25/64	–	1,7	40	10
B051A10000CPG	B052A10000CPG	B053A10000CPG	10,000	.3937	–	–	1,7	40	10
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	13/32	–	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	27/64	–	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	7/16	–	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	29/64	–	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	15/32	–	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	31/64	–	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	1/2	–	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	33/64	–	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	35/64	–	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)





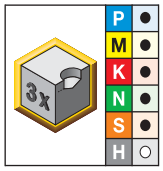


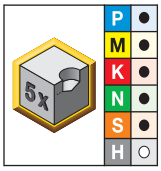
● first choice
○ alternate choice

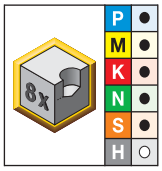
short • KC7325	long • KC7325	extra long • KC7325	D1 diameter mm	in	fraction	wire size	L5	LS	D
B051A14200CPG	B052A14200CPG	B053A14200CPG	14,200	.5591	–	–	2,5	48	16
B051A14288CPG	B052A14288CPG	B053A14288CPG	14,288	.5625	9/16	–	2,5	48	16
B051A14300CPG	B052A14300CPG	B053A14300CPG	14,300	.5630	–	–	2,5	48	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	37/64	–	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	19/32	–	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	39/64	–	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	5/8	–	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	41/64	–	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	21/32	–	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	11/16	–	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	45/64	–	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	23/32	–	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	in	fraction	wire size	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	47/64	—	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	3/4	—	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 <.0591" (1,5mm) have coolant exiting the shank.

Tolerance • Inch

nominal size range	D1 tolerance	D tolerance h6
.0394–.1181	.0000/-.0006 (h8)	.0000/-.0002
>.1181–.2362	.0000/-.0005 (h7)	.0000/-.0003
>.2362–.3937	.0000/-.0006 (h7)	.0000/-.0004
>.3937–.7087	.0000/-.0007 (h7)	.0000/-.0004
>.7087–.7874	.0000/-.0008 (h7)	.0000/-.0005

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 (.0394–.7874")





Material Group		Cutting Speed — vc Range — m/min				Metric 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

Material Group		Cutting Speed — vc Range — SFM				Inch Recommended Feed Rate (f) by Diameter									
		min	Starting Value	max		3/64 .047	5/64 .078	1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	0	200	**230**	330	IPR	.001–.003	.002–.004	.002–.004	.003–.005	.004–.007	.004–.009	.005–.010	.006–.012	.007–.014	.009–.018
	1	200	**230**	330	IPR	.002–.004	.002–.004	.002–.005	.004–.006	.004–.009	.005–.010	.006–.012	.007–.014	.009–.017	.011–.021
	2	260	**300**	330	IPR	.002–.004	.002–.004	.002–.005	.003–.006	.005–.009	.006–.010	.007–.012	.008–.014	.009–.017	.012–.021
	3	160	**230**	300	IPR	.002–.004	.002–.005	.003–.006	.004–.007	.005–.009	.006–.011	.008–.013	.009–.015	.010–.019	.013–.023
	4	160	**230**	330	IPR	.002–.005	.002–.005	.002–.006	.003–.007	.005–.009	.006–.011	.007–.013	.008–.015	.009–.019	.011–.023
	5	100	**130**	200	IPR	.001–.002	.002–.002	.002–.003	.002–.004	.003–.006	.004–.007	.005–.009	.006–.009	.007–.013	.009–.016
	6	100	**130**	200	IPR	.001–.002	.002–.002	.002–.003	.002–.004	.003–.006	.004–.007	.005–.009	.006–.009	.007–.013	.009–.016
M	1	70	**100**	130	IPR	.001–.002	.001–.002	.002–.003	.002–.004	.003–.004	.004–.005	.004–.006	.005–.006	.006–.007	.006–.008
	2	100	**130**	160	IPR	.001–.002	.001–.003	.002–.003	.002–.004	.003–.005	.004–.006	.004–.006	.005–.007	.006–.008	.006–.009
	3	70	**100**	130	IPR	.001–.002	.001–.002	.002–.003	.002–.004	.003–.004	.004–.005	.004–.006	.005–.006	.006–.007	.006–.008
K	1	260	**430**	560	IPR	.004–.007	.004–.008	.004–.009	.005–.009	.006–.012	.008–.015	.009–.017	.010–.019	.012–.024	.015–.029
	2	300	**360**	390	IPR	.002–.005	.003–.006	.004–.007	.005–.008	.006–.010	.008–.012	.009–.014	.010–.016	.012–.019	.015–.024
	3	260	**360**	430	IPR	.002–.004	.002–.005	.003–.006	.004–.008	.005–.010	.006–.012	.007–.014	.008–.016	.010–.019	.012–.024
N	1	300	**750**	890	IPR	.002–.005	.002–.005	.003–.006	.004–.006	.005–.008	.006–.009	.008–.011	.009–.013	.011–.016	.013–.019
	2	300	**720**	890	IPR	.002–.003	.002–.005	.003–.006	.004–.008	.005–.009	.006–.011	.008–.013	.009–.014	.011–.017	.013–.021
	3	300	**590**	740	IPR	.004–.005	.004–.006	.005–.006	.005–.006	.006–.008	.006–.009	.008–.011	.009–.013	.011–.016	.013–.017
	4	300	**430**	890	IPR	.002–.003	.002–.005	.003–.006	.004–.008	.005–.009	.006–.011	.008–.013	.009–.014	.011–.016	.013–.019
S	1	70	**80**	100	IPR	.000–.002	.001–.002	.001–.002	.002–.003	.002–.004	.003–.005	.004–.005	.004–.006	.005–.006	.006–.007
	2	30	**70**	100	IPR	.000–.001	.001–.001	.001–.002	.001–.002	.002–.003	.003–.004	.003–.004	.004–.005	.004–.006	.004–.006
	3	70	**80**	130	IPR	.000–.001	.001–.001	.001–.002	.001–.002	.002–.003	.002–.004	.003–.004	.003–.004	.004–.005	.004–.006
	4	70	**80**	160	IPR	.000–.001	.001–.001	.001–.002	.001–.002	.002–.003	.003–.004	.003–.004	.004–.005	.004–.006	.004–.006
H	1	30	**50**	100	IPR	.000–.001	.001–.001	.001–.002	.001–.002	.002–.003	.003–.004	.003–.004	.004–.005	.004–.006	.004–.006
	2	30	**30**	100	IPR	.000–.001	.001–.001	.001–.002	.001–.002	.002–.003	.002–.004	.003–.004	.003–.004	.004–.005	.004–.006

GOdrill™ • B05_CPG Series • Grade KC7325™ • Through Coolant • Drill Diameters 1–20mm (.0394–.7874")



Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter		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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter		3/64 .047	5/64 .078	1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	0	230	260	380	IPR		.001–.003	.002–.004	.002–.004	.003–.005	.004–.007	.004–.009	.005–.010	.006–.012	.007–.014	.009–.018
	1	230	330	460	IPR		.002–.004	.002–.005	.003–.006	.003–.006	.004–.009	.005–.010	.006–.012	.007–.014	.009–.017	.011–.021
	2	300	390	460	IPR		.002–.004	.002–.005	.003–.006	.003–.006	.005–.009	.006–.010	.007–.012	.008–.014	.009–.017	.012–.021
	3	200	260	330	IPR		.002–.004	.002–.005	.003–.006	.004–.007	.005–.009	.006–.011	.008–.013	.009–.015	.010–.019	.013–.023
	4	160	260	330	IPR		.002–.004	.002–.005	.003–.006	.003–.007	.005–.009	.006–.011	.007–.013	.008–.015	.009–.019	.011–.023
	5	130	160	230	IPR		.001–.002	.002–.002	.002–.003	.002–.004	.003–.006	.004–.007	.005–.009	.006–.009	.007–.013	.009–.016
	6	130	160	230	IPR		.001–.002	.002–.002	.002–.003	.002–.004	.003–.006	.004–.007	.005–.009	.006–.009	.007–.013	.009–.016
M	1	70	100	130	IPR		.001–.002	.001–.002	.002–.003	.002–.004	.003–.004	.004–.005	.004–.006	.005–.006	.006–.007	.006–.008
	2	100	130	160	IPR		.001–.002	.001–.003	.002–.003	.002–.004	.003–.005	.004–.006	.004–.006	.005–.007	.006–.008	.006–.009
	3	70	100	130	IPR		.001–.002	.001–.002	.002–.003	.002–.004	.003–.004	.004–.005	.004–.006	.005–.006	.006–.007	.006–.008
K	1	260	390	560	IPR		.003–.006	.004–.007	.004–.009	.005–.009	.006–.012	.008–.015	.009–.017	.010–.019	.012–.024	.015–.029
	2	260	360	460	IPR		.004–.006	.004–.006	.005–.006	.005–.008	.006–.010	.008–.012	.009–.014	.010–.016	.012–.019	.015–.024
	3	260	330	430	IPR		.002–.005	.003–.006	.003–.007	.004–.008	.005–.010	.006–.012	.007–.014	.008–.016	.009–.019	.012–.024
N	1	300	750	1030	IPR		.002–.005	.002–.005	.003–.006	.004–.006	.005–.008	.006–.009	.008–.011	.009–.013	.011–.016	.013–.019
	2	300	740	890	IPR		.002–.003	.002–.005	.003–.006	.004–.008	.005–.009	.006–.011	.008–.013	.009–.014	.011–.017	.013–.021
	3	300	590	890	IPR		.004–.005	.004–.006	.005–.006	.005–.006	.006–.008	.006–.009	.008–.011	.009–.013	.011–.016	.013–.017
	4	300	440	590	IPR		.002–.003	.002–.005	.003–.006	.004–.008	.005–.009	.006–.011	.008–.013	.009–.014	.011–.016	.013–.019
S	1	30	80	100	IPR		.000–.002	.001–.002	.001–.002	.002–.003	.002–.004	.003–.005	.004–.005	.004–.006	.005–.006	.006–.007
	2	30	70	80	IPR		.000–.001	.001–.001	.001–.002	.001–.002	.002–.003	.003–.004	.003–.004	.004–.005	.004–.006	.004–.006
	3	30	80	100	IPR		.000–.001	.001–.001	.001–.002	.001–.002	.002–.003	.002–.004	.003–.004	.003–.004	.004–.005	.004–.006
	4	30	80	130	IPR		.000–.001	.001–.001	.001–.002	.001–.002	.002–.003	.003–.004	.003–.004	.004–.005	.004–.006	.004–.006
H	1	30	50	100	IPR		.000–.001	.001–.001	.001–.002	.001–.002	.002–.003	.003–.004	.003–.004	.004–.005	.004–.006	.004–.006
	2	30	30	100	IPR		.000–.001	.001–.001	.001–.002	.001–.002	.002–.003	.002–.004	.003–.004	.003–.004	.004–.005	.004–.006

3F 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 gray cast iron, ductile iron, and aluminum 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 aluminum die cast alloys.



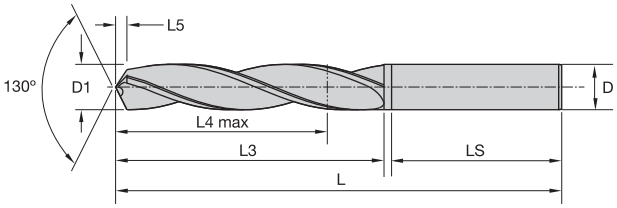
Uncoated K10™ Grade

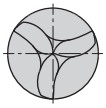
- The uncoated grade helps to prevent built-up edge in drilling aluminum and high-temp alloys.

Customization

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

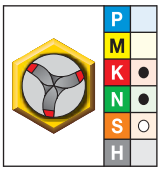








B105 • ~5 x D

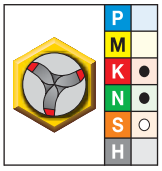


● first choice
○ alternate choice

K10	D1 diameter mm	in	fraction	wire size	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	–	13	74	36	29	1,2	36	6
B105A04800	4,800	.1890	–	12	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	1/4	–	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)

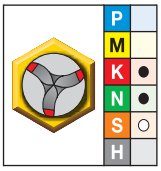


● first choice
○ alternate choice

	D1 diameter									
K10	mm	in	fraction	wire size	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	1/2	–	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

(continued)

(B105 • ~5 x D — continued)



● first choice
○ alternate choice

K10	D1 diameter mm	in	fraction	wire size	L	L3	L4 max	L5	LS	D
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
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 • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

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

3F Drills • B105 Series Grade K10™ • Flood Coolant • Drill Diameters 3–20mm (.1181–.7874")

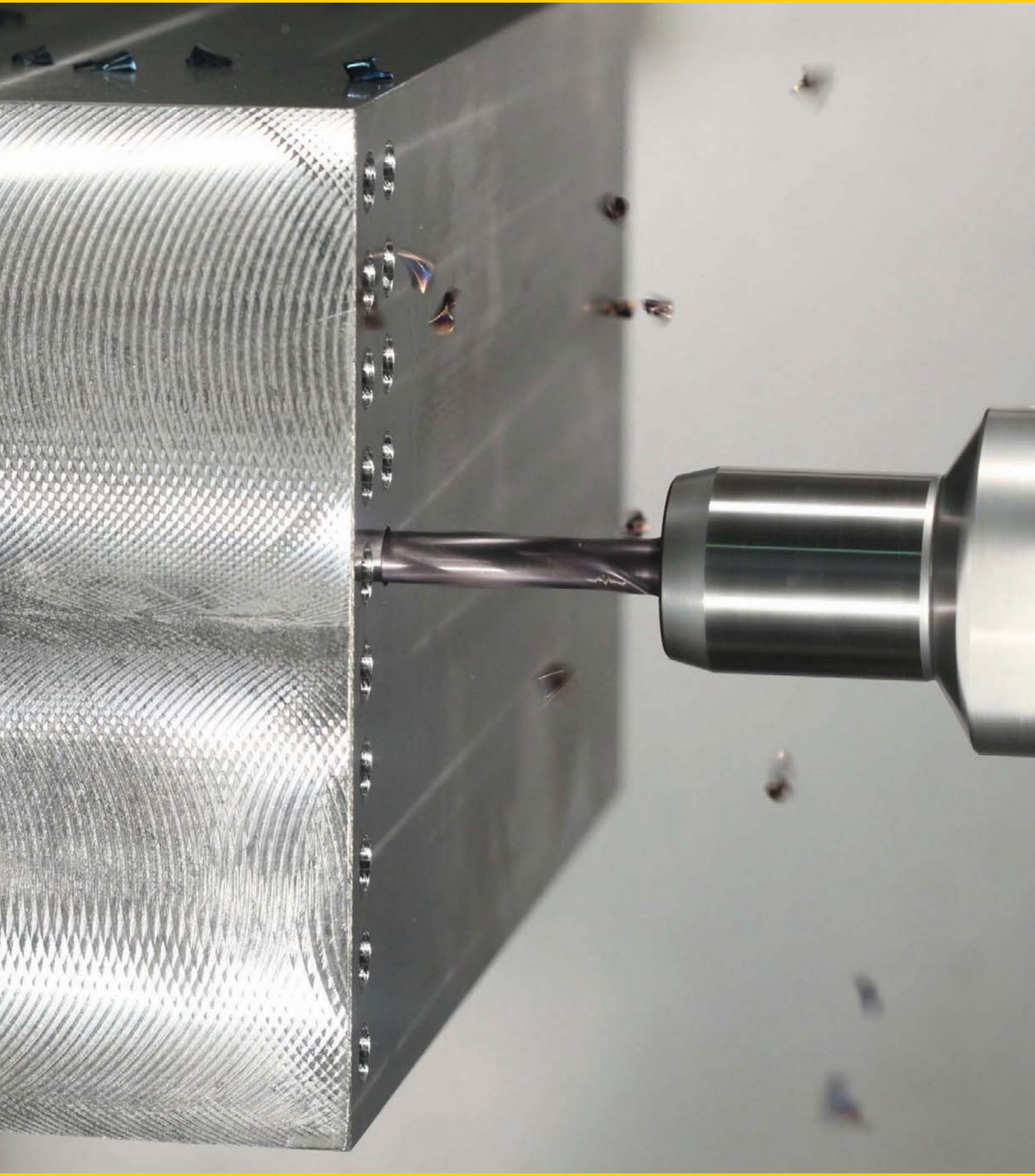




Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
K	1	60	**85**	110	mm/r	0,11–0,20	0,12–0,20	0,16–0,28	0,20–0,35	0,22–0,42	0,24–0,50	0,28–0,61	0,30–0,68
	2	70	**70**	90	mm/r	0,11–0,20	0,12–0,20	0,16–0,28	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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter		1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
K	1	200	**280**	360	IPR	.004–.008	.005–.008	.006–.011	.008–.014	.009–.017	.009–.020	.011–.024	.012–.027
	2	230	**230**	300	IPR	.004–.008	.005–.008	.006–.011	.008–.014	.009–.017	.009–.020	.011–.024	.012–.027
	3	160	**160**	230	IPR	.004–.007	.004–.007	.006–.010	.007–.013	.001–.016	.009–.019	.010–.023	.011–.026
N	1	330	**690**	1340	IPR	.004–.006	.004–.008	.007–.013	.008–.015	.010–.017	.001–.020	.017–.023	.025–.031
	2	330	**820**	820	IPR	.004–.008	.005–.008	.007–.013	.010–.017	.012–.020	.014–.023	.017–.029	.021–.035
	3	330	**590**	1310	IPR	.004–.006	.004–.008	.005–.010	.006–.014	.008–.016	.009–.018	.012–.020	.013–.024
	4	200	**560**	820	IPR	.003–.006	.005–.007	.007–.013	.008–.014	.009–.015	.013–.018	.015–.019	.023–.030
S	4	70	**70**	160	IPR	.001–.002	.002–.003	.003–.004	.004–.005	.004–.006	.005–.007	.007–.009	.009–.012

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 centering 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.

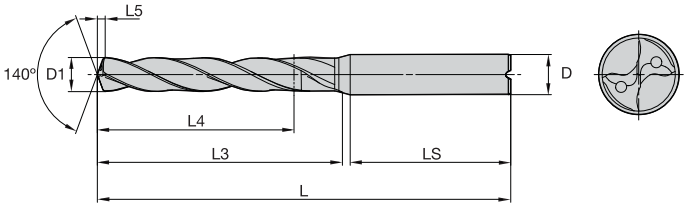


Customization

- 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.





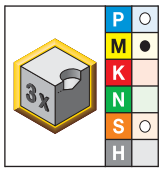


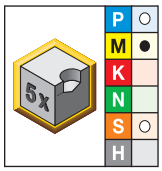
For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

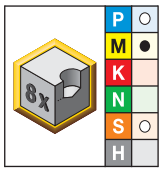


beyond

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





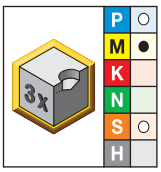


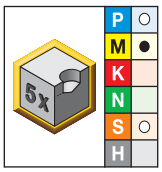
● first choice
○ alternate choice

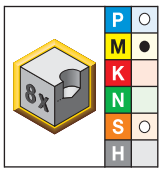
short • KCMS15	long • KCMS15	extra long • KCMS15	D1 diameter mm	in	fraction	wire size	L5	LS	D
B210Z02500SGL	–	–	2,500	.0984	–	–	0,4	28	3
B210A03000SGL	B211A03000SGL	B212A03000SGL	3,000	.1181	–	–	0,4	36	6
B210A03048SGL	B211A03048SGL	–	3,048	.1200	–	31	0,5	36	6
–	B211A03100SGL	–	3,100	.1220	–	–	0,5	36	6
B210A03175SGL	B211A03175SGL	B212A03175SGL	3,175	.1250	1/8	–	0,5	36	6
B210A03200SGL	B211A03200SGL	B212A03200SGL	3,200	.1260	–	–	0,5	36	6
B210A03264SGL	–	B212A03264SGL	3,264	.1285	–	30	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	9/64	–	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	–	26	0,6	36	6
B210A03800SGL	B211A03800SGL	B212A03800SGL	3,800	.1496	–	–	0,6	36	6
–	B211A03861SGL	–	3,861	.1520	–	24	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)





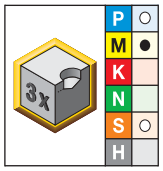


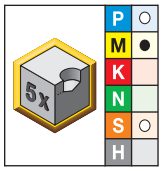
● first choice
○ alternate choice

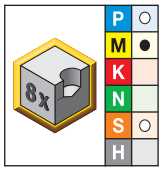
short • KCMS15	long • KCMS15	extra long • KCMS15	D1 diameter mm	in	fraction	wire size	L5	LS	D
–	B211A04763SGL	–	4,763	.1875	3/16	–	0,7	36	6
B210A04800SGL	B211A04800SGL	B212A04800SGL	4,800	.1890	–	–	0,7	36	6
–	B211A04852SGL	B212A04852SGL	4,852	.1910	–	–	0,7	36	6
B210A04900SGL	B211A04900SGL	–	4,900	.1929	–	–	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	–	2	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	15/64	–	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	1/4	–	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	9/32	–	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	5/16	–	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)





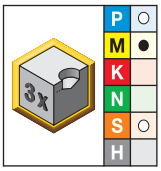


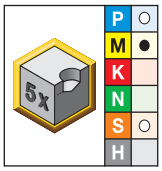
● first choice
○ alternate choice

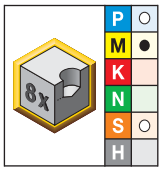
short • KCMS15	long • KCMS15	extra long • KCMS15	D1 diameter mm	in	fraction	wire size	L5	LS	D
B210A08700SGL	B211A08700SGL	–	8,700	.3425	–	–	1,3	40	10
B210A08800SGL	B211A08800SGL	B212A08800SGL	8,800	.3465	–	–	1,3	40	10
–	B211A08900SGL	–	8,900	.3504	–	–	1,3	40	10
B210A09000SGL	B211A09000SGL	B212A09000SGL	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	3/8	–	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	25/64	–	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	7/16	–	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	31/64	–	1,8	45	14
B210A12500SGL	B211A12500SGL	B212A12500SGL	12,500	.4921	–	–	1,9	45	14
B210A12700SGL	B211A12700SGL	–	12,700	.5000	1/2	–	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	17/32	–	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	in	fraction	wire size	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	5/8	–	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	21/32	–	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	3/4	–	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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181 to .2362	.0002/.0006	.0000/-.0003
>.2362 to .3937	.0002/.0008	.0000/-.0004
>.3937 to .7087	.0003/.0010	.0000/-.0004
>.7087 to 1.0000	.0003/.0011	.0000/-.0005

HP Drills • B21_SGL Series • Grade KCMS15 • Through Coolant



Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate per Rev		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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate per Rev		1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	1	360	**520**	690	IPR		.002–.005	.003–.008	.004–.009	.006–.012	.006–.014	.007–.015	.008–.018	.009–.020
	2	430	**560**	690	IPR		.002–.005	.003–.007	.004–.008	.006–.009	.006–.011	.007–.013	.008–.015	.009–.016
	3	360	**490**	620	IPR		.003–.005	.005–.008	.006–.009	.007–.012	.008–.014	.009–.015	.010–.018	.011–.020
	4	260	**390**	490	IPR		.003–.005	.004–.007	.005–.009	.006–.011	.007–.013	.008–.015	.009–.017	.010–.019
	5	200	**260**	300	IPR		.001–.004	.002–.004	.002–.004	.002–.006	.003–.007	.004–.008	.006–.009	.006–.010
	6	230	**390**	560	IPR		.002–.004	.003–.006	.004–.007	.005–.008	.006–.009	.007–.011	.008–.013	.009–.014
M	1	200	**260**	300	IPR		.002–.006	.002–.006	.003–.007	.004–.008	.005–.008	.005–.009	.006–.010	.007–.011
	2	160	**230**	300	IPR		.002–.006	.002–.006	.003–.007	.004–.008	.005–.008	.005–.009	.006–.010	.007–.011
	3	160	**200**	260	IPR		.002–.006	.002–.006	.003–.007	.004–.008	.005–.008	.005–.009	.006–.010	.007–.011
S	1	30	**70**	100	IPR		.001–.003	.002–.004	.002–.004	.002–.004	.003–.006	.004–.006	.006–.008	.006–.008
	2	30	**70**	100	IPR		.001–.004	.002–.004	.002–.004	.002–.004	.003–.006	.004–.006	.006–.008	.006–.008
	3	70	**100**	130	IPR		.001–.004	.002–.004	.002–.004	.002–.004	.003–.006	.004–.006	.006–.008	.006–.008
	4	100	**130**	160	IPR		.001–.002	.002–.002	.002–.003	.003–.004	.004–.005	.005–.006	.006–.007	.006–.008

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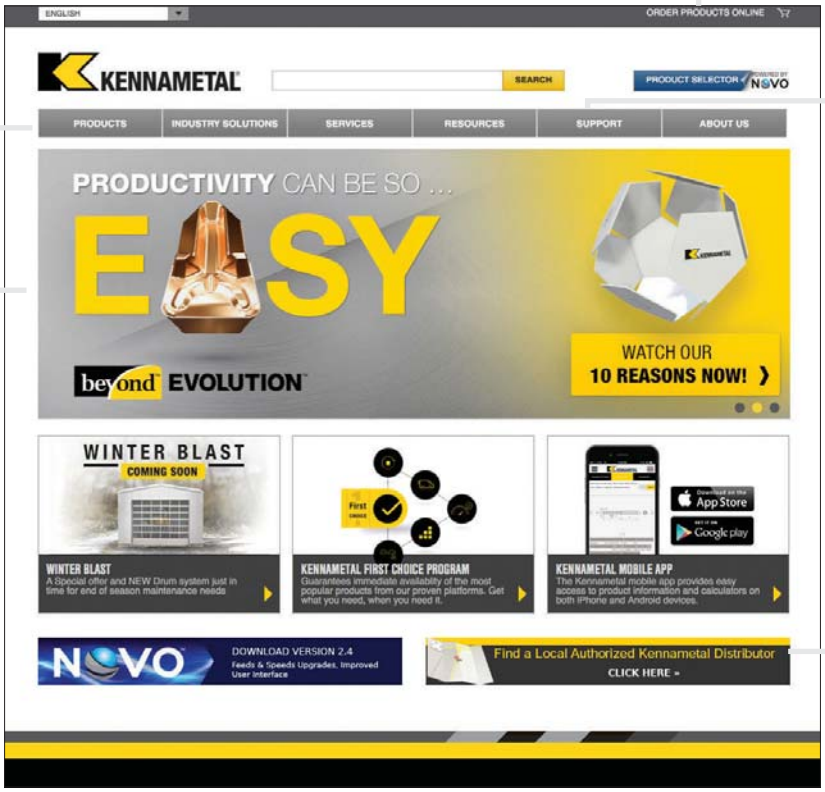

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HP Beyond™ Drills for Steel

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 centering 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%).

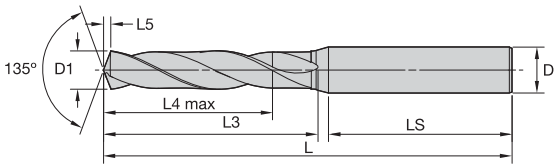
B22_HP Beyond™ drills are the ultimate high-volume production tool.



Customization

- 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.





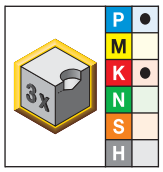


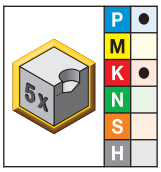


For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

beyond

B221/B222_HP • ~3 x D/~5 x D



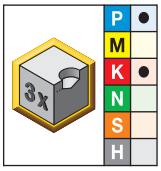


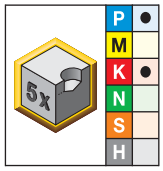
● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	in	fraction	wire size	L5	LS	D
B221A03000HP	B222A03000HP	3,000	.1181	–	–	0,6	36	6
B221A03048HP	B222A03048HP	3,048	.1200	–	31	0,6	36	6
B221A03100HP	–	3,100	.1220	–	–	0,6	36	6
B221A03175HP	B222A03175HP	3,175	.1250	1/8	–	0,6	36	6
B221A03200HP	–	3,200	.1260	–	–	0,6	36	6
B221A03264HP	B222A03264HP	3,264	.1285	–	30	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	–	29	0,7	36	6
B221A03500HP	B222A03500HP	3,500	.1378	–	–	0,7	36	6
B221A03571HP	B222A03571HP	3,571	.1406	9/64	–	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	–	26	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	5/32	–	0,7	36	6
B221A04000HP	B222A04000HP	4,000	.1575	–	–	0,8	36	6
B221A04039HP	–	4,039	.1590	–	21	0,8	36	6
B221A04090HP	–	4,090	.1610	–	20	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	–	19	0,8	36	6
B221A04300HP	–	4,300	.1693	–	–	0,8	36	6
B221A04366HP	B222A04366HP	4,366	.1719	11/64	–	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	–	14	0,9	36	6
B221A04700HP	–	4,700	.1850	–	13	0,9	36	6
B221A04763HP	B222A04763HP	4,763	.1875	3/16	–	0,9	36	6
B221A04800HP	B222A04800HP	4,800	.1890	–	12	0,9	36	6
B221A04852HP	–	4,852	.1910	–	11	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
B221A05106HP	B222A05106HP	5,106	.2010	–	7	1,0	36	6
B221A05159HP	B222A05159HP	5,159	.2031	13/64	–	1,0	36	6
B221A05200HP	–	5,200	.2047	–	–	1,0	36	6
B221A05300HP	–	5,300	.2087	–	–	1,0	36	6

(continued)

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



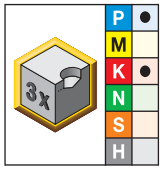


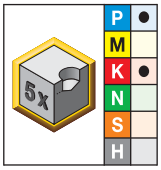
● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	in	fraction	wire size	L5	LS	D
B221A05400HP	–	5,400	.2126	–	–	1,0	36	6
B221A05410HP *	B222A05410HP *	5,410	.2130	–	3	1,0	36	6
B221A05500HP	B222A05500HP	5,500	.2165	–	–	1,0	36	6
B221A05558HP	B222A05558HP *	5,558	.2188	7/32	–	1,0	36	6
B221A05600HP	–	5,600	.2205	–	–	1,1	36	6
B221A05616HP *	–	5,616	.2211	–	2	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	15/64	–	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	1/4	–	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	17/64	–	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	9/32	–	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	19/64	–	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	5/16	–	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	21/64	–	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	11/32	–	1,6	40	10
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

(continued)

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



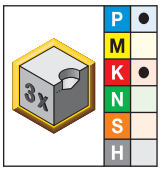


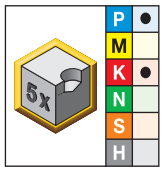
● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	in	fraction	wire size	L5	LS	D
B221A09129HP	B222A09129HP	9,129	.3594	23/64	–	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	3/8	–	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	25/64	–	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	13/32	–	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	27/64	–	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	7/16	–	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	29/64	–	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	15/32	–	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	31/64	–	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	1/2	–	2,4	45	14
B221A12800HP	–	12,800	.5039	–	–	2,4	45	14
B221A12900HP	–	12,900	.5079	–	–	2,4	45	14
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

(continued)

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





● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	in	fraction	wire size	L5	LS	D
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	35/64	–	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	9/16	–	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	37/64	–	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	19/32	–	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	39/64	–	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	5/8	–	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	11/16	–	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	3/4	–	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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

HP Drills • B221_HP, B222_HP Series • Grade KCPK15™ • Flood Coolant • Drill Diameters 3–20mm (.1181–.7874")



Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (fz) by Diameter								
						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

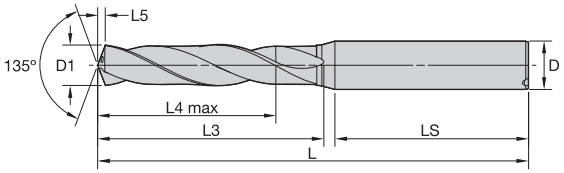
Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter								
						1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	0	260	**360**	560	IPR	.002–.006	.002–.006	.003–.008	.003–.010	.004–.012	.005–.014	.007–.017	.008–.019
	1	230	**360**	490	IPR	.003–.006	.003–.007	.003–.009	.004–.011	.004–.014	.005–.017	.010–.020	.013–.023
	2	300	**390**	520	IPR	.003–.006	.003–.007	.005–.009	.006–.012	.006–.013	.008–.016	.010–.020	.012–.023
	3	200	**300**	390	IPR	.004–.006	.004–.007	.006–.009	.006–.013	.008–.014	.009–.017	.011–.020	.013–.024
	4	160	**260**	390	IPR	.003–.006	.003–.007	.005–.010	.006–.013	.007–.013	.008–.017	.009–.020	.012–.024
	6	160	**260**	390	IPR	.002–.004	.003–.005	.004–.007	.005–.009	.006–.009	.007–.012	.009–.016	.011–.019
K	1	230	**330**	390	IPR	.004–.008	.004–.007	.006–.011	.006–.015	.008–.016	.009–.018	.011–.023	.014–.028
	2	230	**390**	390	IPR	.004–.008	.004–.006	.006–.009	.006–.013	.008–.013	.009–.015	.011–.019	.014–.024
	3	160	**300**	430	IPR	.003–.007	.003–.006	.005–.010	.005–.011	.006–.011	.007–.015	.010–.019	.011–.023

HP Drills • B221HP, B222HP Series • Grade KCPK15™ • Dry Applications • Drill Diameters 3–20mm (.1181–.7874")



Material Group		Cutting Speed — vc			Metric								
		Range — m/min			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
Material Group		Cutting Speed — vc			Inch								
		Range — SFM			Recommended Feed Rate (fz) by Diameter								
		min	Starting Value	max		0.118	0.157	0.236	0.315	0.394	0.472	0.630	0.787
P	0	230	**300**	460	IPR	.002–.004	.002–.005	.004–.007	.006–.009	.007–.012	.008–.014	.011–.017	.014–.023
	1	200	**300**	390	IPR	.003–.005	.003–.006	.005–.008	.007–.011	.008–.014	.010–.017	.013–.020	.017–.027
	2	200	**300**	390	IPR	.003–.005	.003–.006	.005–.008	.007–.011	.008–.014	.010–.017	.013–.020	.017–.027
	3	200	**260**	300	IPR	.002–.003	.003–.005	.004–.008	.006–.008	.007–.011	.008–.013	.011–.017	.014–.021
	4	200	**260**	300	IPR	.003–.005	.004–.007	.005–.009	.006–.011	.007–.013	.008–.015	.009–.017	.010–.019
	6	200	**260**	300	IPR	.002–.003	.003–.005	.004–.008	.006–.008	.007–.011	.008–.013	.011–.017	.014–.021





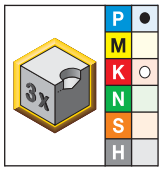


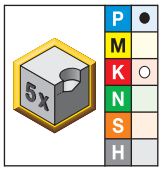


For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

beyond

B224/B225_HP • ~3 x D/~5 x D



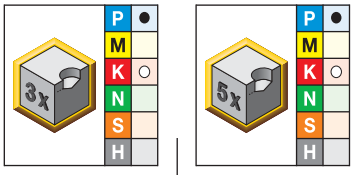


● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	in	fraction	wire size	L5	LS	D
B224A03000HP	B225A03000HP	3,000	.1181	–	–	0,6	36	6
B224A03048HP	B225A03048HP	3,048	.1200	–	31	0,6	36	6
B224A03100HP	B225A03100HP	3,100	.1220	–	–	0,6	36	6
B224A03175HP	B225A03175HP	3,175	.1250	1/8	–	0,6	36	6
B224A03200HP	B225A03200HP	3,200	.1260	–	–	0,6	36	6
B224A03264HP *	B225A03264HP	3,264	.1285	–	30	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	–	29	0,7	36	6
B224A03500HP	B225A03500HP	3,500	.1378	–	–	0,7	36	6
–	B225A03571HP	3,571	.1406	9/64	–	0,7	36	6
B224A03600HP	B225A03600HP	3,600	.1417	–	–	0,7	36	6
B224A03658HP	–	3,658	.1440	–	27	0,7	36	6
B224A03700HP *	B225A03700HP	3,700	.1457	–	–	0,7	36	6
B224A03734HP *	–	3,734	.1470	–	26	0,7	36	6
–	B225A03797HP	3,797	.1495	–	25	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	5/32	–	0,7	36	6
B224A04000HP	B225A04000HP	4,000	.1575	–	–	0,8	36	6
B224A04039HP *	–	4,039	.1590	–	21	0,8	36	6
B224A04090HP	–	4,090	.1610	–	20	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	–	19	0,8	36	6
–	B225A04300HP	4,300	.1693	–	–	0,8	36	6
B224A04366HP	B225A04366HP	4,366	.1719	11/64	–	0,8	36	6
–	B225A04400HP	4,400	.1732	–	–	0,8	36	6
B224A04496HP	B225A04496HP	4,496	.1770	–	16	0,8	36	6
–	B225A04500HP	4,500	.1772	–	–	0,8	36	6
–	B225A04600HP	4,600	.1811	–	–	0,9	36	6
B224A04623HP	–	4,623	.1820	–	14	0,9	36	6
B224A04700HP *	B225A04700HP	4,700	.1850	–	13	0,9	36	6
B224A04763HP	B225A04763HP	4,763	.1875	3/16	–	0,9	36	6
–	B225A04800HP	4,800	.1890	–	12	0,9	36	6
B224A04852HP	–	4,852	.1910	–	11	0,9	36	6

(continued)

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

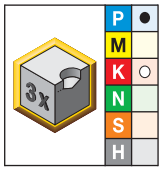


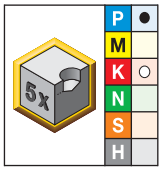
● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	in	fraction	wire size	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	–	7	1,0	36	6
B224A05159HP	B225A05159HP	5,159	.2031	13/64	–	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	–	3	1,0	36	6
B224A05500HP	B225A05500HP	5,500	.2165	–	–	1,0	36	6
B224A05558HP	B225A05558HP	5,558	.2188	7/32	–	1,0	36	6
B224A05600HP	B225A05600HP	5,600	.2205	–	–	1,1	36	6
B224A05616HP *	–	5,616	.2211	–	2	1,1	36	6
–	B225A05700HP	5,700	.2244	–	–	1,1	36	6
B224A05791HP	B225A05791HP	5,791	.2280	–	1	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	15/64	–	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	1/4	–	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	17/64	–	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	9/32	–	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	19/64	–	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	5/16	–	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)



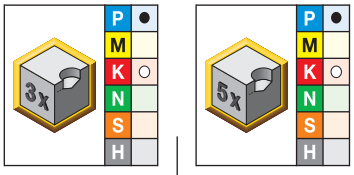


● first choice
○ alternate choice

		D1 diameter						
short • KCPK15	long • KCPK15	mm	in	fraction	wire size	L5	LS	D
–	B225A08300HP	8,300	.3268	–	–	1,6	40	10
B224A08334HP	B225A08334HP	8,334	.3281	21/64	–	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	11/32	–	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	23/64	–	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	3/8	–	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	25/64	–	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	13/32	–	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	27/64	–	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	7/16	–	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	29/64	–	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	15/32	–	2,2	45	12
B224A12000HP	B225A12000HP	12,000	.4724	–	–	2,2	45	12

(continued)

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

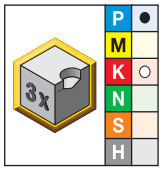


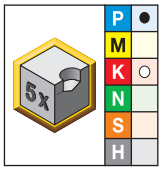
● first choice
○ alternate choice

short • KCPK15	long • KCPK15	D1 diameter mm	in	fraction	wire size	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	31/64	–	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	1/2	–	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	33/64	–	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	17/32	–	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	35/64	–	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	9/16	–	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	37/64	–	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	19/32	–	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	39/64	–	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	5/8	–	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	21/32	–	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	D1 diameter fraction	D1 diameter wire size	L5	LS	D
B224A17000HP	**B225A17000HP**	17,000	.6693	–	–	3,2	48	18
B224A17463HP	**B225A17463HP**	17,463	.6875	11/16	–	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	3/4	–	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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

HP Drills • B224_HP, B225_HP Series • Grade KCPK15™ • Through Coolant or MQL (Minimum Quantity Lubricant) • Drill Diameters 3–20mm (.1181–.7874")



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
P	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
P	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
P	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
P	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
P	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
P	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
K	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
K	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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter	1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	0	460	**790**	950	IPR	.003–.006	.004–.007	.005–.008	.006–.011	.006–.013	.007–.015	.008–.017	.009–.019
P	1	430	**790**	950	IPR	.004–.007	.004–.008	.006–.010	.006–.013	.007–.015	.008–.017	.009–.020	.010–.023
P	2	620	**750**	890	IPR	.004–.007	.004–.008	.006–.010	.006–.013	.007–.015	.008–.017	.010–.020	.013–.023
P	3	430	**520**	620	IPR	.004–.007	.005–.008	.006–.010	.006–.013	.008–.015	.009–.018	.011–.020	.013–.024
P	4	360	**490**	560	IPR	.003–.006	.004–.007	.006–.010	.006–.013	.007–.014	.009–.018	.010–.021	.012–.024
P	5	200	**260**	300	IPR	.002–.006	.003–.006	.004–.008	.006–.010	.006–.011	.007–.013	.009–.016	.010–.019
P	6	360	**490**	620	IPR	.003–.005	.004–.006	.005–.008	.006–.011	.007–.013	.008–.015	.009–.017	.010–.019
K	1	390	**490**	660	IPR	.003–.004	.006–.008	.008–.011	.010–.014	.011–.016	.013–.017	.014–.020	.016–.022
K	2	260	**390**	520	IPR	.003–.004	.005–.007	.008–.010	.009–.012	.010–.014	.012–.016	.013–.018	.015–.020
K	3	200	**260**	390	IPR	.003–.004	.004–.006	.006–.008	.008–.010	.009–.012	.009–.013	.011–.015	.012–.016

YPC Beyond™ Solid Carbide Drills with Through Coolant for Iron

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 centering capabilities.
- Highest possible feed rates.

Corner Chamfer

- Avoids breakout when drilling through holes in gray 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.

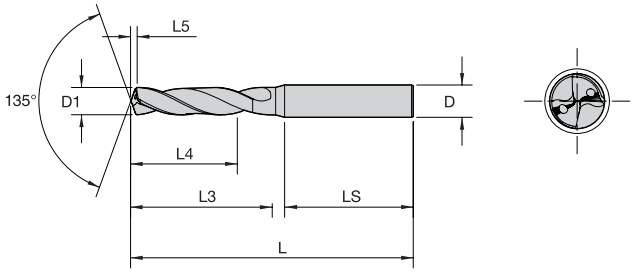
Y-TECH™ technology for superior hole quality.



Customization

- 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.



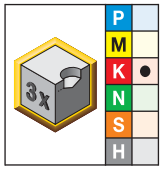


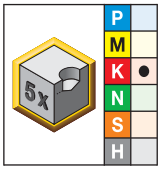


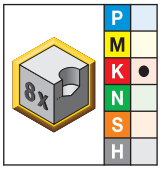
For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

beyond

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





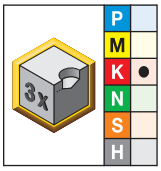


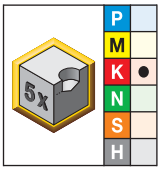
● first choice
○ alternate choice

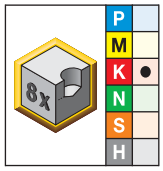
short • KCK10	long • KCK10	extra long • KCK10	D1 diameter mm	in	fraction	wire size	L5	LS	D
B254A03000YPC	B255A03000YPC	B256A03000YPC	3,000	.1181	–	–	0,9	36	6
B254A03048YPC *	B255A03048YPC	–	3,048	.1200	–	31	0,9	36	6
–	B255A03175YPC *	B256A03175YPC	3,175	.1250	1/8	–	0,9	36	6
B254A03200YPC	B255A03200YPC	–	3,200	.1260	–	–	0,9	36	6
–	B255A03250YPC	–	3,250	.1280	–	–	0,9	36	6
–	–	B256A03264YPC	3,264	.1285	–	30	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	–	29	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	–	25	1,1	36	6
B254A03800YPC *	B255A03800YPC	B256A03800YPC *	3,800	.1496	–	–	1,1	36	6
B254A03861YPC *	B255A03861YPC *	–	3,861	.1520	–	24	1,1	36	6
–	B255A03970YPC *	–	3,970	.1563	5/32	–	1,1	36	6
B254A04000YPC	B255A04000YPC	B256A04000YPC	4,000	.1575	–	–	1,1	36	6
B254A04039YPC	B255A04039YPC	–	4,039	.1590	–	21	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	–	19	1,2	36	6
–	B255A04300YPC	B256A04300YPC *	4,300	.1693	–	–	1,2	36	6
–	B255A04366YPC *	B256A04366YPC *	4,366	.1719	11/64	–	1,2	36	6
B254A04500YPC	B255A04500YPC	B256A04500YPC	4,500	.1772	–	–	1,2	36	6
B254A04572YPC	B255A04572YPC	–	4,572	.1800	–	15	1,3	36	6
–	B255A04600YPC *	–	4,600	.1811	–	–	1,3	36	6
–	–	B256A04623YPC	4,623	.1820	–	14	1,3	36	6
–	B255A04700YPC *	B256A04700YPC	4,700	.1850	–	13	1,3	36	6
B254A04763YPC *	–	–	4,763	.1875	3/16	–	1,3	36	6
B254A04800YPC	B255A04800YPC	B256A04800YPC	4,800	.1890	–	12	1,3	36	6
–	–	B256A04852YPC *	4,852	.1910	–	11	1,3	36	6
–	B255A04900YPC *	–	4,900	.1929	–	–	1,3	36	6

(continued)

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





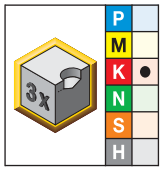


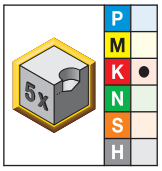
● first choice
○ alternate choice

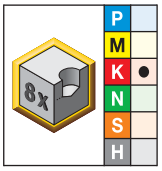
short • KCK10	long • KCK10	extra long • KCK10	D1 diameter mm	in	fraction	wire size	L5	LS	D
B254A05000YPC	B255A05000YPC	B256A05000YPC	5,000	.1969	–	–	1,4	36	6
B254A05055YPC	B255A05055YPC	–	5,055	.1990	–	8	1,4	36	6
B254A05100YPC	B255A05100YPC	B256A05100YPC	5,100	.2008	–	–	1,4	36	6
B254A05106YPC *	–	–	5,106	.2010	–	7	1,4	36	6
–	B255A05159YPC *	–	5,159	.2031	13/64	–	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
–	B255A05400YPC *	–	5,400	.2126	–	–	1,5	36	6
–	B255A05410YPC *	–	5,410	.2130	–	3	1,5	36	6
B254A05500YPC *	B255A05500YPC	B256A05500YPC	5,500	.2165	–	–	1,5	36	6
B254A05558YPC *	B255A05558YPC *	–	5,558	.2188	7/32	–	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	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	1/4	–	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	17/64	–	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	9/32	–	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	19/64	–	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	5/16	–	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	21/64	–	2,2	40	10

(continued)

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





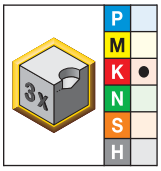


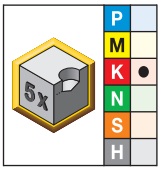
● first choice
○ alternate choice

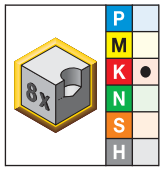
short • KCK10	long • KCK10	extra long • KCK10	D1 diameter mm	in	fraction	wire size	L5	LS	D
B254A08400YPC	–	–	8,400	.3307	–	–	2,2	40	10
B254A08433YPC *	B255A08433YPC	–	8,433	.3320	–	–	2,2	40	10
B254A08500YPC	B255A08500YPC	B256A08500YPC	8,500	.3346	–	–	2,2	40	10
B254A08600YPC	B255A08600YPC	B256A08600YPC	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	23/64	–	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
B254A09500YPC	B255A09500YPC	B256A09500YPC	9,500	.3740	–	–	2,5	40	10
B254A09525YPC *	B255A09525YPC *	–	9,525	.3750	3/8	–	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	25/64	–	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	13/32	–	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	27/64	–	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	7/16	–	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	15/32	–	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	31/64	–	3,1	45	14

(continued)

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





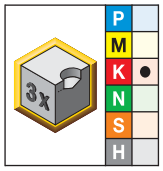


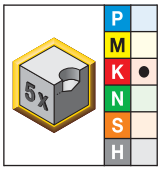
● first choice
○ alternate choice

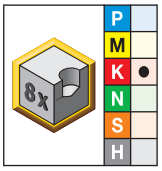
short • KCK10	long • KCK10	extra long • KCK10	D1 diameter mm	in	fraction	wire size	L5	LS	D
–	–	B256A12400YPC *	12,400	.4882	–	–	3,1	45	14
B254A12500YPC	B255A12500YPC	B256A12500YPC	12,500	.4921	–	–	3,2	45	14
–	B255A12700YPC	B256A12700YPC	12,700	.5000	1/2	–	3,2	45	14
B254A12800YPC	–	B256A12800YPC	12,800	.5039	–	–	3,2	45	14
B254A13000YPC	B255A13000YPC	B256A13000YPC	13,000	.5118	–	–	3,3	45	14
–	B255A13096YPC *	B256A13096YPC	13,096	.5156	33/64	–	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	17/32	–	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	35/64	–	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	9/16	–	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	37/64	–	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	19/32	–	3,8	48	16
B254A15200YPC	–	B256A15200YPC	15,200	.5984	–	–	3,8	48	16
B254A15250YPC *	B255A15250YPC	–	15,250	.6004	–	–	3,8	48	16
–	–	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	5/8	–	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	21/32	–	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	11/16	–	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	45/64	–	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	23/32	–	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	3/4	–	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

(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	in	fraction	wire size	L5	LS	D
B254A20638YPC *	B255A20638YPC	B256A20638YPC	20,638	.8125	13/16	–	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	7/8	–	5,5	56	25
B254A23416YPC	B255A23416YPC *	–	23,416	.9219	59/64	–	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	63/64	–	6,1	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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

Application Data

YPC Drills • B25_YPC • Grade KCK10™ • Through Coolant • Drill Diameters 3–20mm (.1181–.7874")





Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
					Recommended Feed Rate (f) by Diameter								
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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch	1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
					Recommended Feed Rate (f) by Diameter								
K	1	430	**520**	690	IPR	.005–.009	.006–.010	.006–.013	.009–.017	.012–.018	.013–.020	.015–.024	.017–.029
	2	300	**430**	590	IPR	.005–.009	.006–.010	.006–.013	.009–.017	.012–.018	.013–.020	.015–.024	.017–.029
	3	230	**300**	430	IPR	.004–.007	.005–.009	.009–.013	.009–.018	.010–.019	.011–.020	.012–.024	.013–.029

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.

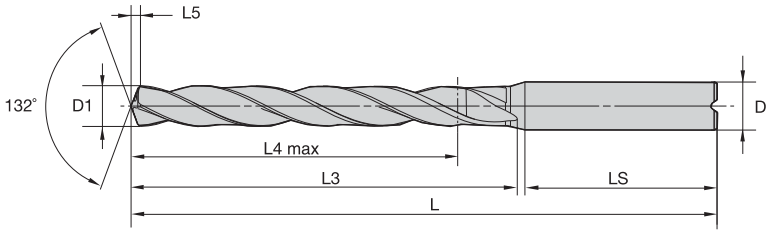
KC7315™ Grade

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

Customization

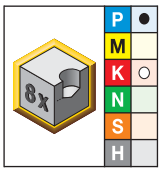
- Intermediate diameters available as semi-standards.
- Length variations and step drills available as engineered solutions.
- For follow-up operations, such as machining screw holes in connecting rods, the point angle of the step drill for the screw head should be adjusted.







B256 • ~8 x D



● first choice
○ alternate choice

	D1 diameter									
extra long • KC7315	mm	in	fraction	wire size	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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181 to .2362	.0002/.0006	.0000/-.0003
>.2362 to .3937	.0002/.0008	.0000/-.0004
>.3937 to .7087	.0003/.0010	.0000/-.0004
>.7087 to 1.0000	.0003/.0011	.0000/-.0005

SE Drills • B256 Series • Grade KC7315™ • Through Coolant • Drill Diameters 3–20mm (.1181– .7874")



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	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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter								
						1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	0	430	**480**	660	IPR	.003–.004	.003–.005	.004–.005	.004–.006	.004–.008	.005–.009	.006–.011	.008–.012
	1	390	**480**	570	IPR	.003–.004	.004–.006	.004–.006	.005–.008	.005–.009	.006–.011	.007–.013	.009–.015
	2	260	**330**	390	IPR	.003–.004	.003–.005	.004–.007	.006–.008	.006–.010	.007–.013	.009–.017	.010–.020
	3	260	**300**	390	IPR	.003–.004	.004–.006	.004–.006	.005–.008	.005–.009	.006–.011	.007–.013	.009–.015
	4	200	**230**	260	IPR	.002–.004	.003–.005	.004–.005	.004–.006	.004–.007	.005–.009	.006–.011	.007–.012
K	1	390	**490**	660	IPR	.003–.004	.006–.008	.008–.011	.010–.014	.011–.016	.013–.017	.014–.020	.016–.022
	2	260	**390**	520	IPR	.003–.004	.005–.007	.008–.010	.009–.012	.010–.014	.012–.016	.013–.018	.015–.020
	3	200	**260**	390	IPR	.003–.004	.004–.006	.006–.008	.008–.010	.009–.012	.009–.013	.011–.015	.012–.016

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

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 centering 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.

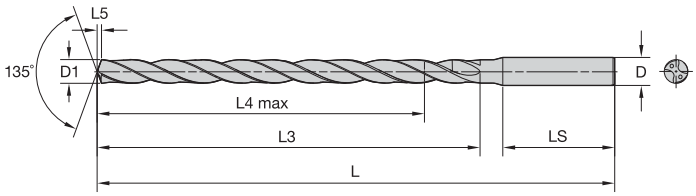
Designed for deep-hole applications without pilot drill.



Customization

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

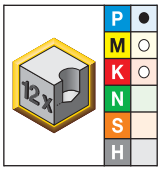






beyond

B269_HP • ~12 x D

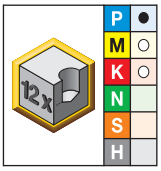


● first choice
○ alternate choice

extra long • KCPK15	D1 diameter mm	in	fraction	wire size	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	1/8	–	93	52	44	0,6	36	6
B269A03264HP	3,264	.1285	–	30	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	5/32	–	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	–	13	107	68	57	0,9	36	6
B269A04763HP	4,763	.1875	3/16	–	125	82	69	0,9	36	6
B269A04800HP	4,800	.1890	–	12	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	–	3	125	84	71	1,0	36	6
B269A05500HP	5,500	.2165	–	–	125	84	71	1,0	36	6
B269A05558HP	5,558	.2188	7/32	–	125	84	71	1,0	36	6
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

(continued)

(B269_HP • ~12 x D — continued)

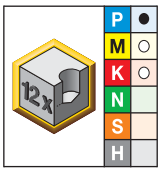


● first choice
○ alternate choice

extra long • KCPK15	D1 diameter mm	in	fraction	wire size	L	L3	L4 max	L5	LS	D
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	1/4	–	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	17/64	–	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	9/32	–	153	111	94	1,3	36	8
B269A07500HP	7,500	.2953	–	–	153	112	95	1,4	36	8
B269A07541HP	7,541	.2969	19/64	–	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	5/16	–	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	21/64	–	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	11/32	–	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	23/64	–	185	139	118	1,7	40	10
B269A09500HP	9,500	.3740	–	–	185	140	119	1,8	40	10
B269A09525HP	9,525	.3750	3/8	–	185	140	119	1,8	40	10
B269A09800HP	9,800	.3858	–	–	185	141	119	1,8	40	10
B269A09921HP	9,921	.3906	25/64	–	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	13/32	–	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	27/64	–	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	7/16	–	218	167	142	2,1	45	12
B269A11200HP	11,200	.4409	–	–	218	167	142	2,1	45	12
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	31/64	–	246	193	165	2,3	45	14
B269A12500HP	12,500	.4921	–	–	246	193	165	2,3	45	14
B269A12700HP	12,700	.5000	1/2	–	246	194	166	2,4	45	14

(continued)

(B269_HP • ~12 x D — continued)



● first choice
○ alternate choice

extra long • KCPK15	D1 diameter mm	in	fraction	wire size	L	L3	L4 max	L5	LS	D
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	9/16	—	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	37/64	—	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	5/8	—	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	11/16	—	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	3/4	—	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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

HP Drills • B269_HP Series • Grade KCPK15™ • Through Coolant • Drill Diameters 3–20mm (.1181–.7874")





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	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

Material Group		Cutting Speed — vc Range — SFM			Inch Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	0	360	**460**	560	IPR	.004–.006	.005–.008	.006–.008	.007–.010	.010–.011	.008–.014	.009–.017	.011–.019
	1	330	**470**	490	IPR	.005–.007	.006–.009	.007–.009	.008–.011	.011–.013	.009–.016	.011–.020	.013–.022
	2	230	**330**	360	IPR	.005–.007	.005–.008	.006–.010	.009–.013	.009–.015	.011–.020	.013–.025	.015–.030
	3	230	**300**	360	IPR	.005–.007	.006–.009	.007–.009	.008–.011	.011–.013	.009–.016	.011–.020	.013–.022
	4	200	**230**	300	IPR	.004–.006	.004–.008	.006–.008	.007–.009	.007–.010	.008–.013	.009–.016	.010–.018
	5	200	**260**	300	IPR	.001–.004	.002–.004	.002–.004	.002–.006	.003–.007	.004–.008	.006–.009	.006–.010
	6	260	**490**	520	IPR	.003–.005	.004–.004	.005–.008	.006–.011	.007–.013	.008–.015	.009–.017	.010–.019
M	1	160	**200**	260	IPR	.002–.003	.002–.005	.003–.006	.004–.007	.005–.008	.005–.009	.006–.009	.007–.011
	2	130	**160**	260	IPR	.002–.003	.002–.005	.003–.006	.004–.007	.005–.008	.005–.009	.006–.009	.007–.011
	3	130	**160**	230	IPR	.001–.003	.002–.004	.002–.006	.003–.006	.004–.007	.005–.008	.006–.009	.006–.010
K	1	300	**490**	490	IPR	.004–.006	.006–.008	.008–.012	.009–.014	.010–.017	.012–.018	.014–.023	.016–.028
	2	260	**400**	400	IPR	.004–.006	.006–.008	.008–.012	.009–.014	.010–.017	.012–.018	.014–.023	.016–.028
	3	260	**260**	460	IPR	.004–.006	.006–.008	.009–.013	.009–.015	.010–.018	.011–.020	.012–.024	.013–.028

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 aluminum, 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 centering 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 aluminum and other non-ferrous materials.
- The uncoated grade helps to prevent built-up edge in drilling aluminum and high-temp alloys.

New KCMS20 Grade (B27_SGL)

- Monolayer PVD AlTiN coated ultrafine 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.

Customization

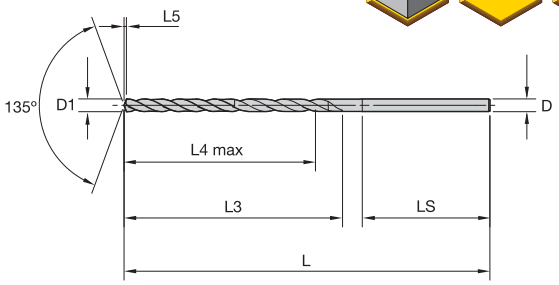
- Intermediate diameters available as semi-standards.
- Length variations, including even longer versions up to 550mm (21.65"), available as custom solutions.
- One-shot drilling of deep holes with a small step is possible.
- Maximum 2mm (.08") step range. Consult the custom solutions department for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



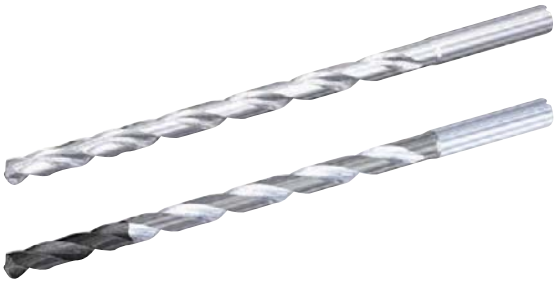




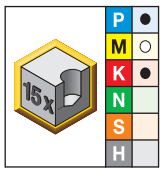


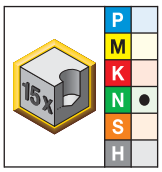


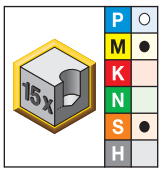
For information on L5, see B224_HP drills or B210_SGL drills.



B271Z_HPG/HPS/SGL • 15 x D





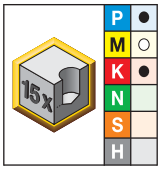


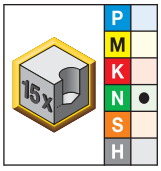
● first choice
○ alternate choice

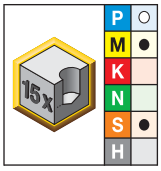
KCPK20	KN25	KCMS20	D1 diameter mm	in	fraction	wire size	L	L3	L4 max	LS	D
B271Z02383KMG	B271Z02383KMS	–	2,383	.0938	3/32	–	86	51	44	30	3
–	B271Z02400KMS	–	2,400	.0945	–	–	86	51	44	30	3
–	B271Z02439KMS	–	2,439	.0960	–	41	86	51	44	30	3
–	B271Z02489KMS	–	2,489	.0980	–	40	86	51	44	30	3
B271Z02500KMG	B271Z02500KMS	B271Z02500SGL	2,500	.0984	–	–	86	51	44	30	3
–	B271Z02578KMS	–	2,578	.1015	–	38	86	51	44	30	3
–	B271Z02600KMS	–	2,600	.1024	–	–	86	51	44	30	3
B271Z02642KMG	–	–	2,642	.1040	–	37	86	51	44	30	3
B271Z02705KMG	–	–	2,705	.1065	–	36	86	52	45	30	3
B271Z02779KMG	B271Z02779KMS *	–	2,779	.1094	7/64	–	86	52	45	30	3
–	B271Z02800KMS	–	2,800	.1102	–	–	86	52	45	30	3
B271Z02820KMG *	B271Z02820KMS *	–	2,820	.1110	–	34	86	52	45	30	3
–	B271Z02870KMS *	–	2,870	.1130	–	33	86	52	45	30	3
–	B271Z02900KMS	–	2,900	.1142	–	–	86	52	45	30	3
–	B271Z02947KMS *	–	2,947	.1160	–	32	86	52	45	30	3
B271Z03000HPG	B271Z03000HPS	B271Z03000SGL	3,000	.1181	–	–	86	52	45	30	3
B271Z03175HPG	B271Z03175HPS	B271Z03175SGL	3,175	.1250	1/8	–	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	5/32	–	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	–	14	124	86	75	34	5
B271Z04763HPG	B271Z04763HPS	B271Z04763SGL	4,763	.1875	3/16	–	124	86	75	34	5
B271Z04800HPG	–	–	4,800	.1890	–	12	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	–	3	143	102	89	36	6
B271Z05500HPG	B271Z05500HPS	B271Z05500SGL	5,500	.2165	–	–	143	102	89	36	6
B271Z05558HPG	–	–	5,558	.2188	7/32	–	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	1/4	E	162	119	104	38	7

(continued)

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





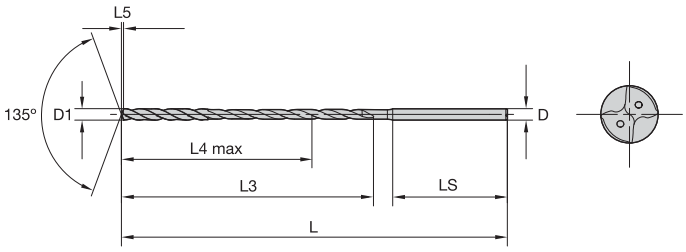


● first choice
○ alternate choice

KCPK20	KN25	KCMS20	D1 diameter mm	in	fraction	wire size	L	L3	L4 max	LS	D
B271Z06500HPG	B271Z06500HPS	B271Z06500SGL	6,500	.2559	—	—	162	119	104	38	7
B271Z06528HPG	—	—	6,528	.2570	—	F	162	119	104	38	7
B271Z06746HPG	B271Z06746HPS	B271Z06746SGL	6,746	.2656	17/64	—	162	120	104	38	7
B271Z06909HPG	—	—	6,909	.2720	—	I	162	121	105	38	7
B271Z07000HPG	B271Z07000HPS	B271Z07000SGL	7,000	.2756	—	—	162	121	105	38	7
B271Z07145HPG	B271Z07145HPS	B271Z07145SGL	7,145	.2813	9/32	—	181	135	118	40	8
B271Z07500HPG	B271Z07500HPS	B271Z07500SGL	7,500	.2953	—	—	181	136	119	40	8
B271Z07541HPG *	—	—	7,541	.2969	19/64	—	181	136	119	40	8
B271Z07938HPG	—	B271Z07938SGL	7,938	.3125	5/16	—	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	21/64	—	200	153	134	42	9
B271Z08500HPG	B271Z08500HPS	B271Z08500SGL	8,500	.3346	—	—	200	153	134	42	9
B271Z08733HPG	B271Z08733HPS	—	8,733	.3438	11/32	—	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	3/8	—	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	13/32	—	238	187	164	46	11
B271Z10500HPG	B271Z10500HPS	B271Z10500SGL	10,500	.4134	—	—	238	187	164	46	11
B271Z10716HPG	—	—	10,716	.4219	27/64	—	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	7/16	—	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	1/2	—	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	9/16	—	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	5/8	—	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.

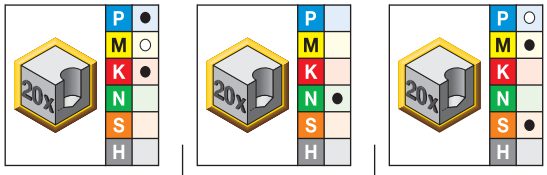




For information on L5, see B224_HP drills or B210_SGL drills.



B272Z_HPG/HPS/SGL • 20 x D

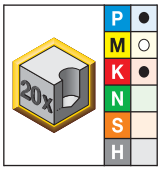


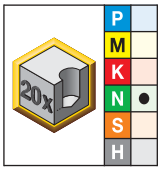
● first choice
○ alternate choice

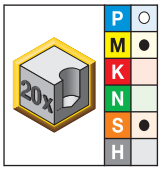
KCPK20	KN25	KCMS20	D1 diameter mm	in	fraction	wire size	L	L3	L4 max	LS	D
B272Z02383KMG	B272Z02383KMS	–	2,383	.0938	3/32	–	101	63	56	30	3
B272Z02400KMG	B272Z02400KMS *	–	2,400	.0945	–	–	101	63	56	30	3
–	B272Z02439KMS	–	2,439	.0960	–	41	101	63	56	30	3
B272Z02489KMG	B272Z02489KMS *	–	2,489	.0980	–	40	101	63	56	30	3
B272Z02500KMG	B272Z02500KMS	B272Z02500SGL	2,500	.0984	–	–	101	63	56	30	3
B272Z02779KMG	–	–	2,779	.1094	7/64	–	101	66	59	30	3
–	B272Z02800KMS	–	2,800	.1102	–	–	101	66	59	30	3
–	B272Z02947KMS *	–	2,947	.1160	–	32	101	67	60	30	3
B272Z03000HPG	B272Z03000HPS	B272Z03000SGL	3,000	.1181	–	–	101	67	60	30	3
B272Z03175HPG	B272Z03175HPS	B272Z03175SGL	3,175	.1250	1/8	–	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	5/32	–	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	–	14	149	109	98	34	5
B272Z04763HPG	B272Z04763HPS	B272Z04763SGL	4,763	.1875	3/16	–	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	–	3	173	129	116	36	6
B272Z05500HPG	B272Z05500HPS	B272Z05500SGL	5,500	.2165	–	–	173	130	117	36	6
B272Z05558HPG	–	–	5,558	.2188	7/32	–	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	1/4	E	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	–	F	197	152	137	38	7
B272Z06746HPG	B272Z06746HPS	B272Z06746SGL	6,746	.2656	17/64	–	197	154	138	38	7
B272Z06800HPG	–	–	6,800	.2677	–	–	197	154	138	38	7
B272Z06909HPG	–	–	6,909	.2720	–	I	197	155	139	38	7

(continued)

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





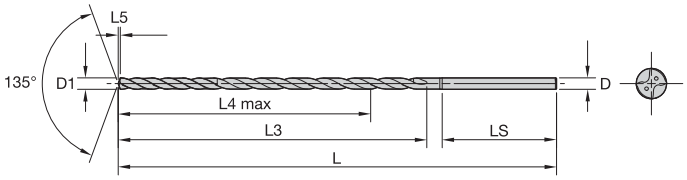


● first choice
○ alternate choice

KCPK20	KN25	KCMS20	D1 diameter mm	in	fraction	wire size	L	L3	L4 max	LS	D
B272Z07000HPG	B272Z07000HPS	B272Z07000SGL	7,000	.2756	—	—	197	156	140	38	7
B272Z07145HPG	B272Z07145HPS	B272Z07145SGL	7,145	.2813	9/32	—	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	19/64	—	221	174	157	40	8
B272Z07938HPG	—	B272Z07938SGL	7,938	.3125	5/16	—	221	177	159	40	8
B272Z08000HPG	B272Z08000HPS	B272Z08000SGL	8,000	.3150	—	—	221	178	160	40	8
B272Z08334HPG *	—	—	8,334	.3281	21/64	—	245	194	175	42	9
B272Z08433HPG	—	—	8,433	.3320	—	Q	245	195	176	42	9
B272Z08500HPG	B272Z08500HPS	B272Z08500SGL	8,500	.3346	—	—	245	196	177	42	9
B272Z08733HPG	B272Z08733HPS	—	8,733	.3438	11/32	—	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	3/8	—	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	13/32	—	293	238	215	46	11
B272Z10500HPG	B272Z10500HPS	B272Z10500SGL	10,500	.4134	—	—	293	240	217	46	11
B272Z10716HPG	—	—	10,716	.4219	27/64	—	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	7/16	—	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	1/2	—	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	5/8	—	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.

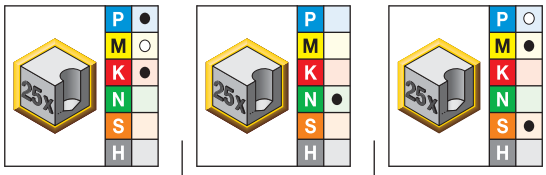




For information on L5, see B224_HP drills or B210_SGL drills.



B273Z_HPG/HPS/SGL • 25 x D

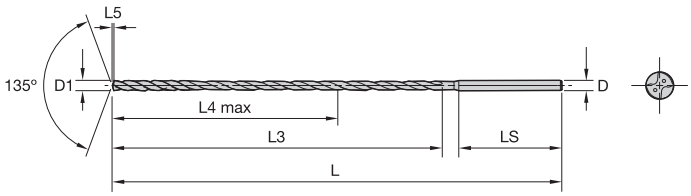


● first choice
○ alternate choice

KCPK20	KN25	KCMS20	D1 diameter mm	in	fraction	wire size	L	L3	L4 max	LS	D
B273Z02383KMG	B273Z02383KMS	–	2,383	.0938	3/32	–	116	74	67	30	3
–	B273Z02439KMS *	–	2,439	.0960	–	41	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	7/64	–	116	80	73	30	3
–	B273Z02800KMS *	–	2,800	.1102	–	–	116	80	73	30	3
–	B273Z02820KMS *	–	2,820	.1110	–	34	116	80	73	30	3
–	B273Z02870KMS *	–	2,870	.1130	–	33	116	81	74	30	3
–	B273Z02947KMS *	–	2,947	.1160	–	32	116	82	75	30	3
B273Z03000HPG	B273Z03000HPS	B273Z03000SGL	3,000	.1181	–	–	116	82	75	30	3
B273Z03175HPG	B273Z03175HPS	B273Z03175SGL	3,175	.1250	1/8	–	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	1/4	E	232	182	167	38	7
B273Z06500HPG *	B273Z06500HPS	B273Z06500SGL	6,500	.2559	–	–	232	184	169	38	7
B273Z06746HPG	B273Z06746HPS *	–	6,746	.2656	17/64	–	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	11/32	–	290	241	221	42	9
B273Z09000HPG	–	B273Z09000SGL	9,000	.3543	–	–	290	245	225	42	9
–	B273Z09525HPS *	–	9,525	.3750	3/8	–	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	1/2	–	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	9/16	–	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.

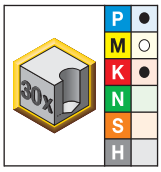


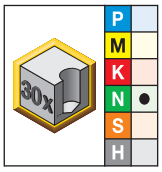


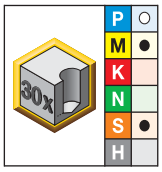
For information on L5, see B224_HP drills or B210_SGL drills.



B274Z_HPG/HPS/SGL • 30 x D





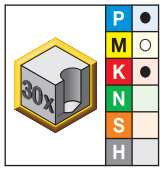


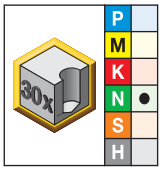
● first choice
○ alternate choice

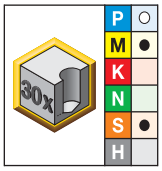
KCPK20	KN25	KCMS20	D1 diameter mm	in	fraction	wire size	L	L3	L4 max	LS	D
B274Z02383KMG	B274Z02383KMS	–	2,383	.0938	3/32	–	131	86	79	30	3
–	B274Z02400KMS	–	2,400	.0945	–	–	131	87	80	30	3
–	B274Z02439KMS *	–	2,439	.0960	–	41	131	87	80	30	3
B274Z02500KMG	B274Z02500KMS	B274Z02500SGL	2,500	.0984	–	–	131	88	81	30	3
B274Z02600KMG	B274Z02600KMS	–	2,600	.1024	–	–	131	90	83	30	3
–	B274Z02642KMS *	–	2,642	.1040	–	37	131	91	84	30	3
–	B274Z02779KMS *	–	2,779	.1094	7/64	–	131	94	87	30	3
B274Z02800KMG	B274Z02800KMS *	–	2,800	.1102	–	–	131	94	87	30	3
–	B274Z02870KMS *	–	2,870	.1130	–	33	131	95	88	30	3
–	B274Z02900KMS *	–	2,900	.1142	–	–	131	96	89	30	3
–	B274Z02947KMS *	–	2,947	.1160	–	32	131	97	90	30	3
B274Z03000HPG	B274Z03000HPS	B274Z03000SGL	3,000	.1181	–	–	131	97	90	30	3
B274Z03175HPG	B274Z03175HPS	B274Z03175SGL	3,175	.1250	1/8	–	165	115	106	32	4
B274Z03500HPG	B274Z03500HPS	B274Z03500SGL	3,500	.1378	–	–	165	121	112	32	4
B274Z03970HPG	–	B274Z03970SGL	3,970	.1563	5/32	–	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	3/16	–	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	1/4	E	267	214	199	38	7
B274Z06500HPG	B274Z06500HPS	B274Z06500SGL	6,500	.2559	–	–	267	217	202	38	7
–	B274Z06746HPS *	B274Z06746SGL	6,746	.2656	17/64	–	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	9/32	–	301	242	225	40	8
–	–	B274Z07500SGL	7,500	.2953	–	–	301	249	232	40	8

(continued)

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





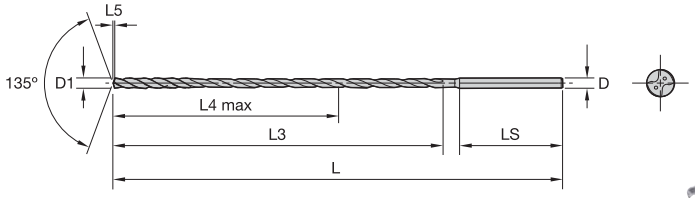


● first choice
○ alternate choice

KCPK20	KN25	KCMS20	D1 diameter mm	D1 diameter in	D1 diameter fraction	D1 diameter wire size	L	L3	L4 max	LS	D
B274Z07700HPG *	—	—	7,700	.3031	—	—	301	252	235	40	8
B274Z07938HPG	—	B274Z07938SGL	7,938	.3125	5/16	—	301	257	239	40	8
B274Z08000HPG	B274Z08000HPS	B274Z08000SGL	8,000	.3150	—	—	301	258	240	40	8
B274Z08334HPG	—	—	8,334	.3281	21/64	—	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	11/32	—	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	23/64	—	369	306	285	44	10
B274Z09525HPG	B274Z09525HPS *	B274Z09525SGL	9,525	.3750	3/8	—	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	27/64	—	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	1/2	—	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.



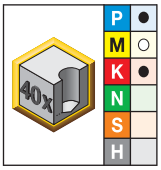


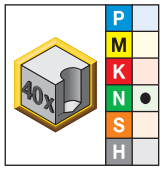
For information on L5, see B224_HP drills or B210_SGL drills.

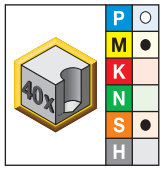


beyond

B275Z_HPG/HPS/SGL • 40 x D







● first choice
○ alternate choice

KCPK20	KN25	KCMS20	D1 diameter mm	in	fraction	wire size	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	1/8	–	205	146	137	32	4
B275Z03500HPG	B275Z03500HPS	B275Z03500SGL	3,500	.1378	–	–	205	156	147	32	4
B275Z03571HPG	B275Z03571HPS	B275Z03571SGL	3,571	.1406	9/64	–	205	158	149	32	4
B275Z03970HPG	B275Z03970HPS	B275Z03970SGL	3,970	.1563	5/32	–	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	3/16	–	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	1/4	E	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	9/32	–	381	314	297	40	8
B275Z07500HPG	B275Z07500HPS	B275Z07500SGL	7,500	.2953	–	–	381	324	307	40	8
B275Z07938HPG	B275Z07938HPS	B275Z07938SGL	7,938	.3125	5/16	–	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	3/8	–	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	13/32	–	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

Tolerance • Inch

nominal size range	D1 HPG/SGL tolerance h7	D1 HPS tolerance h8	D tolerance h6
.0394–.1181	.0000/-.0004	.0000/-.0006	.0000/-.0002
>.1181–.2362	.0000/-.0005	.0000/-.0007	.0000/-.0003
>.2362–.3937	.0000/-.0006	.0000/-.0009	.0000/-.0004
>.3937–.7087	.0000/-.0007	.0000/-.0011	.0000/-.0004

Deep-Hole Drills • B27_HPG Series • Grade KCPK20™ • Through Coolant • Drill Diameters 3–16mm (.1181–.6300")





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	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

Material Group		Cutting Speed – vc Range – SFM min	Starting Value	max		Inch Recommended Feed Rate (f) by Diameter 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	0.551	5/8 .625
P	0	330	**330**	410	IPR	.005–.006	.006–.006	.006–.008	.008–.010	.008–.012	.010–.014	.012–.016	.013–.018
	1	300	**330**	360	IPR	.006–.007	.006–.008	.007–.010	.009–.012	.010–.015	.012–.017	.014–.019	.016–.021
	2	300	**330**	360	IPR	.006–.007	.006–.008	.007–.010	.009–.012	.010–.015	.012–.017	.014–.019	.016–.021
	3	260	**310**	360	IPR	.006–.007	.006–.008	.007–.010	.009–.012	.010–.015	.012–.017	.014–.019	.016–.021
	4	260	**300**	360	IPR	.006–.007	.006–.008	.007–.010	.009–.012	.010–.015	.012–.017	.014–.019	.016–.021
	5	200	**260**	300	IPR	.001–.004	.002–.004	.002–.004	.002–.006	.003–.007	.004–.008	.005–.009	.006–.009
	6	360	**490**	620	IPR	.003–.005	.004–.004	.005–.008	.006–.011	.007–.013	.008–.015	.008–.016	.009–.017
M	1	130	**160**	200	IPR	.002–.003	.002–.005	.003–.006	.004–.006	.004–.006	.005–.007	.005–.007	.006–.008
	2	100	**130**	160	IPR	.002–.003	.002–.004	.003–.005	.004–.006	.004–.006	.004–.006	.005–.007	.005–.007
	3	100	**130**	160	IPR	.002–.003	.002–.004	.003–.005	.004–.006	.004–.006	.004–.006	.005–.007	.005–.007
K	1	260	**330**	390	IPR	.006–.008	.007–.008	.008–.010	.009–.013	.011–.016	.013–.018	.015–.021	.018–.023
	2	260	**300**	330	IPR	.006–.007	.006–.008	.007–.010	.009–.012	.010–.015	.012–.017	.014–.019	.016–.021
	3	200	**300**	390	IPR	.006–.007	.006–.008	.007–.010	.009–.012	.010–.015	.012–.017	.014–.019	.016–.021

Deep-Hole Drills • B27_HPS Series • Grade KN25™ • Through Coolant • Drill Diameters 3–16mm (.1181–.6300")





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	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

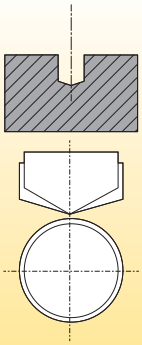
Material Group		Cutting Speed – vc Range – SFM min	Starting Value	max		Inch Recommended Feed Rate (f) by Diameter 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	0.551	5/8 .625
N	1	390	**660**	980	IPR	.005–.007	.005–.007	.006–.009	.008–.011	.010–.014	.012–.016	.014–.018	.016–.020
	2	390	**560**	980	IPR	.005–.007	.006–.008	.006–.010	.008–.012	.011–.015	.013–.017	.015–.019	.017–.021
	3	330	**490**	980	IPR	.005–.007	.006–.008	.006–.010	.008–.012	.011–.015	.013–.017	.015–.019	.017–.021
	4	260	**660**	980	IPR	.001–.002	.001–.002	.001–.002	.002–.002	.002–.003	.002–.003	.002–.003	.002–.004

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



Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate per Rev		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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate per Rev		1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	.551	5/8 .625
P	1	200	**260**	300	IPR		.001-.002	.002-.002	.002-.002	.002-.004	.003-.005	.004-.006	.005-.007	.006-.007
	2	230	**390**	560	IPR		.002–.004	.003–.005	.004–.006	.005–.006	.006–.007	.006–.008	.007–.009	.008–.009
M	1	130	**160**	200	IPR		.002-.003	.002-.004	.003-.004	.003-.004	.004-.005	.004-.005	.004-.006	.005-.006
	2	100	**130**	160	IPR		.002–.003	.002–.004	.003–.004	.003–.004	.004–.005	.004–.005	.004–.006	.005–.006
	3	100	**130**	160	IPR		.002-.003	.002-.004	.003-.004	.003-.004	.004-.005	.004-.005	.004-.006	.005-.006
S	1	70	**100**	130	IPR		.004-.005	.004-.005	.004-.006	.005-.006	.005-.006	.006-.007	.006-.007	.006-.008
	2	70	**100**	130	IPR		.004–.005	.004–.005	.004–.006	.005–.006	.005–.006	.006–.007	.006–.007	.006–.008
	3	70	**100**	130	IPR		.004-.005	.004-.005	.004-.006	.005-.006	.005-.006	.006-.007	.006-.007	.006-.008
	4	70	**100**	130	IPR		.004–.006	.004–.006	.004–.006	.005–.007	.005–.007	.006–.008	.006–.008	.006–.008

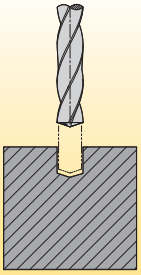


1) Pilot Drill Hole — IMPORTANT!

- 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 +.0004" (+0,010mm).
- 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.

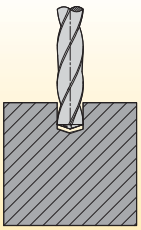


2) Feed B27_ into Pilot Hole

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

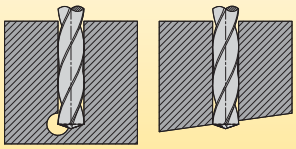
Recommendations:

- Reduce cutting speed to minimize imbalances in machine spindle/adapter!



3) Drill Hole

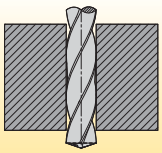
Cutting Parameters: Start recommended speed and feed rate at .039" (1mm) from the bottom of the pilot hole, clockwise.



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 aluminum 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

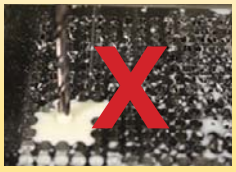
Cutting Parameters: 50–500 RPM and feed rate 2–6 m/min.

Recommendations:

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

Reduce cutting speed to minimize imbalances in machine spindle/adapter!





5) Vertical Applications

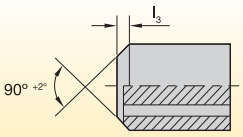
- If the pilot holes are close to each other, chips can fall into the neighboring hole.
- Do not enter a pilot hole that might contain chips with a deep hole drill to avoid chip jamming, wear, or breakage.
- If required holes are close to each other, use smart drilling strategies, make sure the pilot 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 adapter/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 optimized 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	catalog number	order number	catalog number	order number	catalog number	order number	catalog number	order number	catalog number	order number	catalog 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 Aluminum Machining with MQL

Primary Application

B284/B285_HPS series solid carbide drills offer the highest metal removal rates and longest tool life in aluminum 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 aluminum 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 aluminum 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 centering 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 Optimized for MQL Applications

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

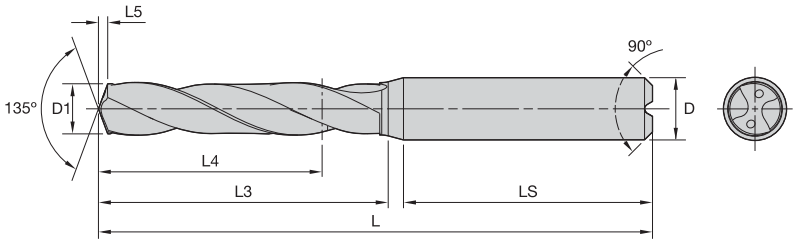
Much more cost-effective compared to PCD-tipped drills.



Customization

- 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 aluminum with Si>9%, based on TiB_2 and DLC.

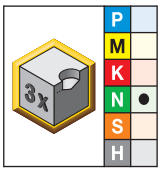


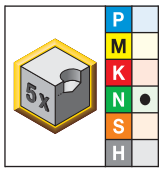


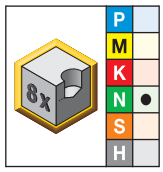


For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

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





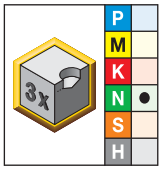


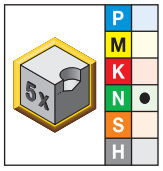
● first choice
○ alternate choice

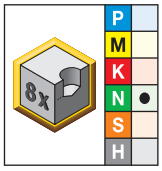
short • KN15	long • KN15	extra long • KN15	D1 diameter mm	in	fraction	wire size	L5	LS	D
B284D03000HPS	B285D03000HPS	B286D03000HPS	3,000	.1181	–	–	0,6	36	6
B284D03100HPS	B285D03100HPS	B286D03100HPS	3,100	.1220	–	–	0,6	36	6
B284D03175HPS	B285D03175HPS	B286D03175HPS	3,175	.1250	1/8	–	0,6	36	6
B284D03200HPS	B285D03200HPS	B286D03200HPS	3,200	.1260	–	–	0,6	36	6
B284D03264HPS	B285D03264HPS	B286D03264HPS	3,264	.1285	–	30	0,6	36	6
B284D03300HPS	B285D03300HPS	B286D03300HPS	3,300	.1299	–	–	0,6	36	6
B284D03455HPS	B285D03455HPS	B286D03455HPS	3,455	.1360	–	29	0,6	36	6
B284D03500HPS	B285D03500HPS	B286D03500HPS	3,500	.1378	–	–	0,6	36	6
B284D03571HPS	B285D03571HPS	B286D03571HPS	3,571	.1406	9/64	–	0,7	36	6
B284D03700HPS	B285D03700HPS	B286D03700HPS	3,700	.1457	–	–	0,7	36	6
B284D03734HPS	B285D03734HPS	B286D03734HPS	3,734	.1470	–	26	0,7	36	6
B284D03900HPS	B285D03900HPS	B286D03900HPS	3,900	.1535	–	–	0,7	36	6
B284D03970HPS	B285D03970HPS	B286D03970HPS	3,970	.1563	5/32	–	0,7	36	6
B284D04000HPS	B285D04000HPS	B286D04000HPS	4,000	.1575	–	–	0,7	36	6
B284D04039HPS	B285D04039HPS	B286D04039HPS	4,039	.1590	–	21	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	–	18	0,8	36	6
B284D04366HPS	–	–	4,366	.1719	11/64	–	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	–	13	0,9	36	6
B284D04763HPS	B285D04763HPS	B286D04763HPS	4,763	.1875	3/16	–	0,9	36	6
B284D04800HPS	B285D04800HPS	B286D04800HPS	4,800	.1890	–	12	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	–	7	0,9	36	6
B284D05159HPS	B285D05159HPS	B286D05159HPS	5,159	.2031	13/64	–	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	–	3	1,0	36	6
B284D05500HPS	B285D05500HPS	B286D05500HPS	5,500	.2165	–	–	1,0	36	6
B284D05558HPS	B285D05558HPS	B286D05558HPS	5,558	.2188	7/32	–	1,0	36	6

(continued)

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





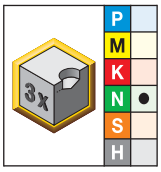


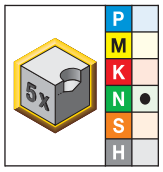
● first choice
○ alternate choice

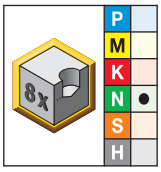
short • KN15	long • KN15	extra long • KN15	D1 diameter mm	in	fraction	wire size	L5	LS	D
B284D05600HPS	B285D05600HPS	B286D05600HPS	5,600	.2205	–	–	1,0	36	6
B284D05791HPS	B285D05791HPS	B286D05791HPS	5,791	.2280	–	1	1,1	36	6
B284D05800HPS	–	–	5,800	.2283	–	–	1,1	36	6
B284D05954HPS	–	–	5,954	.2344	15/64	–	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	1/4	–	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	17/64	–	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	9/32	–	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	19/64	–	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	5/16	–	1,5	36	8
B284D08000HPS	B285D08000HPS	B286D08000HPS	8,000	.3150	–	–	1,5	36	8
B284D08334HPS	B285D08334HPS	B286D08334HPS	8,334	.3281	21/64	–	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	11/32	–	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	23/64	–	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	3/8	–	1,8	40	10
B284D09900HPS	B285D09900HPS	B286D09900HPS	9,900	.3898	–	–	1,8	40	10
B284D09921HPS	B285D09921HPS	B286D09921HPS	9,921	.3906	25/64	–	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	13/32	–	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	in	fraction	wire size	L5	LS	D
B284D10716HPS	B285D10716HPS	B286D10716HPS	10,716	.4219	27/64	—	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	7/16	—	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	29/64	—	2,1	45	12
B284D11800HPS	B285D11800HPS	B286D11800HPS	11,800	.4646	—	—	2,2	45	12
B284D11908HPS	B285D11908HPS	B286D11908HPS	11,908	.4688	15/32	—	2,2	45	12
B284D12000HPS	B285D12000HPS	B286D12000HPS	12,000	.4724	—	—	2,2	45	12
B284D12304HPS	B285D12304HPS	B286D12304HPS	12,304	.4844	31/64	—	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	1/2	—	2,3	45	14
B284D13000HPS	B285D13000HPS	B286D13000HPS	13,000	.5118	—	—	2,4	45	14
B284D13096HPS	B285D13096HPS	B286D13096HPS	13,096	.5156	33/64	—	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	9/16	—	2,6	48	16
B284D14500HPS	B285D14500HPS	B286D14500HPS	14,500	.5709	—	—	2,7	48	16
B284D14684HPS	B285D14684HPS	B286D14684HPS	14,684	.5781	37/64	—	2,7	48	16
B284D15000HPS	B285D15000HPS	B286D15000HPS	15,000	.5906	—	—	2,8	48	16
B284D15083HPS	B285D15083HPS	B286D15083HPS	15,083	.5938	19/32	—	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	5/8	—	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	21/32	—	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	11/16	—	3,2	48	18
B284D17500HPS	B285D17500HPS	B286D17500HPS	17,500	.6890	—	—	3,2	48	18
B284D17859HPS	B285D17859HPS	B286D17859HPS	17,859	.7031	45/64	—	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	3/4	—	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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

HP Drills • B28_HPS Series • Grade KN15™ • MQL and Through Coolant • Drill Diameters 3-20mm (.1181–.7874")





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	**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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max		Inch Recommended Feed Rate (f) by Diameter 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
N	1	390	**750**	**1480**	IPR	.005–.010	.006–.011	.007–.014	.008–.017	.011–.020	.013–.022	.015–.027	.017–.032
	2	390	**720**	**1150**	IPR	.006–.009	.006–.011	.007–.013	.009–.015	.011–.018	.013–.021	.015–.026	.018–.032
	3	330	**590**	**1310**	IPR	.005–.008	.006–.008	.006–.011	.008–.013	.011–.016	.013–.018	.015–.024	.017–.027
	4	330	**430**	**980**	IPR	.004–.007	.005–.008	.006–.010	.006–.012	.007–.013	.008–.015	.009–.017	.011–.018

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 centering 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, hole straightness).

KC7315™ Grade

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

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

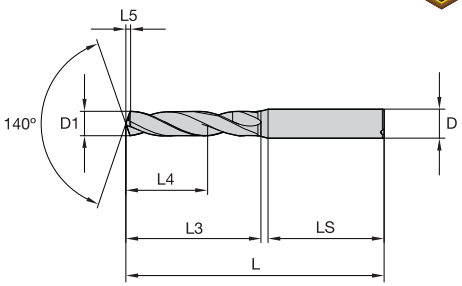


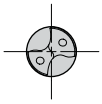
Customization

- 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.





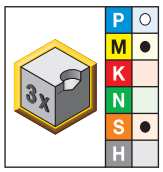


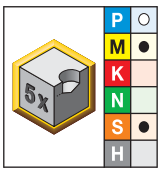




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B291/B292_YPL • ~3 x D/~5 x D



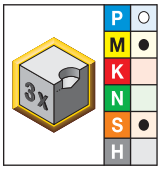


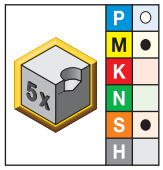
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	in	fraction	wire size	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	1/8	–	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	–	29	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	5/32	–	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	–	13	0,9	36	6
B291A04763YPL	B292A04763YPL	4,763	.1875	3/16	–	0,9	36	6
B291A04800YPL	B292A04800YPL	4,800	.1890	–	12	0,9	36	6
B291A04851YPL	B292A04851YPL	4,851	.1910	–	11	0,9	36	6
B291A04900YPL	–	4,900	.1929	–	–	0,9	36	6
B291A04915YPL	B292A04915YPL	4,915	.1935	–	10	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	–	3	1,1	36	6
B291A05500YPL	B292A05500YPL	5,500	.2165	–	–	1,1	36	6
–	B292A05558YPL	5,558	.2188	7/32	–	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)



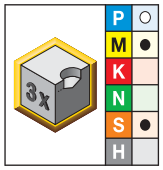


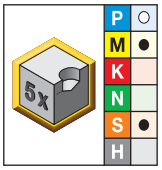
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	in	fraction	wire size	L5	LS	D
B291A06350YPL	B292A06350YPL	6,350	.2500	1/4	–	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	17/64	–	1,3	36	8
B291A06747YPL	–	6,747	.2656	17/64	–	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	9/32	–	1,4	36	8
–	B292A07145YPL	7,145	.2813	9/32	–	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	5/16	–	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	21/64	–	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	11/32	–	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	23/64	–	1,8	40	10
–	B292A09130YPL	9,130	.3594	23/64	–	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	3/8	–	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	13/32	–	2,0	45	12
B291A10500YPL	B292A10500YPL	10,500	.4134	–	–	2,0	45	12
B291A10716YPL	B292A10716YPL	10,716	.4219	27/64	–	2,0	45	12
B291A11000YPL	B292A11000YPL	11,000	.4331	–	–	2,1	45	12
–	B292A11112YPL	11,112	.4375	7/16	–	2,1	45	12
B291A11113YPL	–	11,113	.4375	7/16	–	2,1	45	12
B291A11500YPL	B292A11500YPL *	11,500	.4528	–	–	2,2	45	12
B291A11509YPL	B292A11509YPL	11,509	.4531	29/64	–	2,2	45	12
B291A11800YPL	–	11,800	.4646	–	–	2,2	45	12
B291A11908YPL	B292A11908YPL	11,908	.4688	15/32	–	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	in	fraction	wire size	L5	LS	D
B291A12000YPL	B292A12000YPL	12,000	.4724	–	–	2,3	45	12
B291A12300YPL	–	12,300	.4843	–	–	2,3	45	14
–	B292A12304YPL	12,304	.4844	31/64	–	2,3	45	14
B291A12500YPL	B292A12500YPL	12,500	.4921	–	–	2,4	45	14
B291A12700YPL	B292A12700YPL	12,700	.5000	1/2	–	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	9/16	–	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	5/8	–	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	11/16	–	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	3/4	–	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: *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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

Y-TECH™ Drill • B29_YPL Series • Grade KC7315™ • Through Coolant • Drill Diameters 3–20mm (.1181–.7874")



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	**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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter		1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	5	150	**210**	260	IPR		.002–.003	.002–.004	.003–.005	.004–.006	.004–.008	.005–.008	.006–.010	.007–.012
	6	160	**200**	300	IPR		.002–.002	.002–.003	.002–.004	.004–.006	.004–.006	.004–.008	.005–.009	.006–.011
M	1	130	**160**	200	IPR		.003–.004	.003–.005	.005–.007	.006–.008	.006–.008	.007–.009	.008–.010	.009–.011
	2	130	**160**	260	IPR		.003–.004	.003–.005	.003–.007	.005–.008	.006–.009	.007–.009	.008–.010	.009–.011
	3	130	**160**	230	IPR		.002–.002	.002–.003	.002–.003	.002–.003	.002–.004	.002–.004	.002–.004	.003–.004
S	1	50	**70**	100	IPR		.002–.003	.002–.003	.003–.004	.004–.005	.004–.006	.005–.006	.006–.008	.007–.009
	2	70	**70**	100	IPR		.002–.003	.002–.003	.002–.003	.003–.004	.004–.005	.004–.005	.005–.006	.006–.007
	3	80	**100**	160	IPR		.001–.002	.001–.002	.002–.003	.002–.004	.002–.004	.002–.004	.003–.004	.003–.005
	4	100	**100**	160	IPR		.001–.002	.001–.002	.002–.003	.002–.004	.002–.004	.002–.004	.003–.004	.003–.005
H	1	30	**70**	100	IPR		.000–.001	.001–.001	.001–.002	.001–.002	.002–.003	.002–.004	.003–.004	.003–.004

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 gray cast iron, nodular iron, and non-ferrous and aluminum 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 centering 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 aluminum die cast alloys.
- The uncoated grade KF1 helps to prevent built-up edge in drilling aluminum.

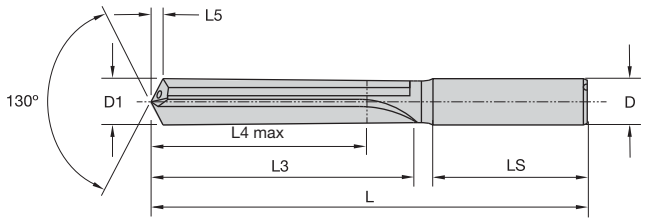
Best suited for high-quality, close tolerance holes that require a very good surface finish.

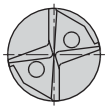


Customization

- 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.

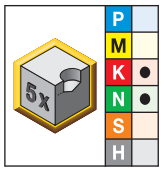








B411 • ~5 x D

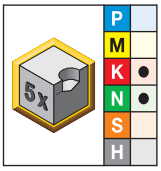


● first choice
○ alternate choice

KF1	D1 diameter mm	in	fraction	wire size	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	–	12	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

(continued)

(B411 • ~5 x D — continued)



● first choice
○ alternate choice

KF1	D1 diameter mm	in	fraction	wire size	L	L3	L4 max	L5	LS	D
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
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

Tolerance • Inch

nominal size range	D1 tolerance k6	D tolerance h6
>.1181–.2362	.0000/.0004	.0000/-.0003
>.2362–.3937	.0000/.0004	.0000/-.0004
>.3937–.7087	.0000/.0005	.0000/-.0004
>.7087–1.0000	.0000/.0006	.0000/-.0005

TX Drills • B411 Series • Grade KF1 • Through Coolant • Drill Diameters 3–25mm (.1181–.9843")

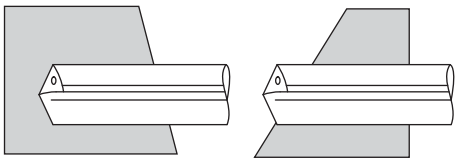


Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max		Metric Recommended Feed Rate (f) by Diameter 3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0	25,4
K	1	115	**120**	140	mm/r	0,11–0,20	0,12–0,24	0,15–0,28	0,18–0,33	0,20–0,38	0,23–0,44	0,30–0,53	0,34–0,65	0,40–0,76
N	1	100	**250**	450	mm/r	0,12–0,25	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
	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
	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
	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

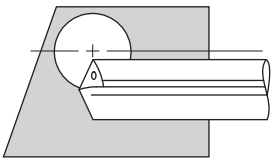
Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max		Inch Recommended Feed Rate (f) by Diameter 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750	1/1 1.000
K	1	380	**390**	460	IPR	.004–.008	.005–.009	.006–.011	.007–.013	.008–.015	.009–.017	.012–.021	.013–.026	.016–.030
N	1	330	**820**	1480	IPR	.005–.010	.005–.011	.006–.014	.008–.017	.010–.020	.013–.022	.014–.027	.017–.032	.023–.038
	2	660	**820**	980	IPR	.005–.008	.006–.010	.006–.013	.008–.015	.011–.017	.013–.021	.015–.025	.017–.031	.024–.038
	3	330	**490**	980	IPR	.004–.007	.005–.008	.006–.009	.007–.012	.008–.015	.009–.017	.012–.021	.013–.026	.016–.030
	4	330	**560**	820	IPR	.004–.006	.005–.008	.006–.010	.006–.011	.007–.013	.008–.014	.009–.016	.009–.017	.011–.020

TX Drill Applications

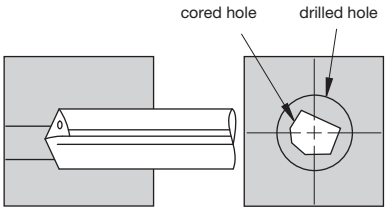
The excellent stability of the TX drill enables it to be used for drilling through inclined planes, intersecting holes, and cored holes:



inclined planes



intersecting holes



cored holes

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

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

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SPF Drills for CFRP Composite Materials

Primary Application

B53_SPF series solid carbide drills offer a material-specific design and grade to machine carbon fiber-reinforced polymer (CFRP) composite materials by minimizing delamination and increasing tool life.

Features and Benefits

SPF Drill-Point Design

- Special 90° point angle increases centering 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.



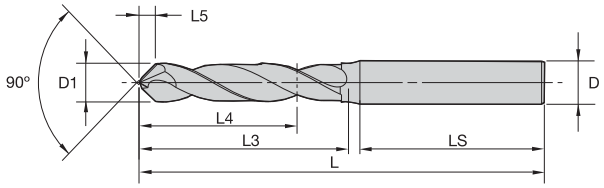
Designed to machine carbon fiber-reinforced polymers.

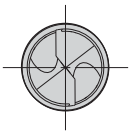


Customization

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



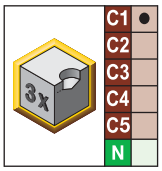


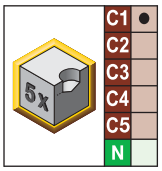




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B531/B532_SPF • ~3 x D/~5 x D





● first choice
○ alternate choice

short • KDF400	long • KDF400	D1 diameter mm	in	fraction	wire size	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	11/64	–	2,0	36	6
B531A04851SPF	B532A04851SPF *	4,851	.1910	–	11	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	5/16	–	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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

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

SPF Drills • B53_ Series • Grade KDF400™ • Dry Applications • Drill Diameters 3–12mm (.1181-.4724")



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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter		1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500
C	1	300	390	490	IPR		.001–.008	.001–.008	.001–.008	.001–.008	.001–.008	.001–.008

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-fiber 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 centering 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.



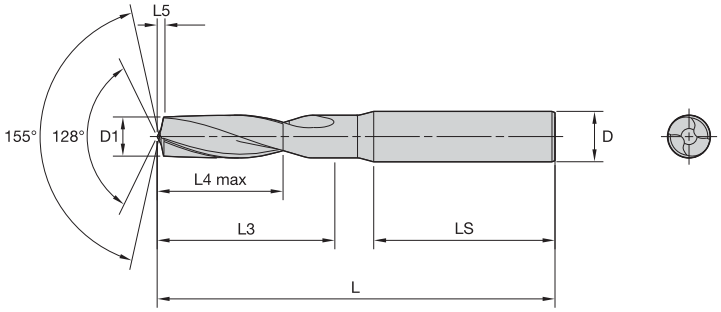
k6 Tolerance

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

Customization

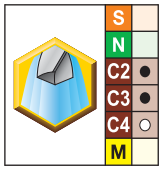
- Intermediate diameters available as semi-standards.
- Length variations and step drills, as well as shank variations, available as custom solutions for carbide and PCD versions.
- A four-margin land design for increased stability is available as semi-standard B54_DAL.







B551A_DAL • ~3 x D



● first choice
○ alternate choice

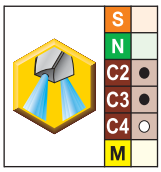
short • KN15	D1 diameter mm	in	fraction	L	L3	L4 max	L5	LS	D
B551A04763DAL *	4,763	.1875	3/16	66	28	20	0,8	36	6
B551A06350DAL	6,350	.2500	1/4	79	34	24	1,1	36	8
B551A07938DAL	7,938	.3125	5/16	79	41	29	1,4	36	8
B551A09525DAL	9,525	.3750	3/8	89	47	35	1,7	40	10
B551A11113DAL *	11,113	.4375	7/16	102	55	40	2,0	45	12
B551A12700DAL *	12,700	.5000	1/2	107	60	43	2,3	45	14
B551A14288DAL *	14,288	.5625	9/16	115	65	45	2,5	48	16
B551A15875DAL *	15,875	.6250	5/8	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	in	fraction	L	L3	L4 max	L5	LS	D
B556A04763DAL *	4,763	.1875	3/16	66	28	20	0,8	36	6
B556A04826DAL	4,826	.1900	—	66	28	20	0,9	36	6
B556A06350DAL	6,350	.2500	1/4	79	34	24	1,1	36	8
B556A06375DAL *	6,375	.2510	—	79	34	24	1,1	36	8
B556A07938DAL	7,938	.3125	5/16	79	41	29	1,4	36	8
B556A09525DAL *	9,525	.3750	3/8	89	47	35	1,7	40	10
B556A11113DAL *	11,113	.4375	7/16	102	55	40	2,0	45	12
B556A12700DAL *	12,700	.5000	1/2	107	60	43	2,3	45	14
B556A14288DAL *	14,288	.5625	9/16	115	65	45	2,5	48	16
B556A15875DAL *	15,875	.6250	5/8	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 (.1181–.7874")



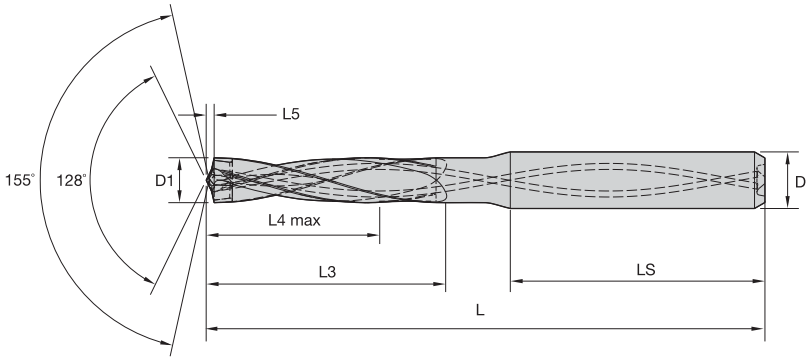
Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max		Metric Recommended Feed Rate (f) by Diameter 3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
C	2	15	80	120	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
C	3	10	10	15	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
C	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
Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max		Inch Recommended Feed Rate (f) by Diameter 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
C	2	50	260	390	IPR	.000–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009
C	3	30	30	50	IPR	.001–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009
C	4	30	50	80	IPR	.001–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009

Stack Drill • B556/B546 Series • Grade KN15 • Through Coolant • Drill Diameters 3–20mm (.1181–.7874")



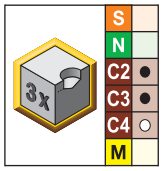
Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max		Metric Recommended Feed Rate (f) by Diameter 3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
C	2	15	120	150	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
C	3	10	15	25	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
C	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
Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max		Inch Recommended Feed Rate (f) by Diameter 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
C	2	50	390	490	IPR	.000–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009
C	3	30	50	80	IPR	.001–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009
C	4	30	80	160	IPR	.001–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009







PCD Twist Drill • PDC251 Series • ~3 x D



● first choice
○ alternate choice

KD1415	D1 diameter mm	in	fraction	L	L3	L4 max	L5	LS	D
PDC251A04763DA	4,7630	0.188	3/16	66	28	20	0,8	36	6
PDC251A06350DA	6,3500	0.250	1/4	79	34	24	1,1	36	8
PDC251A07938DA *	7,9380	0.313	5/16	79	41	29	1,4	36	8
PDC251A09525DA *	9,5250	0.375	3/8	89	47	35	1,7	40	10
PDC251A11113DA *	11,1130	0.438	7/16	102	55	40	2,0	45	12
PDC251A12700DA *	12,7000	0.500	1/2	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

Tolerance • Inch

nominal size range	D1 tolerance k6	D tolerance h6
>.1181–.2362	.0000/.0004	.0000/-.0003
>.2362–.3937	.0000/.0004	.0000/-.0004
>.3937–.7087	.0000/.0005	.0000/-.0004
>.7087–1.0000	.0000/.0006	.0000/-.0005

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

Stack Drill • PDC25 Series • Grade KD1415™ • Dry • Drill Diameters 3–20mm (.1181–.7874")



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
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
C	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
C	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
Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max		Inch Recommended Feed Rate (f) by Diameter 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
C	2	50	260	390	IPR	.000–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009
C	3	30	30	50	IPR	.001–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009
C	4	30	50	80	IPR	.001–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009

Stack Drill • PDC251 Series • Grade KD1415 • Through Coolant • Drill Diameters 3–20mm (.1181–.7874")



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
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
C	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
C	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
Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max		Inch Recommended Feed Rate (f) by Diameter 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
C	2	50	390	490	IPR	.000–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009
C	3	30	50	80	IPR	.001–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009
C	4	30	80	160	IPR	.001–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009

FB Drills with Through Coolant for Flat-Bottom Applications

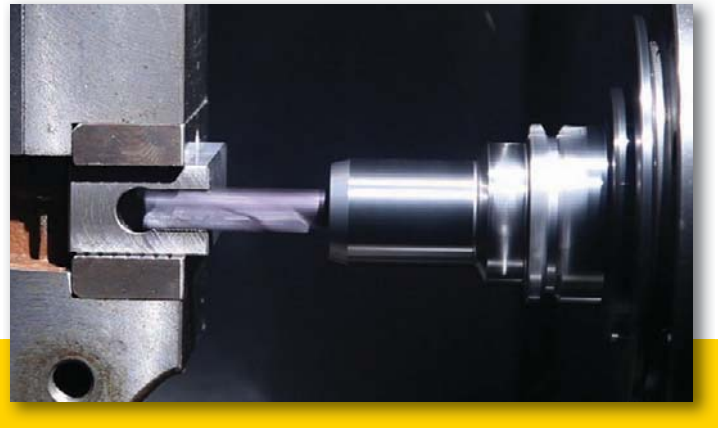
Primary Application

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 uncoated KN15™ grade offers the same advantages for drilling in non-ferrous materials, such as aluminum, copper, and brass. The B707_FBL series with the new KCMS15™ grade was optimized for applications in stainless steel and high-temperature alloys.



Features and Benefits

Unique FB Drill-Point Design

- Two effective cutting edges over center enable high feed rates.
- Creates a true flat-bottom hole from O.D. to center.
- 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.

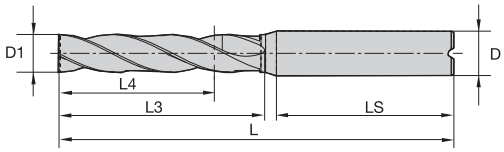
Productivity tools that combine two operations in one.

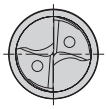


Customization

- 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.

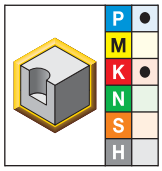


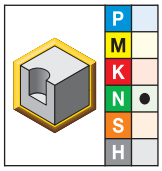


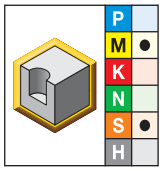




B707_FBG/FBS/FBL • ~3 x D





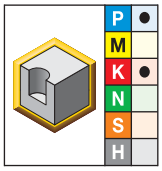


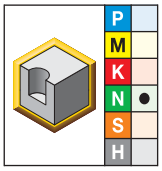
● first choice
○ alternate choice

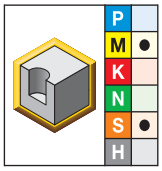
B707A-FBG • KC7315	B707A-FBS • KN15	B707A-FBL • KCMS15	D1 diameter mm	in	fraction	wire size	L	L3	L4 max	LS	D
B707A03000FBG	B707A03000FBS	B707A03000FBL	3,000	.1181	–	–	62	20	14	36	6
B707A03175FBG	B707A03175FBS	B707A03175FBL	3,175	.1250	1/8	–	62	20	14	36	6
B707A03500FBG	B707A03500FBS	B707A03500FBL	3,500	.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	5/32	–	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	3/16	–	66	28	20	36	6
B707A04800FBG	B707A04800FBS	B707A04800FBL	4,800	.1890	–	12	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	1/4	–	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

(continued)

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





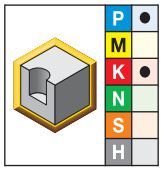


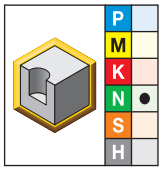
● first choice
○ alternate choice

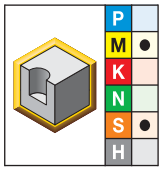
B707A-FBG • KC7315	B707A-FBS • KN15	B707A-FBL • KCMS15	D1 diameter mm	in	fraction	wire size	L	L3	L4 max	LS	D
B707A07145FBG	–	–	7,145	.2813	9/32	–	79	41	29	36	8
–	B707A07400FBS	–	7,400	.2913	–	–	79	41	29	36	8
B707A07500FBG	B707A07500FBS	B707A07500FBL	7,500	.2953	–	–	79	41	29	36	8
B707A07800FBG	–	–	7,800	.3071	–	–	79	41	29	36	8
B707A07938FBG	B707A07938FBS	B707A07938FBL	7,938	.3125	5/16	–	79	41	29	36	8
B707A08000FBG	B707A08000FBS	B707A08000FBL	8,000	.3150	–	–	79	41	29	36	8
B707A08334FBG	–	–	8,334	.3281	21/64	–	89	47	35	40	10
B707A08500FBG	B707A08500FBS	B707A08500FBL	8,500	.3346	–	–	89	47	35	40	10
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	23/64	–	89	47	35	40	10
B707A09500FBG	B707A09500FBS	B707A09500FBL	9,500	.3740	–	–	89	47	35	40	10
B707A09525FBG	B707A09525FBS	B707A09525FBL	9,525	.3750	3/8	–	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	13/32	–	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	29/64	–	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	15/32	–	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	1/2	–	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	9/16	–	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

(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	in	fraction	wire size	L	L3	L4 max	LS	D
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	5/8	—	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	11/16	—	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	3/4	—	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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

Flat-Bottom Drills • B707_FBG Series • Grade KC7315™ • Through Coolant • Drill Diameters 3–20mm (.1181–.7874")



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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max		Inch Recommended Feed Rate (f) by Diameter 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	0	330	440	560	IPR	.002–.006	.004–.007	.004–.008	.004–.010	.007–.011	.006–.012	.006–.015	.008–.017
	1	330	440	560	IPR	.003–.006	.005–.008	.004–.009	.005–.011	.008–.013	.007–.015	.008–.017	.009–.019
	2	430	490	590	IPR	.003–.005	.004–.006	.006–.008	.005–.009	.007–.011	.007–.012	.008–.014	.009–.015
	3	260	350	430	IPR	.004–.006	.005–.008	.005–.009	.006–.009	.008–.012	.008–.015	.010–.017	.011–.018
	4	230	320	430	IPR	.003–.006	.005–.008	.004–.009	.006–.011	.008–.012	.007–.014	.008–.016	.009–.018
	6	230	320	430	IPR	.003–.005	.004–.006	.004–.006	.005–.008	.006–.009	.006–.010	.007–.012	.008–.013
K	1	230	280	330	IPR	.004–.007	.005–.008	.005–.010	.006–.012	.009–.014	.008–.015	.009–.018	.010–.021
	2	330	370	430	IPR	.004–.006	.005–.007	.005–.008	.006–.010	.008–.012	.008–.013	.009–.015	.010–.017
	3	230	340	460	IPR	.003–.005	.004–.006	.004–.008	.005–.009	.007–.011	.007–.012	.008–.014	.009–.015

Flat-Bottom Drills • B707_FBS Series • Grade KN15™ • Through Coolant • Drill Diameters 3–20mm (.1181–.7874")



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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max		Inch Recommended Feed Rate (f) by Diameter 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
N	1	390	850	1310	IPR	.003–.008	.003–.009	.005–.013	.006–.016	.006–.017	.007–.018	.008–.020	.009–.023
	2	390	820	920	IPR	.003–.008	.003–.009	.004–.013	.006–.016	.006–.017	.008–.018	.008–.020	.009–.023
	3	330	660	850	IPR	.003–.006	.003–.006	.004–.009	.006–.010	.006–.012	.008–.015	.009–.017	.010–.018
	4	200	490	660	IPR	.001–.002	.001–.002	.001–.002	.002–.002	.002–.003	.002–.003	.002–.003	.002–.004

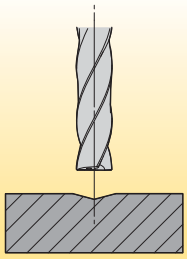
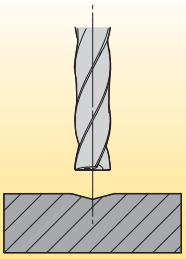
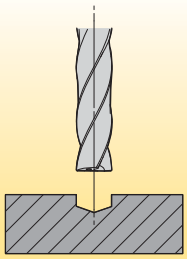
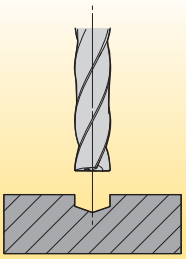
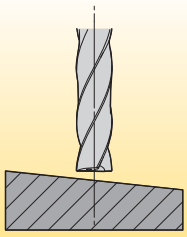
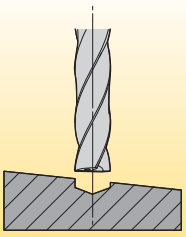
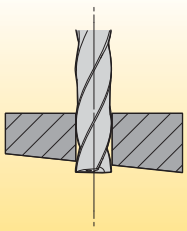
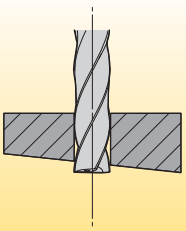
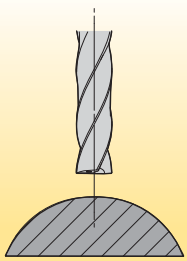
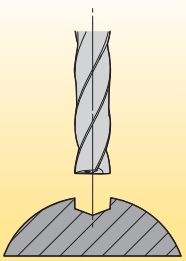
Flat-Bottom Drills • B707_FBL Series • Grade KCMS15™ • Through Coolant • Drill Diameters 3–20mm (.1181–.7874")



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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter								
						1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	5	150	**160**	200	IPR	.002–.003	.002–.004	.002–.005	.004–.006	.004–.006	.005–.008	.006–.009	.006–.009
	6	130	**160**	200	IPR	.001–.002	.002–.003	.002–.004	.003–.005	.004–.006	.004–.006	.005–.007	.006–.008
M	1	130	**160**	200	IPR	.002–.003	.002–.004	.002–.005	.004–.006	.004–.006	.005–.008	.006–.009	.006–.009
	2	130	**160**	260	IPR	.002–.004	.003–.004	.003–.006	.005–.008	.005–.008	.006–.009	.007–.009	.008–.010
	3	130	**180**	230	IPR	.001–.002	.001–.002	.002–.002	.002–.003	.002–.003	.002–.004	.003–.004	.003–.005
S	1	70	**80**	100	IPR	.002–.003	.002–.003	.003–.004	.004–.005	.004–.006	.005–.006	.006–.008	.007–.009
	2	30	**70**	100	IPR	.002–.003	.002–.003	.002–.003	.003–.004	.004–.005	.004–.005	.005–.006	.006–.007
	3	100	**110**	160	IPR	.001–.002	.001–.002	.002–.003	.002–.004	.002–.004	.002–.004	.003–.004	.003–.005
	4	100	**110**	160	IPR	.001–.002	.001–.002	.002–.003	.002–.004	.002–.004	.002–.004	.003–.004	.003–.005

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

beyond

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 centering 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%.

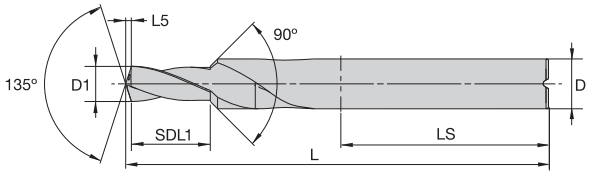
Drill and chamfer in one shot before tapping.

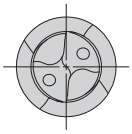


Customization

- Intermediate diameters available as semi-standards.
- Using Kennametal slim line hydraulic chucks together is recommended if workpiece contours need to be bypassed.

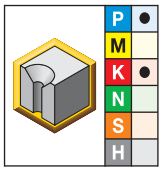








B731_HP • Short



● first choice
○ alternate choice

short • KCPK15	D1 diameter mm	in	fraction	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	5/16	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	25/64	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	27/64	107	27	2,0	45	14
B731A12000HP	12,000	.4724	–	115	27	2,2	48	16
B731A12304HP *	12,304	.4844	31/64	115	28	2,3	48	16
B731A12500HP	12,500	.4921	–	115	27	2,3	48	16
B731A13096HP	13,096	.5156	33/64	115	31	2,4	48	16
B731A13495HP	13,495	.5313	17/32	123	32	2,5	48	18
B731A14000HP	14,000	.5512	–	123	29	2,6	48	18
B731A16670HP *	16,670	.6563	21/32	131	38	3,1	50	20
B731A17463HP	17,463	.6875	11/16	131	40	3,2	50	20
B731A19446HP *	19,446	.7656	49/64	153	43	3,6	56	25

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

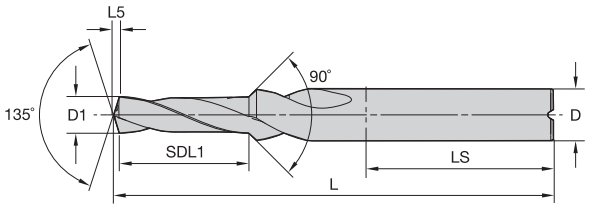
Tolerance • Metric

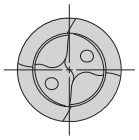
nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

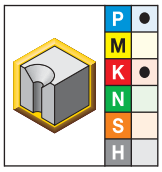








B732_HP • Long



● first choice
○ alternate choice

long • KCPK15	D1 diameter mm	in	fraction	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	5/16	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	25/64	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	27/64	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	33/64	123	44	2,4	48	16
B732A13495HP *	13,495	.5313	17/32	123	45	2,5	48	18
B732A14000HP	14,000	.5512	–	123	43	2,6	48	18
B732A16670HP	16,670	.6563	21/32	141	55	3,1	50	20
B732A17463HP	17,463	.6875	11/16	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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

HP Step Drills • B73_HP Series • Grade KCPK15™ • Through Coolant • Drill Diameters 3–20mm (.1181–.7874")



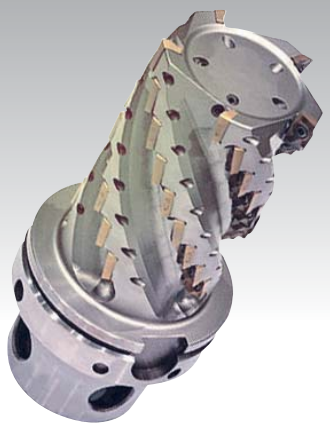
Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter								
						3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	150	**240**	270	mm/r	0,06–0,14	0,08–0,18	0,09–0,20	0,12–0,26	0,14–0,30	0,15–0,33	0,17–0,39	0,20–0,43
	1	140	**220**	240	mm/r	0,07–0,17	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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter								
						1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	0	490	**790**	890	IPR	.002–.006	.003–.007	.004–.008	.005–.010	.006–.012	.006–.013	.007–.015	.008–.017
	1	460	**720**	790	IPR	.003–.007	.004–.008	.004–.009	.006–.012	.006–.014	.007–.015	.008–.018	.009–.020
	2	590	**690**	790	IPR	.003–.006	.004–.007	.004–.008	.006–.009	.006–.011	.007–.013	.008–.015	.009–.017
	3	390	**490**	590	IPR	.004–.007	.005–.008	.006–.009	.007–.012	.008–.014	.009–.015	.010–.018	.011–.020
	4	330	**460**	590	IPR	.003–.007	.004–.008	.005–.009	.006–.011	.007–.013	.008–.015	.009–.017	.010–.018
	6	460	**490**	590	IPR	.003–.005	.004–.006	.004–.007	.005–.008	.006–.009	.007–.011	.008–.013	.008–.014
K	1	460	**520**	590	IPR	.004–.007	.005–.009	.005–.010	.006–.013	.008–.015	.008–.016	.009–.019	.011–.020
	2	330	**490**	660	IPR	.004–.006	.005–.008	.005–.009	.006–.011	.008–.013	.008–.014	.009–.016	.011–.018
	3	330	**460**	590	IPR	.003–.006	.004–.007	.005–.008	.006–.009	.006–.011	.007–.013	.008–.015	.009–.015

Engineered Solutions

You Won't Find These Solutions in a Catalog

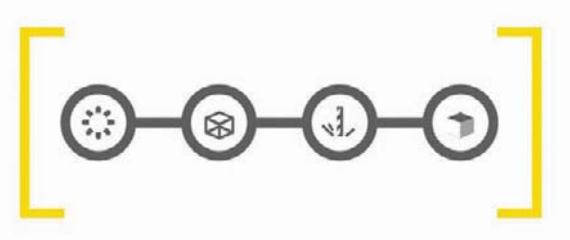
Kennametal engineered solutions pinpoint and address specific needs of customers, workpiece materials, or workpiece configurations. Solutions include standard products, custom designs, and old-fashioned process know-how that can only come from many decades of tooling expertise.
They are the result of 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 optimize the manufacturing process throughout every step. The result is low implementation time and costs, and rapid return on investment.



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 145º point angle, it is also perfectly suited as a pilot drill for the B95_drill series with through coolant and 140º 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 15º helix angle to maximize stability in applications above 54 HRC.
- B95_ series with 30º helix angle to improve chip evacuation in higher length-to-diameter ratios.

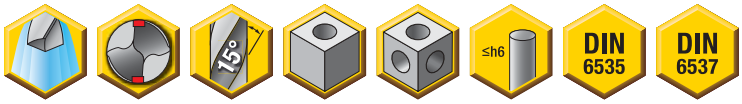
New KCH10 and KCH15 Grades

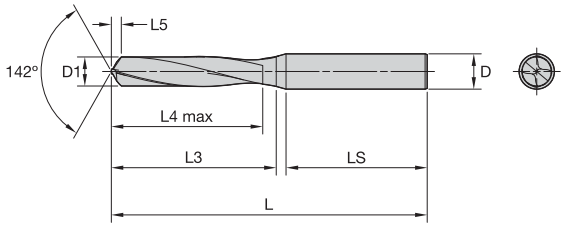
- KCH10 on B94_ series consists of a special fine-grain carbide substrate with higher hardness.
- KCH15 on B95_ series, with its higher toughness, supports edge strength at increased rake angles, which are applied to improve chip evacuation in higher L/D ratios.
- Both series carry a high temperature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



Customization

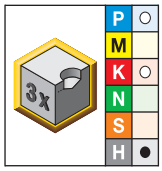
- Intermediate diameters available as semi-standards.
- Four margin land designs also available as semi-standards.
- Length variations and step drills available as custom solutions.
- High step diameter ratios and very complex step drill geometries are not recommended for hard materials.







B941A • ~3 x D



● first choice
○ alternate choice

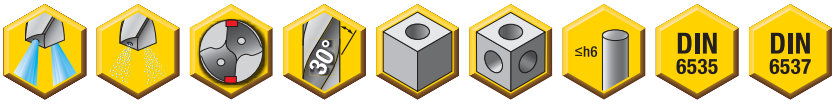
short • KCH10	D1 diameter mm	D1 diameter in	L	L3	L4 max	L5	LS	D
B941Z02500	2,500	.0984	50	16	11	0,5	28	3
B941A03000	3,000	.1181	62	20	14	0,6	36	6
B941A03300	3,300	.1299	62	20	14	0,6	36	6
B941A03400	3,400	.1339	62	20	14	0,6	36	6
B941A03500	3,500	.1378	62	20	14	0,6	36	6
B941A04000	4,000	.1575	66	24	17	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

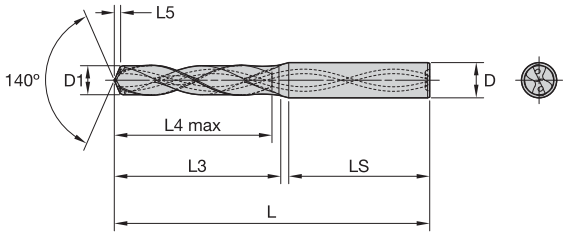
Tolerance • Metric

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

Tolerance • Inch

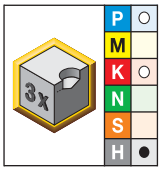
nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005







B951A • ~3 x D

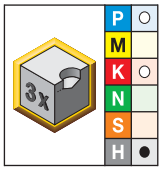


● first choice
○ alternate choice

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
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

(continued)

(B951A • ~3 x D — continued)



● first choice
○ alternate choice

short • KCH15	D1 diameter mm	in	fraction	L	L3	L4 max	L5	LS	D
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





Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate per Rev		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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate per Rev		1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	4	160	**230**	330	IPR	.0024-.0059	.0031-.0067	.0047-.0091	.0055-.0110	.0067-.0130	.0075-.0150	.0091-.0185	.0114-.0232
	5	130	**160**	230	IPR	.0031–.0063	.0039–.0079	.0047–.0094	.0063–.0110	.0079–.0126	.0094–.0142	.0110–.0173	.0126–.0205
	6	100	**130**	200	IPR	.0020-.0028	.0024-.0039	.0031-.0055	.0039-.0071	.0047-.0087	.0055-.0094	.0071-.0126	.0091-.0161
K	1	260	**430**	490	IPR	.0043-.0087	.0047-.0094	.0063-.0122	.0079-.0150	.0091-.0173	.0098-.0193	.0122-.0024	.0150-.0185
	2	230	**360**	330	IPR	.0039–.0067	.0047–.0075	.0063–.0098	.0079–.0122	.0091–.0142	.0098–.0157	.0122–.0189	.0150–.0236
	3	260	**360**	390	IPR	.0028-.0059	.0035-.0075	.0047-.0098	.0055-.0118	.0067-.0138	.0075-.0157	.0098-.0189	.0118-.0236
H	1	70	**100**	130	IPR	.0012-.0024	.0016-.0031	.0024-.0039	.0031-.0047	.0035-.0051	.0039-.0055	.0047-.0063	.0055-.0071
	2	50	**100**	130	IPR	.0008–.0016	.0012–.0024	.0020–.0031	.0028–.0039	.0031–.0043	.0035–.0047	.0039–.0055	.0043–.0063
	3	50	**80**	110	IPR	.0008-.0016	.0008-.0020	.0016-.0028	.0024-.0035	.0028-.0039	.0031-.0043	.0035-.0051	.0039-.0059
	4	50	**70**	100	IPR	.0008–.0016	.0012–.0024	.0020–.0031	.0028–.0039	.0031–.0043	.0035–.0047	.0039–.0055	.0043–.0063

KMH Drill • B95_Series • Grade KCH15 • Through Coolant



Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max		Metric Recommended Feed Rate per Rev 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
Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max		Inch Recommended Feed Rate per Rev 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	4	160	**230**	330	IPR	.0024-.0059	.0031-.0067	.0047-.0091	.0055-.0110	.0067-.0130	.0075-.0150	.0091-.0185	.0114-.0232
	5	160	**200**	260	IPR	.0031–.0055	.0039–.0079	.0047–.0079	.0063–.0094	.0079–.0110	.0094–.0126	.0110–.0157	.0126–.0189
	6	130	**160**	230	IPR	.0020-.0031	.0024-.0039	.0031-.0055	.0039-.0071	.0051-.0087	.0055-.0094	.0071-.0126	.0091-.0161
K	1	260	**430**	560	IPR	.0043-.0087	.0047-.0094	.0063-.0122	.0079-.0150	.0091-.0173	.0098-.0193	.0122-.0024	.0150-.0185
	2	300	**360**	390	IPR	.0039–.0067	.0047–.0075	.0063–.0098	.0079–.0122	.0091–.0142	.0098–.0157	.0122–.0189	.0150–.0236
	3	260	**360**	430	IPR	.0028-.0059	.0035-.0075	.0047-.0098	.0055-.0118	.0067-.0138	.0075-.0157	.0098-.0189	.0118-.0236
H	1	70	**110**	150	IPR	.0012-.0024	.0016-.0031	.0024-.0039	.0031-.0047	.0035-.0051	.0039-.0055	.0047-.0063	.0055-.0071
	2	50	**100**	150	IPR	.0008–.0016	.0012–.0024	.0020–.0031	.0028–.0039	.0031–.0043	.0035–.0047	.0039–.0055	.0043–.0063
	3	50	**80**	130	IPR	.0008-.0016	.0008-.0020	.0016-.0028	.0024-.0035	.0028-.0039	.0031-.0043	.0035-.0051	.0039-.0059
	4	50	**70**	110	IPR	.0008–.0016	.0012–.0024	.0020–.0031	.0028–.0039	.0031–.0043	.0035–.0047	.0039–.0055	.0043–.0063

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 (.0938–.1181") 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 centering 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.

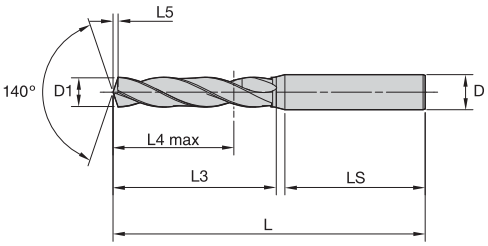


Customization

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





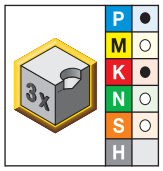


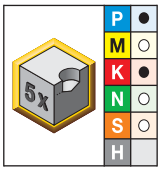




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B966A/B967A • ~3 x D/~5 x D



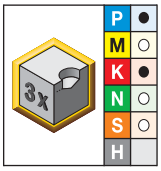


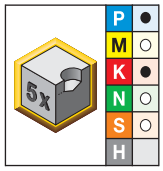
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	in	fraction	wire size	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	–	13	0,8	36	6
B966A04800	B967A04800	4,800	.1890	–	12	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)



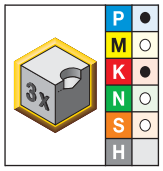


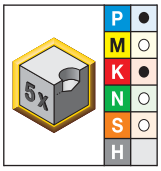
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	in	fraction	wire size	L5	LS	D
B966A06300	–	6,300	.2480	–	–	1,1	36	8
B966A06350	–	6,350	.2500	1/4	–	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	in	fraction	wire size	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	1/2	–	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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

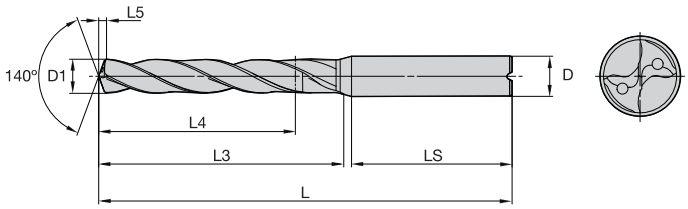
Kenna Universal™ Drills • B966, B967 Series • Grade KC7315™ • Flood Coolant • Drill Diameters 3–20mm (.1181–.7874")



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	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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (fz) by Diameter	1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	0	230	300	380	IPR	.002–.004	.003–.005	.004–.007	.004–.009	.005–.010	.006–.012	.007–.014	.009–.018
	1	200	230	330	IPR	.002–.005	.004–.006	.004–.009	.005–.010	.006–.012	.007–.014	.009–.017	.011–.021
	2	260	300	330	IPR	.002–.005	.003–.006	.005–.009	.006–.010	.007–.012	.008–.014	.009–.017	.012–.021
	3	160	230	300	IPR	.003–.006	.004–.007	.005–.009	.006–.011	.008–.013	.009–.015	.010–.019	.013–.023
	4	160	230	330	IPR	.002–.006	.003–.007	.005–.009	.006–.011	.007–.013	.008–.015	.009–.019	.011–.023
	5	130	160	230	IPR	.002–.005	.003–.006	.004–.007	.005–.009	.006–.010	.007–.011	.009–.014	.010–.017
	6	100	130	200	IPR	.002–.003	.002–.004	.003–.006	.004–.007	.005–.009	.006–.009	.007–.013	.009–.016
M	1	100	130	160	IPR	.002–.003	.002–.004	.003–.004	.004–.005	.004–.006	.005–.006	.006–.007	.006–.008
	2	130	160	200	IPR	.002–.003	.002–.004	.003–.005	.004–.006	.004–.006	.005–.007	.006–.008	.006–.009
	3	100	130	160	IPR	.002–.003	.002–.004	.003–.004	.004–.005	.004–.006	.005–.006	.006–.007	.006–.008
K	1	260	430	560	IPR	.004–.009	.005–.009	.006–.012	.008–.015	.009–.017	.010–.019	.012–.002	.015–.019
	2	300	360	390	IPR	.004–.007	.005–.008	.006–.010	.008–.012	.009–.014	.010–.016	.012–.019	.015–.024
	3	260	360	430	IPR	.003–.006	.004–.008	.005–.010	.006–.012	.007–.014	.008–.016	.010–.019	.012–.024
N	1	300	750	890	IPR	.003–.006	.004–.006	.005–.008	.006–.009	.008–.011	.009–.013	.011–.016	.013–.019
	2	300	720	890	IPR	.003–.006	.004–.008	.005–.009	.006–.011	.008–.013	.009–.014	.011–.017	.013–.021
	3	300	590	740	IPR	.005–.006	.005–.006	.006–.008	.006–.009	.008–.011	.009–.013	.011–.016	.013–.017
	4	300	430	890	IPR	.003–.006	.004–.008	.005–.009	.006–.011	.008–.013	.009–.014	.011–.016	.013–.019
S	1	70	80	100	IPR	.001–.002	.002–.003	.002–.004	.003–.005	.004–.005	.004–.006	.005–.006	.006–.007
	2	30	70	100	IPR	.001–.002	.001–.002	.002–.003	.003–.004	.003–.004	.004–.005	.004–.006	.004–.006
	3	70	80	130	IPR	.001–.002	.001–.002	.002–.003	.002–.004	.003–.004	.003–.004	.004–.005	.004–.006
	4	70	80	160	IPR	.001–.002	.001–.002	.002–.003	.003–.004	.003–.004	.004–.005	.004–.006	.004–.006

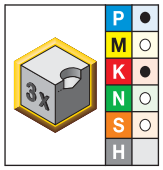


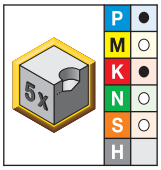




For information on L, L3, and L4 max, see the Solid Carbide Drills foldout table.

B976A/B977A • ~3 x D/~5 x D



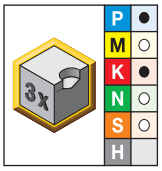


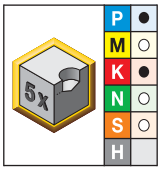
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	in	fraction	wire size	L5	LS	D
B976Z02383	–	2,383	.0938	3/32	—	0,4	28	3
B976Z02400	–	2,400	.0945	—	—	0,4	28	3
B976Z02439	–	2,439	.0960	—	41	0,4	28	3
B976Z02489	–	2,489	.0980	—	40	0,4	28	3
B976Z02500	–	2,500	.0984	—	—	0,4	28	3
B976Z02578	–	2,578	.1015	—	38	0,4	28	3
B976Z02600	–	2,600	.1024	—	—	0,4	28	3
B976Z02642	–	2,642	.1040	—	37	0,4	28	3
B976Z02705	–	2,705	.1065	—	36	0,4	28	3
B976Z02779	–	2,779	.1094	7/64	—	0,4	28	3
B976Z02800	–	2,800	.1102	—	—	0,5	28	3
B976Z02820	–	2,820	.1110	—	34	0,5	28	3
B976Z02870	–	2,870	.1130	—	33	0,5	28	3
B976Z02900	–	2,900	.1142	—	—	0,5	28	3
B976Z02947 *	–	2,947	.1160	—	32	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	1/8	—	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	—	29	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	—	26	0,6	36	6
B976A03797	B977A03797	3,797	.1495	—	25	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	5/32	—	0,7	36	6
B976A04000	B977A04000	4,000	.1575	—	—	0,7	36	6
B976A04039	B977A04039	4,039	.1590	—	21	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)



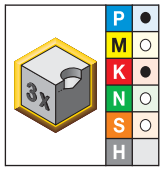


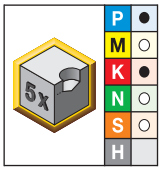
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	in	fraction	wire size	L5	LS	D
B976A04300	B977A04300	4,300	.1693	–	–	0,7	36	6
B976A04366	B977A04366	4,366	.1719	11/64	–	0,7	36	6
–	B977A04400	4,400	.1732	–	–	0,7	36	6
B976A04496	B977A04496	4,496	.1770	–	16	0,7	36	6
B976A04500	B977A04500	4,500	.1772	–	–	0,7	36	6
–	B977A04580	4,580	.1803	–	15	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	–	14	0,8	36	6
–	B977A04650	4,650	.1831	–	–	0,8	36	6
B976A04700	B977A04700	4,700	.1850	–	13	0,8	36	6
B976A04763	B977A04763	4,763	.1875	3/16	–	0,8	36	6
B976A04800	B977A04800	4,800	.1890	–	12	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	–	7	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	–	3	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	7/32	–	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	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	1/4	–	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	17/64	–	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	9/32	–	1,2	36	8

(continued)

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



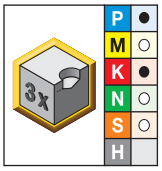


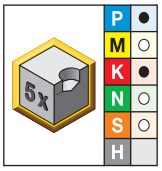
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	in	fraction	wire size	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	19/64	–	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	5/16	–	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	21/64	–	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	11/32	–	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	23/64	–	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	3/8	–	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	25/64	–	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	13/32	–	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)



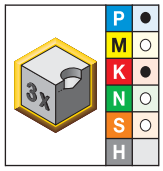


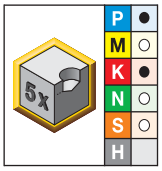
● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	in	fraction	wire size	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	27/64	–	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	7/16	–	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	29/64	–	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	15/32	–	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	31/64	–	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	1/2	–	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	33/64	–	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	17/32	–	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	9/16	–	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)



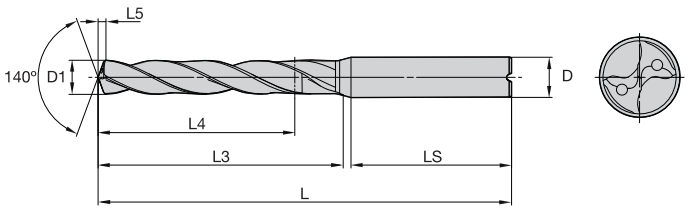


● first choice
○ alternate choice

short • KC7315	long • KC7315	D1 diameter mm	in	fraction	wire size	L5	LS	D
–	B977A15800	15,800	.6220	–	–	2,7	48	16
B976A15875	B977A15875	15,875	.6250	5/8	–	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	21/32	–	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	11/16	–	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	3/4	–	3,3	50	20
–	B977A19200	19,200	.7559	–	–	3,3	50	20
–	B977A19253	19,253	.7580	–	–	3,3	50	20
–	B977A19446	19,446	.7656	49/64	–	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

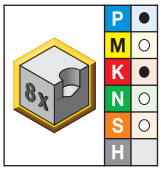
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.







B978A • ~8 x D

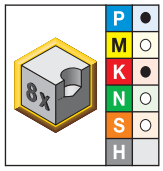


● first choice
○ alternate choice

extra long • KC7315	D1 diameter mm	in	fraction	wire size	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	5/32	–	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	3/16	–	94	56	48	1,0	36	6
B978A04800	4,800	.1890	–	12	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	7/32	–	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	1/4	–	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	17/64	–	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	9/32	–	110	72	61	1,5	36	8

(continued)

(B978A • ~8 x D — continued)

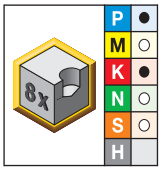


● first choice
○ alternate choice

	D1 diameter									
extra long • KC7315	mm	in	fraction	wire size	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	19/64	–	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	5/16	–	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	21/64	–	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	11/32	–	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	23/64	–	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	3/8	–	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	25/64	–	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	13/32	–	141	94	79	2,2	45	12
B978A10500	10,500	.4134	–	–	141	94	79	2,2	45	12
B978A10716	10,716	.4219	27/64	–	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	7/16	–	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	29/64	–	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	15/32	–	141	94	79	2,5	45	12
B978A12000	12,000	.4724	–	–	141	94	79	2,5	45	12
B978A12304 *	12,304	.4844	31/64	–	155	108	91	2,6	45	14
B978A12500	12,500	.4921	–	–	155	108	91	2,7	45	14
B978A12700	12,700	.5000	1/2	–	155	108	91	2,7	45	14
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

(continued)

(B978A • ~8 x D — continued)



● first choice
○ alternate choice

	D1 diameter									
extra long • KC7315	mm	in	fraction	wire size	L	L3	L4 max	L5	LS	D
B978A14000	14,000	.5512	—	—	155	108	91	3,0	45	14
B978A14288	14,288	.5625	9/16	—	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	5/8	—	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	11/16	—	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	3/4	—	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

Tolerance • Inch

nominal size range	D1 tolerance m7	D tolerance h6
>.1181–.2362	.0002/.0006	.0000/-.0003
>.2362–.3937	.0002/.0008	.0000/-.0004
>.3937–.7087	.0003/.0010	.0000/-.0004
>.7087–1.0000	.0003/.0011	.0000/-.0005

Kenna Universal™ Drills • B97_Series • Grade KC7315™ • Through Coolant • Drill Diameters 2–20mm (.0787–.7874")

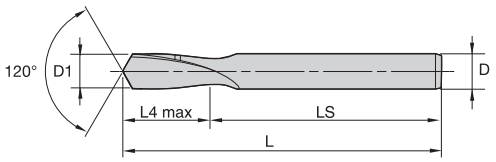


Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter		2,0	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	80	**120**	160	mm/r		0,04–0,10	0,06–0,12	0,07–0,14	0,09–0,19	0,11–0,22	0,13–0,26	0,15–0,30	0,19–0,36	0,24–0,46
	1	70	**100**	140	mm/r		0,05–0,12	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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter		5/64 .078	1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	0	260	**390**	520	IPR		.002-.004	.002-.005	.003-.005	.004-.007	.004-.009	.005-.010	.006-.012	.007-.014	.009-.018
	1	230	**330**	460	IPR		.002-.005	.003-.006	.003-.006	.004-.009	.005-.010	.006-.012	.007-.014	.009-.017	.011-.022
	2	300	**390**	460	IPR		.002-.005	.003-.006	.003-.006	.005-.009	.006-.010	.007-.012	.008-.014	.009-.017	.012-.021
	3	200	**260**	330	IPR		.002-.005	.003-.006	.004-.007	.005-.009	.006-.011	.008-.013	.009-.015	.010-.019	.013-.023
	4	160	**260**	330	IPR		.002-.005	.003-.006	.003-.007	.005-.009	.006-.011	.007-.013	.008-.015	.009-.019	.011-.023
	5	160	**200**	260	IPR		.002-.005	.003-.005	.004-.006	.005-.008	.006-.009	.008-.011	.009-.012	.011-.015	.013-.017
	6	130	**160**	230	IPR		.002-.002	.002-.003	.002-.004	.003-.006	.004-.007	.005-.009	.006-.009	.007-.013	.009-.016
M	1	100	**130**	160	IPR		.001-.002	.002-.003	.002-.004	.003-.004	.004-.005	.004-.006	.005-.006	.006-.007	.006-.008
	2	130	**160**	200	IPR		.001-.003	.002-.003	.002-.004	.003-.005	.004-.006	.004-.006	.005-.007	.006-.008	.006-.009
	3	100	**130**	160	IPR		.001-.002	.002-.003	.002-.004	.003-.004	.004-.005	.004-.006	.005-.006	.006-.007	.006-.008
K	1	260	**390**	560	IPR		.004-.007	.004-.009	.005-.009	.006-.012	.008-.015	.009-.017	.010-.019	.012-.024	.015-.029
	2	260	**360**	460	IPR		.004-.006	.005-.006	.005-.008	.006-.010	.008-.012	.009-.014	.010-.016	.012-.019	.015-.024
	3	260	**330**	430	IPR		.003-.006	.003-.007	.004-.008	.005-.010	.006-.012	.007-.014	.008-.016	.009-.019	.012-.024
N	1	300	**750**	1030	IPR		.002-.005	.003-.006	.004-.006	.005-.008	.006-.009	.008-.011	.009-.013	.011-.016	.013-.019
	2	300	**740**	890	IPR		.002-.005	.003-.006	.004-.008	.005-.009	.006-.011	.008-.013	.009-.014	.011-.017	.013-.021
	3	300	**590**	890	IPR		.004-.006	.005-.006	.005-.006	.006-.008	.006-.009	.008-.011	.009-.013	.011-.016	.013-.017
	4	300	**440**	590	IPR		.002-.005	.003-.006	.000-.008	.005-.009	.006-.011	.008-.013	.009-.014	.011-.016	.013-.019
S	1	30	**80**	100	IPR		.001-.002	.001-.002	.002-.003	.002-.004	.003-.005	.004-.005	.004-.006	.005-.006	.006-.007
	2	30	**70**	80	IPR		.001-.002	.001-.002	.001-.002	.002-.003	.003-.004	.003-.004	.004-.005	.004-.006	.004-.006
	3	30	**80**	100	IPR		.001-.001	.001-.002	.001-.002	.002-.003	.002-.004	.003-.004	.003-.004	.004-.005	.004-.006
	4	30	**80**	130	IPR		.001-.001	.001-.002	.001-.002	.002-.003	.003-.004	.003-.004	.004-.005	.004-.006	.004-.006

KENNAMETAL®







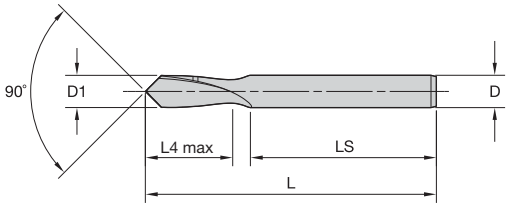


B501 • 120°



● first choice
○ alternate choice

B501 • K10	D1 diameter mm	in	fraction	wire size	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

B505 • K10	D1 diameter mm	in	fraction	wire size	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

Tolerance • Inch

D1	tolerance h8	tolerance h6
>.1181–.2362	.0000/-.0007	.0000/-.0003
>.2362–.3937	.0000/-.0009	.0000/-.0004
>.3937–.7087	.0000/-.0011	.0000/-.0004

Non-Coolant Spot Drills • B50_ Series • Grade K10 • Dry and Flood Coolant Drill • Diameters 3–20mm (.1181–.7874")





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	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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter	1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	0	160	210	330	IPR	.002–.004	.002–.005	.003–.006	.004–.006	.005–.007	.006–.008	.006–.009	.007–.011
	1	130	180	260	IPR	.002–.004	.002–.005	.003–.006	.004–.006	.005–.007	.006–.008	.006–.009	.007–.011
	2	130	180	260	IPR	.002–.004	.002–.005	.003–.006	.004–.006	.005–.007	.006–.008	.006–.009	.007–.011
	3	130	180	260	IPR	.002–.004	.002–.005	.003–.006	.004–.006	.005–.007	.006–.008	.006–.009	.007–.011
	4	130	180	260	IPR	.002–.003	.002–.004	.002–.005	.003–.006	.004–.006	.005–.007	.006–.009	.006–.009
	5	100	130	200	IPR	.001–.002	.001–.002	.002–.003	.002–.004	.003–.005	.004–.006	.005–.007	.006–.008
	6	100	130	200	IPR	.001–.002	.001–.002	.002–.003	.002–.004	.003–.005	.004–.006	.005–.007	.006–.008
M	1	100	110	160	IPR	.002–.003	.002–.004	.002–.004	.032–.005	.004–.006	.004–.007	.004–.008	.005–.009
	2	100	130	160	IPR	.001–.002	.002–.003	.002–.004	.002–.004	.003–.005	.003–.006	.004–.007	.004–.008
	3	80	100	130	IPR	.001–.002	.002–.003	.002–.004	.002–.004	.003–.005	.003–.006	.004–.007	.004–.008
K	1	200	300	390	IPR	.002–.005	.003–.006	.004–.006	.005–.007	.006–.008	.006–.009	.007–.010	.008–.012
	2	200	260	330	IPR	.002–.005	.003–.006	.004–.006	.005–.007	.006–.008	.006–.009	.007–.010	.008–.012
	3	200	300	390	IPR	.002–.005	.003–.006	.004–.006	.005–.007	.006–.008	.006–.009	.007–.010	.008–.012
N	1	300	750	890	IPR	.002–.005	.003–.006	.004–.007	.005–.010	.006–.011	.007–.013	.008–.013	.009–.015
	2	300	720	890	IPR	.002–.005	.003–.006	.004–.007	.005–.010	.006–.011	.007–.013	.008–.013	.009–.015
	3	300	590	740	IPR	.002–.005	.003–.006	.004–.007	.005–.010	.006–.011	.007–.013	.008–.013	.009–.015
	4	300	430	890	IPR	.002–.005	.003–.006	.004–.007	.005–.010	.006–.011	.007–.013	.008–.013	.009–.015
S	1	70	80	100	IPR	.001–.002	.002–.003	.002–.004	.002–.004	.003–.004	.003–.005	.004–.006	.004–.008
	2	30	70	100	IPR	.001–.002	.002–.003	.002–.004	.002–.004	.003–.004	.003–.005	.004–.006	.004–.008
	3	70	80	130	IPR	.001–.002	.002–.003	.002–.004	.002–.004	.003–.004	.003–.005	.004–.006	.004–.008
	4	70	80	160	IPR	.001–.002	.002–.003	.002–.004	.002–.004	.003–.004	.003–.005	.004–.006	.004–.008

KENNAMETAL



Modular Drills

Introduction **H2–H5**

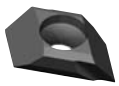
KenTIP FS **H6–H28**

KenTIP **H30–H48**

KSEM **H50–H101**

Tube Sheet Grooving Tool H98–H101

KSEM PLUS **H102–H133**

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	
										20,00≤Ø<21,00	.8071≤Ø<.8268	
										21,00≤Ø<27,99	.8268≤Ø<1.1020	

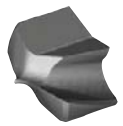
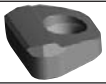
* Apart from our standard drills, we can offer you a wide variety of special coating solutions and edge preparations to fulfill all your needs. If a specific drill is not suitable for your workpiece material, please contact our **Engineered Solutions Department**.

■ 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																			
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	■					□	□					■	□	□	■	□	□	□	H18
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	—		■	□						■	□	□								H32
				■	■			■	■	■	□	■	■								
12,50–36,01	.4921–1.4177							■													H42
								■													
10,00–31,20	.3937–1.2283							■	■												H43
7,94≤Ø<9,50	.3125≤Ø<.3740	12 x D	■					□**	□					■	□	□	■	□	□	□	H38
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	■					□**	□					■	□	□	■	□	□	□	

** 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 catalog.

(continued)

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 center 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	—		■	■	■					■	□	□								H52
				■	■	■				■	■	□	□								
				■	■	■					■	□	■								
				■	■						■	□	□								
				■	■	■				■	■	□	□								
				■	■	■	■	■	■	■	□	■	■								
				■	■	■					■	□	■								
12,50–40,00	.4921–1.5748	—						■													H85
								■													
								■													
12,50≤Ø<16,50	.4921≤Ø<.6496	15 x D	■					□	□	□				■	■	□	□	■	□	□	H72
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)									H115
			■	■	■	■	□	□	□	■		■									
13,00–40,00 mm PDD reference only																					H111
DFR inserts for A1 Heads with FDS28		—																			H113
28,00≤Ø<31,75	1.1024≤Ø<1.2500																				
DFT inserts for A1 Heads FDS32 and above																					H112
31,75≤Ø≤127,00	1.2500≤Ø≤5.0000																				
DFC inserts for B1 Heads, all FDS sizes																					H114
28,00≤Ø≤127,00	1.1024≤Ø≤5.0000																				
DPA are supporting various solutions				■	■	■	□			■											H114
28,00≤Ø≤127,00	1.1020≤Ø≤5.0000	3–20 x D (max 1250mm)	■					□	□	□				□		■	□	■	□	□	H126

** 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 catalog.

KenTIP™ FS

The Perfect Fusion of a Solid Carbide and an Indexable Drill

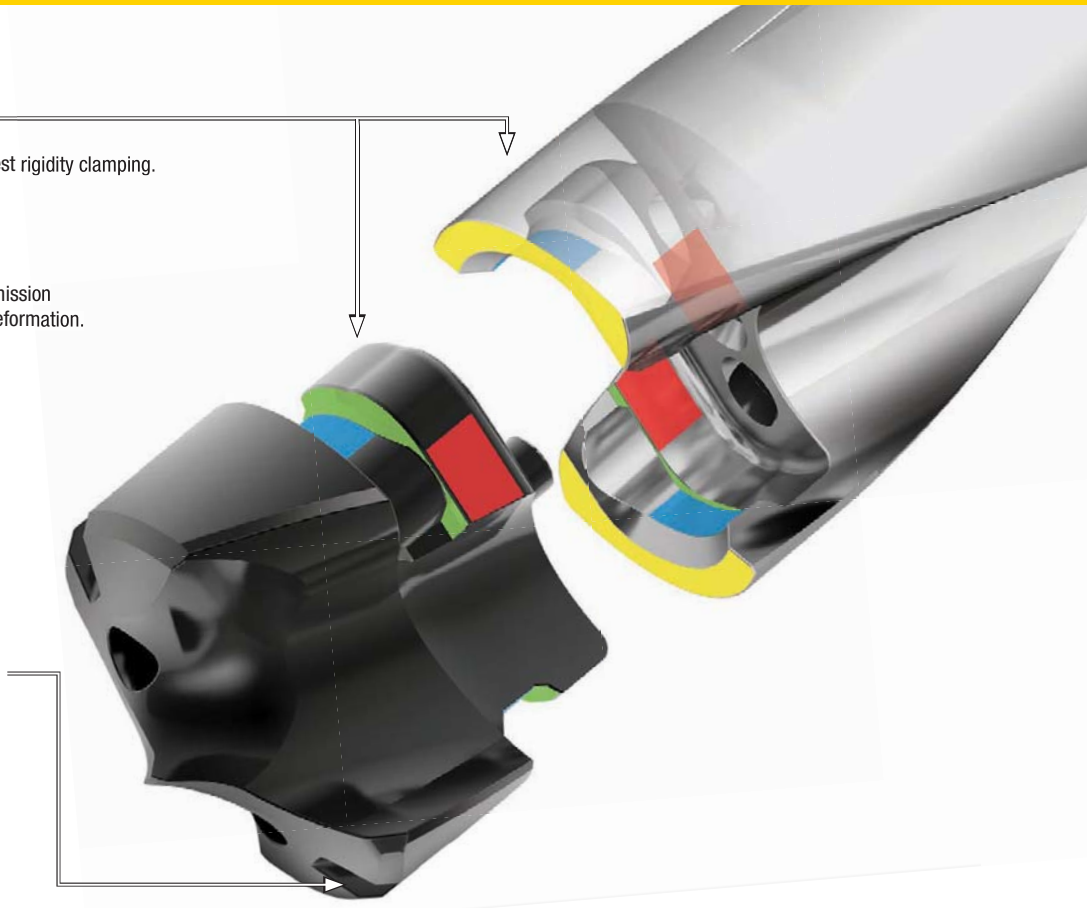
The new modular drill KenTIP FS covers more applications and provides better performance than any other modular system, delivering substantial cost savings and process simplifications on your shop floor.

3-point geometries, 3 high-performance grades, 3 different shank styles.
This modular drilling system covers a 6–26mm (.2363–1.0236") 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.

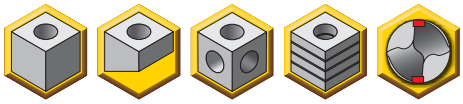
Multi-Coolant
Coolant delivery to the drill point and to the rake face for guaranteed coolant delivery where it is needed.

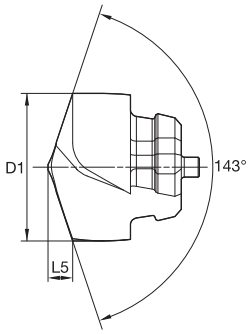
Unique Point Geometries
3 material-specific, self-centering point designs enable excellent hole quality and optimum tool performance.



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 centering capabilities for drilling without precentering, even in deeper holes.
- KCP15A™ is an AlTiN PVD monolayer coating.
- Enhanced thermal stability.
- Excellent balance between toughness and wear resistance.
- Without internal coolant.

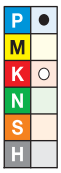






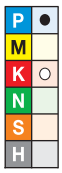
HPG Geometry

KenTIP FS Inserts • HPG KCP15A • No Internal Coolant Channels



● first choice
○ alternate choice

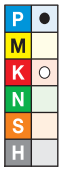
KCP15A	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFSS06000HPGM	6,000	.2362	1,370	.0539	A
KTFSS06100HPGM	6,100	.2402	1,380	.0543	A
KTFSS06200HPGM	6,200	.2441	1,400	.0551	A
KTFSS06300HPGM	6,300	.2480	1,440	.0567	B
KTFSS06350HPGM	6,350	.2500	1,450	.0571	B
KTFSS06400HPGM *	6,400	.2520	1,450	.0571	B
KTFSS06500HPGM	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



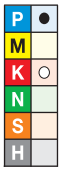
KCP15A	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFSS08733HPGM	8,732	.3438	1,930	.0760	G
KTFSS08800HPGM	8,800	.3465	1,940	.0764	G
KTFSS08839HPGM *	8,839	.3480	1,950	.0768	G
KTFSS08900HPGM *	8,900	.3504	1,960	.0772	G
KTFSS09000HPGM	9,000	.3543	2,010	.0791	H
KTFSS09093HPGM *	9,093	.3580	2,030	.0799	H
KTFSS09100HPGM	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

KenTIP FS HPG Geometry

Tolerance

D1 inch	tolerance k8
.2362	.000/+.0007
>.2362–.3937	.000/+.0009
>.3937–.7087	.000/+.0011
>.7087–1.0236	.000/+.0013

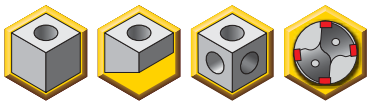
Modular Drill Carbide Insert Blades • KenTIP™ FS • HPG Geometry • Grade KCP15A™ • No Internal Coolant Channels on the Insert • Through Coolant on the Body • Metric

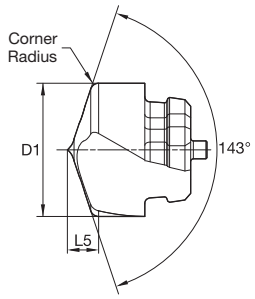
Material Group		Cutting Speed — vc Range — m/min			Metric						
					Recommended Feed Rate per Rev						
		min	Starting Value	max		8,0	10,0	12,0	14,0	16,0	20,0
P	1	90	**130**	170	mm/r	0,11–0,22	0,13–0,28	0,14–0,34	0,17–0,43	0,19–0,50	0,25–0,53
	2	100	**140**	180	mm/r	0,11–0,26	0,13–0,32	0,14–0,36	0,17–0,40	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

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

Material Group		Cutting Speed — vc Range — SFM			Inch						
					Recommended Feed Rate per Rev						
		min	Starting Value	max		0.315	0.394	0.472	0.551	0,630	0.787
P	1	300	**430**	560	IPR	0.004–0.009	0.005–0.011	0.006–0.013	0.007–0.017	0.007–0.020	0.010–0.021
	2	330	**460**	590	IPR	0.004–0.010	0.005–0.013	0.006–0.014	0.007–0.016	0.007–0.020	0.010–0.021
	3	200	**330**	430	IPR	0.004–0.012	0.005–0.015	0.006–0.016	0.008–0.020	0.009–0.020	0.012–0.022
	4	200	**330**	430	IPR	0.004–0.012	0.005–0.015	0.006–0.016	0.007–0.020	0.007–0.020	0.009–0.020
	5	200	**230**	330	IPR	0.004–0.009	0.004–0.010	0.004–0.011	0.006–0.013	0.006–0.014	0.008–0.018
	6	200	**230**	230	IPR	0.004–0.009	0.004–0.010	0.004–0.011	0.006–0.013	0.006–0.014	0.008–0.018
K	1	260	**390**	560	IPR	0.006–0.013	0.006–0.014	0.007–0.015	0.008–0.018	0.010–0.021	0.012–0.026
	2	260	**360**	390	IPR	0.006–0.013	0.006–0.013	0.007–0.014	0.008–0.018	0.010–0.021	0.012–0.026
	3	160	**260**	330	IPR	0.006–0.013	0.007–0.014	0.007–0.016	0.008–0.018	0.008–0.019	0.009–0.021

- 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.





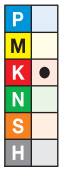


HPC Geometry

KenTIP FS Inserts • HPC KC7410 • With Internal Coolant Channels



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



● 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

KenTIP FS HPC Geometry

Tolerance

D1 inch	tolerance k8
.2362	.000/+.0007
>.2362–.3937	.000/+.0009
>.3937–.7087	.000/+.0011
>.7087–1.0236	.000/+.0013

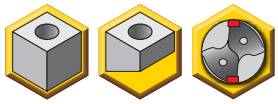
Modular Drill Carbide Insert Blades • KenTIP™ FS • HPC Geometry • Grade KC7410™ • Through Coolant • Metric

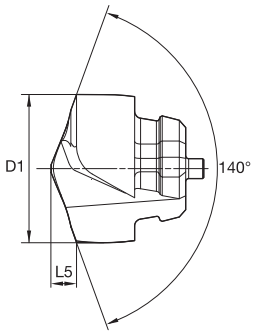
Material Group		Cutting Speed – vc Range – m/min			Metric						
					Recommended Feed Rate per Rev						
		min	Starting Value	max		8,0	10,0	12,0	14,0	16,0	20,0
K	1	100	**175**	200	mm/r	0,14–0,34	0,16–0,39	0,19–0,45	0,23–0,50	0,26–0,58	0,3–0,64
	2	100	**160**	180	mm/r	0,14–0,34	0,16–0,39	0,19–0,45	0,23–0,50	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

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

Material Group		Cutting Speed – vc Range – SFM			Inch						
					Recommended Feed Rate per Rev						
		min	Starting Value	max		.315	.394	.472	.551	.630	.787
K	1	330	**570**	660	IPR	0.005–0.013	0.006–0.015	0.007–0.017	0.009–0.019	0.010–0.022	0.011–0.025
	2	330	**520**	590	IPR	0.005–0.013	0.006–0.015	0.007–0.017	0.009–0.019	0.010–0.022	0.011–0.025
	3	230	**280**	390	IPR	0.005–0.010	0.005–0.013	0.006–0.014	0.007–0.016	0.008–0.018	0.011–0.021

- 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.

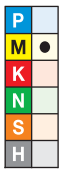




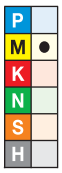


HPL Geometry

KenTIP FS Inserts • HPL KCMS15 • With Internal Coolant Channels



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

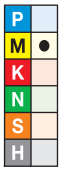


● first choice
○ alternate choice

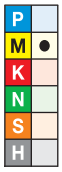
KCMS15	D1 mm	D1 in	L5 mm	L5 in	seat size
KTFST10600HPLM *	10,600	.4173	2,250	.0886	K
KTFST10700HPLM	10,700	.4213	2,270	.0894	K
KTFST10800HPLM *	10,800	.4252	2,290	.0902	K
KTFST10900HPLM *	10,900	.4291	2,310	.0909	K
KTFST11000HPLM	11,000	.4331	2,340	.0921	L
KTFST11100HPLM	11,100	.4370	2,350	.0925	L
KTFST11113HPLM	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

KenTIP FS HPL Geometry
Tolerance

D1 inch	tolerance k8
.2362	.000/+.0007
>.2362–.3937	.000/+.0009
>.3937–.7087	.000/+.0011
>.7087–1.0236	.000/+.0013

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

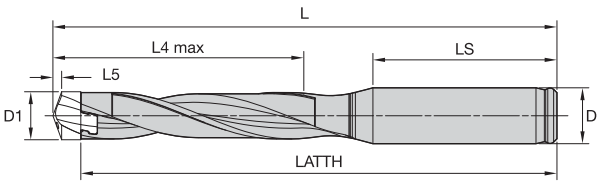
Material Group		Cutting Speed — vc Range — m/min			Metric						
					Recommended Feed Rate per Rev						
		min	Starting Value	max		8,0	10,0	12,0	14,0	16,0	20,0
M	1	50	**60**	90	mm/r	0,08–0,15	0,09–0,18	0,11–0,20	0,12–0,22	0,13–0,24	0,16–0,28
	2	30	**60**	90	mm/r	0,08–0,15	0,09–0,18	0,11–0,20	0,12–0,22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

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

Material Group		Cutting Speed — vc Range — SFM			Inch						
					Recommended Feed Rate per Rev						
		min	Starting Value	max		.315	.394	.472	.551	.630	.787
M	1	160	**200**	300	IPR	0.003–0.006	0.004–0.007	0.004–0.008	0.005–0.009	0.005–0.009	0.006–0.011
	2	100	**200**	300	IPR	0.003–0.006	0.004–0.007	0.004–0.008	0.005–0.009	0.005–0.009	0.006–0.011
	3	70	**160**	200	IPR	0.003–0.006	0.004–0.007	0.004–0.008	0.005–0.009	0.005–0.009	0.006–0.011

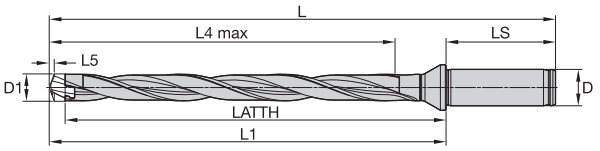
- KenTIP FS toolholder with straight cylindrical round metric shank.
- 12 x D holders feature a flanged shank for improved stiffness.
- Multi-coolant provides an advanced coolant channel layout with four coolant exits in each holder.
- Each tool body is shipped with related insert wrench.

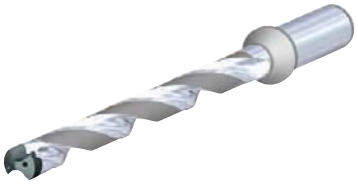






Straight Round Shank (SS Shank)





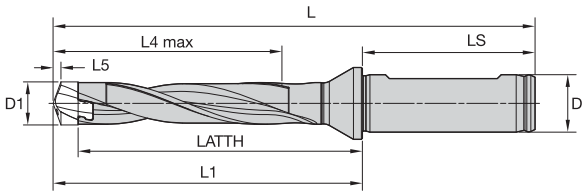
Flanged Round Shank (SF Shank)

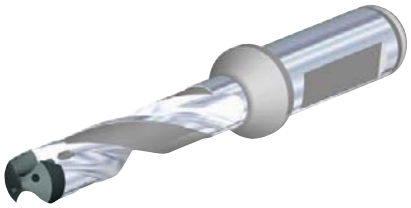
KenTIP FS Round Shank • 1.5 x D/3 x D/5 x D/8 x D/12 x D • Metric

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 0° 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.







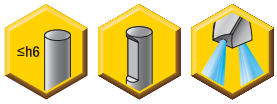
Flanged Shank with Flat (SCF Shank)

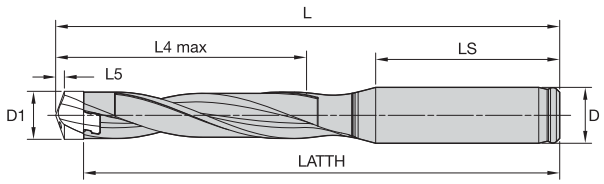
KenTIP FS Flanged Shank with Flat • 1.5 x D/3 x D/5 x D/8 x D/12 x D • Metric

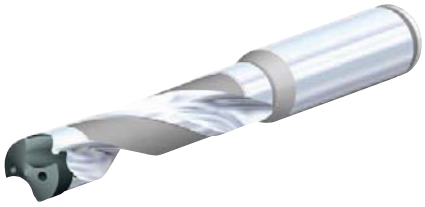
1.5 x D SCF	3 x D SCF	5 x D SCF	8 x D SCF	12 x D SCF	D1 mm	D1 in	D1 max mm	D1 max in	seat size	KenTIP wrench
–	KTFS080R03SCF12M	KTFS080R05SCF12M	KTFS080R08SCF12M	–	8,000	.3150	8,499	.3346	F	170.306
–	KTFS085R03SCF12M	KTFS085R05SCF12M	KTFS085R08SCF12M	–	8,500	.3346	8,999	.3543	G	170.306
–	KTFS090R03SCF12M	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.**

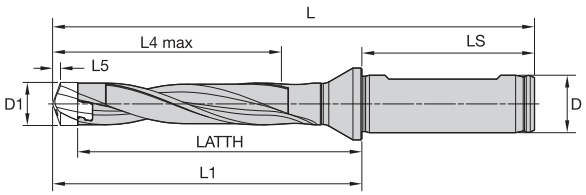
- KenTIP FS toolholder with straight cylindrical round shank. Inch shank <20mm nominal drilling diameter.
- KenTIP FS toolholder with Flanged shank and 0° Flat. Inch shank ≥20mm nominal drilling diameter.
- Multi-coolant provides an advanced coolant channel layout with four coolant exits in each holder.
- Each tool body is shipped with related insert wrench.

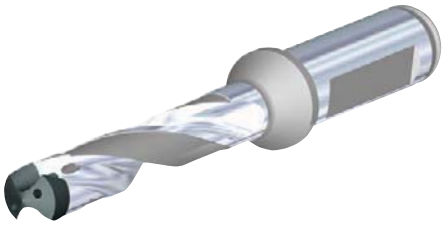






Straight Round Shank (SS Shank)





Flanged Shank with Flat (SCF Shank)

KenTIP FS Round and Flanged Shank with Flat • 3 x D/5 x D/8 x D • Inch

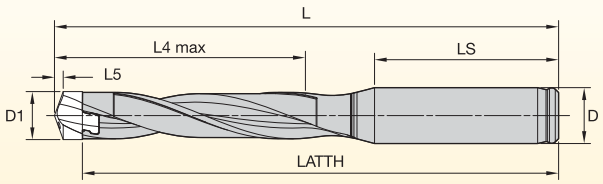
3 x D	5 x D	8 x D	D1 mm	D1 in	D1 max mm	D1 max in	seat size	KenTIP wrench
KTFS0237R03SS031	KTFS0237R05SS031	KTFS0237R08SS031	6,000	.2363	6,299	.2480	A	170.319
KTFS0249R03SS031	KTFS0249R05SS031	KTFS0249R08SS031	6,300	.2481	6,599	.2598	B	170.319
KTFS0260R03SS031	KTFS0260R05SS031	KTFS0260R08SS031	6,600	.2599	6,999	.2755	C	170.319
KTFS0276R03SS031	KTFS0276R05SS031	KTFS0276R08SS031	7,000	.2756	7,499	.2952	D	170.319
KTFS0296R03SS031	KTFS0296R05SS031	KTFS0296R08SS031	7,500	.2953	7,999	.3149	E	170.319
KTFS0315R03SS038	KTFS0315R05SS038	KTFS0315R08SS038	8,000	.3150	8,499	.3346	F	170.306
KTFS0335R03SS038	KTFS0335R05SS038	KTFS0335R08SS038	8,500	.3346	8,999	.3543	G	170.306
KTFS0355R03SS038	KTFS0355R05SS038	KTFS0355R08SS038	9,000	.3544	9,499	.3739	H	170.306
KTFS0375R03SS038	KTFS0375R05SS038	KTFS0375R08SS038	9,500	.3740	9,999	.3936	I	170.306
KTFS0394R03SS044	KTFS0394R05SS044	KTFS0394R08SS044	10,000	.3937	10,499	.4133	J	170.307
KTFS0414R03SS044	KTFS0414R05SS044	KTFS0414R08SS044	10,500	.4134	10,999	.4330	K	170.307
KTFS0434R03SS044	KTFS0434R05SS044	KTFS0434R08SS044	11,000	.4331	11,499	.4527	L	170.307
KTFS0453R03SS050	KTFS0453R05SS050	KTFS0453R08SS050	11,500	.4528	11,999	.4724	M	170.307
KTFS0473R03SS050	KTFS0473R05SS050	KTFS0473R08SS050	12,000	.4725	12,499	.4921	N	170.308
KTFS0493R03SS050	KTFS0493R05SS050	KTFS0493R08SS050	12,500	.4922	12,999	.5117	O	170.308
KTFS0512R03SS056	KTFS0512R05SS056	KTFS0512R08SS056	13,000	.5118	13,499	.5314	P	170.308
KTFS0532R03SS056	KTFS0532R05SS056	KTFS0532R08SS056	13,500	.5315	13,999	.5511	Q	170.308
KTFS0552R03SS056	KTFS0552R05SS056	KTFS0552R08SS056	14,000	.5512	14,499	.5708	R	170.309
KTFS0571R03SS063	KTFS0571R05SS063	KTFS0571R08SS063	14,500	.5709	14,999	.5905	S	170.309
KTFS0591R03SS063	KTFS0591R05SS063	KTFS0591R08SS063	15,000	.5906	15,999	.6299	T	170.309
KTFS0630R03SS063	KTFS0630R05SS063	KTFS0630R08SS063	16,000	.6300	16,999	.6692	U	170.309
KTFS0670R03SS075	KTFS0670R05SS075	KTFS0670R08SS075	17,000	.6693	17,999	.7086	V	170.314
KTFS0709R03SS075	KTFS0709R05SS075	KTFS0709R08SS075	18,000	.7087	18,999	.7479	W	170.314
KTFS0749R03SS075	KTFS0749R05SS075	KTFS0749R08SS075	19,000	.7480	19,999	.7873	X	170.314
KTFS0788R03SCF100	KTFS0788R05SCF100	KTFS0788R08SCF100	20,000	.7874	20,999	.8267	Y	170.314
KTFS0827R03SCF100	KTFS0827R05SCF100	KTFS0827R08SCF100	21,000	.8268	21,999	.8661	Z	170.314
KTFS0867R03SCF100	KTFS0867R05SCF100	KTFS0867R08SCF100	22,000	.8662	22,999	.9054	ZA	170.314
KTFS0906R03SCF100	KTFS0906R05SCF100	KTFS0906R08SCF100	23,000	.9055	23,999	.9448	ZB	170.314
KTFS0945R03SCF100	KTFS0945R05SCF100	KTFS0945R08SCF100	24,000	.9449	24,999	.9842	ZC	170.314
KTFS0985R03SCF100	KTFS0985R05SCF100	KTFS0985R08SCF100	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

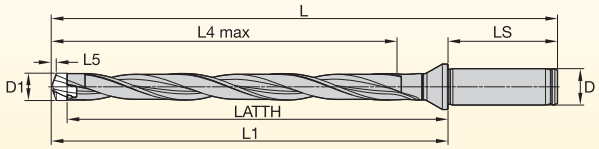
NOTE: Toolholder dimensions:
L: Total length of drill
L4: Max. drilling depth
L5: Protruding length (Insert specific. See related insert pages)
LATTH: Pocket seat reference length
LS: Shank length

(continued)

Modular Drills • Dimension Tables *(continued)*

Flanged Round Shank • Metric





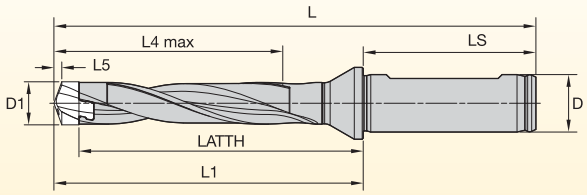
					12 x D SF			
D1 min	D1 max	Seat	LS	flanged D	LATTH	L	L1	L4 max
6,000	6,299	A	45	12	92,5	141	96	76
6,300	6,599	B	45	12	95,3	144	99	79
6,600	6,999	C	45	12	101,2	150	105	84
7,000	7,499	D	45	12	106,9	156	111	90
7,500	7,999	E	45	12	112,7	162	117	96
8,000	8,499	F	45	12	118,4	168	123	102
8,500	8,999	G	45	12	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



D1 min	D1 max	Seat	LS	flanged D	1.5 x D SCF				3 x D SCF				5 x D SCF				8 x D SCF				12 x D SCF			
					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

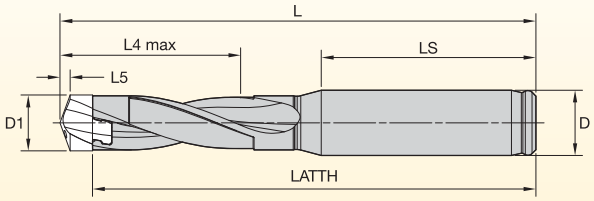
NOTE: Toolholder dimensions:
- L: Total length of drill
- L1: Drill length including flange
- L4: Max. drilling depth
- L5: Protruding length (Insert specific. See related insert pages)
- LATTH: Pocket seat reference length
- LS: Shank length

(continued)

Modular Drills • Dimension Tables *(continued)*

Straight Round Shank • Inch





					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
.3937	.4133	J	1.67	.438	3.32	3.54	1.26	4.10	4.33	2.05	5.36	5.59	3.31
.4134	.4330	K	1.67	.438	3.34	3.58	1.30	4.21	4.45	2.17	5.51	5.75	3.47
.4331	.4527	L	1.67	.438	3.37	3.62	1.34	4.32	4.57	2.28	5.65	5.91	3.62
.4528	.4724	M	1.79	.500	3.60	3.86	1.42	4.54	4.80	2.36	5.96	6.22	3.78
.4725	.4921	N	1.79	.500	3.66	3.94	1.50	4.61	4.88	2.44	6.10	6.38	3.94
.4922	.5117	O	1.79	.500	3.69	3.98	1.54	4.71	5.00	2.56	6.25	6.54	4.09
.5118	.5314	P	1.79	.563	3.76	4.06	1.58	4.86	5.16	2.68	6.44	6.73	4.25
.5315	.5511	Q	1.79	.563	3.83	4.13	1.65	4.93	5.24	2.76	6.58	6.89	4.41
.5512	.5708	R	1.79	.563	3.89	4.21	1.73	5.00	5.32	2.84	6.73	7.05	4.57
.5709	.5905	S	1.91	.625	4.12	4.45	1.77	5.30	5.63	2.95	7.07	7.40	4.72
.5906	.6299	T	1.91	.625	4.22	4.57	1.89	5.48	5.83	3.15	7.37	7.72	5.04
.6300	.6692	U	1.91	.625	4.28	4.65	2.01	5.62	5.98	3.35	7.63	7.99	5.35
.6693	.7086	V	2.00	.750	4.57	4.96	2.13	5.99	6.38	3.54	8.12	8.50	5.67
.7087	.7479	W	2.00	.750	4.67	5.08	2.24	6.16	6.57	3.74	8.41	8.82	5.98
.7480	.7873	X	2.00	.750	4.76	5.20	2.36	6.34	6.77	3.94	8.70	9.13	6.30
.2363	.2480	A	1.52	.313	2.58	2.72	.75	3.09	3.23	1.26	3.80	3.94	1.97
.2481	.2598	B	1.52	.313	2.61	2.76	.79	3.12	3.27	1.30	3.91	4.06	2.09
.2599	.2755	C	1.52	.313	2.64	2.80	.83	3.20	3.35	1.38	4.02	4.17	2.21
.2756	.2952	D	1.52	.313	2.67	2.83	.87	3.30	3.46	1.50	4.17	4.33	2.36
.2953	.3149	E	1.52	.313	2.83	3.00	.95	3.46	3.63	1.58	4.40	4.58	2.52
.3150	.3346	F	1.59	.375	2.97	3.15	1.02	3.60	3.78	1.65	4.62	4.80	2.68
.3346	.3543	G	1.59	.375	2.99	3.19	1.06	3.70	3.90	1.77	4.77	4.96	2.84
.3544	.3739	H	1.59	.375	3.02	3.23	1.10	3.81	4.02	1.89	4.91	5.12	2.99
.3740	.3936	I	1.59	.375	3.09	3.31	1.18	3.88	4.09	1.97	5.06	5.28	3.15

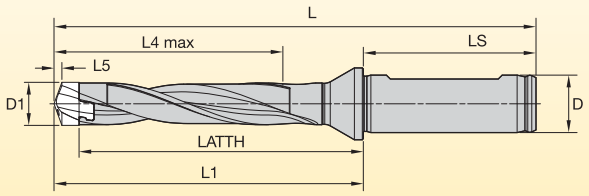
NOTE: Toolholder dimensions:
L: Total length of drill
L4: Max. drilling depth
L5: Protruding length (Insert specific. See related insert pages)
LATTH: Pocket seat reference length
LS: Shank length

(continued)

Modular Drills • Dimension Tables *(continued)*

Flanged Shank with Flat • Inch





D1 min	D1 max	Seat	LS	flanged D	3 x D SCF LATTH	L	L1	L4 max	5 x D SCF LATTH	L	L1	L4 max	8 x D SCF LATTH	L	L1	L4 max
.7874	.8267	Y	2.20	1.000	3.20	5.87	3.66	2.48	4.86	7.52	5.32	4.13	7.34	10.00	7.80	6.61
.8268	.8661	Z	2.20	1.000	3.30	5.98	3.78	2.60	5.03	7.72	5.51	4.33	7.63	10.32	8.11	6.93
.8662	.9054	ZA	2.20	1.000	3.40	6.10	3.90	2.72	5.21	7.91	5.71	4.53	7.92	10.63	8.43	7.24
.9055	.9448	ZB	2.20	1.000	3.49	6.22	4.02	2.84	5.38	8.11	5.91	4.72	8.22	10.94	8.74	7.56
.9449	.9842	ZC	2.20	1.000	3.59	6.34	4.13	2.95	5.55	8.31	6.10	4.92	8.51	11.26	9.06	7.87
.9843	1.0236	ZD	2.20	1.000	3.68	6.46	4.25	3.07	5.73	8.50	6.30	5.12	8.80	11.57	9.37	8.19

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.

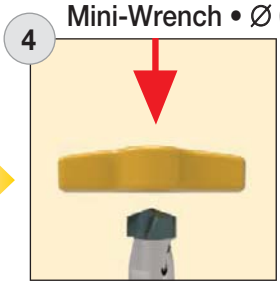


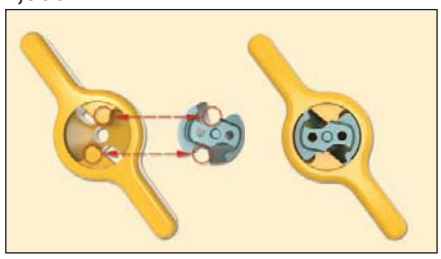
2. Put insert into pocket seat so it rests firmly on the holder.



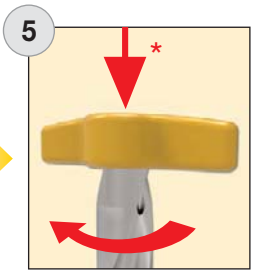
3. Turn slightly in clockwise direction using your fingers.

Mini-Wrench • Ø 6–7,999mm



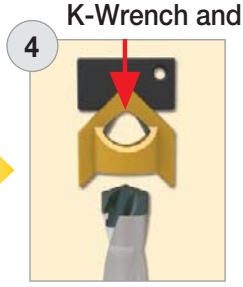


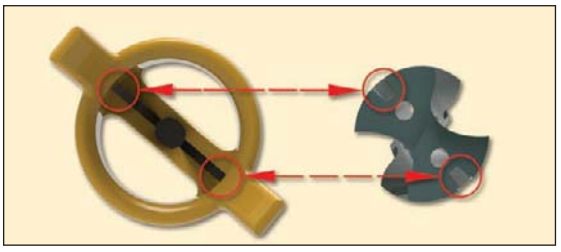
4. Set wrench properly onto insert: **Wrench noses must fit firmly into the chip grooves**.

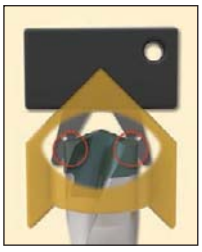


*For unmounting, firmly press wrench on insert to avoid slipping.

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

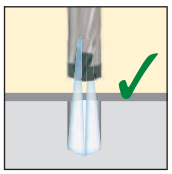
Wrench blades must fit into insert slots.



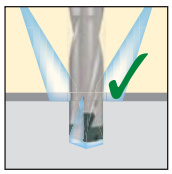
Multi-Wrench



Coolant



Internal coolant is recommended for all applications.



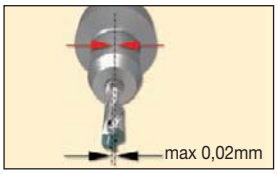
Flood coolant only for drilling depth ≤ 3 x D.



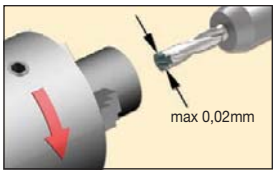
Dry cutting is not recommended. MQL ability is limited.

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.



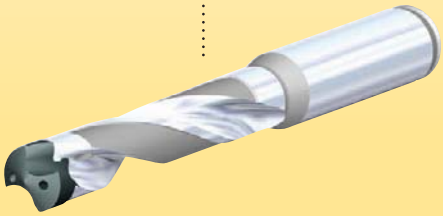
ERICKSON™ ER collet chucks



ERICKSON Hydrochuck HP Line

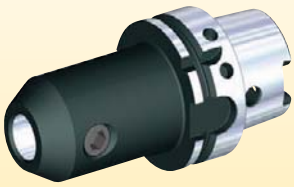


ERICKSON Shrink Fit toolholders for general purpose

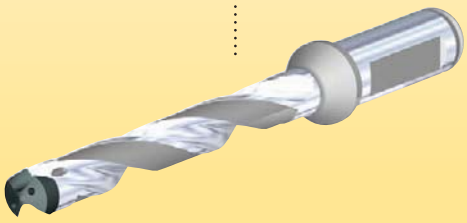


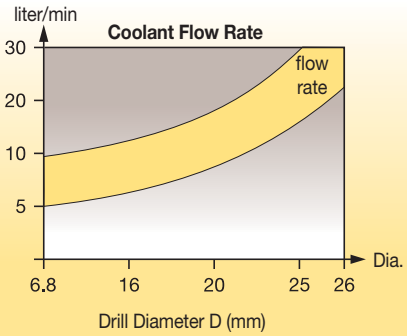
Rotating and Stationary Applications

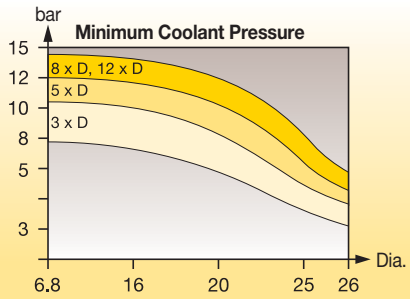
KenTIP FS holders with SCF shanks (Cylindrical with 90° flat and flange) are reducing deflections and represent a stiffer holder solution. As the shank is compatible with end mill adapters, these holders are very flexible in use. SCF shanks can be used in any rotating applications and are suited for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



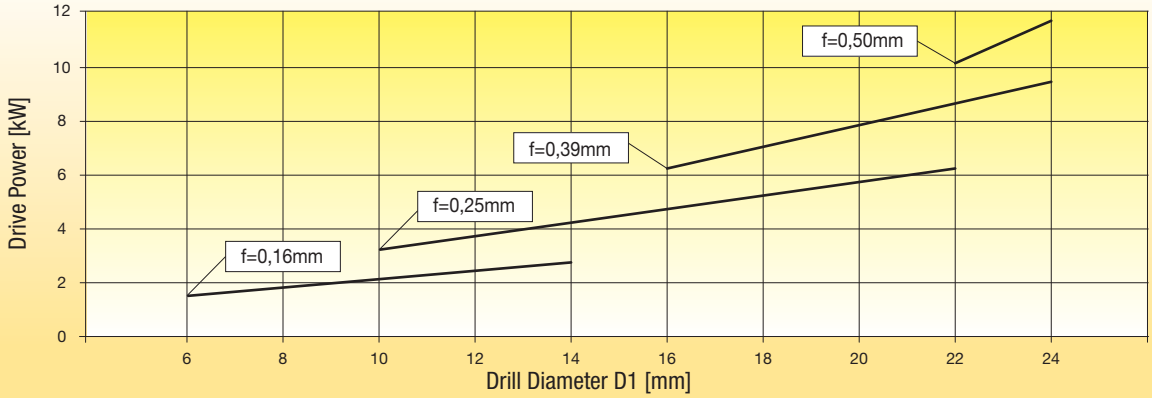
EM adapters



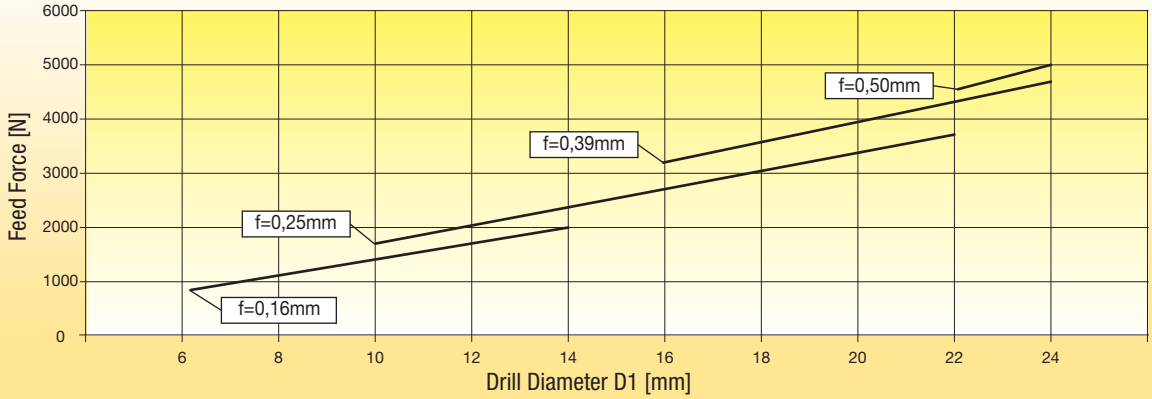




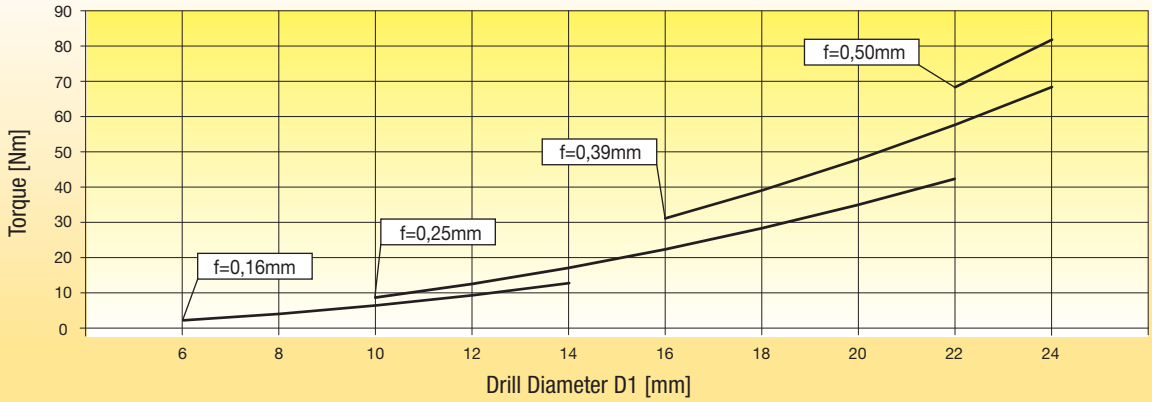
Drive Power (kW)



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.

NOVO KNOWS CAD/CAM

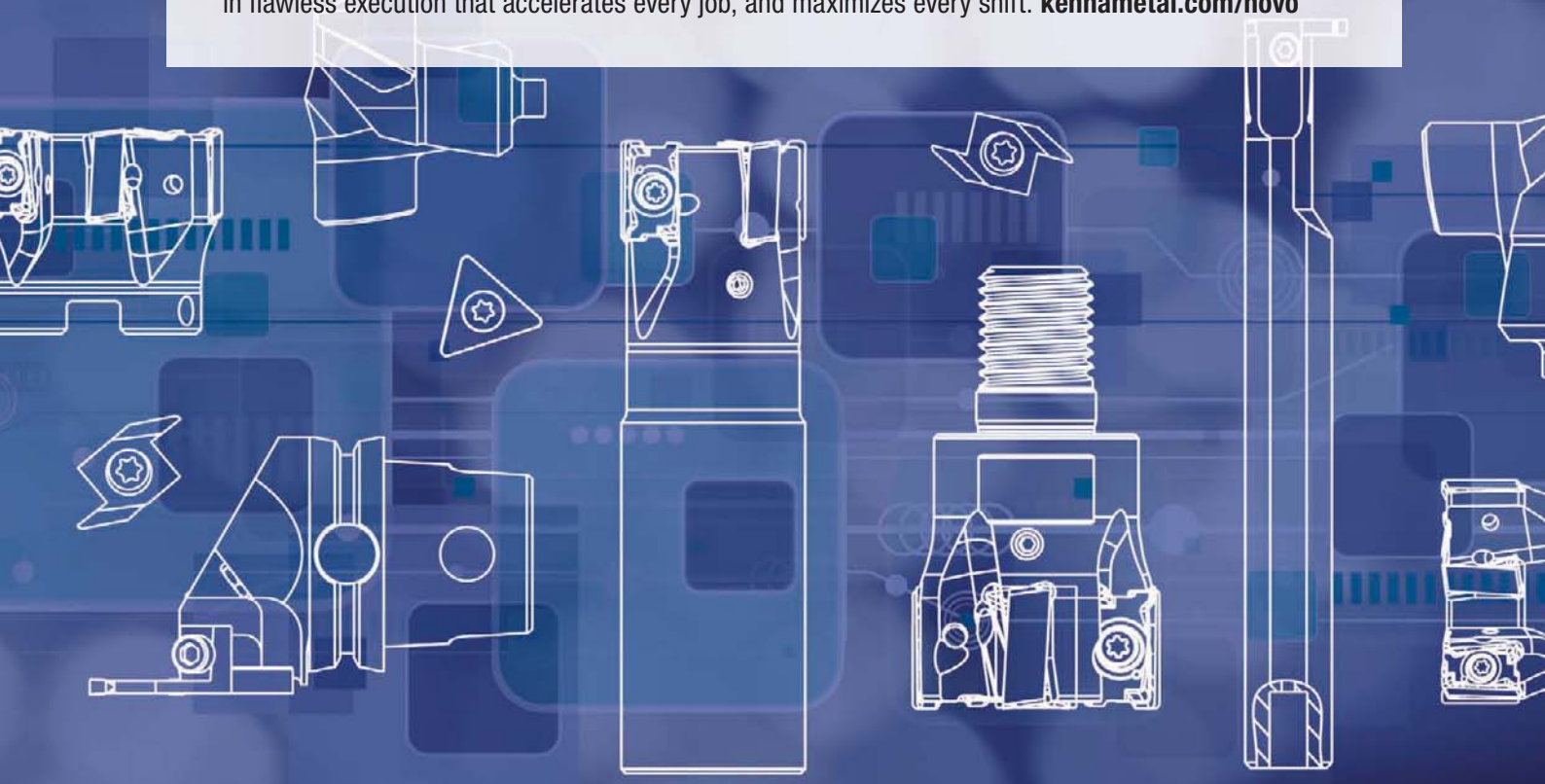
With the addition of NOVO™ applications to your team, your CAD/CAM capabilities become much more accurate, streamlined, and productive.

Before NOVO: The programmer would be in their CAD/CAM software, programming a part. Using the tedious method of finding a tool in a catalog, and then manually inputting the tooling information from the catalog 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 maximizes every shift. **kennametal.com/novo**



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 centering capabilities.

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.

Tailored Grades and Geometries

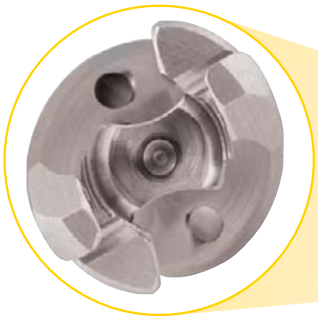
- KCP15™ grade has a new PVD coating enabling longer tool life in all steel applications.
- KCPM45™ grade combines a very tough, fine-grain carbide substrate with a TiAlN PVD coating. It is used on our FEG flat-bottom inserts.
- For applications in cast iron and stainless steel, we recommend to use our 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.

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.

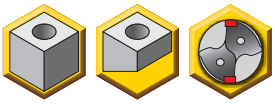
Customization

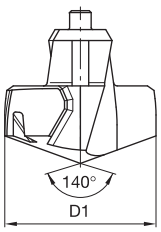
- Intermediate diameters available as semi-standards.
- Close tolerance tips available for precision holes.
- Chamfering insert pockets available.
- Multiple steps possible.
- CounterFix Micro tangential inserts for small diameter step drills.

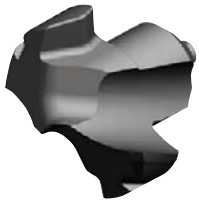
NEW!

CounterFix Micro Tangential Inserts

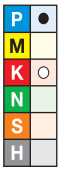
- KenTIP KCP15™ HP cutting edges enable high metal removal rates and superior tool life for steel applications.
- KenTIP HP geometry works with low cutting and feed forces and provides very good centering. Reinforced cutting edges and good chip forming improve tool life due to high wear and edge chipping 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.





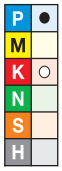

HP

KenTIP Inserts • HP KCP15



● first choice
○ alternate choice

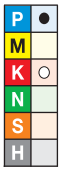
KCP15	D1 mm	D1 in	seat size
KTIP0794HPM	7,938	.3125	F
KTIP0800HPM	8,000	.3150	F
KTIP0810HPM	8,100	.3189	F
KTIP0816HPM	8,164	.3214	F
KTIP0820HPM	8,204	.3230	F
KTIP0830HPM	8,300	.3268	F
KTIP0833HPM	8,334	.3281	F
KTIP0840HPM	8,400	.3307	F
KTIP0843HPM	8,433	.3320	F
KTIP0850HPM	8,500	.3346	G
KTIP0860HPM	8,600	.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



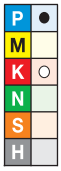
KCP15	D1 mm	D1 in	seat size
KTIP0983HPM	9,830	.3870	I
KTIP0990HPM	9,900	.3898	I
KTIP0992HPM	9,921	.3906	I
KTIP1000HPM	10,000	.3937	J
KTIP1002HPM	10,023	.3946	J
KTIP1008HPM	10,084	.3970	J
KTIP1010HPM	10,100	.3976	J
KTIP1020HPM	10,200	.4016	J
KTIP1026HPM	10,262	.4040	J
KTIP1030HPM	10,300	.4055	J
KTIP1032HPM	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

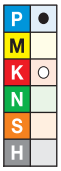


● first choice
○ alternate choice

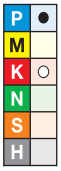
KCP15	D1 mm	D1 in	seat size
KTIP1588HPM	15,875	.6250	T
KTIP1600HPM	16,000	.6299	U
KTIP1603HPM	16,027	.6310	U
KTIP1608HPM	16,078	.6330	U
KTIP1610HPM	16,100	.6339	U
KTIP1620HPM	16,200	.6378	U
KTIP1627HPM	16,271	.6406	U
KTIP1630HPM	16,300	.6417	U
KTIP1640HPM	16,400	.6457	U
KTIP1650HPM	16,500	.6496	U
KTIP1660HPM	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)



KCP15	D1 mm	D1 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



● first choice
○ alternate choice

KCP15	D1 mm	D1 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

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

KenTIP HP Geometry

Tolerance

D1 inch	tolerance k8
.3125–.3906	.000/+.0009
>.3906–.6250	.000/+.0011
>.6692–.7090	.000/+.0010
>.7090–.8228	.000/+.0013

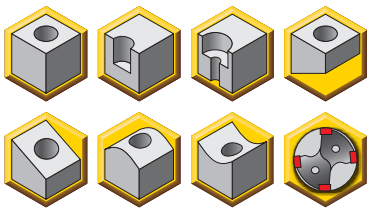
Modular Drill Carbide Insert Blades • KenTIP™ • HP Geometry • Grade KCP15™ • Through Coolant • Metric

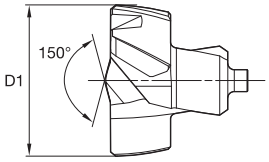
Material Group		Cutting Speed — vc Range — m/min			Metric								
					Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		8,0	10,0	12,0	14,0	16,0	20,0	24,0	28,0
P	1	90	**130**	180	mm/r	0,12–0,21	0,14–0,26	0,15–0,33	0,18–0,41	0,20–0,47	0,26–0,50	0,27–0,51	0,30–0,54
	2	110	**150**	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

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

Material Group		Cutting Speed — vc Range — SFM			Inch								
					Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		.315	.394	.472	.551	.630	.787	.945	1.102
P	1	295	**425**	590	IPR	.005–.008	.006–.010	.006–.013	.007–.016	.008–.019	.010–.020	.011–.020	.012–.021
	2	360	**490**	625	IPR	.005–.010	.006–.012	.006–.014	.007–.015	.008–.019	.010–.020	.011–.020	.012–.021
	3	165	**260**	360	IPR	.005–.011	.005–.015	.007–.015	.009–.019	.009–.019	.013–.021	.013–.021	.014–.022
	4	165	**260**	360	IPR	.005–.011	.005–.015	.007–.015	.007–.019	.007–.019	.009–.019	.014–.018	.011–.018
K	1	195	**330**	590	IPR	.006–.012	.007–.013	.007–.015	.009–.017	.010–.020	.013–.024	.014–.026	.016–.028
	2	195	**260**	295	IPR	.006–.012	.007–.013	.007–.014	.009–.017	.010–.020	.013–.024	.014–.026	.016–.028
	3	130	**230**	295	IPR	.007–.013	.007–.014	.007–.015	.008–.017	.009–.018	.009–.020	.010–.020	.016–.028

- KenTIP FEG flat-bottom inserts create 180° flat holes — only a small cavity remains in the center 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 centering 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

● first choice
○ alternate choice

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

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

KenTIP FEG Geometry Tolerance

D1 Inch	tolerance s7
.3125-.3906	.0009/+.0015
>.3906-.7090	.0011/+.0018
>.7090-.8228	.0014/+.0022

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

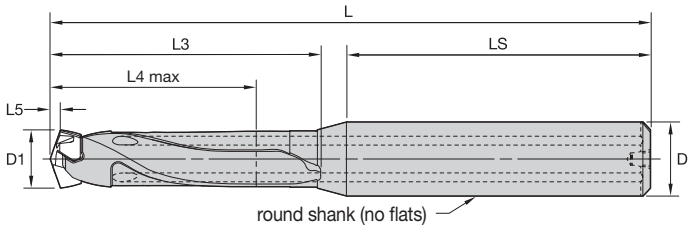
Material Group		Cutting Speed — vc Range — m/min			Metric								
					Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		8,0	10,0	12,0	14,0	16,0	20,0	24,0	28,0
P	1	110	**140**	170	mm/r	0,14–0,23	0,14–0,23	0,14–0,23	0,14–0,23	0,17–0,25	0,19–0,29	0,23–0,38	0,23–0,38
	2	100	**120**	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

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

Material Group		Cutting Speed — vc Range — SFM			Inch								
					Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		0.315	0.394	0.472	0.551	0.630	0.787	0.945	1.102
P	1	360	**460**	560	IPR	.006–.009	.006–.009	.006–.009	.006–.009	.007–.010	.007–.011	.009–.015	.009–.015
	2	330	**390**	460	IPR	.007–.009	.007–.009	.007–.009	.007–.009	.007–.010	.009–.011	.011–.015	.011–.015
	3	260	**330**	390	IPR	.006–.008	.006–.008	.006–.008	.006–.008	.006–.009	.007–.010	.009–.013	.009–.013
	4	230	**300**	360	IPR	.004–.008	.004–.008	.004–.008	.004–.008	.005–.009	.006–.010	.007–.013	.007–.013
M	1	130	**200**	260	IPR	.004–.006	.004–.006	.004–.006	.004–.006	.004–.007	.005–.008	.006–.010	.006–.010
	2	110	**180**	230	IPR	.004–.006	.004–.006	.004–.006	.004–.006	.004–.007	.005–.008	.006–.010	.006–.010
K	1	300	**440**	570	IPR	.007–.009	.007–.009	.007–.009	.007–.009	.008–.011	.009–.012	.011–.015	.011–.015
	2	260	**390**	460	IPR	.007–.009	.007–.009	.007–.009	.007–.009	.008–.011	.009–.012	.011–.015	.011–.015
	3	230	**360**	410	IPR	.006–.009	.006–.009	.006–.009	.006–.009	.007–.010	.008–.011	.009–.015	.009–.015

- Tool body shipped with insert wrench.





For information on L, L3, and L4 max, see the Modular Drills Dimension Tables on page H44.

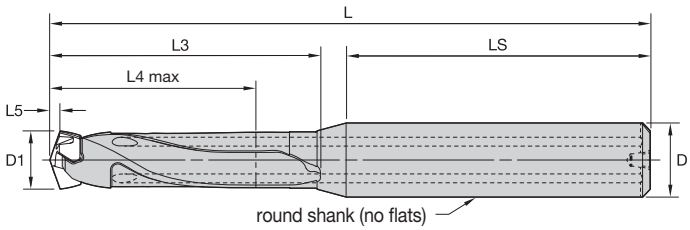


KenTIP Round Shank • 1.5 x D/3 x D/5 x D/8 x D/12 x D • Metric

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.







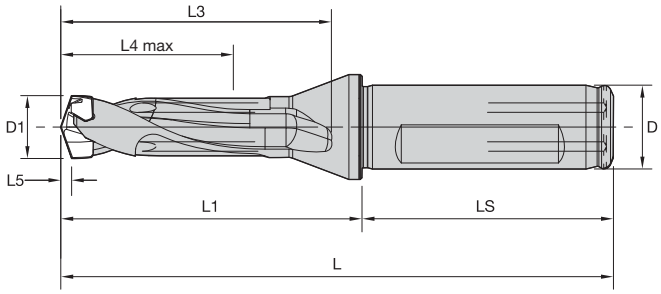
For information on L, L3, and L4 max, see the Modular Drills Dimension Tables on page H45.

KenTIP Round Shank • 3 x D/5 x D/8 x D/12 x D • Inch

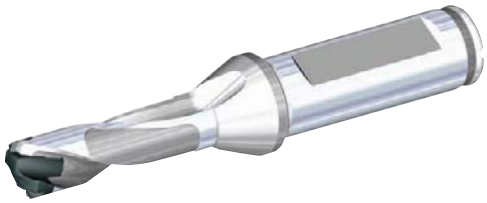
3 x D	5 x D	8 x D	12 x D	D1 mm	D1 in	D1 max mm	D1 max in	seat size	KenTIP wrench
KTIP0313R3SS038	KTIP0313R5SS038	KTIP0313R8SS038	KTIP0313R12SS038	7,940	.3125	8,499	.3346	F	170.306
KTIP0335R3SS038	KTIP0335R5SS038	KTIP0335R8SS038	KTIP0335R12SS038	8,500	.3346	8,999	.3543	G	170.306
KTIP0354R3SS038	KTIP0354R5SS038	KTIP0354R8SS038	KTIP0354R12SS038	9,000	.3543	9,499	.3740	H	170.306
KTIP0374R3SS038	KTIP0374R5SS038	KTIP0374R8SS038	KTIP0374R12SS038	9,500	.3740	9,999	.3937	I	170.306
KTIP0374R3SS044	KTIP0374R5SS044	KTIP0374R8SS044	KTIP0374R12SS044	9,500	.3740	9,999	.3937	I	170.306
KTIP0394R3SS044	KTIP0394R5SS044	KTIP0394R8SS044	KTIP0394R12SS044	10,000	.3937	10,499	.4133	J	170.307
KTIP0413R3SS044	KTIP0413R5SS044	KTIP0413R8SS044	KTIP0413R12SS044	10,500	.4134	10,999	.4330	K	170.307
KTIP0433R3SS044	KTIP0433R5SS044	KTIP0433R8SS044	KTIP0433R12SS044	11,000	.4331	11,499	.4527	L	170.307
KTIP0453R3SS050	KTIP0453R5SS050	KTIP0453R8SS050	KTIP0453R12SS050	11,500	.4528	11,999	.4724	M	170.307
KTIP0472R3SS050	KTIP0472R5SS050	KTIP0472R8SS050	KTIP0472R12SS050	12,000	.4724	12,499	.4921	N	170.308
KTIP0492R3SS050	KTIP0492R5SS050	KTIP0492R8SS050	KTIP0492R12SS050	12,500	.4921	12,999	.5118	O	170.308
KTIP0492R3SS056	KTIP0492R5SS056	KTIP0492R8SS056	KTIP0492R12SS056	12,500	.4921	12,999	.5118	O	170.308
KTIP0512R3SS056	KTIP0512R5SS056	KTIP0512R8SS056	KTIP0512R12SS056	13,000	.5118	13,499	.5315	P	170.308
KTIP0532R3SS056	KTIP0532R5SS056	KTIP0532R8SS056	KTIP0532R12SS056	13,500	.5315	13,999	.5511	Q	170.308
KTIP0551R3SS056	KTIP0551R5SS056	KTIP0551R8SS056	KTIP0551R12SS056	14,000	.5512	14,499	.5708	R	170.309
KTIP0571R3SS063	KTIP0571R5SS063	KTIP0571R8SS063	KTIP0571R12SS063	14,500	.5709	14,999	.5905	S	170.309
KTIP0591R3SS063	KTIP0591R5SS063	KTIP0591R8SS063	KTIP0591R12SS063	15,000	.5906	15,999	.6299	T	170.309
KTIP0630R3SS069	KTIP0630R5SS069	KTIP0630R8SS069	KTIP0630R12SS069	16,000	.6299	16,999	.6693	U	170.309
KTIP0669R3SS069	KTIP0669R5SS069	KTIP0669R8SS069	KTIP0669R12SS069	17,000	.6693	17,999	.7086	V	170.314
KTIP0709R3SS075	KTIP0709R5SS075	KTIP0709R8SS075	KTIP0709R12SS075	18,000	.7087	18,999	.7480	W	170.314
KTIP0748R3SS075	KTIP0748R5SS075	KTIP0748R8SS075	KTIP0748R12SS075	19,000	.7480	19,999	.7874	X	170.314
KTIP0787R3SS081	KTIP0787R5SS081	KTIP0787R8SS081	KTIP0787R12SS081	20,000	.7874	20,999	.8267	Y	170.314
KTIP0827R3SS088	KTIP0827R5SS088	KTIP0827R8SS088	KTIP0827R12SS088	21,000	.8268	21,999	.8661	Z	170.314
KTIP0866R3SS088	KTIP0866R5SS088	KTIP0866R8SS088	KTIP0866R12SS088	22,000	.8661	22,999	.9055	ZA	170.314
KTIP0906R3SS094	KTIP0906R5SS094	KTIP0906R8SS094	KTIP0906R12SS094	23,000	.9055	23,999	.9448	ZB	170.314
KTIP0945R3SS100	KTIP0945R5SS100	KTIP0945R8SS100	KTIP0945R12SS100	24,000	.9449	24,999	.9842	ZC	170.314
KTIP0984R3SS100	KTIP0984R5SS100	KTIP0984R8SS100	KTIP0984R12SS100	25,000	.9843	25,999	1.0236	ZD	170.314
KTIP1024R3SS125	KTIP1024R5SS125	KTIP1024R8SS125	KTIP1024R12SS125	26,000	1.0236	26,999	1.0630	ZE	170.314
KTIP1063R3SS125	KTIP1063R5SS125	KTIP1063R8SS125	KTIP1063R12SS125	27,000	1.0630	27,999	1.1023	ZE	170.314

- Tool body shipped with insert wrench.





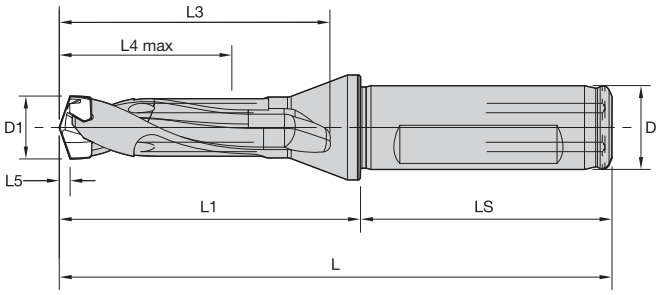
round shank (no flats)
For information on L, L3, and L4 max, see the Modular Drills Dimension Tables on page H46.



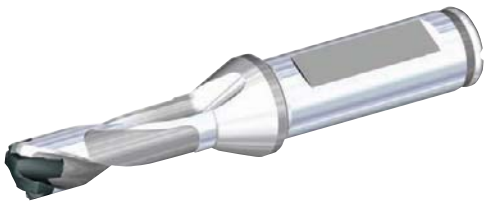
KenTIP Flanged Shank • 1.5 x D/3 x D/5 x D/8 x D • Metric

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

- 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 H47.



KenTIP Flanged Shank • 3 x D/5 x D/8 x D • Inch

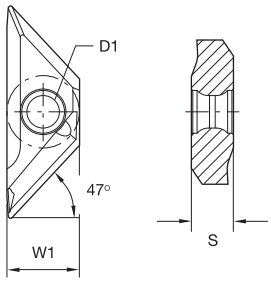
3 x D	5 x D	8 x D	D1 mm	D1 in	D1 max mm	D1 max in	seat size	KenTIP wrench
KTIP0313R3SCF050	KTIP0313R5SCF050	KTIP0313R8SCF050	7,940	.3125	8,499	.3346	F	170.306
KTIP0335R3SCF050	KTIP0335R5SCF050	KTIP0335R8SCF050	8,500	.3346	8,999	.3543	G	170.306
KTIP0354R3SCF050	KTIP0354R5SCF050	KTIP0354R8SCF050	9,000	.3543	9,499	.3740	H	170.306
KTIP0374R3SCF050	KTIP0374R5SCF050	KTIP0374R8SCF050	9,500	.3740	9,999	.3937	I	170.306
KTIP0394R3SCF063	KTIP0394R5SCF063	KTIP0394R8SCF063	10,000	.3937	10,499	.4133	J	170.307
KTIP0413R3SCF063	KTIP0413R5SCF063	KTIP0413R8SCF063	10,500	.4134	10,999	.4330	K	170.307
KTIP0433R3SCF063	KTIP0433R5SCF063	KTIP0433R8SCF063	11,000	.4331	11,499	.4527	L	170.307
KTIP0453R3SCF063	KTIP0453R5SCF063	KTIP0453R8SCF063	11,500	.4528	11,999	.4724	M	170.307
KTIP0472R3SCF063	KTIP0472R5SCF063	KTIP0472R8SCF063	12,000	.4724	12,499	.4921	N	170.308
KTIP0492R3SCF063	KTIP0492R5SCF063	KTIP0492R8SCF063	12,500	.4921	12,999	.5118	O	170.308
KTIP0512R3SCF063	KTIP0512R5SCF063	KTIP0512R8SCF063	13,000	.5118	13,499	.5315	P	170.308
KTIP0532R3SCF063	KTIP0532R5SCF063	KTIP0532R8SCF063	13,500	.5315	13,999	.5511	Q	170.308
KTIP0551R3SCF063	KTIP0551R5SCF063	KTIP0551R8SCF063	14,000	.5512	14,499	.5708	R	170.309
KTIP0571R3SCF063	KTIP0571R5SCF063	KTIP0571R8SCF063	14,500	.5709	14,999	.5905	S	170.309
KTIP0591R3SCF075	KTIP0591R5SCF075	KTIP0591R8SCF075	15,000	.5906	15,999	.6299	T	170.309
KTIP0630R3SCF075	KTIP0630R5SCF075	KTIP0630R8SCF075	16,000	.6299	16,999	.6693	U	170.309
KTIP0669R3SCF075	KTIP0669R5SCF075	KTIP0669R8SCF075	17,000	.6693	17,999	.7086	V	170.314
KTIP0709R3SCF075	KTIP0709R5SCF075	KTIP0709R8SCF075	18,000	.7087	18,999	.7480	W	170.314
KTIP0748R3SCF075	KTIP0748R5SCF075	KTIP0748R8SCF075	19,000	.7480	19,999	.7874	X	170.314
KTIP0787R3SCF100	KTIP0787R5SCF100	KTIP0787R8SCF100	20,000	.7874	20,999	.8267	Y	170.314
KTIP0827R3SCF100	KTIP0827R5SCF100	KTIP0827R8SCF100	21,000	.8268	21,999	.8661	Z	170.314
KTIP0866R3SCF100	KTIP0866R5SCF100	KTIP0866R8SCF100	22,000	.8661	22,999	.9055	ZA	170.314
KTIP0906R3SCF100	KTIP0906R5SCF100	KTIP0906R8SCF100	23,000	.9055	23,999	.9448	ZB	170.314
KTIP0945R3SCF100	KTIP0945R5SCF100	KTIP0945R8SCF100	24,000	.9449	24,999	.9842	ZC	170.314
KTIP0984R3SCF100	KTIP0984R5SCF100	KTIP0984R8SCF100	25,000	.9843	25,999	1.0236	ZD	170.314
KTIP1024R3SCF100	KTIP1024R5SCF100	KTIP1024R8SCF100	26,000	1.0236	26,999	1.0630	ZE	170.314
KTIP1063R3SCF100	KTIP1063R5SCF100	KTIP1063R8SCF100	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

		KC7215	KC7015
P		○	●
M		○	○
K		○	●
N		●	○
S		○	●
H			





FAS-GD • Chamfering Insert

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



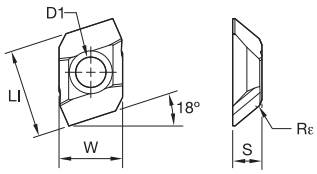
Made-to-order KenTIP holders with chamfering step using standard FAS inserts. Also available for KenTIP FS upon request.

- 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

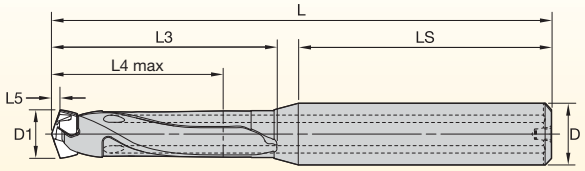
	D1		LI		W		S		Rε		KCU40
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	
CFM0402R00RHP	2,05	0.081	6,000	0.24	4,25	.167	1,98	.078	0,20	.007	●
CFM0402R30RHP	2,05	0.081	6,000	0.24	4,25	.167	1,98	.078	0,20	.009	●
CFM0402R45RHP	2,05	0.081	6,000	0.24	4,25	.167	1,98	.078	0,20	.007	●



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



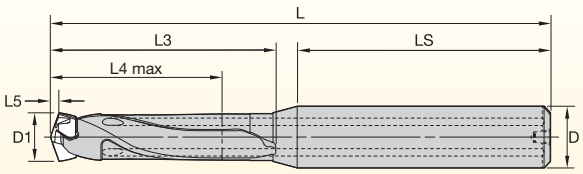


D1 mm	D1 max	seat	L5	LS	round D	1.5 x D L	1.5 x D L3	1.5 x D L4 max	3 x D L	3 x D L3	3 x D L4 max	5 x D L	5 x D L3	5 x D L4 max	8 x D L	8 x D L3	8 x D L4 max	12 x D L	12 x D L3	12 x D L4 max	wrench
8,000	8,499	F	1,4	41	10	67	23	13	79	35	26	97	53	43	123	79	68	157	113	102	**170.306**
8,500	8,999	G	1,5	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 • Round Shank • Inch



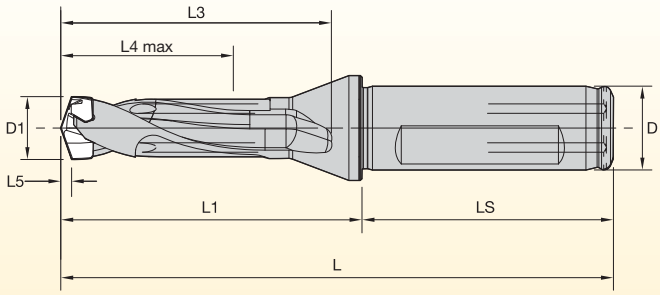


D1 mm	D1 max	seat	L5	LS	round D	3 x D L	3 x D L3	3 x D L4 max	5 x D L	5 x D L3	5 x D L4 max	8 x D L	8 x D L3	8 x D L4 max	12 x D L	12 x D L3	12 x D L4 max	wrench
.3125	.3346	F	.055	1.59	.3750	3.13	1.29	1.00	3.88	2.05	1.67	4.88	3.17	2.67	6.25	4.54	4.02	**170.306**
.3346	.3543	G	.059	1.59	.3750	3.25	1.38	1.06	4.00	2.16	1.77	5.13	3.42	2.83	6.50	4.79	4.25	**170.306**
.3543	.3740	H	.063	1.59	.3750	3.38	1.46	1.12	4.13	2.28	1.87	5.25	3.54	2.99	6.75	5.04	4.49	**170.306**
.3740	.3937	I	.063	1.59	.3750	3.38	1.54	1.18	4.25	2.44	1.97	5.38	3.67	3.15	7.13	5.34	4.72	**170.306**
.3740	.3937	I	.063	1.67	.4375	3.38	1.54	1.18	4.38	2.44	1.97	5.38	3.59	3.15	7.00	5.29	4.72	**170.306**
.3937	.4133	J	.067	1.67	.4375	3.63	1.63	1.24	4.63	2.55	2.07	5.75	3.96	3.30	7.37	5.59	4.96	**170.307**
.4134	.4330	K	.071	1.67	.4375	3.75	1.71	1.30	4.75	2.67	2.16	6.00	4.21	3.46	7.63	5.84	5.20	**170.307**
.4331	.4527	L	.075	1.67	.4375	3.88	1.79	1.36	4.88	2.78	2.26	6.25	4.46	3.62	7.87	6.09	5.43	**170.307**
.4528	.4724	M	.079	1.79	.5000	3.88	1.87	1.42	5.00	2.90	2.36	6.50	4.59	3.78	8.25	6.34	5.67	**170.307**
.4724	.4921	N	.083	1.79	.5000	4.00	1.95	1.48	5.00	3.01	2.46	6.75	4.84	3.94	8.50	6.59	5.91	**170.308**
.4921	.5118	O	.087	1.79	.5000	4.13	2.04	1.54	5.13	3.13	2.56	7.00	5.09	4.09	8.75	6.84	6.14	**170.308**
.4921	.5118	O	.087	1.79	.5625	4.13	2.04	1.54	5.13	3.13	2.56	7.00	5.09	4.09	8.75	6.84	6.14	**170.308**
.5118	.5315	P	.087	1.79	.5625	4.25	2.11	1.60	5.25	3.24	2.66	7.13	5.22	4.25	9.00	7.09	6.38	**170.308**
.5315	.5511	Q	.091	1.79	.5625	4.25	2.19	1.65	5.50	3.39	2.75	7.25	5.34	4.41	9.25	7.34	6.61	**170.308**
.5512	.5708	R	.095	1.79	.5625	4.50	2.27	1.71	5.75	3.50	2.85	7.38	5.47	4.57	9.50	7.59	6.85	**170.309**
.5709	.5905	S	.098	1.91	.6250	4.50	2.34	1.77	5.75	3.61	2.95	7.50	5.47	4.72	9.87	7.85	7.09	**170.309**
.5906	.6299	T	.102	1.91	.6250	4.75	2.43	1.89	6.00	3.76	3.15	7.75	5.72	5.04	1.37	8.35	7.56	**170.309**
.6299	.6693	U	.110	1.91	.6875	4.88	2.59	2.01	6.25	4.06	3.34	8.00	5.97	5.35	11.00	8.97	8.03	**170.309**
.6693	.7086	V	.116	1.91	.6875	5.00	2.99	2.24	6.50	4.47	3.66	8.75	6.72	5.79	11.50	9.47	8.50	**170.314**
.7087	.7480	W	.122	2.00	.7500	5.25	3.13	2.25	6.88	4.76	3.86	9.25	7.13	6.11	12.13	1.01	8.98	**170.314**
.7480	.7874	X	.129	2.00	.7500	5.50	3.38	2.49	7.13	5.01	4.07	9.63	7.51	6.43	12.63	1.51	9.45	**170.314**
.7874	.8267	Y	.136	2.00	.8125	5.75	3.63	2.62	7.50	5.38	4.27	1.00	7.88	6.75	13.13	11.01	9.92	**170.314**
.8268	.8661	Z	.142	2.07	.8750	5.88	3.69	2.60	7.63	5.44	4.33	1.25	8.06	6.93	13.75	11.56	1.39	**170.314**
.8661	.9055	ZA	.150	2.07	.8750	6.00	3.81	2.72	7.88	5.69	4.53	1.63	8.44	7.24	14.25	12.06	1.87	**170.314**
.9055	.9448	ZB	.158	2.15	.9375	6.25	3.98	2.83	8.25	5.98	4.72	11.13	8.86	7.56	14.87	12.61	11.34	**170.314**
.9449	.9842	ZC	.161	3.00	1.0000	7.25	4.13	2.95	9.38	6.26	4.92	12.25	9.13	7.87	16.25	13.13	11.81	**170.314**
.9843	1.0236	ZD	.169	3.00	1.0000	7.38	4.26	3.07	9.63	6.51	5.12	12.63	9.51	8.19	16.75	13.63	12.28	**170.314**
1.0236	1.0630	ZE	.176	3.25	1.2500	7.86	4.49	3.19	9.99	6.62	5.32	13.25	9.88	8.50	17.50	14.13	12.76	**170.314**
1.0630	1.1023	ZE	.185	3.25	1.2500	7.98	4.61	3.31	1.18	6.81	5.51	13.57	1.20	8.82	18.00	14.63	13.23	**170.314**

(continued)

Modular Drills • Dimension Tables *(continued)*

Dimensions for KenTIP™ Modular Drills • Flanged Shank • Metric



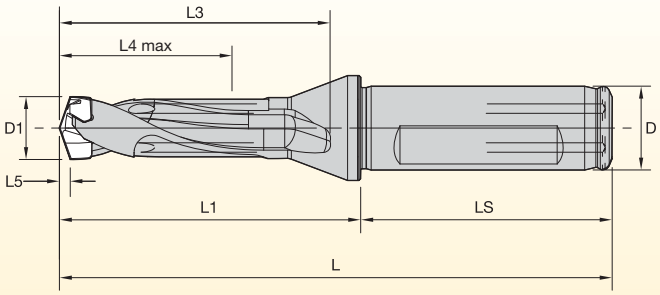


D1 mm	D1 max	seat	L5	LS	Flanged D	1.5 x D L	L3	L4 max	3 x D L	L3	L4 max	5 x D L	L3	L4 max	8 x D L	L3	L4 max	wrench
8,000	8,490	F	1,4	45	12	73	23	13	86	35	26	104	53	43	129	79	68	**170.306**
8,500	8,990	G	1,5	45	12	74	24	14	88	37	27	107	56	45	134	83	72	**170.306**
9,000	9,490	H	1,6	45	12	76	25	14	90	39	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**

(continued)

Modular Drills • Dimension Tables *(continued)*

Dimensions for KenTIP™ Modular Drills • Flanged Shank • Inch





D1 mm	D1 max	seat	L5	LS	Flanged D	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	wrench
.3125	.3343	F	.054	1.77	.5000	3.40	1.41	1.00	4.15	2.16	1.67	5.15	3.16	2.28	**170.306**
.3390	.3539	G	.059	1.77	.5000	3.52	1.53	1.06	4.27	2.28	1.77	5.27	3.28	2.83	**170.306**
.3580	.3736	H	.062	1.77	.5000	3.65	1.66	1.12	4.40	2.41	1.87	5.52	3.53	2.99	**170.306**
.3750	.3933	I	.065	1.77	.5000	3.65	1.66	1.18	4.52	2.53	1.97	5.77	3.78	3.15	**170.306**
.3946	.4130	J	.068	1.89	.6250	3.89	1.78	1.24	4.76	2.66	2.07	6.01	3.91	3.31	**170.307**
.4219	.4327	K	.073	1.89	.6250	3.89	1.78	1.30	4.89	2.78	2.17	6.14	4.03	3.46	**170.307**
.4375	.4524	L	.076	1.89	.6250	4.01	1.91	1.36	5.01	2.91	2.26	6.39	4.28	3.62	**170.307**
.4531	.4720	M	.078	1.89	.6250	4.14	2.03	1.42	5.14	3.03	2.36	6.51	4.41	3.78	**170.307**
.4844	.4917	N	.084	1.89	.6250	4.26	2.16	1.48	5.26	3.16	2.46	6.76	4.66	3.94	**170.308**
.5000	.5114	O	.086	1.89	.6250	4.26	2.16	1.54	5.39	3.28	2.56	6.89	4.78	4.09	**170.308**
.5156	.5311	P	.089	1.89	.6250	4.39	2.28	1.59	5.51	3.41	2.66	7.01	4.91	4.25	**170.308**
.5469	.5508	Q	.095	1.89	.6250	4.39	2.28	1.65	5.64	3.53	2.76	7.26	5.16	4.41	**170.308**
.5625	.5705	R	.097	1.89	.6250	4.51	2.41	1.71	5.76	3.66	2.85	7.51	5.41	4.57	**170.309**
.5774	.5902	S	.100	1.89	.6250	4.64	2.53	1.77	5.89	3.78	2.95	7.64	5.53	4.72	**170.309**
.5938	.6295	T	.102	1.97	.7500	4.84	2.66	1.89	6.22	4.03	3.15	8.09	5.91	5.04	**170.309**
.6310	.6689	U	.109	1.97	.7500	4.97	2.78	2.01	6.47	4.28	3.35	8.47	6.28	5.35	**170.309**
.6719	.7083	V	.116	1.97	.7500	5.22	3.03	2.13	6.72	4.53	3.54	8.84	6.66	5.67	**170.314**
.7188	.7476	W	.124	1.97	.7500	5.34	3.16	2.24	6.97	4.78	3.74	9.22	7.03	5.98	**170.314**
.7500	.7870	X	.129	1.97	.7500	5.47	3.28	2.36	7.22	5.03	3.94	9.47	7.28	6.30	**170.314**
.7969	.8264	Y	.137	2.20	1.0000	5.95	3.53	2.48	7.58	5.16	4.13	10.08	7.66	6.61	**170.314**
.8440	.8657	Z	.146	2.20	1.0000	6.08	3.66	2.60	7.95	5.53	4.33	10.45	8.03	6.93	**170.314**
.8750	.9051	ZA	.151	2.20	1.0000	6.20	3.78	2.72	8.20	5.78	4.53	10.83	8.41	7.24	**170.314**
.9375	.9445	ZB	.162	2.20	1.0000	6.45	4.03	2.83	8.33	5.91	4.72	11.20	8.78	7.56	**170.314**
.9690	.9839	ZC	.167	2.20	1.0000	6.58	4.16	2.95	8.58	6.16	4.92	11.58	9.16	7.87	**170.314**
.9744	1.0232	ZD	.172	2.20	1.0000	6.70	4.28	3.07	8.95	6.53	5.12	11.95	9.53	8.19	**170.314**
1.0240	1.0620	ZE	.176	2.20	1.0000	6.83	4.41	3.19	9.08	6.66	5.32	11.70	9.28	8.50	**170.314**
1.0630	1.1020	ZE	.184	2.20	1.0000	6.95	4.53	3.30	9.20	6.78	5.51	11.95	9.53	8.69	**170.314**

Mounting the KenTIP Inserts



1) Fix drill holder on arbor. For insert exchange, fix arbor 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.

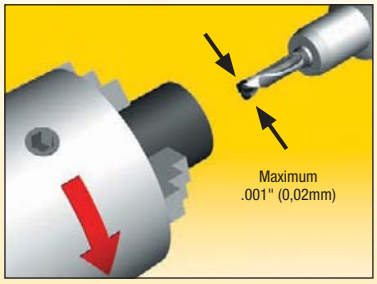
Only when using the 3 x D tool bodies



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

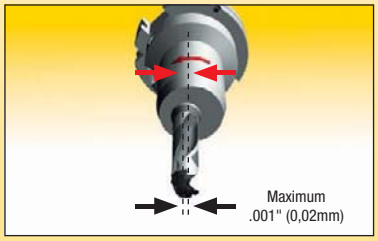
Usage Precautions
Core Deviation

1) For Turning Machines



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

2) For Machining Centers



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

A Natural Fit…

Tube Sheet Drilling with Kennametal



Our advanced drilling 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.

KSEM™ MODULAR DRILL SYSTEM

- Highly stable pocket seat holding replaceable carbide inserts for drill depth up to 10 x D and deeper*.
- Very high performance with the ability to create H10 fit holes in tube sheets in one pass.
- Application- and material-specific insert styles.
- All TEMA standard diameters in stock, with very high availability.



HPG P



HPL M



SPL M S

* Made-to-order holders easily available as made-to-order tools.

Find KSEM Modular Drills on pages H50–H97.

KGEM TUBE SHEET GROOVER

- Internal coolant for longer tool life and better chip formation.
- Covers TEMA standard sizes 19,25mm (.758") and above with circular interpolation.
- Productive solution for shallow or deep-hole applications on a wide range of machines.



Find KGEM Groovers on pages H98–H101.

Experience the advantages at your Authorized Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

kennametal.com

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 centering 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.

Customization

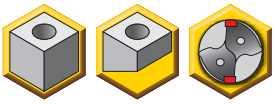
- Intermediate diameters available as semi-standards.
- Extensive step drill capabilities to support advanced applications and for one-shot counterboring and chamfering drills.
- Nearly all shank styles for toolholders available as semi-standards.
- Very high L x D ratios possible up to 25 x D and even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

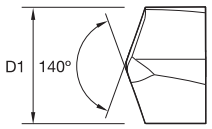
NEW!



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 H43.

- 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 center, 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

P ●
M
K ○
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S
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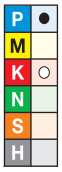
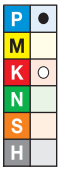
KC7315	D1 mm	D1 in	seat size
KSEM1786HPM	17,860	.7030	1
KSEM1800HPM	18,000	.7087	1
KSEM1826HPM	18,260	.7190	2
KSEM1850HPM	18,500	.7283	2
KSEM1865HPM	18,650	.7340	2
KSEM1900HPM	19,000	.7480	2
KSEM1905HPM	19,050	.7500	2
KSEM1923HPM	19,228	.7570	2
KSEM1927HPM	19,270	.7590	2
KSEM1945HPM	19,450	.7660	2
KSEM1950HPM	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

Tolerance HP • Inch

D1 inch	tolerance h8
.500–.709	+.000/-.0010
>.709–1.181	+.000/-.0013
>1.181–1.575	+.000/-.0015

Application Data

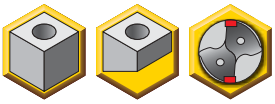
Modular Drill Carbide Insert Blades • KSEM • HP Geometry • Grade KC7315 • Through Coolant • Metric

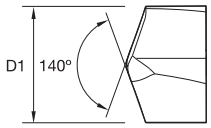
Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max		Metric Recommended Feed Rate (f) by Diameter 12,5	16,0	20,0	25,4	32,0	40,0
P	1	70	**90**	110	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
	2	80	**100**	120	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60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

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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max		Inch Recommended Feed Rate (f) by Diameter 0.462	0.630	0.787	1.000	1.260	1.575
P	1	230	**300**	360	IPR	.006–.012	.007–.014	.007–.016	.010–.021	.011–.024	.013–.027
	2	260	**330**	390	IPR	.006–.012	.007–.014	.007–.016	.010–.021	.014–.024	.016–.027
	3	210	**250**	260	IPR	.006–.011	.007–.012	.007–.014	.010–.018	.009–.021	.013–.024
	4	150	**160**	210	IPR	.005–.011	.006–.012	.006–.014	.008–.018	.009–.021	.012–.024
	5	150	**160**	210	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.013
	6	150	**160**	210	IPR	.005–.009	.006–.010	.006–.011	.008–.015	.009–.017	.010–.021

- 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 centering. 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.

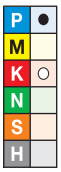




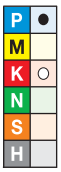


HPG

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

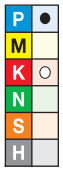


● first choice
○ alternate choice

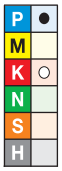
KC7315	D1 mm	D1 in	seat size
KSEM1627HPGM	16,270	.6410	1
KSEM1650HPGM	16,500	.6496	1
KSEM1660HPGM	16,600	.6535	1
KSEM1667HPGM	16,670	.6560	1
KSEM1700HPGM	17,000	.6693	1
KSEM1707HPGM	17,070	.6720	1
KSEM1735HPGM	17,350	.6831	1
KSEM1746HPGM	17,460	.6875	1
KSEM1750HPGM	17,500	.6890	1
KSEM1760HPGM	17,600	.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

Tolerance HPG • Inch

D1 inch	tolerance h8
.500–.709	+.000/-.0010
>.709–1.181	+.000/-.0013
>1.181–1.575	+.000/-.0015

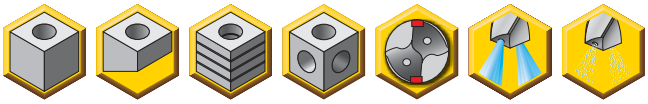
Modular Drill Carbide Insert Blades • KSEM™ • HPG Geometry • Grade KC7315™ • Through Coolant • Metric

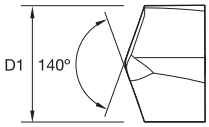
Material Group		Cutting Speed — vc Range — m/min			Metric						
					Recommended Feed Rate (f) by Diameter						
		min	Starting Value	max		12,5	16,0	20,0	25,4	32,0	40,0
P	1	75	**110**	140	mm/r	0,15–0,34	0,17–0,40	0,19–0,45	0,25–0,58	0,29–0,66	0,33–0,76
	2	90	**120**	150	mm/r	0,15–0,34	0,17–0,40	0,19–0,45	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

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

Material Group		Cutting Speed — vc Range — SFM			Inch						
					Recommended Feed Rate (f) by Diameter						
		min	Starting Value	max		0.462	0.630	0.787	1.000	1.260	1.575
P	1	250	**360**	460	IPR	.006–.013	.007–.016	.007–.018	.010–.023	.011–.026	.013–.030
	2	300	**390**	490	IPR	.006–.013	.007–.016	.007–.018	.010–.023	.011–.026	.013–.030
	3	160	**250**	330	IPR	.006–.011	.007–.013	.007–.016	.010–.020	.011–.023	.013–.026
	4	160	**210**	260	IPR	.005–.012	.006–.011	.006–.016	.008–.020	.009–.023	.010–.026
	5	160	**210**	260	IPR	.004–.007	.004–.008	.005–.009	.006–.011	.007–.013	.008–.014
	6	160	**210**	260	IPR	.005–.010	.006–.011	.006–.013	.008–.017	.009–.019	.010–.021
K	1	300	**440**	570	IPR	.007–.014	.008–.017	.010–.019	.012–.023	.015–.028	.017–.032
	2	300	**360**	410	IPR	.007–.013	.008–.016	.010–.019	.012–.023	.015–.028	.017–.032
	3	130	**310**	410	IPR	.007–.014	.008–.016	.008–.017	.009–.019	.010–.021	.011–.022

- 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 centering. 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)

P ● M ○ K N S H	D1		seat size
KCPM45	mm	in	
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

● first choice
○ alternate choice

P ● M ○ K N S H	D1		seat size
KCPM45	mm	in	
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

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

Tolerance HPG • Inch

D1 inch	tolerance h8
.500–.709	+.000/-.0010
>.709–1.181	+.000/-.0013
>1.181–1.575	+.000/-.0015

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.

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

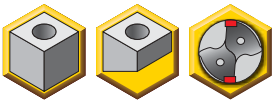
Material Group		Cutting Speed — vc Range — SFM			Inch						
					Recommended Feed Rate (f) by Diameter						
		min	Starting Value	max		.462	.630	.787	1.000	1.260	1.575
P	1	330	**360**	390	IPR	.006–.012	.007–.014	.007–.016	.010–.021	.011–.024	.013–.027
	2	260	**310**	360	IPR	.006–.012	.007–.014	.007–.016	.010–.021	.011–.024	.013–.027
	3	210	**230**	260	IPR	.006–.012	.007–.014	.007–.016	.010–.021	.011–.024	.013–.027
M	1	100	**200**	300	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	2	100	**160**	300	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	3	70	**130**	200	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012

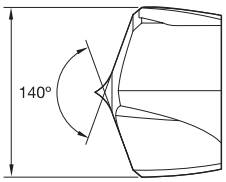
Modular Drill Carbide Insert Blades • KSEM • HPG Geometry • Grade KCPM45 • MQL* • Inch

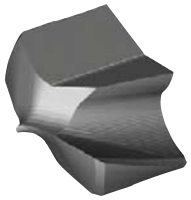
Material Group		Cutting Speed — vc Range — SFM			Inch						
					Recommended Feed Rate (f) by Diameter						
		min	Starting Value	max		.462	.630	.787	1.000	1.260	1.575
P	1	200	**230**	260	IPR	.006–.012	.007–.014	.007–.016	.010–.021	.011–.024	.013–.027
	2	160	**200**	230	IPR	.006–.012	.007–.014	.007–.016	.010–.021	.011–.024	.013–.027
	3	210	**150**	260	IPR	.006–.012	.007–.014	.007–.016	.010–.021	.011–.024	.013–.027
M	1	100	**130**	160	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	2	80	**100**	110	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	3	70	**80**	100	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012

*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 center, 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

Tolerance HPCCL • Inch

D1	tolerance h8
.500–.709	+.000/-.0010
>.709–1.181	+.000/-.0013
>1.181–1.575	+.000/-.0015

Application Data

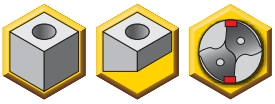
Modular Drill Carbide Insert Blades • KSEM™ • HPCCL Geometry • Grade KC7410™ • Through Coolant • Metric

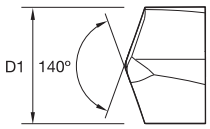
Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter		12,5	16,0	20,0	25,4	32,0	40,0
K	1	100	**175**	200	mm/r	0,17–0,35	0,21–0,42	0,25–0,48	0,31–0,59	0,37–0,70	0,43–0,81
K	2	100	**160**	180	mm/r	0,17–0,33	0,21–0,41	0,25–0,48	0,31–0,59	0,37–0,70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

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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter		0.462	0.630	0.787	1.000	1.260	1.575
K	1	330	**570**	660	IPR	.007–.014	.008–.017	.010–.019	.012–.023	.015–.028	.017–.032
K	2	330	**520**	590	IPR	.007–.013	.008–.016	.010–.019	.012–.023	.015–.028	.017–.032
K	3	230	**280**	330	IPR	.007–.014	.008–.016	.008–.017	.009–.019	.010–.021	.011–.022

- 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

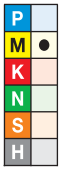
● first choice
○ alternate choice

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

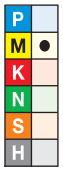
KC7320	D1 mm	D1 in	seat size
KSEM1860HPLM	18,600	.7323	2
KSEM1865HPLM	18,650	.7340	2
KSEM1890HPLM	18,900	.7441	2
KSEM1900HPLM	19,000	.7480	2
KSEM1905HPLM	19,050	.7500	2
KSEM1920HPLM	19,200	.7559	2
KSEM1923HPLM	19,228	.7570	2
KSEM1925HPLM	19,250	.7579	2
KSEM1927HPLM	19,270	.7590	2
KSEM1935HPLM	19,350	.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

Tolerance HPL • Inch

D1 inch	tolerance h8
.500–.709	+.000/-.0010
>.709–1.181	+.000/-.0013
>1.181–1.575	+.000/-.0015

Application Data

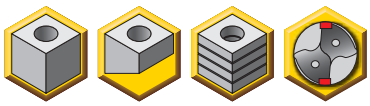
Modular Drill Carbide Insert Blades • KSEM • HPL Geometry • Grade KC7320 • Through Coolant • Metric

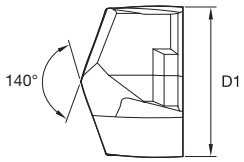
Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter	12,5	16,0	20,0	25,4	32,0	40,0
M	1	30	**60**	90	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
M	2	30	**50**	90	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28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

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

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate (f) by Diameter	0.462	0.630	0.787	1.000	1.260	1.575
M	1	100	**200**	300	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
M	2	100	**160**	300	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
M	3	70	**130**	200	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012

- 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 center 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

P ○
M ●
K
N ○
S ●
H

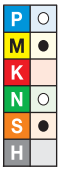
● first choice
○ alternate choice

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

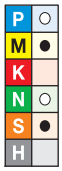
KCMS35	D1 mm	D1 in	seat size
KSEM2000SPLM	20,000	.7874	3
KSEM2024SPLM	20,240	.7969	3
KSEM2050SPLM	20,500	.8071	3
KSEM2064SPLM	20,640	.8126	3
KSEM2100SPLM	21,000	.8268	3
KSEM2150SPLM	21,500	.8465	3
KSEM2200SPLM	22,000	.8661	3
KSEM2223SPLM	22,230	.8752	4
KSEM2250SPLM	22,500	.8858	4
KSEM2300SPLM	23,000	.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

Tolerance SPL • Inch

D1 inch	tolerance h8
.500–.709	+.000/-.0010
>709–1.181	+.000/-.0013
>1.181–1.575	+.000/-.0015

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

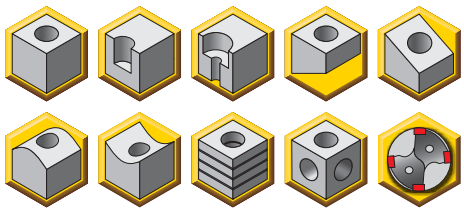
Material Group		Cutting Speed — vc Range — m/min			Metric						
					Recommended Feed Rate (f) by Diameter						
		min	Starting Value	max		12,5	16,0	20,0	25,4	32,0	40,0
P	1	110	**140**	170	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	0,25–0,53	0,29–0,60	0,33–0,69
	2	100	**120**	140	mm/r	0,15–0,31	0,17–0,36	0,19–0,41	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

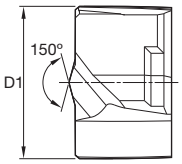
Modular Drill Carbide Insert Blades • KSEM • SPL Geometry • Grade KCMS35 • Through Coolant • Inch

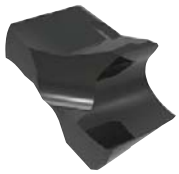
Material Group		Cutting Speed — vc Range — SFM			Inch						
					Recommended Feed Rate (f) by Diameter						
		min	Starting Value	max		0.462	0.630	0.787	1.000	1.260	1.575
P	1	360	**460**	560	IPR	.006–.012	.007–.014	.007–.016	.010–.021	.011–.024	.013–.027
	2	330	**390**	460	IPR	.006–.012	.007–.014	.007–.016	.010–.021	.011–.024	.013–.027
	3	260	**330**	390	IPR	.006–.012	.007–.014	.007–.016	.010–.021	.011–.024	.013–.027
M	1	130	**200**	260	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	2	110	**180**	230	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	3	70	**130**	200	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
N	1	300	**510**	720	IPR	.007–.016	.010–.020	.011–.022	.013–.025	.013–.028	.013–.028
	2	300	**510**	720	IPR	.007–.016	.010–.020	.011–.022	.013–.025	.013–.028	.013–.028
	3	260	**390**	520	IPR	.007–.016	.010–.020	.011–.022	.013–.025	.013–.028	.013–.028
	4	300	**510**	720	IPR	.007–.016	.010–.020	.011–.022	.013–.025	.013–.028	.013–.028
S	1	70	**130**	200	IPR	.002–.004	.003–.005	.004–.006	.004–.007	.005–.008	.006–.010
	2	50	**100**	150	IPR	.002–.004	.003–.005	.004–.006	.004–.007	.005–.008	.006–.010
	3	50	**100**	150	IPR	.002–.004	.003–.005	.004–.006	.004–.007	.005–.008	.006–.010
	4	30	**80**	130	IPR	.002–.004	.003–.005	.004–.006	.004–.007	.005–.008	.006–.010

Application recommendation: We recommend pre-centering 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 center 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 centering 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

P ● M ○ K ○ N S ○ H

● first choice
○ alternate choice

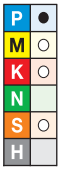
KCPM45	D1 mm	D1 in	seat size
KSEM1600FEGM	16,000	.6299	1
KSEM1650FEGM	16,500	.6496	1
KSEM1700FEGM	17,000	.6693	1
KSEM1750FEGM	17,500	.6890	1
KSEM1800FEGM	18,000	.7087	1
KSEM1850FEGM	18,500	.7283	2
KSEM1900FEGM	19,000	.7480	2
KSEM1905FEGM	19,050	.7500	2
KSEM1950FEGM	19,500	.7677	2
KSEM1984FEGM	19,840	.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

P ● M ○ K ○ N S ○ H

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

Tolerance FEG • Inch

D1 inch	tolerance k7
.500–.709	+.0000/+.0008
>.709–1.181	+.0000/+.0009
>1.181–1.575	+.0000/+.0010

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

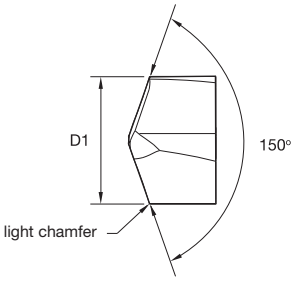
Material Group		Cutting Speed — vc Range — m/min			Metric						
					Recommended Feed Rate (f) by Diameter						
		min	Starting Value	max		12,5	16,0	20,0	25,4	32,0	40,0
P	1	110	**140**	170	mm/r	0,14–0,23	0,17–0,25	0,19–0,29	0,23–0,38	0,26–0,43	0,33–0,76
	2	100	**120**	140	mm/r	0,17–0,23	0,19–0,25	0,22–0,29	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

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

Material Group		Cutting Speed — vc Range — SFM			Inch						
					Recommended Feed Rate (f) by Diameter						
		min	Starting Value	max		0.462	0.630	0.787	1.000	1.260	1.575
P	1	360	**460**	560	IPR	.006–.009	.007–.010	.007–.011	.009–.015	.010–.017	.013–.030
	2	330	**390**	460	IPR	.007–.009	.007–.010	.009–.011	.011–.015	.013–.017	.013–.030
	3	260	**330**	390	IPR	.006–.008	.006–.009	.007–.010	.009–.013	.010–.015	.013–.026
	4	230	**300**	360	IPR	.004–.008	.005–.009	.006–.010	.007–.013	.008–.015	.010–.026
M	1	130	**200**	260	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	2	110	**180**	230	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	3	70	**130**	200	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
K	1	300	**440**	570	IPR	.007–.009	.007–.010	.009–.011	.011–.015	.013–.017	.013–.030
	2	260	**390**	460	IPR	.007–.009	.007–.010	.009–.011	.011–.015	.013–.017	.013–.030
	3	230	**360**	410	IPR	.006–.009	.007–.010	.008–.011	.009–.015	.010–.017	.011–.022
S	1	70	**130**	200	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	3	50	**100**	150	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012

- KSEM PC cutting edges serve mainly as precentering inserts, but can also be used in demanding conditions.
- Steep 150° degree angle with a light corner chamfer. Very good centering 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

Tolerance PC • Inch

D1 inch	tolerance k7
.500–.709	+.0000/+.0008
>.709–1.181	+.0000/+.0009
>1.181–1.575	+.0000/+.0010

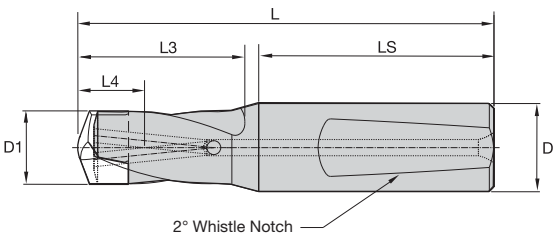
Modular Drill Carbide Insert Blades • KSEM™ • PC Geometry • Grade KC7135™ • Through Coolant • Metric

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

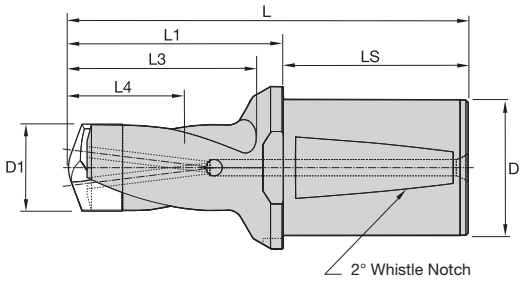
Modular Drill Carbide Insert Blades • KSEM • PC Geometry • Grade KC7135 • Through Coolant • Inch

Material Group		Cutting Speed — vc Range — SFM			Inch					
					Recommended Feed Rate (f) by Diameter					
		min	Starting Value	max		0.462	0.630	0.787	1.000	1.260
P	1	300	**330**	360	IPR	.006–.009	.007–.010	.007–.011	.009–.015	.010–.017
	2	260	**300**	330	IPR	.007–.009	.007–.010	.009–.011	.011–.015	.013–.017
	3	180	**210**	250	IPR	.006–.008	.006–.009	.007–.010	.009–.013	.010–.015
	4	150	**160**	200	IPR	.004–.008	.005–.009	.006–.010	.007–.013	.008–.015
	5	150	**180**	210	IPR	.003–.004	.004–.005	.004–.006	.006–.007	.006–.008
	6	150	**180**	210	IPR	.004–.007	.005–.007	.006–.008	.007–.011	.008–.012
K	1	200	**200**	300	IPR	.003–.009	.004–.011	.004–.012	.006–.017	.006–.019
	2	200	**200**	250	IPR	.007–.009	.008–.011	.009–.012	.011–.015	.013–.017
	3	130	**130**	250	IPR	.006–.009	.007–.010	.008–.011	.009–.015	.010–.017

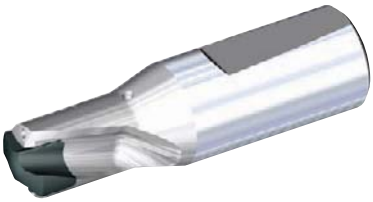
- Use designated insert blade with each drill body.
- For alternatives, see insert blade fitment chart on page H91–H92.
- Drill shipped with central lock screw, wrench, and side pipe plug.
- Order insert blade separately; see pages H52–H71.



Whistle Notch shank D1≤32mm



Whistle Notch shank with Drive D1≥32mm

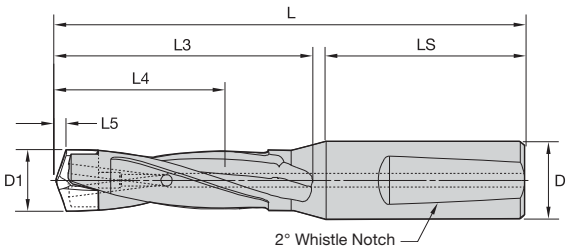


KSEM WN/WD50 Shank • 1 x D • Metric

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**

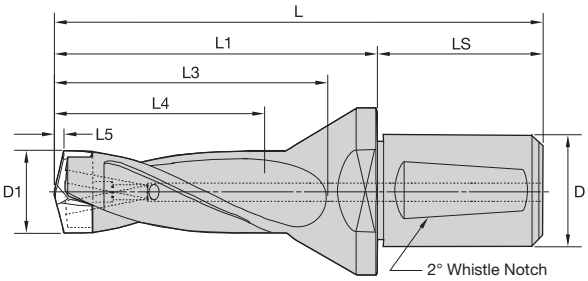
- Use designated insert blade with each drill body.
- For alternatives, see insert blade fitment chart on page H91–H92.
- Drill shipped with central lock screw, wrench, and side pipe plug.
- Order insert blade separately; see pages H52–H71.



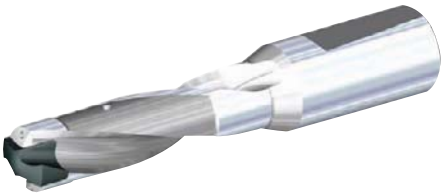


for diameters < 16mm, DIN 6535 - HE
for diameters > 16mm, DIN 1835 part 1 form E

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

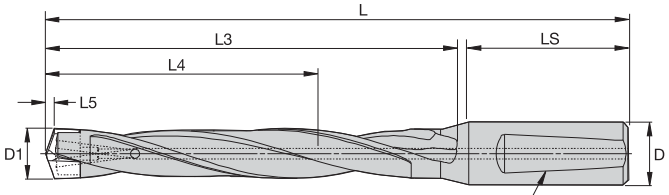


KSEM WD40 Shank • 3 x D/5 x D • Metric

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 H91–H92.
- Drill shipped with central lock screw, wrench, and side pipe plug.
- Order insert blade separately; see pages H52–H71.





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 H94–H95.



KSEM WN Shank • 7 x D/10 x D • Metric

7x	10x	D1		D1 max						
7 x D	10 x D	mm	in	mm	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

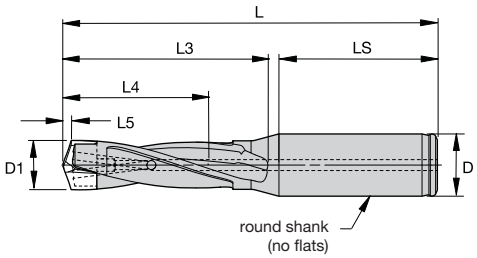
(continued)

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

7 x D	10 x D	D1 mm	D1 in	D1 max mm	D1 max 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**

- Use designated insert blade with each drill body.
- For alternatives, see insert blade fitment chart on page H91–H92.
- Drill shipped with central lock screw and wrench.
- Order insert blade separately; see pages H52–H71.







For information on L, L3, and L4 max, see page H97.

KSEM Round Shank • 3 x D/5 x D • Inch

3 x D	5 x D	D1 mm	D1 in	D1 max mm	D1 max in	L5	LS	D	seat size	central lock screw
–	KSEM0500R5SS050	12,700	.5000	13,200	.5197	.079	1.50	.5000	C	364.017
KSEM0500R3SS075	KSEM0500R5SS075	12,700	.5000	13,200	.5197	.079	2.00	.7500	C	364.017
KSEM0509R3SS075	KSEM0509R5SS075	12,929	.5090	13,429	.5287	.081	2.00	.7500	C	364.017
–	KSEM0516R5SS075	13,106	.5160	13,500	.5314	.082	2.00	.7500	C	364.017
KSEM0531R3SS075	KSEM0531R5SS075	13,494	.5313	13,500	.5314	.084	2.00	.7500	C	364.017
KSEM0547R3SS075	–	13,891	.5469	14,394	.5667	.087	2.00	.7500	B	364.016
–	KSEM0547R5SS075	13,894	.5470	14,394	.5667	.087	2.00	.7500	B	364.016
KSEM0563R3SS075	KSEM0563R5SS075	14,300	.5630	14,500	.5708	.089	2.00	.7500	B	364.016
KSEM0578R3SS075	KSEM0578R5SS075	14,681	.5780	15,181	.5977	.092	2.00	.7500	A	364.016
KSEM0594R3SS075	KSEM0594R5SS075	15,088	.5940	15,588	.6137	.094	2.00	.7500	A	364.016
KSEM0609R3SS075	KSEM0609R5SS075	15,469	.6090	15,874	.6249	.097	2.00	.7500	A	364.016
KSEM0625R3SS075	KSEM0625R5SS075	15,875	.6250	16,375	.6447	.099	2.00	.7500	1	364.010
KSEM0634R3SS075	KSEM0634R5SS075	16,104	.6340	16,604	.6537	.101	2.00	.7500	1	364.010
KSEM0641R3SS075	KSEM0641R5SS075	16,281	.6410	16,781	.6607	.102	2.00	.7500	1	364.010
KSEM0656R3SS075	KSEM0656R5SS075	16,670	.6563	17,170	.6760	.104	2.00	.7500	1	364.010
KSEM0672R3SS075	KSEM0672R5SS075	17,069	.6720	17,569	.6917	.107	2.00	.7500	1	364.010
KSEM0688R3SS075	KSEM0688R5SS075	17,463	.6875	17,963	.7072	.109	2.00	.7500	1	364.010
KSEM0703R3SS075	KSEM0703R5SS075	17,856	.7030	18,000	.7086	.112	2.00	.7500	1	364.010
KSEM0719R3SS075	KSEM0719R5SS075	18,256	.7187	18,756	.7384	.114	2.00	.7500	2	364.010
KSEM0734R3SS075	KSEM0734R5SS075	18,644	.7340	19,144	.7537	.117	2.00	.7500	2	364.010
KSEM0750R3SS075	KSEM0750R5SS075	19,050	.7500	19,550	.7697	.119	2.00	.7500	2	364.010
KSEM0750R3SS100	KSEM0750R5SS100	19,050	.7500	19,550	.7697	.119	3.00	1.0000	2	364.010
KSEM0759R3SS075	KSEM0759R5SS075	19,279	.7590	19,779	.7787	.121	2.00	.7500	2	364.010
KSEM0766R3SS100	KSEM0766R5SS100	19,456	.7660	19,956	.7857	.122	3.00	1.0000	2	364.010
KSEM0781R3SS100	KSEM0781R5SS100	19,844	.7813	19,999	.7873	.124	3.00	1.0000	2	364.010
KSEM0797R3SS100	KSEM0797R5SS100	20,244	.7970	20,744	.8167	.127	3.00	1.0000	3	364.011
KSEM0813R3SS100	KSEM0813R5SS100	20,638	.8125	21,138	.8322	.129	3.00	1.0000	3	364.011
KSEM0844R3SS100	KSEM0844R5SS100	21,431	.8437	21,931	.8634	.134	3.00	1.0000	3	364.011
KSEM0859R3SS100	KSEM0859R5SS100	21,819	.8590	22,000	.8661	.136	3.00	1.0000	3	364.011
KSEM0875R3SS100	KSEM0875R5SS100	22,225	.8750	22,725	.8947	.139	3.00	1.0000	4	364.011
KSEM0875R3SS125	KSEM0875R5SS125	22,225	.8750	22,725	.8947	.139	3.25	1.2500	4	364.011
KSEM0884R3SS100	KSEM0884R5SS100	22,454	.8840	22,954	.9037	.140	3.00	1.0000	4	364.011

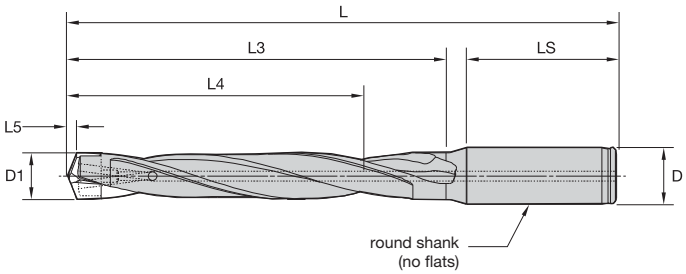
(continued)

(KSEM Round Shank • 3 x D/5 x D • Inch — continued)

		D1		D1 max						
3 x D	5 x D	mm	in	mm	in	L5	LS	D	seat size	central lock screw
KSEM0906R3SS100	KSEM0906R5SS100	23,019	.9063	23,519	.9260	.144	3.00	1.0000	4	364.011
KSEM0922R3SS100	KSEM0922R5SS100	23,419	.9220	23,919	.9417	.146	3.00	1.0000	4	364.011
KSEM0938R3SS100	KSEM0938R5SS100	23,813	.9375	24,000	.9448	.149	3.00	1.0000	4	364.011
KSEM0969R3SS100	KSEM0969R5SS100	24,606	.9687	25,106	.9884	.154	3.00	1.0000	5	364.012
KSEM0984R3SS100	KSEM0984R5SS100	25,003	.9844	25,503	1.0041	.151	3.00	1.0000	5	364.012
KSEM1000R3SS100	KSEM1000R5SS100	25,400	1.0000	25,900	1.0197	.154	3.00	1.0000	5	364.012
–	KSEM1000R5SS125	25,400	1.0000	25,900	1.0197	.154	3.25	1.2500	5	364.012
KSEM1011R3SS125	KSEM1011R5SS125	25,679	1.0110	26,000	1.0236	.156	3.25	1.2500	5	364.012
KSEM1031R3SS125	KSEM1031R5SS125	26,195	1.0313	26,695	1.0510	.159	3.25	1.2500	6	364.012
–	KSEM1047R5SS125	26,594	1.0470	27,094	1.0667	.161	3.25	1.2500	6	364.012
KSEM1063R3SS125	KSEM1063R5SS125	26,988	1.0625	27,488	1.0822	.164	3.25	1.2500	6	364.012
–	KSEM1094R5SS125	27,781	1.0937	28,000	1.1023	.168	3.25	1.2500	6	364.012
KSEM1109R3SS125	KSEM1109R5SS125	28,169	1.1090	28,669	1.1287	.171	3.25	1.2500	7	364.013
KSEM1125R3SS125	KSEM1125R5SS125	28,575	1.1250	29,075	1.1447	.173	3.25	1.2500	7	364.013
KSEM1156R3SS125	KSEM1156R5SS125	29,370	1.1563	29,870	1.1760	.178	3.25	1.2500	7	364.013
KSEM1172R3SS125	KSEM1172R5SS125	29,769	1.1720	30,000	1.1811	.180	3.25	1.2500	7	364.013
KSEM1188R3SS125	KSEM1188R5SS125	30,163	1.1875	30,663	1.2072	.183	3.25	1.2500	8	364.013
–	KSEM1203R5SS125	30,556	1.2030	31,056	1.2227	.185	3.25	1.2500	8	364.013
KSEM1219R3SS125	KSEM1219R5SS125	30,958	1.2188	31,458	1.2385	.188	3.25	1.2500	8	364.013
KSEM1250R3SS125	KSEM1250R5SS125	31,750	1.2500	32,000	1.2598	.192	3.25	1.2500	8	364.013
KSEM1250R3SS150	KSEM1250R5SS150	31,750	1.2500	32,000	1.2598	.192	3.75	1.5000	8	364.013
KSEM1281R3SS150	KSEM1281R5SS150	32,537	1.2810	33,537	1.3204	.197	3.75	1.5000	9	364.015
KSEM1297R3SS150	KSEM1297R5SS150	32,941	1.2969	33,941	1.3363	.200	3.75	1.5000	9	364.015
KSEM1313R3SS150	KSEM1313R5SS150	33,350	1.3130	34,350	1.3524	.202	3.75	1.5000	9	364.015
KSEM1328R3SS150	KSEM1328R5SS150	33,731	1.3280	34,731	1.3674	.204	3.75	1.5000	9	364.015
–	KSEM1344R5SS150	34,138	1.3440	35,138	1.3834	.207	3.75	1.5000	9	364.015
KSEM1375R3SS150	KSEM1375R5SS150	34,925	1.3750	35,925	1.4144	.212	3.75	1.5000	9	364.015
KSEM1406R3SS150	KSEM1406R5SS150	35,712	1.4060	36,000	1.4173	.216	3.75	1.5000	9	364.015
–	KSEM1422R5SS150	36,119	1.4220	37,119	1.4614	.219	3.75	1.5000	10	364.015
KSEM1438R3SS150	KSEM1438R5SS150	36,513	1.4375	37,513	1.4769	.221	3.75	1.5000	10	364.015
–	KSEM1469R5SS150	37,313	1.4690	38,313	1.5084	.226	3.75	1.5000	10	364.015
KSEM1500R3SS150	KSEM1500R5SS150	38,100	1.5000	39,100	1.5394	.231	3.75	1.5000	10	364.015
KSEM1514R3SS150	KSEM1514R5SS150	38,456	1.5140	39,456	1.5534	.233	3.75	1.5000	10	364.015

- Use designated insert blade with each drill body.
- For alternatives, see insert blade fitment chart on page H91–H92.
- Drill shipped with central lock screw and wrench.
- Order insert blade separately; see pages H52–H71.







For information on L, L3, and L4 max, see the Modular Drills Dimension Tables on page H96.

KSEM Round Shank • 7 x D/10 x D • Inch

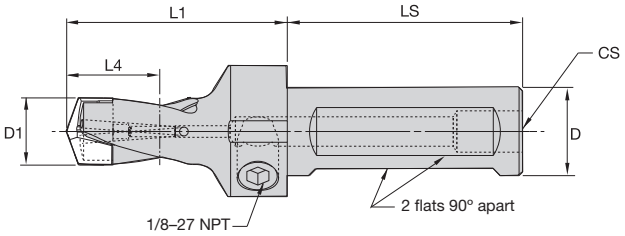
10 x D	7 x D	D1 mm	D1 in	D1 max mm	D1 max in	L5	LS	D	seat size	central lock screw
–	KSEM0500R7SS050	12,700	.5000	13,200	.5197	.079	1.50	.5000	C	364.017
KSEM0500R10SS075	KSEM0500R7SS075	12,700	.5000	13,200	.5197	.079	2.00	.7500	C	364.017
KSEM0509R10SS075	KSEM0509R7SS075	12,929	.5090	13,429	.5287	.081	2.00	.7500	C	364.017
KSEM0516R10SS075	KSEM0516R7SS075	13,096	.5156	13,500	.5314	.082	2.00	.7500	C	364.017
KSEM0531R10SS075	KSEM0531R7SS075	13,494	.5313	13,500	.5314	.084	2.00	.7500	C	364.017
KSEM0547R10SS075	KSEM0547R7SS075	13,891	.5469	14,394	.5667	.087	2.00	.7500	B	364.016
KSEM0563R10SS075	KSEM0563R7SS075	14,288	.5625	14,500	.5708	.089	2.00	.7500	B	364.016
KSEM0578R10SS075	KSEM0578R7SS075	14,681	.5780	15,181	.5977	.092	2.00	.7500	A	364.016
KSEM0594R10SS075	KSEM0594R7SS075	15,083	.5938	15,588	.6137	.094	2.00	.7500	A	364.016
KSEM0609R10SS075	KSEM0609R7SS075	15,479	.6094	15,874	.6249	.097	2.00	.7500	A	364.016
KSEM0625R10SS075	KSEM0625R7SS075	15,875	.6250	16,375	.6447	.099	2.00	.7500	1	364.010
KSEM0634R10SS075	KSEM0634R7SS075	16,104	.6340	16,604	.6537	.101	2.00	.7500	1	364.010
KSEM0656R10SS075	KSEM0656R7SS075	16,670	.6563	17,170	.6760	.104	2.00	.7500	1	364.010
KSEM0688R10SS075	KSEM0688R7SS075	17,463	.6875	17,963	.7072	.109	2.00	.7500	1	364.010
KSEM0719R10SS075	KSEM0719R7SS075	18,256	.7187	18,756	.7384	.114	2.00	.7500	2	364.010
KSEM0750R10SS075	KSEM0750R7SS075	19,050	.7500	19,550	.7502	.119	2.00	.7500	2	364.010
KSEM0750R10SS100	KSEM0750R7SS100	19,050	.7500	19,550	.7502	.119	3.00	1.0000	2	364.010
–	KSEM0759R7SS075	19,279	.7590	19,779	.7787	.121	2.00	.7500	2	364.010
KSEM0759R10SS100	–	19,279	.7590	19,779	.7787	.121	3.00	1.0000	2	364.010
KSEM0781R10SS100	KSEM0781R7SS100	19,844	.7813	19,999	.7873	.124	3.00	1.0000	2	364.010
KSEM0813R10SS100	KSEM0813R7SS100	20,638	.8125	21,138	.8322	.129	3.00	1.0000	3	364.011
KSEM0844R10SS100	KSEM0844R7SS100	21,431	.8437	21,931	.8634	.134	3.00	1.0000	3	364.011
KSEM0875R10SS100	KSEM0875R7SS100	22,225	.8750	22,725	.8947	.139	3.00	1.0000	4	364.011
–	KSEM0875R7SS125	22,225	.8750	22,725	.8947	.139	3.25	1.2500	4	364.011
KSEM0884R10SS100	KSEM0884R7SS100	22,454	.8840	22,954	.9037	.140	3.00	1.0000	4	364.011
KSEM0906R10SS100	KSEM0906R7SS100	23,019	.9063	23,519	.9260	.144	3.00	1.0000	4	364.011
KSEM0938R10SS100	KSEM0938R7SS100	23,813	.9375	24,000	.9448	.149	3.00	1.0000	4	364.011
KSEM0969R10SS100	KSEM0969R7SS100	24,606	.9687	25,106	.9884	.154	3.00	1.0000	5	364.012
KSEM0984R10SS100	KSEM0984R7SS100	25,003	.9844	25,503	1.0041	.151	3.00	1.0000	5	364.012
KSEM1000R10SS100	KSEM1000R7SS100	25,400	1.0000	25,900	1.0197	.154	3.00	1.0000	5	364.012
KSEM1000R10SS125	KSEM1000R7SS125	25,400	1.0000	25,900	1.0197	.154	3.25	1.2500	5	364.012
KSEM1011R10SS125	KSEM1011R7SS125	25,679	1.0110	26,000	1.0236	.156	3.25	1.2500	5	364.012

(continued)

(KSEM Round Shank • 7 x D/10 x D • Inch — continued)

		D1		D1 max						
10 x D	7 x D	mm	in	mm	in	L5	LS	D	seat size	central lock screw
KSEM1031R10SS125	**KSEM1031R7SS125**	26,195	1.0313	26,695	1.0510	.159	3.25	1.2500	6	**364.012**
KSEM1063R10SS125	**KSEM1063R7SS125**	26,988	1.0625	27,488	1.0822	.164	3.25	1.2500	6	**364.012**
KSEM1094R10SS125	**KSEM1094R7SS125**	27,781	1.0937	28,000	1.1023	.168	3.25	1.2500	6	**364.012**
KSEM1125R10SS125	**KSEM1125R7SS125**	28,575	1.1250	29,075	1.1447	.173	3.25	1.2500	7	**364.013**
KSEM1156R10SS125	**KSEM1156R7SS125**	29,370	1.1563	29,870	1.1760	.178	3.25	1.2500	7	**364.013**
KSEM1188R10SS125	**KSEM1188R7SS125**	30,163	1.1875	30,663	1.2072	.183	3.25	1.2500	8	**364.013**
KSEM1219R10SS125	**KSEM1219R7SS125**	30,958	1.2188	31,458	1.2385	.188	3.25	1.2500	8	**364.013**
KSEM1250R10SS125	**KSEM1250R7SS125**	31,750	1.2500	32,000	1.2598	.192	3.25	1.2500	8	**364.013**
KSEM1250R10SS150	**KSEM1250R7SS150**	31,750	1.2500	32,000	1.2598	.192	3.75	1.5000	8	**364.013**

- Use designated insert blade with each drill body.
- For alternatives, see insert blade fitment chart on page H91–H92.
- Drill shipped with central lock screw, wrench, and side pipe plug.
- Order insert blade separately; see pages H52–H71.

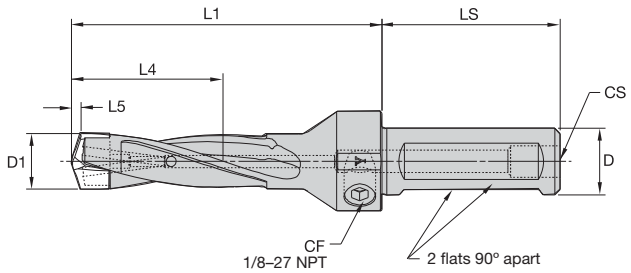




KSEM Flanged Shank • 1 x D • Inch

1 x D	D1 mm	D1 in	D1 max mm	D1 max in	L	L1	L4 max	L5	LS	D	seat size	CS	central lock screw	wrench
KSEM0493R1SSF075	12,522	.4930	13,500	.5314	3.94	1.94	.53	.07	2.00	.750	C	1/8-27 NPT	**364.017**	**170.294**
KSEM0532R1SSF075	13,513	.5320	14,500	.5708	4.00	2.00	.61	.08	2.00	.750	B	1/8-27 NPT	**364.016**	**170.289**
KSEM0571R1SSF075	14,503	.5710	15,874	.6249	4.00	2.00	.63	.09	2.00	.750	A	1/8-27 NPT	**364.016**	**170.289**
KSEM0625R1SSF075	15,875	.6250	18,000	.7086	4.19	2.19	.71	.10	2.00	.750	1	1/8-27 NPT	**364.010**	**170.270**
KSEM0709R1SSF075	18,009	.7090	19,999	.7873	4.25	2.25	.78	.11	2.00	.750	2	1/8-27 NPT	**364.010**	**170.270**
KSEM0788R1SSF100	20,015	.7880	22,000	.8661	5.50	2.50	.87	.13	3.00	1.000	3	1/4-18 NPT	**364.011**	**170.272**
KSEM0867R1SSF100	22,022	.8670	24,000	.9448	5.56	2.56	.95	.14	3.00	1.000	4	1/4-18 NPT	**364.011**	**170.272**
KSEM0945R1SSF100	24,003	.9450	26,000	1.0236	5.63	2.63	1.02	.15	3.00	1.000	5	1/4-18 NPT	**364.012**	**170.274**
KSEM1024R1SSF125	26,010	1.0240	28,000	1.1023	6.13	2.88	1.11	.16	3.25	1.250	6	1/4-18 NPT	**364.012**	**170.274**
KSEM1103R1SSF125	28,016	1.1030	30,000	1.1811	6.19	2.94	1.18	.17	3.25	1.250	7	1/4-18 NPT	**364.013**	**170.276**
KSEM1182R1SSF125	30,023	1.1820	32,000	1.2598	6.25	3.00	1.27	.18	3.25	1.250	8	1/4-18 NPT	**364.013**	**170.276**
KSEM1260R1SSF125	32,004	1.2600	36,000	1.4173	6.50	3.25	1.42	.19	3.25	1.250	9	1/4-18 NPT	**364.015**	**170.276**
KSEM1418R1SSF125	36,017	1.4180	40,000	1.5748	6.63	3.38	1.57	.22	3.25	1.250	10	1/4-18 NPT	**364.015**	**170.276**

- Use designated insert blade with each drill body.
- For alternatives, see insert blade fitment chart on page H91–H92.
- Drill shipped with central lock screw, wrench, and side pipe plug.
- Order insert blade separately; see pages H52–H71.





For information on L, L3, and L4 max, see the Modular Drills Dimension Tables on page H96.

KSEM Flanged Shank • 3 x D/5 x D • Inch

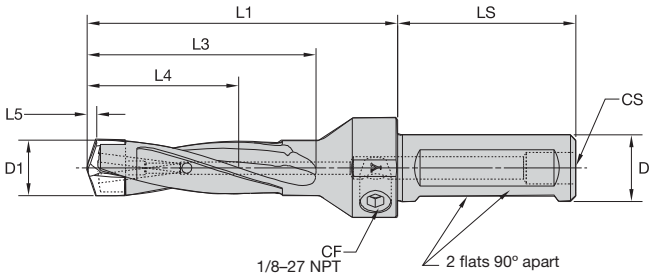
3 x D	5 x D	D1 mm	D1 in	D1 max mm	D1 max in	L5	LS	D	seat size	CS	central lock screw
KSEM0500R3SSF075	KSEM0500R5SSF075	12,700	.5000	13,200	.5197	.08	2.00	.750	C	1/8-27 NPT	364.017
KSEM0509R3SSF075	KSEM0509R5SSF075	12,929	.5090	13,429	.5287	.08	2.00	.750	C	1/8-27 NPT	364.017
KSEM0516R3SSF075	KSEM0516R5SSF075	13,106	.5160	13,500	.5314	.08	2.00	.750	C	1/8-27 NPT	364.017
KSEM0531R3SSF075	KSEM0531R5SSF075	13,487	.5310	13,500	.5314	.08	2.00	.750	C	1/8-27 NPT	364.017
KSEM0547R3SSF075	KSEM0547R5SSF075	13,894	.5470	14,394	.5667	.09	2.00	.750	B	1/8-27 NPT	364.016
KSEM0563R3SSF075	KSEM0563R5SSF075	14,300	.5630	14,500	.5708	.09	2.00	.750	B	1/8-27 NPT	364.016
KSEM0578R3SSF075	KSEM0578R5SSF075	14,681	.5780	15,181	.5977	.09	2.00	.750	A	1/8-27 NPT	364.016
KSEM0594R3SSF075	KSEM0594R5SSF075	15,088	.5940	15,588	.6137	.09	2.00	.750	A	1/8-27 NPT	364.016
KSEM0609R3SSF075	KSEM0609R5SSF075	15,469	.6090	15,874	.6249	.10	2.00	.750	A	1/8-27 NPT	364.016
KSEM0625R3SSF075	KSEM0625R5SSF075	15,875	.6250	16,375	.6447	.10	2.00	.750	1	1/8-27 NPT	364.010
KSEM0634R3SSF075	–	16,104	.6340	16,604	.6537	.10	2.00	.750	1	1/8-27 NPT	364.010
KSEM0641R3SSF075	–	16,281	.6410	16,781	.6607	.10	2.00	.750	1	1/8-27 NPT	364.010
KSEM0672R3SSF075	–	17,069	.6720	17,569	.6917	.11	2.00	.750	1	1/8-27 NPT	364.010
KSEM0688R3SSF075	KSEM0688R5SSF075	17,463	.6875	17,963	.7072	.11	2.00	.750	1	1/8-27 NPT	364.010
KSEM0703R3SSF075	–	17,856	.7030	18,000	.7086	.11	2.00	.750	1	1/8-27 NPT	364.010
KSEM0734R3SSF075	–	18,644	.7340	19,144	.7537	.12	2.00	.750	2	1/8-27 NPT	364.010
KSEM0750R3SSF075	KSEM0750R5SSF075	19,050	.7500	19,550	.7502	.12	2.00	.750	2	1/8-27 NPT	364.010
KSEM0750R3SSF100	KSEM0750R5SSF100	19,050	.7500	19,550	.7502	.12	3.00	1.000	2	1/4-18 NPT	364.010
KSEM0759R3SSF100	–	19,279	.7590	19,779	.7787	.12	3.00	1.000	2	1/4-18 NPT	364.010
KSEM0766R3SSF100	–	19,456	.7660	19,956	.7857	.12	3.00	1.000	2	1/4-18 NPT	364.010
KSEM0781R3SSF100	–	19,844	.7813	19,999	.7873	.12	3.00	1.000	2	1/4-18 NPT	364.010
KSEM0797R3SSF100	–	20,244	.7970	20,744	.8167	.13	3.00	1.000	3	1/4-18 NPT	364.011
KSEM0813R3SSF100	KSEM0813R5SSF100	20,638	.8125	21,138	.8322	.13	3.00	1.000	3	1/4-18 NPT	364.011
KSEM0859R3SSF100	–	21,819	.8590	22,000	.8661	.14	3.00	1.000	3	1/4-18 NPT	364.011
KSEM0875R3SSF100	KSEM0875R5SSF100	22,225	.8750	22,725	.8947	.14	3.00	1.000	4	1/4-18 NPT	364.011
KSEM0875R3SSF125	KSEM0875R5SSF125	22,225	.8750	22,725	.8947	.14	3.25	1.250	4	1/4-18 NPT	364.011
KSEM0884R3SSF100	–	22,454	.8840	22,954	.9037	.14	3.00	1.000	4	1/4-18 NPT	364.011
KSEM0906R3SSF100	–	23,019	.9063	23,519	.9260	.14	3.00	1.000	4	1/4-18 NPT	364.011
KSEM0922R3SSF100	–	23,419	.9220	23,919	.9417	.15	3.00	1.000	4	1/4-18 NPT	364.011
KSEM0938R3SSF100	KSEM0938R5SSF100	23,813	.9375	24,000	.9448	.15	3.00	1.000	4	1/4-18 NPT	364.011
KSEM0969R3SSF100	KSEM0969R5SSF100	24,606	.9687	25,106	.9884	.15	3.00	1.000	5	1/4-18 NPT	364.012
KSEM0984R3SSF100	KSEM0984R5SSF100	25,003	.9844	25,503	1.0041	.15	3.00	1.000	5	1/4-18 NPT	364.012

(continued)

(KSEM Flanged Shank • 3 x D/5 x D • Inch — continued)

 3 x D	 5 x D	D1 mm	D1 in	D1 max mm	D1 max in	L5	LS	D	seat size	CS	 central lock screw
KSEM1000R3SSF100	**KSEM1000R5SSF100**	25,400	1.0000	25,900	1.0197	.15	3.00	1.000	5	1/4-18 NPT	**364.012**
KSEM1000R3SSF125	**KSEM1000R5SSF125**	25,400	1.0000	25,900	1.0197	.15	3.25	1.250	5	1/4-18 NPT	**364.012**
KSEM1011R3SSF100	–	25,679	1.0110	26,000	1.0236	.16	3.00	1.000	5	1/4-18 NPT	**364.012**
KSEM1031R3SSF125	–	26,195	1.0313	26,695	1.0510	.16	3.25	1.250	6	1/4-18 NPT	**364.012**
KSEM1047R3SSF125	–	26,594	1.0470	27,094	1.0667	.16	3.25	1.250	6	1/4-18 NPT	**364.012**
KSEM1063R3SSF125	**KSEM1063R5SSF125**	26,988	1.0625	27,488	1.0822	.16	3.25	1.250	6	1/4-18 NPT	**364.012**
KSEM1094R3SSF125	–	27,781	1.0937	28,000	1.1023	.17	3.25	1.250	6	1/4-18 NPT	**364.012**
KSEM1109R3SSF125	–	28,169	1.1090	28,669	1.1287	.17	3.25	1.250	7	1/4-18 NPT	**364.013**
KSEM1125R3SSF125	**KSEM1125R5SSF125**	28,575	1.1250	29,075	1.1447	.17	3.25	1.250	7	1/4-18 NPT	**364.013**
KSEM1156R3SSF125	–	29,370	1.1563	29,870	1.1760	.18	3.25	1.250	7	1/4-18 NPT	**364.013**
KSEM1188R3SSF125	**KSEM1188R5SSF125**	30,163	1.1875	30,663	1.2072	.18	3.25	1.250	8	1/4-18 NPT	**364.013**
KSEM1203R3SSF125	–	30,556	1.2030	31,056	1.2227	.19	3.25	1.250	8	1/4-18 NPT	**364.013**
KSEM1250R3SSF125	**KSEM1250R5SSF125**	31,750	1.2500	32,000	1.2598	.19	3.25	1.250	8	1/4-18 NPT	**364.013**
KSEM1250R3SSF150	**KSEM1250R5SSF150**	31,750	1.2500	32,000	1.2598	.19	3.75	1.500	8	1/4-18 NPT	**364.013**
KSEM1281R3SSF150	–	32,540	1.2811	36,000	1.4173	.20	3.75	1.500	9	1/4-18 NPT	**364.015**
KSEM1281R5SSF150	–	32,540	1.2811	36,000	1.4173	.22	3.75	1.500	9	1/4-18 NPT	**364.015**
KSEM1297R3SSF150	**KSEM1297R5SSF150**	32,940	1.2969	36,000	1.4173	.23	3.75	1.500	9	1/4-18 NPT	**364.015**
KSEM1313R3SSF150	**KSEM1313R5SSF150**	33,340	1.3126	36,000	1.4173	.23	3.75	1.500	9	1/4-18 NPT	**364.015**
KSEM1328R3SSF150	–	33,730	1.3280	36,000	1.4173	.23	3.75	1.500	9	1/4-18 NPT	**364.015**
–	**KSEM1328R5SSF150**	33,730	1.2380	36,000	1.4173	.23	3.75	1.500	9	1/4-18 NPT	**364.015**
KSEM1344R3SSF150	**KSEM1344R5SSF150**	34,130	1.3437	36,000	1.4173	.24	3.75	1.500	9	1/4-18 NPT	**364.015**
KSEM1375R3SSF150	**KSEM1375R5SSF150**	34,930	1.3752	36,000	1.4173	.24	3.75	1.500	9	1/4-18 NPT	**364.015**
KSEM1406R3SSF150	**KSEM1406R5SSF150**	35,720	1.4063	36,000	1.4173	.25	3.75	1.500	9	1/4-18 NPT	**364.015**
KSEM1422R3SSF150	**KSEM1422R5SSF150**	36,120	1.4220	40,000	1.5748	.25	3.75	1.500	10	1/4-18 NPT	**364.015**
KSEM1438R3SSF150	**KSEM1438R5SSF150**	36,520	1.4378	40,000	1.5748	.25	3.75	1.500	10	1/4-18 NPT	**364.015**
KSEM1469R3SSF150	**KSEM1469R5SSF150**	37,310	1.4689	40,000	1.5748	.26	3.75	1.500	10	1/4-18 NPT	**364.015**
KSEM1500R3SSF150	**KSEM1500R5SSF150**	38,100	1.5000	40,000	1.5748	.26	3.75	1.500	10	1/4-18 NPT	**364.015**
KSEM1514R3SSF150	**KSEM1514R5SSF150**	38,460	1.5142	40,000	1.5748	.27	3.75	1.500	10	1/4-18 NPT	**364.015**

- Use designated insert blade with each drill body.
- For alternatives, see insert blade fitment chart on page H91–H92.
- Drill shipped with central lock screw, wrench, and side pipe plug.
- Order insert blade separately; see pages H52–H71.





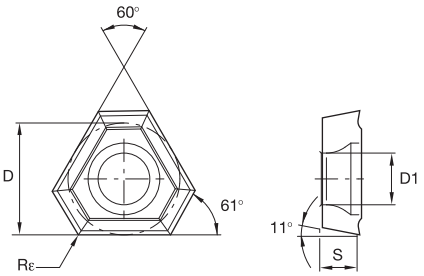
KSEM Flanged Shank • 8 x D • Inch

8 x D	D1 mm	D1 in	D1 max mm	D1 max in	L1	L3	L4 max	L5	LS	D	seat size	CS	central lock screw	wrench
KSEM0625R8SSF075	15,875	.6250	16,375	.6447	6.25	5.63	5.00	.10	2.00	.750	1	1/8-27 NPT	**364.010**	**170.271**
KSEM0688R8SSF075	17,463	.6875	17,963	.7072	7.00	6.38	5.50	.11	2.00	.750	1	1/8-27 NPT	**364.010**	**170.271**
KSEM0750R8SSF075	19,050	.7500	19,550	.7502	7.50	6.88	6.00	.12	2.00	.750	2	1/8-27 NPT	**364.010**	**170.281**
KSEM0750R8SSF100	19,050	.7500	19,550	.7502	7.50	6.88	6.00	.12	3.00	1.000	2	1/4-18 NPT	**364.010**	**170.281**
KSEM0813R8SSF100	20,638	.8125	21,138	.8322	8.00	7.38	6.50	.13	3.00	1.000	3	1/4-18 NPT	**364.011**	**170.282**
KSEM0875R8SSF100	22,225	.8750	22,725	.8947	8.50	7.88	7.00	.14	3.00	1.000	4	1/4-18 NPT	**364.011**	**170.282**
KSEM0875R8SSF125	22,225	.8750	22,725	.8947	8.50	7.88	7.00	.14	3.25	1.250	4	1/4-18 NPT	**364.011**	**170.282**
KSEM0938R8SSF100	23,813	.9375	24,000	.9448	9.13	8.51	7.50	.15	3.00	1.000	4	1/4-18 NPT	**364.011**	**170.282**
KSEM0984R8SSF100	25,003	.9844	25,503	1.0041	9.50	8.88	7.88	.15	3.00	1.000	5	1/4-18 NPT	**364.012**	**170.283**
KSEM1000R8SSF100	25,400	1.0000	25,900	1.0197	9.63	9.01	8.00	.15	3.00	1.000	5	1/4-18 NPT	**364.012**	**170.283**
KSEM1000R8SSF125	25,400	1.0000	25,900	1.0197	9.63	9.01	8.00	.15	3.25	1.250	5	1/4-18 NPT	**364.012**	**170.283**
KSEM1063R8SSF125	26,988	1.0625	27,488	1.0822	10.25	9.63	8.50	.16	3.25	1.250	6	1/4-18 NPT	**364.012**	**170.283**
KSEM1125R8SSF125	28,575	1.1250	29,075	1.1447	10.75	10.13	9.00	.17	3.25	1.250	7	1/4-18 NPT	**364.013**	**170.284**
KSEM1188R8SSF125	30,163	1.1875	30,663	1.2072	11.38	10.76	9.50	.18	3.25	1.250	8	1/4-18 NPT	**364.013**	**170.284**
KSEM1250R8SSF125	31,750	1.2500	32,000	1.2598	11.88	11.26	10.00	.19	3.25	1.250	8	1/4-18 NPT	**364.013**	**170.284**
KSEM1250R8SSF150	31,750	1.2500	32,000	1.2598	11.88	11.26	10.00	.19	3.75	1.500	8	1/4-18 NPT	**364.013**	**170.284**

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

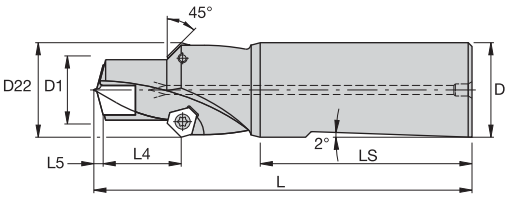
P		●	○
M	●	○	○
K		○	●
N	○	●	○
S		○	●
H			

TPGX-GD Geometry

	D		S		Rε		D1				
catalog number	mm	in	mm	in	mm	in	mm	in	KC7015	KC7315	KC7140
TPGX0902ZPRGD	5,56	.219	2,38	.094	0,20	.008	2,50	.098	●	●	●
TPGX1102ZPRGD	6,35	.250	2,38	.094	0,20	.008	2,85	.112	●	●	●
TPGX1303ZPRGD	7,94	.313	3,18	.125	0,20	.008	3,40	.134	●	●	●
TPGX1603ZPRGD	9,52	.375	3,18	.125	0,20	.008	4,40	.173	●	●	●

- 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 H52–H71.
- Order TPGX chamfering insert separately; see page H85.



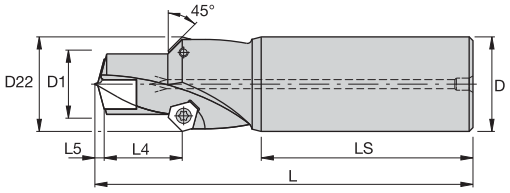




KSEM Bodies • WN/WD50 Shank with Chamfer • 1 x D • Metric

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**

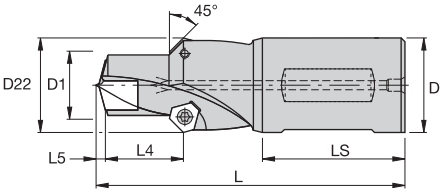
- Use any KSEM insert blade diameter within the designated seat size.
- Drill shipped with central lock screw, insert screw, and wrenches.
- Order insert blades separately; see pages H52–H71.
- Order TPGX chamfering insert separately; see page H85.

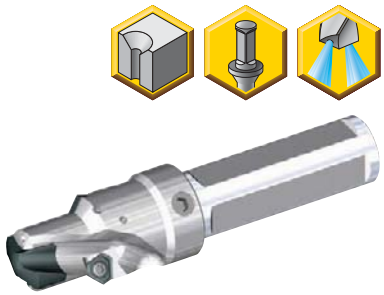




KSEM Bodies • WN/WD50 Shank with Chamfer • 1 x D • Metric

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**

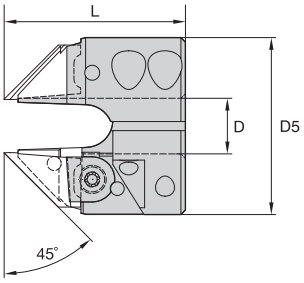


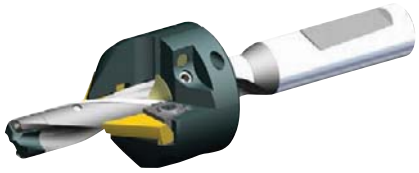


KSEM Bodies • Flanged Shank with Chamfer • 1 x D • Inch

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	pipe plug	wrench
KSEM0493R1SSF075F45	12,500	.4921	13,500	.5314	.70	4.00	.53	.08	2.00	.750	C	KSEM1250	**364.017**	**HSFS0125**	**170.051**
KSEM0532R1SSF075F45	13,600	.5354	14,500	.5708	.74	4.25	.57	.08	2.00	.750	B	KSEM1360	**364.016**	**HSFS0125**	**170.289**
KSEM0571R1SSF075F45	14,600	.5748	15,874	.6249	.77	4.25	.62	.09	2.00	.750	A	KSEM1460	**364.016**	**HSFS0125**	**170.289**
KSEM0625R1SSF075F45	15,880	.6252	18,000	.7086	.88	4.25	.71	.10	2.00	.750	1	KSEM0625	**364.010**	**HSFS0125**	**170.270**
KSEM0709R1SSF075F45	18,260	.7189	19,999	.7873	.96	4.25	.78	.11	2.00	.750	2	KSEM0719	**364.010**	**HSFS0125**	**170.270**
KSEM0788R1SSF100F45	20,000	.7874	22,000	.8661	1.11	5.50	.87	.13	3.00	1.000	3	KSEM2000	**364.011**	**HSFS0125**	**170.272**
KSEM0867R1SSF100F45	22,230	.8752	24,000	.9448	1.19	5.50	.94	.14	3.00	1.000	4	KSEM0875	**364.011**	**HSFS0125**	**170.272**
KSEM0945R1SSF100F45	24,500	.9646	26,000	1.0236	1.34	5.75	1.02	.15	3.00	1.000	5	KSEM2450	**364.012**	**HSFS0125**	**170.055**
KSEM1024R1SSF125F45	26,187	1.0310	28,000	1.1023	1.42	5.75	1.10	.16	3.25	1.250	6	KSEM1031	**364.012**	**HSFS0125**	**170.055**
KSEM1103R1SSF125F45	28,169	1.1090	30,000	1.1811	1.50	6.25	1.18	.17	3.25	1.250	7	KSEM1109	**364.013**	**HSFS0125**	**170.276**
KSEM1182R1SSF125F45	30,160	1.1874	32,000	1.2598	1.58	6.25	1.26	.18	3.25	1.250	8	KSEM1188	**364.013**	**HSFS0125**	**170.276**
KSEM1260R1SSF125F45	32,500	1.2795	36,000	1.4173	1.66	6.25	1.42	.19	3.25	1.250	9	KSEM3250	**364.015**	**HSFS0125**	**170.276**
KSEM1418R1SSF125F45	36,119	1.4220	40,000	1.5748	1.82	6.25	1.57	.22	3.25	1.250	10	KSEM1422	**364.015**	**HSFS0125**	**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 catalog 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.

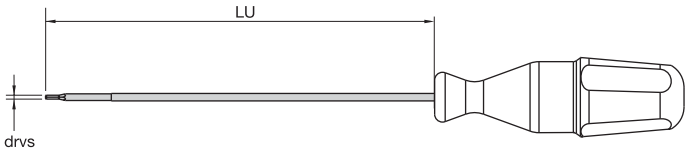




KSEM Chamfer Rings

	D		L		D5					
catalog 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 I30.



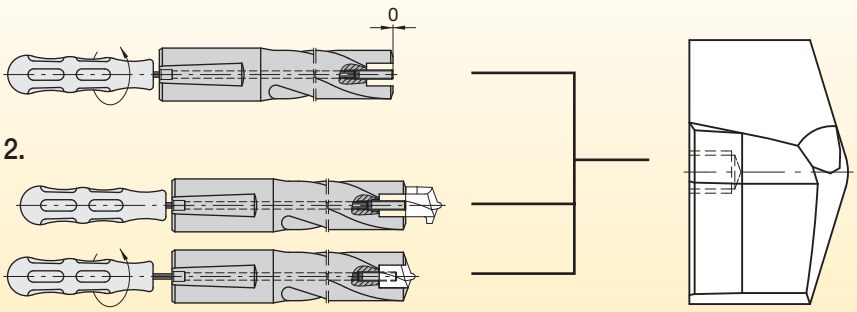


KSEM Wrenches

order number	catalog 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.

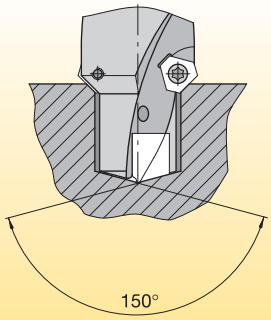
2) Tighten the insert using the screwdriver to fit securely in the insert seat.

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

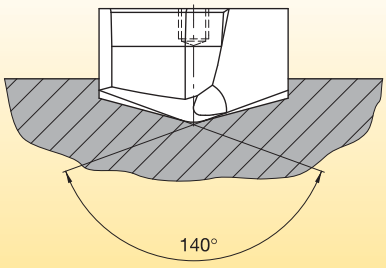
Repair of Damaged Threaded Pin

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.

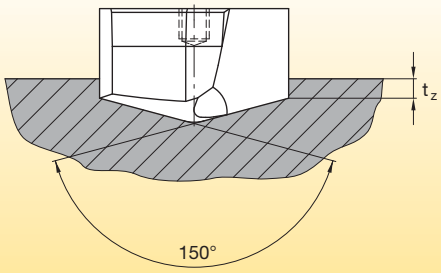
NOTE: For inserts without a connector pin, avoid jamming during mounting through precise positioning.



Precentering with FAS centering tool



HP inserts of the follower drill



Centering using PC inserts

Why is pre-centering necessary?

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

Why pre-center 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-center with PC inserts using toolholders as short as possible (1 x D).

What happens if...
...a center 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

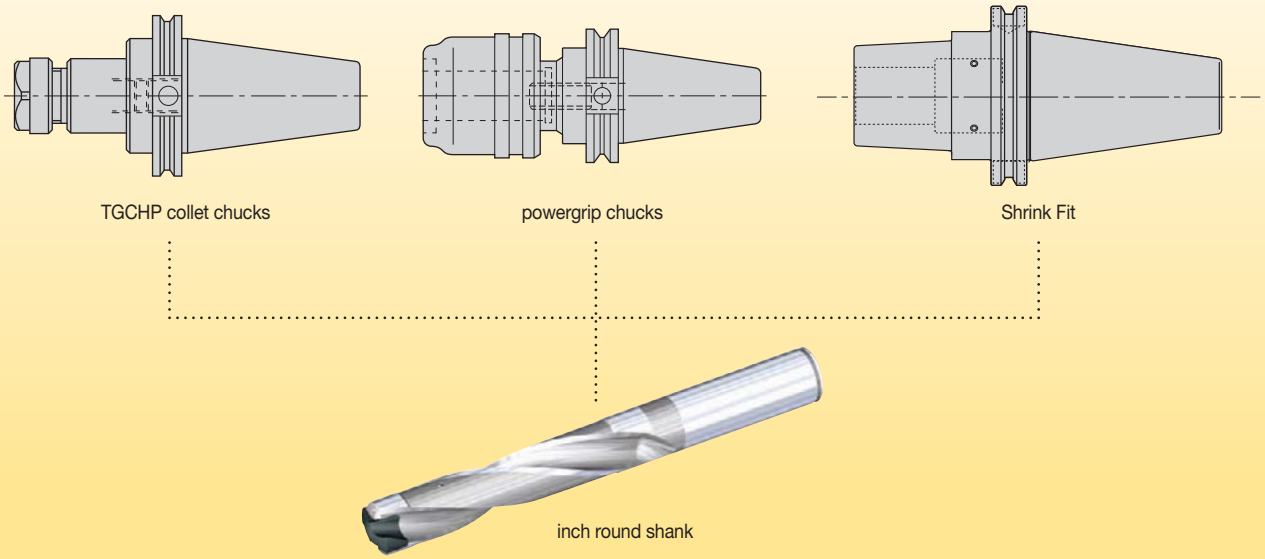
- Pre-center, using the same cutting insert as used for the follower drill but without the cutting edges penetrating the workpiece (spot drill ø approximately 90% of drill ø D1).

...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

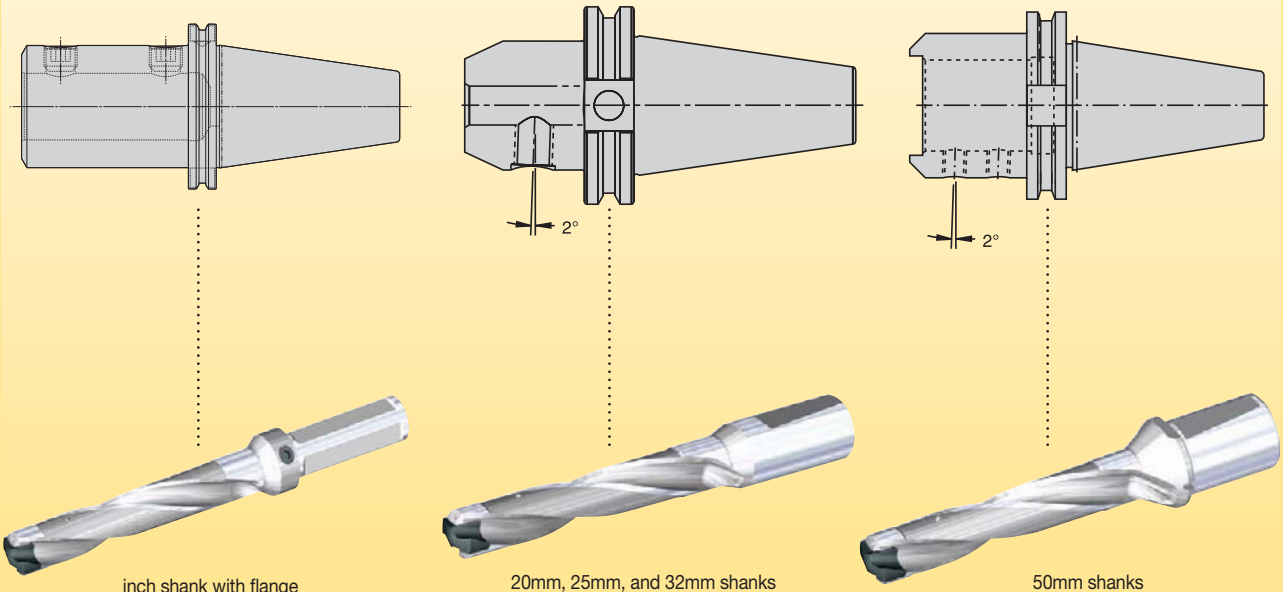
Inch Drill Bodies with Flange

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 adapters. The 50mm shank uses a WD adapter. Choose the correct adapter to minimize runout and securely hold the drill.

SSF straight-shank flanged adapter | WN adapters | WD adapters



inch shank with flange

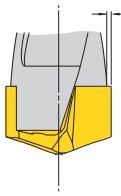
20mm, 25mm, and 32mm shanks
(DIN 1835, Form E)

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 .0098" (0,250mm) 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	–	–

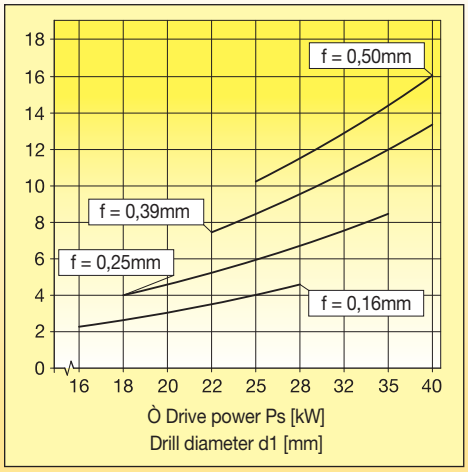
(continued)

(continued)

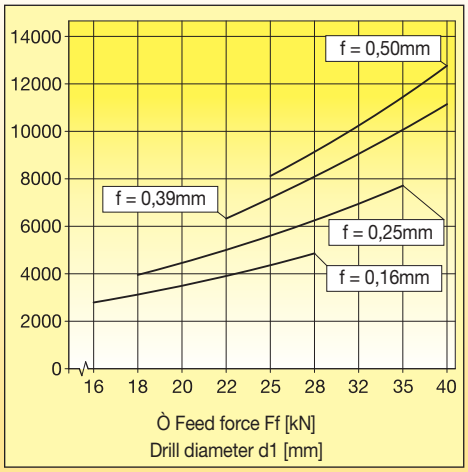
diameter D

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	–	–	–	–

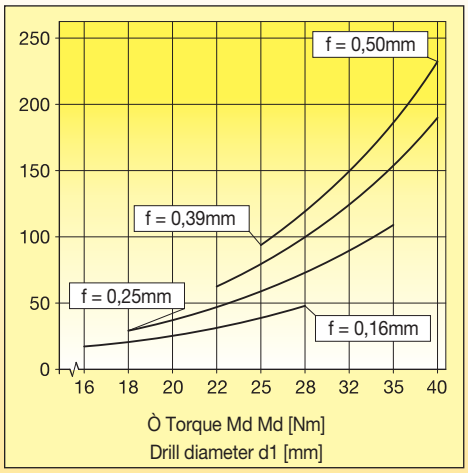
Drive Power (kW)



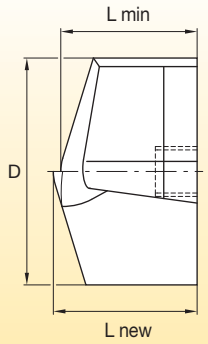
Feed Force (kN)



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:

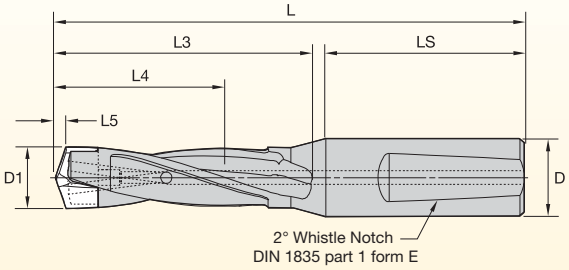
relative drilling depth	coolant pressure
1–3 x D	8 bars
5 x D	12 bars
7 x D	20 bars
10 x D	30 bars

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

Modular Drills • Dimension Tables

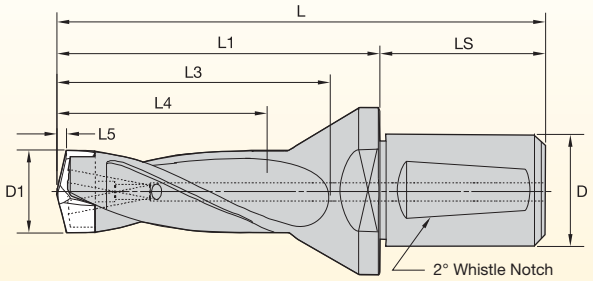
Dimensions for KSEM™ Whistle Notch Shank • WN/WD 3 x D to 10 x D • Metric





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**
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**

(continued)

Modular Drills • Dimension Tables *(continued)*

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

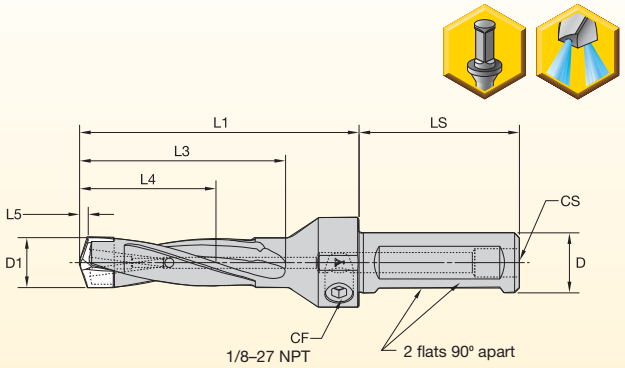


D1		WN/WD Shank Metric								WN Shank Metric					
		3 x D				5 x D				7 x D			10 x D		
mm	inch	L	L1	L4 max	wrench	L	L1	L4 max	wrench	L	L4 max	wrench	L	L4 max	wrench
30,00	11.811	190	–	90	**170.276**	250	–	150	**170.276**	310	210	**170.277**	400	300	**170.284**
30,01	11.815	–	–	–	**–**	264	–	160	**170.276**	–	–	**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**	–	–	**–**	–	–	**–**

(continued)

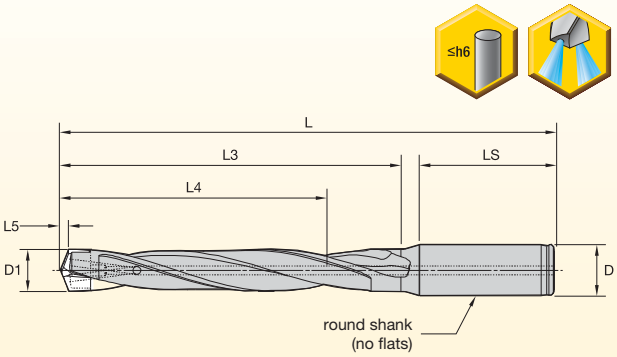
Modular Drills • Dimension Tables *(continued)*

Dimensions for KSEM Flanged Shank • 5 x D/8 x D • Inch



D1		5 x D			8 x D		
			L4			L4	
mm	inch	L1	max	wrench	L1	max	wrench
12,700	.5000	3.94	2.50	**170.294**	–	–	**–**
12,929	.5090	4.00	2.55	**170.294**	–	–	**–**
13,106	.5160	4.00	2.58	**170.294**	–	–	**–**
13,487	.5310	4.13	2.66	**170.294**	–	–	**–**
13,894	.5470	4.13	2.73	**170.289**	–	–	**–**
14,300	.5630	4.25	2.81	**170.289**	–	–	**–**
14,681	.5780	4.31	2.89	**170.289**	–	–	**–**
15,088	.5940	4.38	2.97	**170.289**	–	–	**–**
15,469	.6090	4.5	3.05	**170.289**	–	–	**–**
15,875	.6250	4.75	3.15	**170.270**	6.25	5.00	**170.271**
17,463	.6875	5.25	3.54	**170.270**	7.00	5.50	**170.271**
19,050	.7500	5.88	3.94	**170.271**	7.50	6.00	**170.281**
19,050	.7500	6.00	3.94	**170.271**	7.50	6.00	**170.281**
20,637	.8125	6.25	4.33	**170.273**	8.00	6.50	**170.282**
20,638	.8125	6.25	4.33	**170.273**	–	–	**170.282**
22,225	.8750	6.63	4.72	**170.273**	8.50	7.00	**170.282**
22,225	.8750	6.75	4.72	**170.273**	8.50	7.00	**170.282**
23,813	.9375	6.63	4.72	**170.273**	9.13	7.50	**170.282**
24,606	.9688	7.13	5.12	**170.275**	–	–	**–**
25,003	.9844	7.13	5.12	**170.275**	9.50	7.88	**170.283**
25,400	1.0000	7.25	5.12	**170.275**	9.63	8.00	**170.283**
25,400	1.0000	7.25	5.12	**170.275**	9.63	8.00	**170.283**
26,988	1.0625	7.63	5.51	**170.275**	10.25	8.50	**170.283**
28,575	1.1250	8.13	5.91	**170.277**	10.75	9.00	**170.284**
30,163	1.1875	8.50	6.30	**170.277**	11.38	9.50	**170.284**
31,750	1.2500	8.50	6.30	**170.277**	11.88	10.00	**170.284**
31,750	1.2500	8.75	6.30	**170.277**	11.88	10.00	**170.284**

Dimensions for KSEM Round Shank • 7 x D/10 x D • Inch



D1		7 x D			10 x D		
			L4			L4	
mm	inch	L1	max	wrench	L1	max	wrench
12,70	.5000	5.63	3.50	**170.295**	7.75	5.00	**170.296**
12,70	.5000	6.13	3.50	**170.295**	–	–	**–**
12,93	.5090	6.25	3.56	**170.295**	7.88	5.09	**170.296**
13,10	.5160	6.25	3.61	**170.295**	8.00	5.16	**170.296**
13,49	.5310	6.38	3.72	**170.295**	8.13	5.31	**170.296**
13,89	.5470	6.50	3.83	**170.290**	8.25	5.47	**170.291**
14,29	.5630	6.63	3.94	**170.290**	8.38	5.63	**170.291**
14,68	.5780	6.75	4.05	**170.290**	8.50	5.78	**170.291**
15,08	.5940	6.88	4.16	**170.290**	8.75	5.94	**170.291**
15,48	.6090	7.00	4.27	**170.290**	8.88	6.09	**170.291**
15,88	.6250	7.38	4.41	**170.270**	9.00	6.25	**170.281**
16,10	.6335	8.00	4.59	**170.271**	9.13	6.34	**170.281**
16,67	.6563	8.00	4.96	**170.271**	9.38	6.56	**170.281**
17,46	.6875	8.00	4.96	**170.271**	9.75	6.88	**170.281**
18,25	.7188	8.88	5.51	**170.271**	10.25	7.19	**170.281**
19,05	.7500	8.88	5.51	**170.271**	10.50	7.50	**170.281**
19,05	.7500	9.88	5.51	**170.281**	11.50	7.50	**170.281**
19,28	.7585	8.88	5.51	**170.271**	–	–	**–**
19,28	.7585	–	–	**–**	11.50	7.59	**170.281**
19,85	.7813	9.88	5.51	**170.281**	11.75	7.81	**170.281**
20,64	.8125	10.25	6.06	**170.273**	12.13	8.13	**170.282**
21,43	.8438	10.25	6.06	**170.273**	12.50	8.44	**170.282**
22,23	.8750	10.88	6.61	**170.282**	12.75	8.75	**170.282**
22,23	.8750	11.13	6.61	**170.282**	–	–	**–**
22,45	.8835	10.88	6.61	**170.282**	12.88	8.84	**170.282**
23,02	.9063	10.88	6.61	**170.282**	13.13	9.06	**170.282**
23,81	.9375	10.88	6.61	**170.282**	13.44	9.38	**170.282**
24,61	.9688	11.63	7.17	**170.275**	13.88	9.69	**170.283**
25,00	.9844	11.63	7.17	**170.283**	14.00	9.84	**170.283**
25,40	1.0000	11.63	7.17	**170.283**	14.13	10.00	**170.283**
25,40	1.0000	11.88	7.17	**170.283**	14.38	10.00	**170.283**
25,68	1.0105	12.25	7.08	**170.283**	14.50	10.11	**170.283**
26,20	1.0313	12.50	7.72	**170.283**	14.75	10.31	**170.283**
26,99	1.0625	12.50	7.72	**170.283**	15.13	10.63	**170.283**
27,78	1.0938	12.50	7.72	**170.283**	15.50	10.94	**170.283**
28,58	1.1250	13.13	8.27	**170.284**	15.75	11.25	**170.284**
29,37	1.1563	13.13	8.27	**170.284**	16.13	11.56	**170.284**
30,16	1.1875	13.75	8.82	**170.284**	16.50	11.88	**170.284**
30,96	1.2188	13.75	8.82	**170.284**	16.88	12.19	**170.284**
31,75	1.2500	13.75	8.82	**170.284**	17.13	12.50	**170.284**
31,75	1.2500	14.25	8.82	**170.284**	17.63	12.50	**170.284**

(continued)

Modular Drills • Dimension Tables *(continued)*

Dimensions for KSEM Round Shank • 3 x D/5 x D • Inch



D1		3 x D			5 x D		
			L4			L4	
mm	inch	L1	max	wrench	L1	max	wrench
12,700	.5000	–	–	**170.294**	4.63	2.50	**170.294**
12,700	.5000	4.13	1.50	**170.294**	5.13	2.50	**170.294**
12,929	.5090	4.25	1.53	**170.294**	5.25	2.55	**170.294**
13,106	.5160	–	–	**170.294**	5.25	2.58	**170.294**
13,487	.5310	4.25	1.59	**170.294**	5.38	2.66	**170.294**
13,894	.5470	4.38	1.64	**170.289**	5.44	2.73	**170.289**
14,300	.5630	4.38	1.69	**170.289**	5.50	2.81	**170.289**
14,681	.5780	4.50	1.73	**170.289**	5.63	2.89	**170.289**
15,088	.5940	4.50	1.78	**170.289**	5.75	2.97	**170.289**
15,469	.6090	4.63	1.83	**170.289**	5.88	3.05	**170.289**
15,875	.6250	4.63	1.88	**170.270**	6.00	3.15	**170.270**
16,091	.6335	–	–	**170.270**	6.50	3.54	**170.270**
16,104	.6340	4.75	1.90	**170.270**	–	–	**170.270**
16,281	.6410	4.75	1.92	**170.270**	6.50	3.54	**170.270**
16,662	.6560	4.88	1.97	**170.270**	–	–	**170.270**
16,669	.6563	–	–	**170.270**	6.50	3.54	**170.270**
17,069	.6720	4.88	2.02	**170.270**	6.50	3.54	**170.270**
17,463	.6875	4.88	2.06	**170.270**	6.50	3.54	**170.270**
17,856	.7030	5.00	2.11	**170.270**	6.50	3.54	**170.270**
18,256	.7188	–	–	**170.270**	7.25	3.94	**170.270**
18,263	.7190	5.00	2.16	**170.270**	–	–	**170.270**
18,644	.7340	5.13	2.20	**170.270**	7.25	3.94	**170.270**
19,050	.7500	6.13	2.25	**170.270**	8.25	3.94	**170.271**
19,050	.7500	5.13	2.25	**170.270**	7.25	3.94	**170.270**
19,279	.7585	5.25	2.28	**170.270**	7.25	3.94	**170.270**
19,456	.7660	6.25	2.30	**170.270**	8.25	3.94	**170.271**
19,845	.7813	6.25	2.34	**170.270**	8.13	3.94	**170.271**
19,837	.7810	–	–	**–**	–	–	**170.271**
20,244	.7970	6.38	2.39	**170.272**	8.50	4.33	**170.272**
20,638	.8125	6.38	2.44	**170.272**	8.50	4.33	**170.272**
21,431	.8438	–	–	**170.272**	8.50	4.33	**170.272**
21,438	.8440	6.50	2.53	**170.272**	–	–	**170.272**
21,829	.8590	6.63	2.58	**170.272**	8.50	4.33	**170.272**
21,819	.8590	–	–	**170.272**	–	–	**170.272**
22,225	.8750	6.88	2.63	**170.272**	9.00	4.72	**170.273**
22,225	.8750	6.63	2.63	**170.272**	9.25	4.72	**170.273**
22,454	.8835	6.75	2.65	**170.272**	9.00	4.72	**170.273**
22,454	.8840	–	–	**170.272**	–	–	**170.273**
23,012	.9060	6.75	2.72	**170.272**	–	–	**170.273**
23,019	.9063	–	–	**170.272**	9.00	4.72	**170.273**

D1		3 x D			5 x D		
			L4			L4	
mm	inch	L1	max	wrench	L1	max	wrench
23,419	.9220	6.88	2.77	**170.272**	9.00	4.72	**170.273**
23,813	.9375	6.88	2.81	**170.272**	9.00	4.72	**170.273**
24,606	.9688	–	–	**170.272**	9.50	5.12	**170.274**
24,613	.9690	7.00	2.91	**170.274**	–	–	**170.274**
25,003	.9844	7.13	2.95	**170.274**	9.50	5.12	**170.274**
25,400	1.0000	7.13	3.00	**170.274**	9.75	5.12	**170.274**
25,400	1.0000	–	–	**170.274**	9.50	5.12	**170.274**
25,679	1.0105	–	–	**170.274**	10.00	5.06	**170.274**
25,679	1.0110	7.50	3.03	**170.274**	–	–	**–**
26,187	1.0310	7.50	3.09	**170.274**	–	–	**–**
26,195	1.0313	–	–	**170.274**	10.25	5.51	**170.275**
26,594	1.0470	–	–	**170.274**	10.25	5.51	**170.275**
26,988	1.0625	7.63	3.19	**170.274**	10.25	5.51	**170.275**
27,781	1.0938	–	–	**170.274**	10.25	5.51	**170.275**
28,169	1.1090	7.88	3.33	**170.274**	10.75	5.91	**170.276**
28,575	1.1250	7.88	3.38	**170.276**	10.75	5.91	**170.276**
29,362	1.1560	8.00	3.47	**170.276**	–	–	**–**
29,370	1.1563	–	–	**170.276**	10.75	5.91	**170.276**
29,769	1.1720	8.13	3.52	**170.276**	10.75	5.91	**170.276**
30,163	1.1875	8.13	3.56	**170.276**	11.25	6.30	**170.277**
30,556	1.2030	–	–	**170.276**	11.25	6.30	**170.277**
30,958	1.2188	–	–	**170.276**	11.25	6.30	**170.277**
30,963	1.2190	8.25	3.66	**170.276**	–	–	**–**
31,750	1.2500	8.38	3.75	**170.276**	11.75	6.30	**170.277**
31,750	1.2500	8.88	3.75	**170.276**	11.25	6.30	**170.277**
32,537	1.2810	9.00	3.84	**170.276**	12.50	6.41	**170.277**
32,941	1.2970	–	–	**170.276**	12.50	6.48	**170.277**
32,944	1.2970	9.13	3.89	**170.276**	–	–	**–**
33,350	1.3130	9.13	3.94	**170.276**	12.50	6.56	**170.277**
33,731	1.3280	9.25	3.98	**170.276**	–	–	**–**
33,734	1.3280	–	–	**170.276**	12.50	6.64	**170.277**
34,138	1.3440	–	–	**170.276**	13.00	6.72	**170.277**
34,925	1.3750	9.38	4.13	**170.276**	13.00	6.87	**170.277**
35,712	1.4060	9.50	4.22	**170.276**	13.00	7.03	**170.277**
36,119	1.4220	–	–	**170.276**	13.50	7.11	**170.277**
36,513	1.4380	–	–	**170.276**	13.50	7.19	**170.277**
36,525	1.4380	9.63	4.31	**170.276**	–	–	**–**
37,313	1.4690	–	–	**170.276**	13.50	7.34	**170.277**
38,100	1.5000	9.88	4.50	**170.276**	13.50	7.50	**170.277**
38,456	1.5140	10.00	4.54	**170.276**	13.50	7.57	**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.

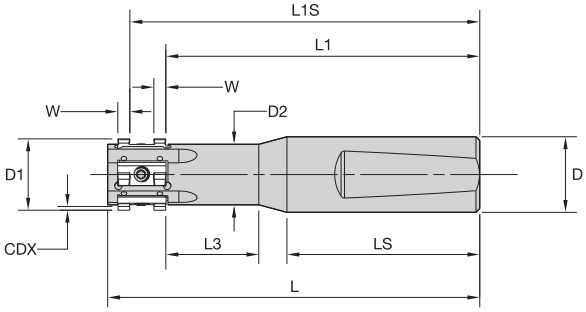
Features and Benefits

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.


KENNAMETAL
KENNAMETAL







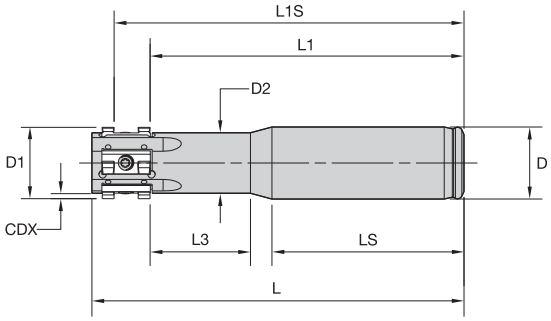
KGEM Groover Body • Metric



order number	catalog number	D1 mm	D1 in	D2	D mm	D in	L	LS	L1	L1S	L3	CDX	insert screw
5408657	KGEM1588R1WN20M	15,88	.625	13,50	20,00	.787	101,00	51,00	85,00	94,52	25,63	1,00	MS1861
5134143	KGEM1905R1WN20M	18,87	.743	16,00	20,00	.787	98,42	50,80	83,03	92,55	24,58	1,00	MS1861
5134145	KGEM1905R3WN20M	18,87	.743	16,00	20,00	.787	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.







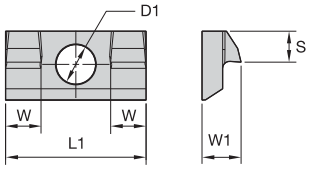
KGEM Groover Body • Inch



order number	catalog number	D1 mm	D1 in	D2	D	L	LS	L1	L1S	L3	CDX	insert screw
5134142	KGEM0750R1SS075	18,87	.743	.63	.75	3 7/8	2.000	3.269	3.644	1.045	.039	MS1861
5134144	KGEM0750R3SS075	18,87	.743	.63	.75	4 7/8	2.000	4.269	4.644	2.045	.039	MS1861

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.





● first choice
○ alternate choice

P		●
M		●
K		
N		
S		●
H		

KGEM Groover Insert

order number	catalog 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	●

Application Data

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

KGEM Tube Sheet Groover • KGIP GD Geometry • Grade KCU45 • Through Coolant • Inch

Material Group	fz (inch/tooth)	tooth	RPM	vc (SFM)	VFC (inch/min)	VFL (inch/min)	DH (inch)	DT (inch)
P	0.002–0.003	4	1300–1500	252–291	0.097–0.168	10.4–18.0	0.75	0.743
M	0.002–0.003	4	600–900	116–174	0.067–0.101	7.2–10.8	0.75	0.743
S	0.002–0.003	4	250–300	48–58	0.019–0.034	2.0–3.6	0.75	0.743

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 center inserts and modular heads due to better chip flow.
- No precentering 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 15º.

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

Center 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

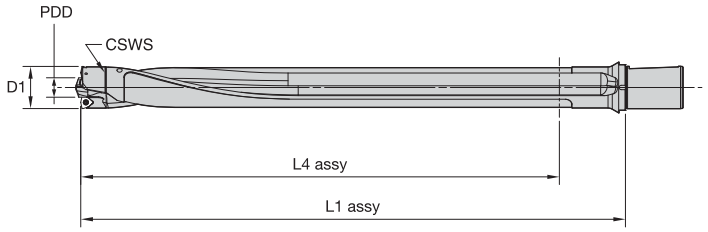
- KCU25™ grade — high metal removal rates, advanced TiCN-Al-CVD coating, and superior tool life in stable working conditions.
- KCU40™ grade — multilayered TiAlN-PVD coating with high wear resistance and reliability in most materials at medium cutting speeds.
- KC7140™ grade — TiCN-based, PVD-coated 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.

Customization

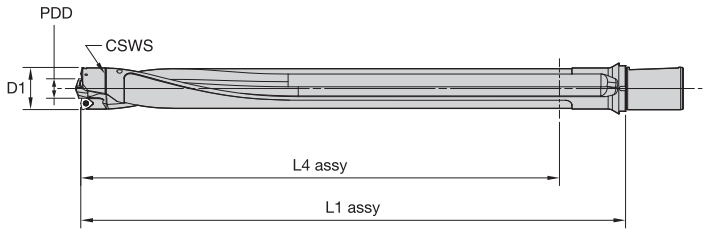
- Heads are available in intermediate diameters, and up to Ø 127mm as semi-standards.
- Tool bodies available in all popular shank styles up to shank length of 1200mm. Some restrictions with L/D ratios over 20 x D apply.
- Toolholders can be designed with helical chip flutes for better chip evacuation (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 customization. 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 catalog number	PDD (mm) center insert size reference	outboard insert Drill Fix™ DFC DPA guiding pads	CSWS	KSEM PLUS body order number	KSEM PLUS body ANSI catalog 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

(continued)

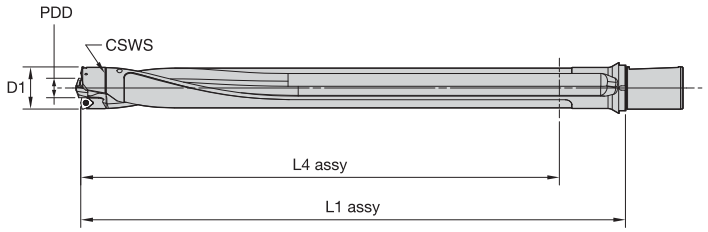
(KSEM PLUS Overview and Assembly for Systems Using A1 Heads — continued)



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 catalog number	PDD (mm) center insert size reference	outboard insert Drill Fix™ DFC DPA guiding pads	CSWS	KSEM PLUS body order number	KSEM PLUS body ANSI catalog 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						

(continued)

(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 catalog number	PDD (mm) center insert size reference	outboard insert Drill Fix™ DFC DPA guiding pads	CSWS	KSEM PLUS body order number	KSEM PLUS body ANSI catalog 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							

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See pages H102–H106, H108–H125, and H133 for KSEM PLUS A1 and B1 head systems.



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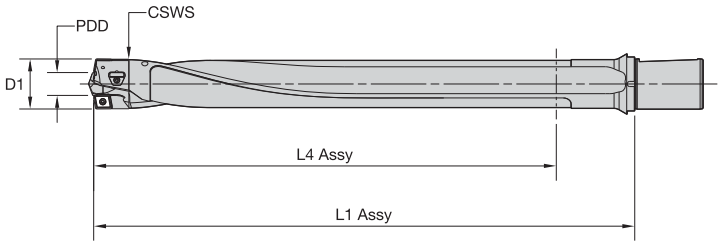

available KSEM PLUS heads				requested insert size reference per head		available tool bodies per CSWS connecting size 3 x D, 5 x D, 8 x D, 10 x D (metric and inch bodies)					
D1		KSEM PLUS head order number	KSEM PLUS head ANSI catalog number	PDD (mm) center insert size reference	outboard insert Drill Fix™ DFC DPA guiding pads	CSWS	KSEM PLUS body order number	KSEM PLUS body ANSI catalog 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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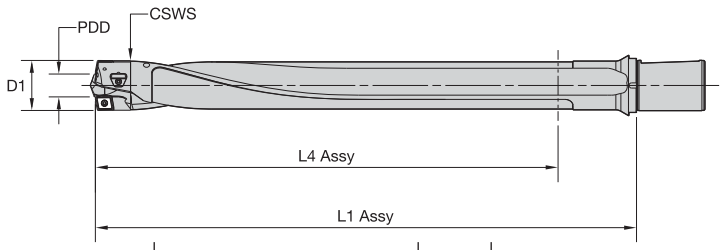
(KSEM PLUS Overview and Assembly for Systems Using B1 Heads — continued)



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 catalog number	PDD (mm) center insert size reference	outboard insert Drill Fix™ DFC DPA guiding pads	CSWS	KSEM PLUS body order number	KSEM PLUS body ANSI catalog 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							

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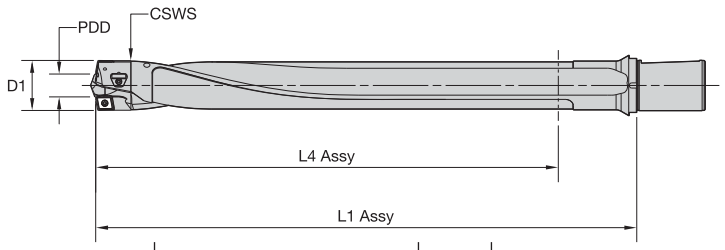
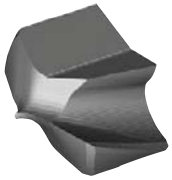
(KSEM PLUS Overview and Assembly for Systems Using B1 Heads — continued)

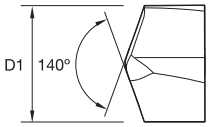


available KSEM PLUS heads				requested insert size reference per head			available tool bodies per CSWS connecting size 3 x D, 5 x D, 8 x D, 10 x D (metric and inch bodies)				
D1		KSEM PLUS head order number	KSEM PLUS head ANSI catalog number	PDD (mm) center insert size reference	outboard insert Drill Fix™ DFC DPA guiding pads	CSWS	KSEM PLUS body order number	KSEM PLUS body ANSI catalog 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 H116 to configure your insert setup depending on the application.



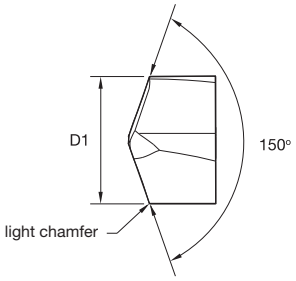
HPG/HPCCL



D1 (mm) = PDD



PC



D1 (mm) = PDD

KSEM PLUS Center Inserts

P	M	K	N	S	H
●	●	○	○	○	

P	M	K	N	S	H
		●			

P	M	K	N	S	H
○	●	○	○	●	●

● 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 KSEMP HPG • KSEM HPCCL • Inch

D1	tolerance h8
.500–.709	+.000/-.0010
>.709–1.181	+.000/-.0013
>1.181–1.575	+.000/-.0015

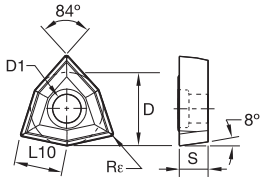
Tolerance KSEM PC • Metric

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

Tolerance KSEM PC • Inch

D1 inch	tolerance k7
.500–.709	+.0000/+.0008
>.709–1.181	+.0000/+.0009
>1.181–1.575	+.0000/+.0010



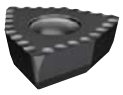


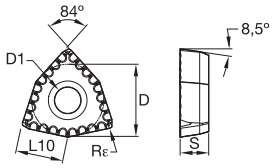
● first choice
○ alternate choice

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

DFT-HP

	L10		D		D1		S		Rε			
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	KCU25	KCU40
DFT05T308D32HP	5,29	.208	8,00	.315	3,40	.134	3,75	.148	0,80	.031	●	●
DFT05T308D33HP	5,29	.208	8,00	.315	3,40	.134	3,75	.148	0,80	.031	●	●
DFT06T308D36HP	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●	●
DFT06T308D39HP	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●	●
DFT06T308D44HP	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●	●
DFT070408D45HP	7,94	.313	12,00	.472	4,40	.173	4,75	.187	0,80	.031	●	●
DFT070408D50HP	7,94	.313	12,00	.472	4,40	.173	4,75	.187	0,80	.031	●	●
DFT090508D56HP	9,92	.391	15,00	.591	5,50	.217	5,25	.207	0,80	.031	●	●
DFT090508D63HP	9,92	.391	15,00	.591	5,50	.217	5,25	.207	0,80	.031	●	●



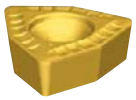


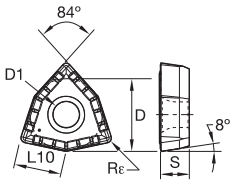
● first choice
○ alternate choice

P											●	
M											○	
K												
N											○	
S											○	
H												

DFT • DS

	L10		D		D1		S		Rε		
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	KCU40
DFT05T308D32DS	5,29	.208	8,00	.315	3,40	.134	3,75	.148	0,80	.031	●
DFT05T308D33DS	5,29	.208	8,00	.315	3,40	.134	3,75	.148	0,80	.031	●
DFT06T308D36DS	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●
DFT06T308D39DS	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●
DFT06T308D44DS	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●
DFT070408D45DS	7,94	.313	12,00	.472	4,40	.173	4,75	.187	0,80	.031	●
DFT070408D50DS	7,94	.313	12,00	.472	4,40	.173	4,75	.187	0,80	.031	●
DFT090508D56DS	9,92	.391	15,00	.591	5,50	.217	5,25	.207	0,80	.031	●
DFT090508D63DS	9,92	.391	15,00	.591	5,50	.217	5,25	.207	0,80	.031	●



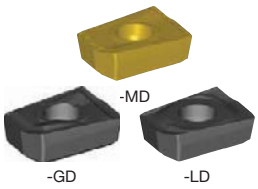


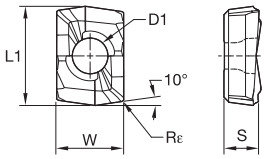
● first choice
○ alternate choice

P	●
M	●
K	○
N	○
S	○
H	

DFT-MD

	L10		D		D1		S		Rε		
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	KC7140
DFT05T308D32MD	5,29	.208	8,00	.315	3,40	.134	3,75	.148	0,80	.031	●
DFT05T308D33MD	5,29	.208	8,00	.315	3,40	.134	3,75	.148	0,80	.031	●
DFT06T308D36MD	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●
DFT06T308D39MD	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●
DFT06T308D44MD	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●
DFT070408D45MD	7,94	.313	12,00	.472	4,40	.173	4,75	.187	0,80	.031	●
DFT070408D50MD	7,94	.313	12,00	.472	4,40	.173	4,75	.187	0,80	.031	●
DFT090508D56MD	9,92	.391	15,00	.591	5,50	.217	5,25	.207	0,80	.031	●
DFT090508D63MD	9,92	.391	15,00	.591	5,50	.217	5,25	.207	0,80	.031	●



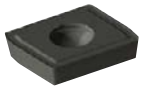


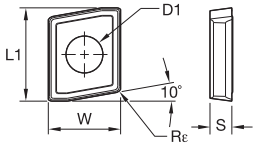
● first choice
○ alternate choice

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

DFR-GD, -MD, -LD

	LI		W		D1		S		Rε					
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	KC7140	KC7225	KCU25	KCU40
DFR040304D28GD	10,76	.424	7,26	0.29	2,85	.112	3,79	.149	0,40	.016	–	–	●	●
DFR040304D28LD	10,76	.424	7,26	0.29	2,85	.112	3,78	.149	0,40	.016	–	●	–	–
DFR040304D28MD	10,76	.424	7,26	0.29	2,85	.112	3,79	.149	0,40	.016	●	–	–	–





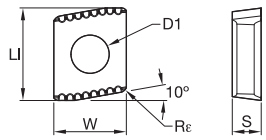
● first choice
○ alternate choice

P	●	●
M	○	○
K	●	○
N	○	●
S	○	●
H		

DFC-HP

	LI		W		D1		S		Rε		KCU25	KCU40
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in		
DFC040310D28HP	10,00	.3940	7,60	.2990	2,85	.1120	3,18	.1250	0,50	.0200	●	●
DFC05T312D32HP	12,00	.4720	9,40	.3700	3,40	.1340	3,75	.1480	0,80	.0320	●	●
DFC06T312D36HP	16,00	.6300	12,40	.4880	4,40	.1730	3,75	.1480	0,80	.0320	●	●
DFC070416D45HP	18,00	.7090	14,50	.5710	4,40	.1730	4,75	.1870	0,80	.0320	●	●
DFC090520D56HP	24,00	.9450	19,00	.7480	5,50	.2170	5,25	.2070	0,80	.0310	●	●





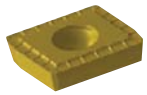
● first choice
○ alternate choice

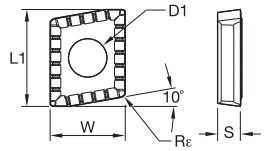
P	●	
M	○	
K	○	
N	●	
S	●	
H		

DFC-DS

NEW!

	LI		W		D1		S		Rε		KCU40
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	
DFC040310D28DS	10,00	.394	7,60	.299	2,85	.112	3,18	.125	0,50	.020	●
DFC05T312D32DS	12,00	.472	9,40	.370	3,40	.134	3,75	.148	0,80	.031	●
DFC06T312D36DS	16,00	.630	12,40	.488	4,40	.173	3,75	.148	0,80	.031	●
DFC070416D45DS	18,00	.709	14,50	.571	4,40	.173	4,75	.187	0,80	.031	●
DFC090520D56DS	24,00	.945	19,00	.748	5,50	.217	5,25	.207	0,80	.031	●



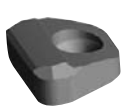


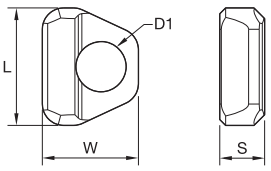
● first choice
○ alternate choice

P	●	
M	●	
K	○	
N	○	
S	○	
H		

DFC-MD

	LI		W		D1		S		Rε		KC7140
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	
DFC040310D28MD	10,00	.3940	7,60	.2990	2,85	.1120	3,18	.1250	0,50	.0200	●
DFC05T312D32MD	12,00	.4720	9,40	.3700	3,40	.1340	3,75	.1480	0,80	.0310	●
DFC06T312D36MD	16,00	.6300	12,40	.4880	4,40	.1730	3,75	.1480	0,80	.0310	●
DFC070416D45MD	18,00	.7090	14,50	.5710	4,40	.1730	4,75	.1870	0,80	.0310	●
DFC090520D56MD	24,00	.9450	19,00	.7480	5,50	.2170	5,25	.2070	0,80	.0310	●





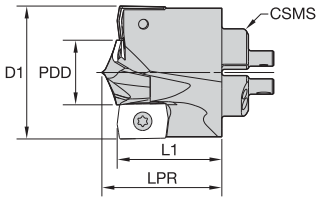
● first choice
○ alternate choice

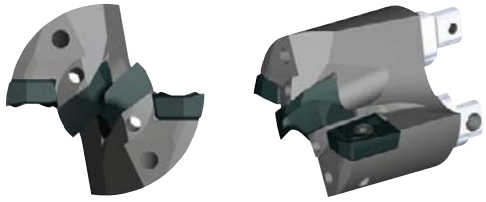
P	●	
M	●	
K	●	
N	●	
S	●	
H		

DPA Guiding Pads

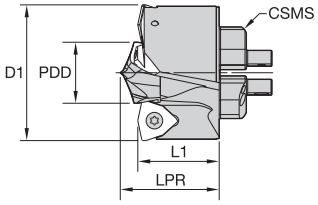
	L		W		D1		S		KCU40
catalog number	mm	in	mm	in	mm	in	mm	in	
DPA07T3D25	8,60	.3390	7,00	.2760	2,85	.1120	3,50	.1380	●
DPA09T4D32	11,00	.4330	9,00	.3540	3,40	.1340	4,20	.1650	●
DPA13T5D50	16,00	.6300	13,00	.5120	4,40	.1730	5,20	.2050	●

- 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.



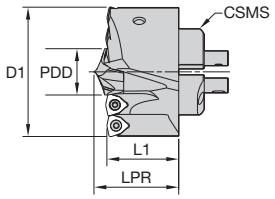


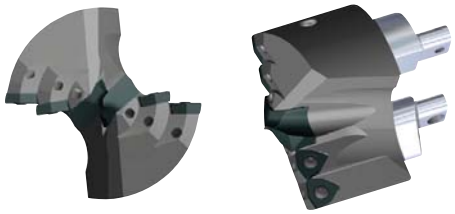
2 x DFR
diameter: 28–<31,75mm



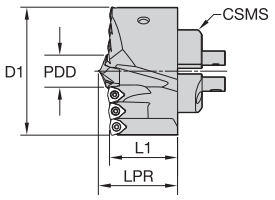


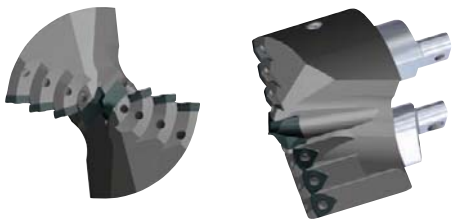
2 x DFT
diameter: 31,75–70,34mm





4 x DFT
diameter: 70,35–93,34mm





6 x DFT
diameter: 93,35–127mm

KSEM PLUS A1 Heads 1.102–4" (28–101,60mm)

order number	ISO catalog number	ANSI catalog number	D1 mm	D1 in	PDD mm	PDD in	LPR mm	LPR in	L1 mm	L1 in	CSMS system size
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 1.102–4" (28–101,60mm) — continued)

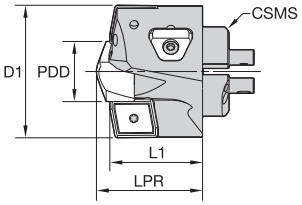
order number	ISO catalog number	ANSI catalog number	D1 mm	D1 in	PDD mm	PDD in	LPR mm	LPR in	L1 mm	L1 in	CSMS system size
3794394	KSEMP3600FDS36A1M	KSEMP3600FDS36A1M	36,00	1.417	13,00	.5118	22,7	.893	20,0	.787	FDS36
3794919	KSEMP3651FDS36A1M	KSEMP1438FDS36A1	36,53	1.438	14,00	.5512	22,9	.900	20,0	.787	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

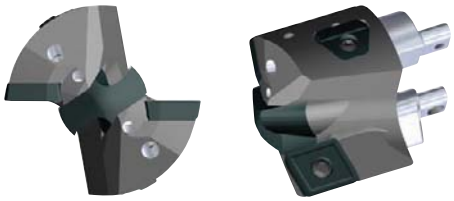
(continued)

(KSEM PLUS A1 Heads 1.102–4" (28–101,60mm) — continued)

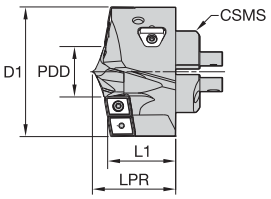
order number	ISO catalog number	ANSI catalog number	D1		PDD		LPR		L1		CSMS system size
			mm	in	mm	in	mm	in	mm	in	
5397515	KSEMP7600FDS71A1M	KSEMP7600FDS71A1M	76,00	2.992	31,00	1.2200	47,7	1.876	47,7	1.876	FDS71
5397516	KSEMP7620FDS71A1M	KSEMP3000FDS71A1	76,20	3.000	31,00	1.2200	47,7	1.876	47,7	1.876	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.



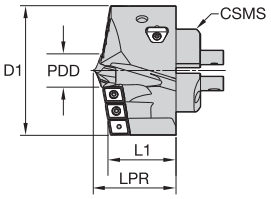


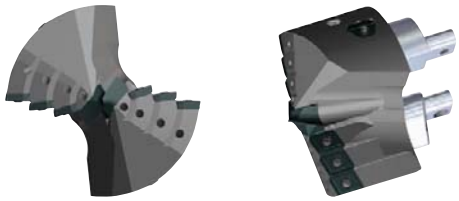
2 x DFC
diameter: 28–70,34mm





4 x DFC
diameter: 70,35–93,34mm





6 x DFC
diameter: 93,35–127mm

KSEM PLUS B1 Heads 1.102–4" (28–101,60mm)

order number	ISO catalog number	ANSI catalog 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 1.102–4" (28–101,60mm) — continued)

order number	ISO catalog number	ANSI catalog 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)

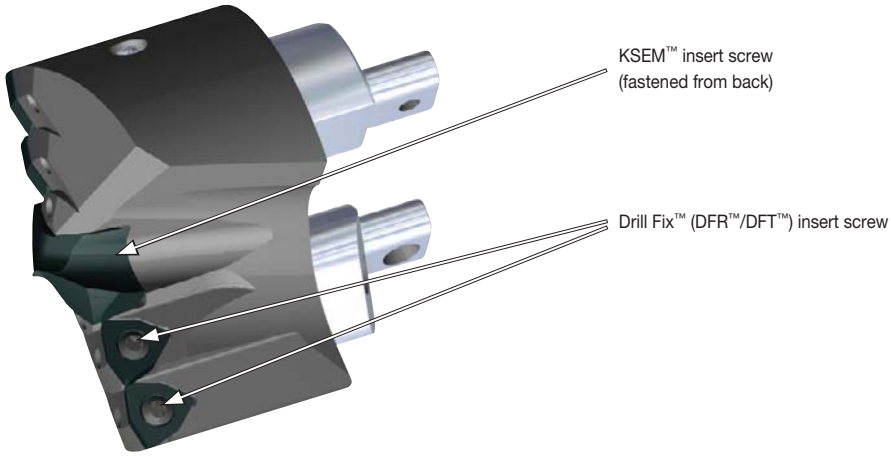
(KSEM PLUS B1 Heads 1.102–4" (28–101,60mm) — continued)

order number	ISO catalog number	ANSI catalog 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

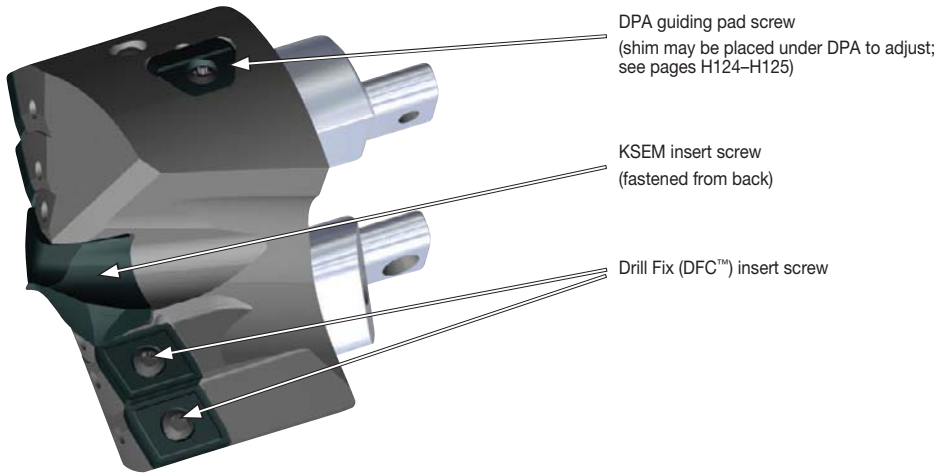
NOTE: When one screw is listed, it is for both insert and guiding pad. When two screws are listed, the first one is for the insert screw, and the second one is for the guiding pad. Find complete KSEM PLUS B1 product overview on pages H108–H110.

- 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 1.102–4" (28–101,60mm) • 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 1.102–4" (28–101,60mm) • 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 1.102–4" (28–101,60mm) • 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 1.102–4" (28–101,60mm) • Spare Parts — continued)



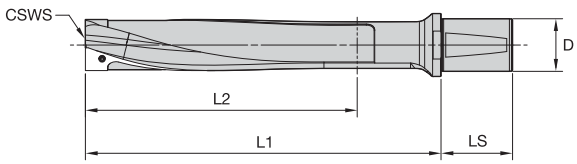






D1		PDD									
mm	in	mm	in	CSMS system size	KSEM insert screw	Torx wrench	DFC insert screw	Torx wrench	DPA guiding pad screw	Torx wrench	shim pack
63,50	2.500	28,00	1.102	FDS63	364.012	170.347	191.726	170.356	191.916	170.355	193.556
64,00	2.520	28,00	1.102	FDS63	364.012	170.347	191.726	170.356	191.916	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 H115–H120.
- 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 catalog 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 catalog 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 catalog 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 catalog 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**

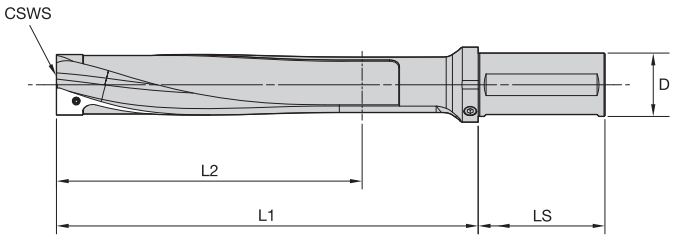
KSEM PLUS WD Shanks • 10 x D • Metric





10 x D catalog 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**

- Order KSEM PLUS heads according to the connection coupling size (CSWS).
- Order KSEM PLUS heads separately; see pages H115–H120.
- Wrench will be shipped with KSEM PLUS head.
- Custom solution for cast iron application with twisted flutes available.





KSEM PLUS SSF Shanks • 1.5 x D • Inch

1.5 x D catalog number	CSWS system size	D	L1	L2	LS	clamp screw	pipe plug
SSF150FDS280299	FDS28	1.5000	2.99	1.26	3.75	**193.537**	**HSFS0125**
SSF150FDS320323	FDS32	1.5000	3.23	1.34	3.75	**193.523**	**HSFS0125**
SSF150FDS360362	FDS36	1.5000	3.62	1.58	3.75	**193.524**	**HSFS0125**
SSF200FDS400394	FDS40	2.0000	3.94	1.69	4.00	**193.524**	**HSFS0125**
SSF200FDS450441	FDS45	2.0000	4.41	1.97	4.00	**193.525**	**HSFS0125**
SSF200FDS500480	FDS50	2.0000	4.80	2.13	4.00	**193.525**	**HSFS0125**
SSF200FDS560551	FDS56	2.0000	5.51	2.56	4.00	**193.526**	**HSFS0125**
SSF200FDS630606	FDS63	2.0000	6.06	2.80	4.00	**193.526**	**HSFS0125**
SSF200FDS710677	FDS71	2.0000	6.77	3.15	4.00	**193.526**	**HSFS0500**
SSF200FDS800756	FDS80	2.0000	7.56	3.54	4.00	**193.545**	**HSFS0500**
SSF200FDS900835	FDS90	2.0000	8.35	3.94	4.00	**193.545**	**HSFS0500**

KSEM PLUS SSF Shanks • 3 x D • Inch

3 x D catalog number	CSWS system size	D	L1	L2	LS	clamp screw	pipe plug
SSF150FDS280502	FDS28	1.5000	5.04	2.80	3.75	**193.537**	**HSFS0125**
SSF150FDS320573	FDS32	1.5000	5.75	3.35	3.75	**193.523**	**HSFS0125**
SSF150FDS360652	FDS36	1.5000	6.54	3.82	3.75	**193.524**	**HSFS0125**
SSF200FDS400721	FDS40	2.0000	7.20	4.21	3.75	**193.524**	**HSFS0125**
SSF200FDS450809	FDS45	2.0000	8.11	4.80	4.00	**193.525**	**HSFS0125**
SSF200FDS500896	FDS50	2.0000	8.98	5.32	4.00	**193.525**	**HSFS0125**
SSF200FDS561020	FDS56	2.0000	10.20	6.14	4.00	**193.526**	**HSFS0125**
SSF200FDS631138	FDS63	2.0000	11.38	6.85	4.00	**193.526**	**HSFS0125**
SSF200FDS711150	FDS71	2.0000	11.50	7.87	4.00	**193.526**	**HSFS0500**
SSF200FDS801287	FDS80	2.0000	12.87	8.86	4.00	**193.545**	**HSFS0500**
SSF200FDS901425	FDS90	2.0000	14.25	9.84	4.00	**193.545**	**HSFS0500**

KSEM PLUS SSF Shanks • 5 x D • Inch







5 x D catalog number	CSWS system size	D	L1	L2	LS	clamp screw	pipe plug
SSF150FDS280746	FDS28	1.5000	7.48	5.24	3.75	193.537	HSFS0125
SSF150FDS320850	FDS32	1.5000	8.50	6.10	3.75	193.523	HSFS0125
SSF150FDS360960	FDS36	1.5000	9.61	6.89	3.75	193.524	HSFS0125
SSF200FDS401066	FDS40	2.0000	10.67	7.68	4.00	193.524	HSFS0125
SSF200FDS451196	FDS45	2.0000	11.97	8.66	4.00	193.525	HSFS0125
SSF200FDS501330	FDS50	2.0000	13.31	9.65	4.00	193.525	HSFS0125
SSF200FDS561507	FDS56	2.0000	15.08	11.02	4.00	193.526	HSFS0125
SSF200FDS631688	FDS63	2.0000	16.89	12.36	4.00	193.526	HSFS0125
SSF200FDS711780	FDS71	2.0000	17.80	14.17	4.00	193.526	HSFS0500
SSF200FDS801996	FDS80	2.0000	19.96	15.95	4.00	193.545	HSFS0500
SSF200FDS902213	FDS90	2.0000	22.13	17.72	4.00	193.545	HSFS0500

KSEM PLUS SSF Shanks • 8 x D • Inch







8 x D catalog number	CSWS system size	D	L1	L2	LS	clamp screw	pipe plug
SSF150FDS281112	FDS28	1.5000	11.14	8.90	3.75	193.537	HSFS0125
SSF150FDS321263	FDS32	1.5000	12.64	10.24	3.75	193.523	HSFS0125
SSF150FDS361421	FDS36	1.5000	14.21	11.50	3.75	193.524	HSFS0125
SSF200FDS401586	FDS40	2.0000	15.87	12.87	4.00	193.524	HSFS0125
SSF200FDS451775	FDS45	2.0000	17.76	14.45	4.00	193.525	HSFS0125
SSF200FDS501980	FDS50	2.0000	19.80	16.14	4.00	193.525	HSFS0125
SSF200FDS562240	FDS56	2.0000	22.40	18.35	4.00	193.526	HSFS0125
SSF200FDS632515	FDS63	2.0000	25.16	20.63	4.00	193.526	HSFS0125

KSEM PLUS SSF Shanks • 10 x D • Inch



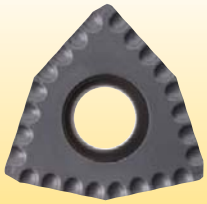




10 x D catalog number	CSWS system size	D	L1	L2	LS	clamp screw	pipe plug
SSF150FDS281356	FDS28	1.5000	13.58	11.34	3.75	193.537	HSFS0125
SSF150FDS321539	FDS32	1.5000	15.39	12.99	3.75	193.523	HSFS0125
SSF150FDS361728	FDS36	1.5000	17.28	14.57	3.75	193.524	HSFS0125
SSF200FDS401933	FDS40	2.0000	19.33	16.34	4.00	193.524	HSFS0125
SSF200FDS452161	FDS45	2.0000	21.61	18.31	4.00	193.525	HSFS0125
SSF200FDS502413	FDS50	2.0000	24.13	20.47	4.00	193.525	HSFS0125
SSF200FDS562783	FDS56	2.0000	27.28	23.23	4.00	193.526	HSFS0125
SSF200FDS633066	FDS63	2.0000	30.67	26.14	4.00	193.526	HSFS0125

KSEM PLUS Carbide Insert Recommendations

Material Group	Outboard/ Inboard	Insert Style	Grade	Page(s)	Comments
P	O	DFR-GD	KCU25, KCU40	H113	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		H112, H114	
		DFC-/DFT-DS	KCU40	H112, H114	Reduce feed rate by 10% to further improve chip formation in long-chipping steels and low carbon steel.
	I	KSEMP-HPG	KC7315	H111	Must use KSEMP center inserts in P-materials to avoid excessive wear on head & inserts.
M	O	DFR-MD	KC7140	H113	Recommended outboard insert style for working in all M-materials.
		DFC-/DFT-MD		H113–H114	
		DFC-/DFT-DS	KCU40	H112, H114	Reduce feed rate by 20% to further improve chip formation and/or run with lower power consumption.
	I	KSEMP-HPG	KC7315	H111	Recommended inboard insert style for working in all M-materials.
		KSEM-PC	KC7135	H70, H111	For unstable conditions in stainless steel, use KSEM PC inserts.
		KSEM-HPL	KC7320	H62	If chip control issue resulting from center insert occurs in M-materials, use KSEM HPL insert inboard. Reduction of feed rate up to 20% is recommended.
K	O	DFR-LD	KCU25	H113	Recommended insert styles for working in all K-Materials.
		DFC-/DFT-HP		H112, H114	
	I	KSEM-HPCCL	KC7410	H60, H111	
N	O	DFR-GD	KC7225	H113	Recommended outboard insert styles for working in all non-ferrous materials.
		DFC-/DFT-HP	KCU40	H112, H114	
		DFC-/DFT-DS	KCU40	H112, H114	Reduce feed rate by 15% for diameters <56mm and up to 50% for larger diameters to improve chip formation.
		DFR/DFT-ST	KD1425	J98	Use PCD tipped outboard when working with CFRP, CFRP/metal stacks and plastics (N3, N5, and N6).
	I	KSEMP-HPG	KC7315	H111	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	H113	Recommended outboard insert style for working in all S-materials.
		DFC-/DFT-HP	KCU40	H112, H114	
		DFC-/DFT-DS	KCU40	H112, H114	Reduce feed rate by 20% to further improve chip formation and/or run with lower power consumption.
	I	KSEM-PC	KC7135	H70, H111	If center 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

Modular Drill • KSEM PLUS™ • Inch • A1 and B1 Style

Material Group		Condition	Cutting Speed — vc Range — SFM			Recommended Feed Rate (fz) by Diameter					
			min	Starting Value	max	Ø	KSEM 14….17 DFR/DFC04... 1.102–1.249	KSEM 15….18 DFT/DFC05... 1.250–1.416	KSEM 13….22 DFT/DFC06... 1.417–1.771	KSEM 18….28 DFT/DFC07... 1.772–2.204	KSEM 20….34 DFT/DFC09... 2.205–4.0295
			Inch								
P	1	S	370	**775**	944	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	290	**532**	698	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	205	**327**	451	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
	2	S	295	**623**	755	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		U	233	**427**	558	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		I	164	**262**	361	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
	3	S	295	**591**	755	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		U	230	**394**	558	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		I	164	**230**	361	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
	4	S	295	**459**	722	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		U	230	**361**	525	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		I	264	**262**	361	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
	5	S	295	**427**	689	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		U	230	**328**	689	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		I	164	**230**	492	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
	6	S	230	**295**	591	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		U	164	**246**	394	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		I	131	**197**	328	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
M	1	S	197	**361**	443	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	131	**230**	295	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	98	**164**	213	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
	2	S	197	**328**	443	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	131	**197**	295	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	98	**164**	213	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
	3	S	164	**295**	443	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	131	**197**	295	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	82	**131**	213	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
K	1	S	295	**558**	755	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
		U	197	**394**	525	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
		I	131	**230**	295	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
	2	S	295	**525**	722	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
		U	197	**361**	525	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
		I	131	**230**	328	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
	3	S	295	**492**	689	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
		U	197	**328**	492	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
		I	115	**197**	295	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
N	1	S	492	**787**	1181	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	328	**525**	787	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	197	**328**	525	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
	2	S	492	**722**	1181	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	328	**492**	787	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	197	**328**	525	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
	3	S	492	**722**	1181	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	328	**492**	787	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	197	**328**	525	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
	4	S	492	**722**	1181	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	328	**492**	787	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	197	**328**	525	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
	5	S	492	**722**	1181	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	328	**492**	787	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	197	**328**	525	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
	6	S	492	**656**	1181	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	328	**459**	787	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	197	**295**	525	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
	7	S	361	**722**	853	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	230	**459**	558	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	148	**295**	361	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
S	1	S	82	**164**	246	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	66	**131**	197	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	49	**98**	164	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
	2	S	66	**131**	197	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	49	**98**	148	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	39	**82**	115	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
	3	S	66	**131**	197	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	49	**98**	148	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	39	**82**	131	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
	4	S	66	**131**	197	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	49	**98**	148	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	39	**82**	131	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014

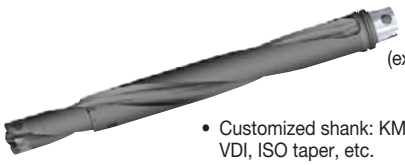


Application	Workpiece Shape	A1 Head	B1 Head
Flat Face		✓	✓
Cored Hole		✗	✓
Stacked Plates		✗	✓
Angled Exit (exit only!)		✓ <3°	✓ max 15°
Angled Entrance		✓ <3°	✓ <3°
Cross Holes		✗	✓ max 50% of D1

KSEM PLUS Customized Solution Capabilities:



- Intermediate head Ø.
- Custom head to use reground KSEM™ inserts.
- Heads for cross holes Ø = d1.



(example)

- Customized shank: KM™, HSK, VDI, ISO taper, etc.
- Customized flute helix.
- Step drill.

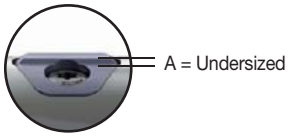


- Drill body up to L1 = 20 x D and total length of 1250mm.

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.

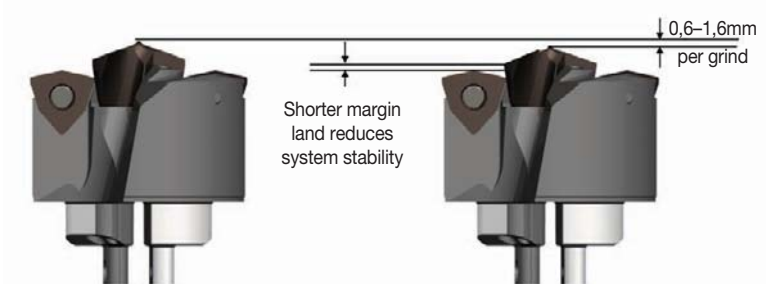
NOTE: For best results with slanted exits and in cross hole drilling, we recommend guiding pads adjustment results in an undersize of A = 30 µm (edge of guiding pads to cutting edges).

Coolant Recommendations



Internal coolant is recommended for optimum chip flow and tool life.

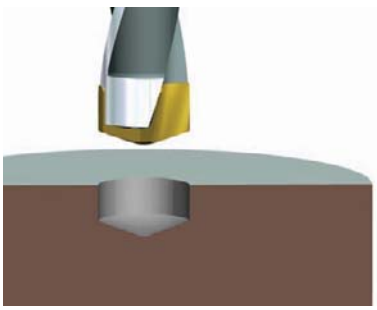
KSEM PLUS Piloting Insert SHOULD NOT Be Reground:



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



Combination Tools

Tool Selection Guide **I2–I3**

BF Combination Drilling System **I4–I20**

B343_HPG Drill for BF I8–I10

KenTIP for BF I11–I13

BF Bodies I14–I15

BF Inserts I16–I17

SEFAS Combination Drilling System **I22–I30**

SEFAS Bodies I25–I28

SEFAS Hardware I29

SEFAS Chamfering Inserts I30



		standard							standard range			customized solution range			
		● first choice ○ alternate choice						hole tolerance	diameter range		drilling depth L/D1	diameter range		drilling depth	
		P	M	K	N	S	H		D1 mm min–max	D1 inch min–max		D1 mm min–max	D1 inch min–max		
	**BF with Solid Carbide Drill** Combination Tool	●		●				IT7–11	3,4–18 (B343 drill)	.134–.709 (B343 drill)	approx. 3 x D	3,4–22,5	.134–.70	.1–5 x D	
	**BF with KenTIP™** Combination Tool	●	●	●				IT7–11	8–18,99	.313–.826	3 x D 4 x D 5 x D	8–25,99	.313–1.023	3–5 x D	
	**SEFAS™** Combination Tool	●	○	●	●	○		IT7–11	4–20	.157–.787	approx. 3 x D 5 x D 8 x D 12 x D	3,4–25	.134–1.039	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 customized solution.

	coolant		■ standard and □ customized solution capabilities [1]			■ standard and □ customized solution capabilities [1]								page(s)
	■		■ ■			■			□		■	□		■	I8–I10
	■		■ ■			■			□		■	□		■	I11–I13
	■		■ ■		□	■			□		■			■	I25–I30

Combination Tools

Combination drilling tools are customizable using standard components and combine centering, 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: 3F drills may be used with one insert in limited applications.
Consult your Kennametal Sales Representative for more information.



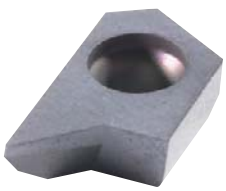
Provide high flexibility to adapt the tool to varying hole geometries.



SEFAS™ Combination Drilling System

- High-performance, self-centering 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 centering, 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

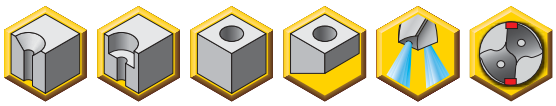
- Choose between solid carbide drills and KenTIP drill bodies.
- Various grades and insert styles.
- Flexible modular system for adjusting the drill length or insert style to manufacture different geometries.

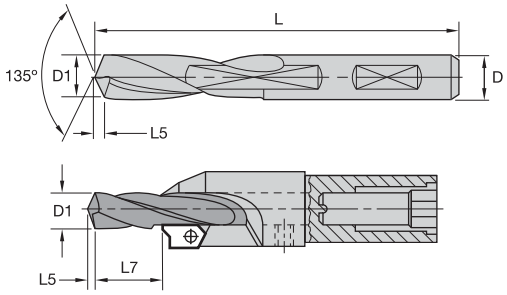
Choose between solid carbide drills and KenTIP™ drill bodies.

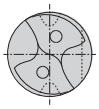


Customization

- Length variations available as engineered solutions.
- TX drills for aluminum available as engineered solutions.
- BF inserts can be customized to almost any geometry.









B343_HPG



● first choice
○ alternate choice

KC7315	D1 in	D1 mm	D1 fraction	D1 wire size	D mm	D in	L mm	L in	L7 min mm	L7 min in	L7 max mm	L7 max in	L5 mm	L5 in
B343S03175HPG	.125	3,18	1/8	–	4	.158	55	2.2	1,0	.039	8,6	.339	0,60	.024
B343S03400HPG	.134	3,40	–	–	4	.158	55	2.2	1,0	.039	10,0	.394	0,63	.025
B343S03500HPG	.138	3,50	–	–	4	.158	55	2.2	1,6	.063	10,6	.417	0,65	.025
B343S03797HPG *	.150	3,80	–	25	4	.158	55	2.2	3,3	.130	12,3	.484	0,70	.028
B343S03800HPG	.150	3,80	–	–	4	.158	55	2.2	3,3	.130	12,3	.484	0,70	.028
B343S03970HPG	.156	3,97	5/32	–	4	.158	55	2.2	4,2	.165	13,2	.520	0,73	.029
B343S04000HPG	.158	4,00	–	–	4	.158	55	2.2	4,4	.173	13,4	.528	0,74	.029
B343S04100HPG	.161	4,10	–	–	5	.197	62	2.4	3,7	.146	13,7	.539	0,76	.030
B343S04200HPG	.165	4,20	–	–	5	.197	62	2.4	4,2	.165	14,2	.559	0,78	.031
B343S04300HPG	.169	4,30	–	–	5	.197	62	2.4	4,7	.185	14,7	.579	0,79	.031
B343S04500HPG	.177	4,50	–	–	5	.197	62	2.4	5,6	.221	15,6	.614	0,83	.033
B343S04600HPG *	.181	4,60	–	–	5	.197	62	2.4	5,8	.228	15,8	.622	0,85	.033
B343S04623HPG	.182	4,62	–	14	5	.197	62	2.4	5,9	.232	15,9	.626	0,85	.034
B343S04763HPG	.188	4,76	3/16	–	5	.197	62	2.4	6,6	.260	16,6	.654	0,88	.035
B343S04900HPG *	.193	4,90	–	–	5	.197	62	2.4	7,2	.284	17,2	.677	0,90	.036
B343S05000HPG	.197	5,00	–	–	5	.197	62	2.4	7,6	.299	17,6	.693	0,92	.036
B343S05100HPG	.201	5,10	–	–	6	.236	66	2.6	6,8	.268	17,8	.701	0,94	.037
B343S05200HPG	.205	5,20	–	–	6	.236	66	2.6	7,2	.284	18,2	.717	0,96	.038
B343S05300HPG	.209	5,30	–	–	6	.236	66	2.6	7,6	.299	18,6	.732	0,98	.039
B343S05400HPG	.213	5,40	–	–	6	.236	66	2.6	8,0	.315	19,0	.748	1,00	.039
B343S05410HPG	.213	5,41	–	–	6	.236	66	2.6	8,0	.315	19,0	.748	1,00	.039
B343S05500HPG	.217	5,50	–	–	6	.236	66	2.6	8,4	.331	19,4	.764	1,02	.040
B343S05550HPG	.219	5,55	–	–	6	.236	66	2.6	8,3	.327	19,3	.760	1,02	.040
B343S05558HPG *	.219	5,56	7/32	–	6	.236	66	2.6	8,4	.331	19,4	.764	1,03	.040
B343S05600HPG	.221	5,60	–	–	6	.236	66	2.6	8,5	.335	19,5	.768	1,03	.041
B343S05800HPG	.228	5,80	–	–	6	.236	66	2.6	9,3	.366	20,3	.799	1,07	.042
B343S06000HPG	.236	6,00	–	–	6	.236	66	2.6	10,0	.394	21,0	.827	1,11	.044
B343S06100HPG	.240	6,10	–	–	7	.276	74	2.9	9,1	.358	21,1	.831	1,13	.044
B343S06200HPG	.244	6,20	–	–	7	.276	74	2.9	9,5	.374	21,5	.847	1,14	.045
B343S06300HPG	.248	6,30	–	–	7	.276	74	2.9	9,8	.386	21,8	.858	1,16	.046
B343S06350HPG	.250	6,35	1/4	–	7	.276	74	2.9	10,0	.394	22,0	.866	1,17	.046
B343S06400HPG	.252	6,40	–	–	7	.276	74	2.9	10,2	.402	22,2	.874	1,18	.047
B343S06500HPG	.256	6,50	–	–	7	.276	74	2.9	10,5	.413	22,5	.886	1,20	.047
B343S06528HPG	.257	6,53	–	F	7	.276	74	2.9	10,6	.417	22,6	.890	1,21	.047
B343S06600HPG	.260	6,60	–	–	7	.276	74	2.9	10,9	.429	22,9	.902	1,22	.048
B343S06700HPG	.264	6,70	–	–	7	.276	74	2.9	11,2	.441	23,2	.913	1,24	.049

(continued)

(B343_HPG — continued)

P ●
M
K ●
N
S
H

● first choice
○ alternate choice

KC7315	D1 in	D1 mm	D1 fraction	D1 wire size	D mm	D in	L mm	L in	L7 min mm	L7 min in	L7 max mm	L7 max in	L5 mm	L5 in
B343S06746HPG	.266	6,75	17/64	–	7	.276	74	2.9	11,4	.449	23,4	.921	1,25	.049
B343S06800HPG	.268	6,80	–	–	7	.276	74	2.9	11,5	.453	23,5	.925	1,26	.049
B343S06900HPG	.272	6,90	–	–	7	.276	74	2.9	11,9	.469	23,9	.941	1,27	.050
B343S07000HPG	.276	7,00	–	–	7	.276	74	2.9	12,2	.480	24,2	.953	1,29	.051
B343S07145HPG	.281	7,14	9/32	–	8	.315	79	3.1	11,1	.437	24,1	.949	1,32	.052
B343S07300HPG	.287	7,30	–	–	8	.315	79	3.1	11,6	.457	24,6	.969	1,35	.053
B343S07400HPG	.291	7,40	–	–	8	.315	79	3.1	11,9	.469	24,9	.980	1,37	.054
B343S07500HPG	.295	7,50	–	–	8	.315	79	3.1	12,3	.484	25,3	.996	1,38	.055
B343S07541HPG *	.297	7,54	19/64	–	8	.315	79	3.1	12,4	.488	25,4	1.000	1,39	.055
B343S07800HPG	.307	7,80	–	–	8	.315	79	3.1	13,2	.520	26,2	1.032	1,44	.057
B343S07900HPG	.311	7,90	–	–	8	.315	79	3.1	13,5	.532	26,5	1.043	1,46	.057
B343S07938HPG	.313	7,94	5/16	–	8	.315	79	3.1	13,6	.535	26,6	1.047	1,47	.058
B343S08000HPG	.315	8,00	–	–	8	.315	79	3.1	13,8	.543	26,8	1.055	1,48	.058
B343S08100HPG	.319	8,10	–	–	9	.354	84	3.3	12,6	.496	26,6	1.047	1,50	.059
B343S08200HPG	.323	8,20	–	–	9	.354	84	3.3	12,8	.504	26,8	1.055	1,51	.060
B343S08300HPG	.327	8,30	–	–	9	.354	84	3.3	13,1	.516	27,1	1.067	1,53	.060
B343S08334HPG *	.328	8,33	21/64	–	9	.354	84	3.3	13,2	.520	27,2	1.071	1,54	.061
B343S08400HPG	.331	8,40	–	–	9	.354	84	3.3	13,4	.528	27,4	1.079	1,55	.061
B343S08433HPG *	.332	8,43	–	Q	9	.354	84	3.3	13,5	.532	27,5	1.083	1,56	.061
B343S08500HPG	.335	8,50	–	–	9	.354	84	3.3	13,7	.539	27,7	1.091	1,57	.062
B343S08600HPG	.339	8,60	–	–	9	.354	84	3.3	14,0	.551	28,0	1.102	1,59	.063
B343S08700HPG	.343	8,70	–	–	9	.354	84	3.3	14,3	.563	28,3	1.114	1,61	.063
B343S08733HPG *	.344	8,73	11/32	–	9	.354	84	3.3	14,4	.567	28,4	1.118	1,61	.064
B343S08800HPG	.347	8,80	–	–	9	.354	84	3.3	14,5	.571	28,5	1.122	1,62	.064
B343S09000HPG	.354	9,00	–	–	9	.354	84	3.3	15,1	.595	29,1	1.146	1,66	.065
B343S09100HPG	.358	9,10	–	–	10	.394	89	3.5	14,3	.563	28,8	1.134	1,68	.066
B343S09347HPG	.368	9,35	–	U	10	.394	89	3.5	15,0	.591	29,5	1.161	1,73	.068
B343S09400HPG *	.370	9,40	–	–	10	.394	89	3.5	15,1	.595	29,6	1.165	1,74	.068
B343S09500HPG *	.374	9,50	–	–	10	.394	89	3.5	15,4	.606	29,9	1.177	1,75	.069
B343S09525HPG *	.375	9,53	3/8	–	10	.394	89	3.5	15,4	.606	29,9	1.177	1,76	.069
B343S09700HPG *	.382	9,70	–	–	10	.394	89	3.5	15,9	.626	30,4	1.197	1,79	.071
B343S09800HPG	.386	9,80	–	–	10	.394	89	3.5	16,2	.638	30,7	1.209	1,81	.071
B343S09921HPG *	.391	9,92	25/64	–	10	.394	89	3.5	16,5	.650	31,0	1.221	1,83	.072
B343S10000HPG	.394	10,00	–	–	10	.394	89	3.5	16,7	.658	31,2	1.228	1,85	.073
B343S10100HPG	.398	10,10	–	–	11	.433	95	3.7	15,9	.630	30,9	1.220	1,86	.073
B343S10200HPG	.402	10,20	–	–	11	.433	95	3.7	16,2	.638	31,2	1.228	1,88	.074
B343S10300HPG	.406	10,30	–	–	11	.433	95	3.7	16,4	.646	31,4	1.236	1,90	.075
B343S10320HPG	.406	10,32	13/32	–	11	.433	95	3.7	16,5	.650	31,5	1.240	1,91	.075
B343S10400HPG	.409	10,40	–	–	11	.433	95	3.7	16,7	.658	31,7	1.248	1,92	.076
B343S10500HPG	.413	10,50	–	–	11	.433	95	3.7	16,9	.665	31,9	1.256	1,94	.076
B343S10600HPG	.417	10,60	–	–	11	.433	95	3.7	17,2	.677	32,2	1.268	1,96	.077
B343S10700HPG	.421	10,70	–	–	11	.433	95	3.7	17,4	.685	32,4	1.276	1,98	.078
B343S10710HPG	.422	10,71	27/64	–	11	.433	95	3.7	17,4	.685	32,4	1.276	1,98	.078
B343S10800HPG	.425	10,80	–	–	11	.433	95	3.7	17,7	.697	32,7	1.287	1,99	.079
B343S11000HPG	.433	11,00	–	–	11	.433	95	3.7	18,1	.713	33,1	1.303	2,03	.080
B343S11100HPG	.437	11,10	–	–	12	.472	102	4.0	17,4	.685	32,9	1.295	2,05	.081
B343S11110HPG	.438	11,11	7/16	–	12	.472	102	4.0	17,4	.685	32,9	1.295	2,05	.081
B343S11200HPG *	.441	11,20	–	–	12	.472	102	4.0	17,6	.693	33,1	1.303	2,07	.081
B343S11300HPG *	.445	11,30	–	–	12	.472	102	4.0	17,9	.705	33,4	1.315	2,09	.082
B343S11500HPG	.453	11,50	–	–	12	.472	102	4.0	18,3	.721	33,8	1.331	2,12	.084
B343S11508HPG *	.453	11,51	29/64	–	12	.472	102	4.0	18,3	.721	33,8	1.331	2,12	.084
B343S11700HPG	.461	11,70	–	–	12	.472	102	4.0	18,8	.740	34,3	1.350	2,16	.085

(continued)

(B343_HPG — continued)



● first choice
○ alternate choice

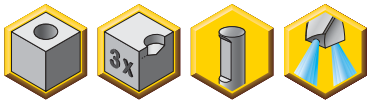
KC7315	D1 in	D1 mm	D1 fraction	D1 wire size	D mm	D in	L mm	L in	L7 min mm	L7 min in	L7 max mm	L7 max in	L5 mm	L5 in
B343S11800HPG	.465	11,80	—	—	12	.472	102	4.0	19,0	.748	34,5	1.358	2,18	.086
B343S11900HPG	.469	11,90	15/32	—	12	.472	102	4.0	19,3	.760	34,8	1.370	2,20	.087
B343S12000HPG	.472	12,00	—	—	12	.472	102	4.0	19,5	.768	35,0	1.378	2,22	.087
B343S12200HPG	.480	12,20	—	—	13	.512	102	4.0	18,9	.744	34,9	1.374	2,25	.073
B343S12500HPG	.492	12,50	—	—	13	.512	102	4.0	19,6	.772	35,6	1.400	2,31	.089
B343S12700HPG *	.500	12,70	1/2	—	13	.512	102	4.0	20,1	.791	36,1	1.421	2,34	.091
B343S12800HPG	.504	12,80	—	—	13	.512	102	4.0	20,3	.799	36,3	1.429	2,36	.092
B343S13000HPG	.512	13,00	—	—	13	.512	102	4.0	20,7	.815	36,7	1.445	2,40	.093
B343S13200HPG	.520	13,20	—	—	14	.551	107	4.2	20,4	.803	36,9	1.453	2,44	.096
B343S13500HPG	.532	13,50	—	—	14	.551	107	4.2	21,1	.831	37,6	1.480	2,49	.098
B343S14000HPG	.551	14,00	—	—	14	.551	107	4.2	22,1	.870	38,6	1.520	2,58	.102
B343S14200HPG	.559	14,20	—	—	15	.591	111	4.4	21,5	.847	38,5	1.516	2,62	.103
B343S14280HPG	.563	14,28	9/16	—	15	.591	111	4.4	21,7	.854	38,7	1.524	2,64	.104
B343S15000HPG	.591	15,00	—	—	15	.591	111	4.4	23,2	.913	40,2	1.583	2,77	.109
B343S15500HPG	.610	15,50	—	—	16	.630	115	4.5	23,2	.913	40,7	1.602	2,86	.113
B343S15870HPG	.625	15,87	5/8	—	16	.630	115	4.5	23,9	.941	41,4	1.630	2,93	.115
B343S16000HPG	.630	16,00	—	—	16	.630	115	4.5	24,2	.953	41,7	1.642	2,95	.116
B343S16500HPG	.650	16,50	—	—	17	.669	115	4.5	24,2	.953	42,2	1.661	3,05	.120
B343S16670HPG *	.656	16,67	21/32	—	17	.669	115	4.5	24,5	.965	42,5	1.673	3,08	.121
B343S17000HPG	.669	17,00	—	—	17	.669	115	4.5	25,1	.988	43,1	1.697	3,14	.124
B343S17500HPG	.689	17,50	—	—	18	.709	117	4.6	25,1	.988	43,6	1.717	3,23	.127
B343S17700HPG	.697	17,70	—	—	18	.709	117	4.6	25,5	1.004	44,0	1.732	3,27	.129
B343S18000HPG	.709	18,00	—	—	18	.709	117	4.6	26,0	1.024	44,5	1.752	3,32	.131

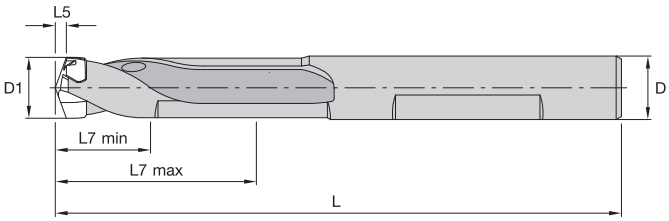
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

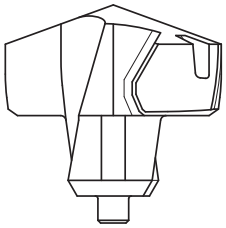
Tolerance

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.







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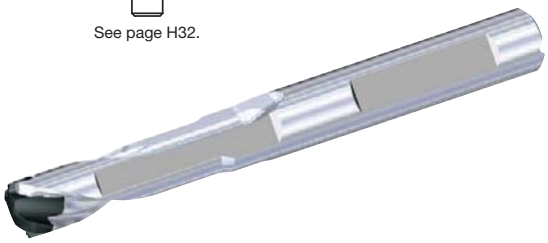
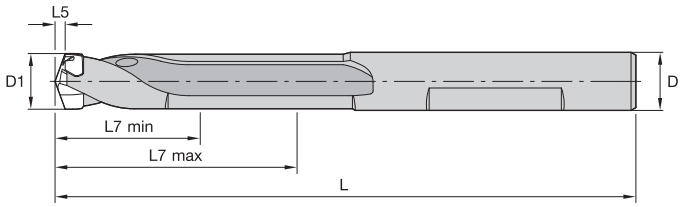


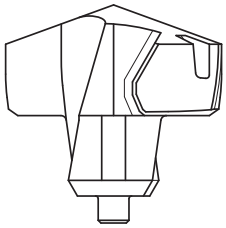
KenTIP • 3 x D • Metric

catalog number	D1 mm	D1 in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L7 min mm	L7 min in	L7 max mm	L7 max in	L5 mm	L5 in	insert blade seat size
KTIP080R3BF08M	8,00	.315	8,50	.335	8,0	.315	80,0	3.150	11,5	.453	25,5	1.004	1,4	.055	F
KTIP080R3BF09M	8,00	.315	8,50	.335	9,0	.354	81,0	3.189	11,5	.453	25,5	1.004	1,4	.055	F
KTIP085R3BF09M	8,50	.335	9,00	.354	9,0	.354	82,0	3.228	12,5	.492	27,0	1.063	1,5	.059	G
KTIP090R3BF09M	9,00	.354	9,50	.374	9,0	.354	82,0	3.228	13,5	.532	28,5	1.122	1,6	.063	H
KTIP090R3BF10M	9,00	.354	9,50	.374	10,0	.394	91,0	3.583	13,5	.532	28,5	1.122	1,6	.063	H
KTIP095R3BF10M	9,50	.374	10,00	.394	10,0	.394	92,0	3.622	15,0	.591	30,0	1.181	1,6	.063	I
KTIP100R3BF10M	10,00	.394	10,50	.413	10,0	.394	93,0	3.661	16,0	.630	31,5	1.240	1,7	.067	J
KTIP100R3BF11M	10,00	.394	10,50	.413	11,0	.433	94,0	3.701	16,0	.630	31,5	1.240	1,7	.067	J
KTIP105R3BF11M	10,50	.413	11,00	.433	11,0	.433	94,0	3.701	17,0	.669	33,0	1.299	1,8	.071	K
KTIP110R3BF11M	11,00	.433	11,50	.453	11,0	.433	96,0	3.780	18,5	.728	34,5	1.358	1,9	.075	L
KTIP110R3BF12M	11,00	.433	11,50	.453	12,0	.472	106,0	4.173	18,5	.728	34,5	1.358	1,9	.075	L
KTIP115R3BF12M	11,50	.453	12,00	.472	12,0	.472	107,0	4.213	19,5	.768	36,0	1.417	2,0	.079	M
KTIP120R3BF12M	12,00	.472	12,50	.492	12,0	.472	108,0	4.252	20,5	.787	37,5	1.476	2,1	.083	N
KTIP120R3BF13M	12,00	.472	12,50	.492	13,0	.512	108,0	4.252	20,5	.787	37,5	1.476	2,1	.083	N
KTIP125R3BF13M	12,50	.492	13,00	.512	13,0	.512	110,0	4.331	22,0	.866	39,0	1.535	2,2	.087	O
KTIP130R3BF13M	13,00	.512	13,50	.532	13,0	.512	111,0	4.370	23,0	.906	40,5	1.595	2,2	.087	P
KTIP130R3BF14M	13,00	.512	13,50	.532	14,0	.551	111,0	4.370	23,0	.906	40,5	1.595	2,2	.087	P
KTIP135R3BF14M	13,50	.532	14,00	.551	14,0	.551	112,0	4.409	24,5	.965	42,0	1.654	2,3	.091	Q
KTIP140R3BF14M	14,00	.551	14,50	.571	14,0	.551	113,0	4.449	25,5	1.000	43,5	1.713	2,4	.095	R
KTIP140R3BF15M	14,00	.551	14,50	.571	15,0	.591	118,0	4.646	25,5	1.004	43,5	1.713	2,4	.095	R
KTIP145R3BF15M	14,50	.571	15,00	.591	15,0	.591	118,0	4.646	26,5	1.043	45,0	1.772	2,5	.098	S
KTIP150R3BF15M	15,00	.591	16,00	.630	15,0	.591	121,0	4.764	29,0	1.142	48,0	1.890	2,6	.102	T
KTIP150R3BF16M	15,00	.591	16,00	.630	16,0	.630	121,0	4.764	29,0	1.142	48,0	1.890	2,6	.102	T
KTIP160R3BF16M	16,00	.630	17,00	.669	16,0	.630	123,0	4.843	31,5	1.240	51,0	2.008	2,8	.110	U
KTIP160R3BF17M	16,00	.630	17,00	.669	17,0	.669	124,0	4.882	31,5	1.240	51,0	2.008	2,8	.110	U
KTIP170R3BF17M	17,00	.669	18,00	.709	17,0	.669	127,0	5.000	34,0	1.339	54,0	2.126	2,9	.120	V
KTIP170R3BF18M	17,00	.669	18,00	.709	18,0	.709	127,0	5.000	34,0	1.339	54,0	2.126	2,9	.115	V
KTIP180R3BF18M	18,00	.709	19,00	.748	18,0	.709	130,0	5.118	36,5	1.437	57,0	2.244	3,1	.122	W

- Tool body with insert wrench included.
- Order KenTIP blades separately.







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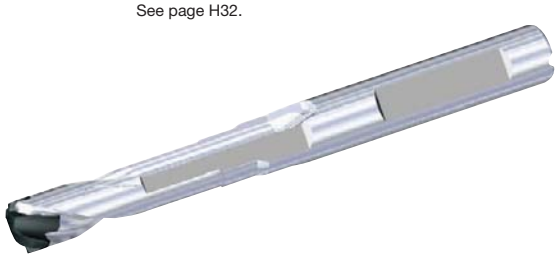
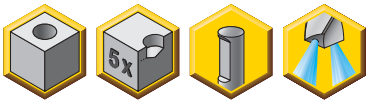
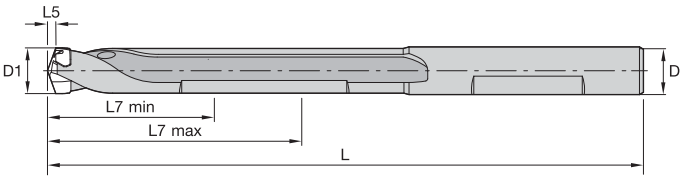


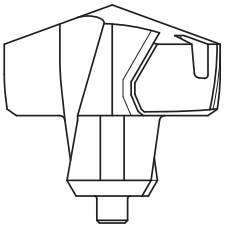
KenTIP • 4 x D • Metric

catalog number	D1 mm	D1 in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L7 min mm	L7 min in	L7 max mm	L7 max in	L5 mm	L5 in	insert blade seat size
KTIP080R4BF09M	8,00	.315	8,50	.335	9,0	.354	89,5	3.524	20,0	.787	34,0	1.339	1,4	.054	F
KTIP085R4BF09M	8,50	.335	9,00	.354	9,0	.354	91,0	3.583	21,5	.847	36,0	1.417	1,5	.058	G
KTIP090R4BF10M	9,00	.354	9,50	.374	10,0	.394	100,5	3.957	23,0	.906	38,0	1.496	1,6	.061	H
KTIP095R4BF10M	9,50	.374	10,00	.394	10,0	.394	102,0	4.016	25,0	.984	40,0	1.575	1,6	.065	I
KTIP100R4BF11M	10,00	.394	10,50	.413	11,0	.433	104,5	4.114	26,5	1.043	42,0	1.654	1,7	.068	J
KTIP105R4BF11M	10,50	.413	11,00	.433	11,0	.433	105,0	4.134	28,0	1.102	44,0	1.732	1,8	.071	K
KTIP110R4BF12M	11,00	.433	11,50	.453	12,0	.472	117,5	4.626	30,0	1.181	46,0	1.811	1,9	.075	L
KTIP115R4BF12M	11,50	.453	12,00	.472	12,0	.472	119,0	4.685	31,5	1.240	48,0	1.890	2,0	.078	M
KTIP120R4BF13M	12,00	.472	12,50	.492	13,0	.512	120,5	4.744	33,0	1.299	50,0	1.969	2,1	.083	N
KTIP125R4BF13M	12,50	.492	13,00	.512	13,0	.512	123,0	4.843	35,0	1.378	52,0	2.047	2,2	.087	O
KTIP130R4BF14M	13,00	.512	13,50	.532	14,0	.551	124,5	4.902	36,5	1.437	54,0	2.126	2,2	.087	P
KTIP135R4BF14M	13,50	.532	14,00	.551	14,0	.551	126,0	4.961	38,5	1.516	56,0	2.205	2,3	.091	Q
KTIP140R4BF15M	14,00	.551	14,50	.571	15,0	.591	132,5	5.217	40,0	1.575	58,0	2.284	2,4	.095	R
KTIP145R4BF15M	14,50	.571	15,00	.591	15,0	.591	133,0	5.236	41,5	1.634	60,0	2.362	2,5	.098	S
KTIP150R4BF16M	15,00	.591	16,00	.630	16,0	.630	137,0	5.394	45,0	1.772	64,0	2.520	2,6	.102	T
KTIP160R4BF17M	16,00	.630	17,00	.669	17,0	.669	141,0	5.551	48,5	1.909	68,0	2.677	2,8	.110	U
KTIP170R4BF18M	17,00	.669	18,00	.709	18,0	.709	145,0	5.709	52,0	2.047	72,0	2.835	2,9	.115	V
KTIP180R4BF18M	18,00	.709	19,00	.748	18,0	.709	149,0	5.866	55,5	2.185	76,0	2.992	3,1	.122	W

- Tool body with insert wrench included.
- Order KenTIP blades separately.







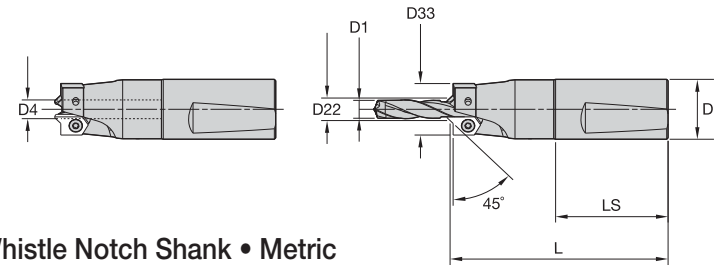
See page H32.



KenTIP • 5 x D • Metric

catalog number	D1 mm	D1 in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L7 min mm	L7 min in	L7 max mm	L7 max in	L5 mm	L5 in	insert blade seat size
KTIP080R5BF09M	8,00	.315	8,50	.335	9,0	.354	98,0	3.858	28,5	1.122	42,5	1.673	1,4	.054	F
KTIP085R5BF09M	8,50	.335	9,00	.354	9,0	.354	100,0	3.937	30,5	1.201	45,0	1.772	1,5	.059	G
KTIP090R5BF10M	9,00	.354	9,50	.374	10,0	.394	110,0	4.331	32,5	1.280	47,5	1.870	1,6	.061	H
KTIP095R5BF10M	9,50	.374	10,00	.394	10,0	.394	112,0	4.409	35,0	1.378	50,0	1.969	1,6	.065	I
KTIP100R5BF11M	10,00	.394	10,50	.413	11,0	.433	115,0	4.528	37,0	1.457	52,5	2.067	1,7	.068	J
KTIP105R5BF11M	10,50	.413	11,00	.433	11,0	.433	116,0	4.567	39,0	1.535	55,0	2.165	1,8	.071	K
KTIP110R5BF12M	11,00	.433	11,50	.453	12,0	.473	129,0	5.079	41,5	1.634	57,5	2.264	1,9	.075	L
KTIP115R5BF12M	11,50	.453	12,00	.472	12,0	.473	131,0	5.158	43,5	1.713	60,0	2.362	2,0	.078	M
KTIP120R5BF13M	12,00	.472	12,50	.492	13,0	.512	133,0	5.236	45,5	1.791	62,5	2.461	2,1	.083	N
KTIP125R5BF13M	12,50	.492	13,00	.512	13,0	.512	136,0	5.354	48,0	1.890	65,0	2.559	2,2	.087	O
KTIP130R5BF14M	13,00	.512	13,50	.532	14,0	.551	138,0	5.433	50,0	1.969	67,5	2.658	2,2	.087	P
KTIP135R5BF14M	13,50	.532	14,00	.551	14,0	.551	140,0	5.512	52,5	2.067	70,0	2.756	2,3	.091	Q
KTIP140R5BF15M	14,00	.551	14,50	.571	15,0	.591	147,0	5.787	54,5	2.146	72,5	2.854	2,4	.095	R
KTIP145R5BF15M	14,50	.571	15,00	.591	15,0	.591	148,0	5.827	56,5	2.244	75,0	2.953	2,5	.098	S
KTIP150R5BF16M	15,00	.591	16,00	.630	16,0	.630	153,0	6.024	61,0	2.402	80,0	3.150	2,6	.102	T
KTIP160R5BF17M	16,00	.630	17,00	.669	17,0	.669	158,0	6.221	65,5	2.579	85,0	3.347	2,8	.110	U
KTIP170R5BF18M	17,00	.669	18,00	.709	18,0	.709	163,0	6.417	70,0	2.756	90,0	3.543	2,9	.115	V
KTIP180R5BF18M	18,00	.709	19,00	.748	18,0	.709	168,0	6.614	74,5	2.933	95,0	3.740	3,1	.122	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

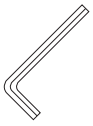



DIN 1835 Form A	DIN 1835 Form E	D1	D1 max	D4	D	D22	D33	L	LS	insert
3.37042R320	**3.37042R820**	3,40	4,00	4,00	20,0	9,0	14,9	87,5	50,0	3.41020..
3.37051R320	**3.37051R820 ***	4,10	4,50	5,00	20,0	9,5	15,4	87,5	50,0	3.41020..
3.37052R320	**3.37052R820**	4,60	5,00	5,00	20,0	10,0	15,9	87,5	50,0	3.41020..
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



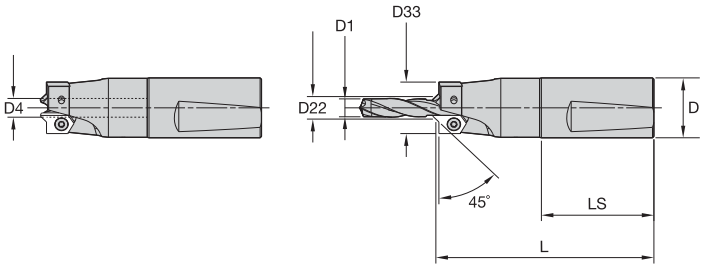




D1	back-up screw	drill clamp screw	hex wrench	insert screw	wrench
3,40	**192.888**	**192.718**	**170.003**	**192.432**	**170.028**
4,10	**192.888**	**192.718**	**170.003**	**192.432**	**170.028**
4,60	**192.888**	**192.718**	**170.003**	**192.432**	**170.028**
5,10	**192.888**	**192.718**	**170.003**	**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.

- Drill body shipped with all screws and wrenches.
- Order the inserts and drills separately.
- Drills up to and including .359" shanks use only one insert.





Round Shank • Inch

catalog number	D1	D1 max	D4	D	D22	D33	L	LS	insert
KBFI4	.125	.156	4,0	.75	.36	.59	3.44	1.97	3.41020..
KBFI5B	.182	.188	5,0	.75	.40	.62	3.44	1.97	3.41020..
KBFI6B	.213	.230	6,0	.75	.44	.66	3.44	1.97	3.41020..
KBFI7	.250	.266	7,0	.75	.46	.68	3.83	1.97	3.41020..
KBFI8	.281	.313	8,0	.75	.50	.72	3.83	1.97	3.41020..
KBFI9	.328	.344	9,0	1.00	.54	.76	4.31	2.20	3.41020..
KBFI10	.359	.391	10,0	1.00	.58	1.10	4.62	2.20	3.41220..
KBFI11	.406	.430	11,0	1.00	.62	1.14	4.62	2.20	3.41220..
KBFI12 *	.438	.469	12,0	1.00	.66	1.18	5.02	2.20	3.41220..
KBFI13	.484	.510	13,0	1.00	.70	1.22	5.02	2.20	3.41220..
KBFI14	.516	.550	14,0	1.25	.72	1.24	5.00	2.40	3.41220..
KBFI15	.563	.590	15,0	1.25	.76	1.28	5.00	2.36	3.41220..
KBFI16	.625	.630	16,0	1.25	.80	1.32	5.14	2.36	3.41220..
KBFI17	.656	.670	17,0	1.25	.84	1.36	5.00	2.40	3.41220..
KBFI18	.688	.700	18,0	1.25	.88	1.40	5.00	2.36	3.41220..

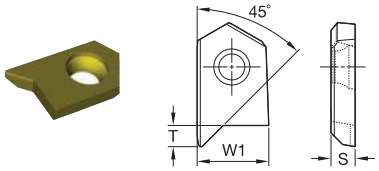
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts

D1	back-up screw	drill clamp screw	insert screw	wrench
.125	**192.888**	**192.718**	**192.432**	**170.028**
.182	**192.888**	**192.718**	**192.432**	**170.028**
.213	**192.888**	**192.718**	**192.432**	**170.028**
.250	**192.888**	**192.718**	**192.432**	**170.028**
.281	**192.888**	**192.718**	**192.432**	**170.028**
.328	**192.889**	**192.718**	**192.432**	**170.028**
.359	**192.889**	**192.720**	**191.725**	**170.025**
.406	**192.889**	**192.720**	**191.725**	**170.025**
.438	**192.889**	**192.720**	**191.725**	**170.025**
.484	**192.889**	**192.720**	**191.725**	**170.025**
.516	**192.889**	**192.720**	**191.725**	**170.025**
.563	**192.889**	**192.720**	**191.725**	**170.025**
.625	**192.889**	**192.720**	**191.725**	**170.025**
.656	**192.889**	**192.720**	**191.725**	**170.025**
.688	**192.889**	**192.720**	**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.

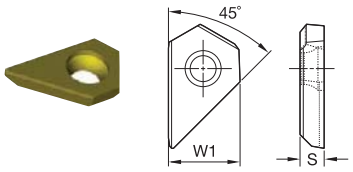


● first choice
○ alternate choice

P	●	●
M	●	
K	●	●
N		
S		
H		

BF Insert R901 • 45° with Spot Face

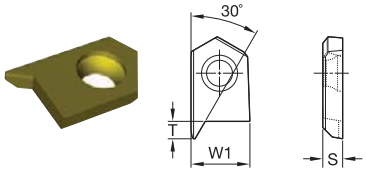
	S		W1		T		CS5	KC7315
catalog number	mm	in	mm	in	mm	in		
3.41020R901	3,00	.118	6,10	.240	2,90	.114	●	●
3.41220R901	3,50	.138	10,10	.398	3,05	.120	●	●



BF Insert R902 • 45°

	S		W1		CS5	KC7315
catalog number	mm	in	mm	in		
3.41020R902	3,00	.118	6,10	.240	●	●
3.41220R902	3,50	.138	10,10	.398	●	●

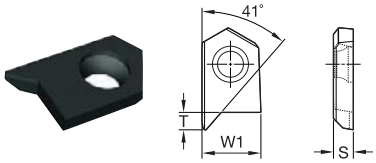
- When using the 60° insert or special insert, the assembled tool should be inspected.
- These insert combinations require that the steel body be altered to provide insert coverage.



BF Insert R903 • 60° with Spot Face

	S		W1		T		CS5	KC7315
catalog number	mm	in	mm	in	in	mm		
3.41020R903	3,00	.118	6,10	.240	0.114	2,90	●	●
3.41220R903	3,50	.138	10,10	.398	0.120	3,05	●	●

- Standard steel drill bodies are designed for inserts with 41° and 45° chamfers.

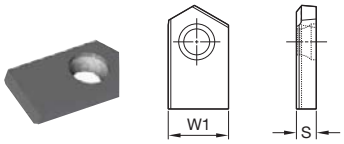


● first choice
○ alternate choice

P	●
M	
K	●
N	
S	
H	

BF Insert R904 • 41° with Spot Face

	S		W1		T		
catalog number	mm	in	mm	in	mm	in	KC7315
3.41020R904	3,00	.118	6,10	.240	2,90	.114	●
3.41220R904	3,50	.138	10,10	.398	3,05	.120	●

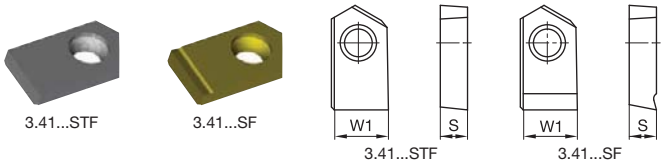


● first choice
○ alternate choice

P	
M	
K	○
N	●
S	
H	

BF Insert R900 • Semi-Finished

	S		W1		
catalog number	mm	in	mm	in	KMF
3.41020R900	3,00	.118	6,10	.240	●
3.41220R900	3,50	.138	10,10	.398	●



● first choice
○ alternate choice

P	●	
M	●	
K	●	○
N		●
S		
H		

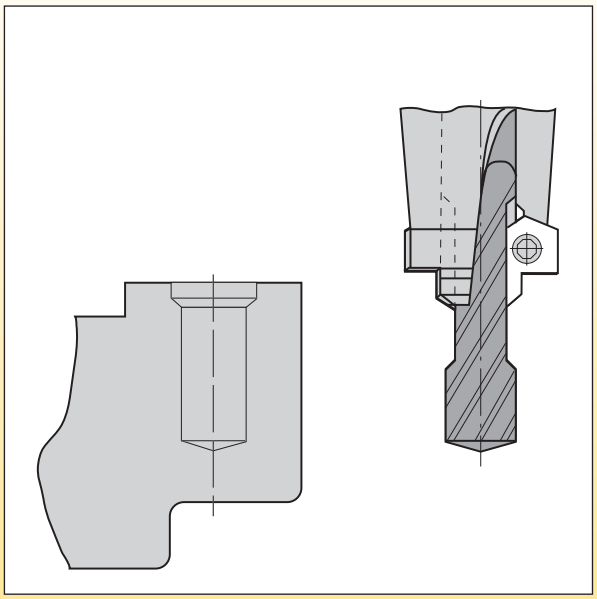
BF Insert R900 S(T)F • Semi-Finished

	S		W1			
catalog number	mm	in	mm	in	CS5	KMF
3.41020R900STF	3,00	.118	6,10	.240	●	–
3.41220R900SF	3,50	.138	10,10	.398	–	●
3.41220R900STF	3,50	.138	10,10	.398	●	–

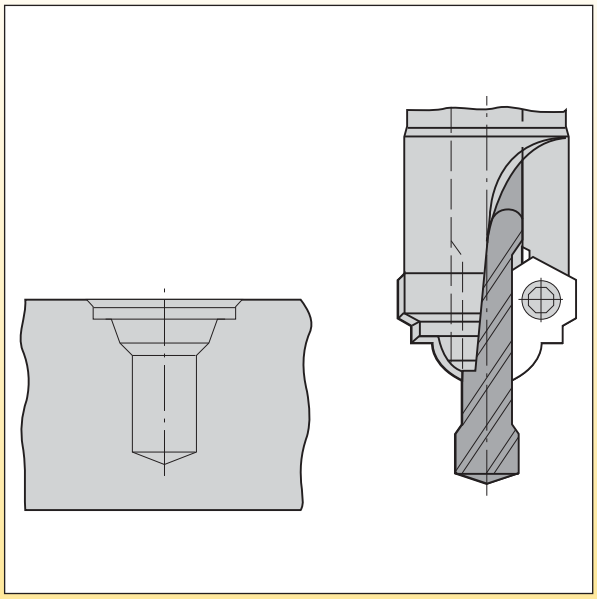
Engineered Solutions Available!



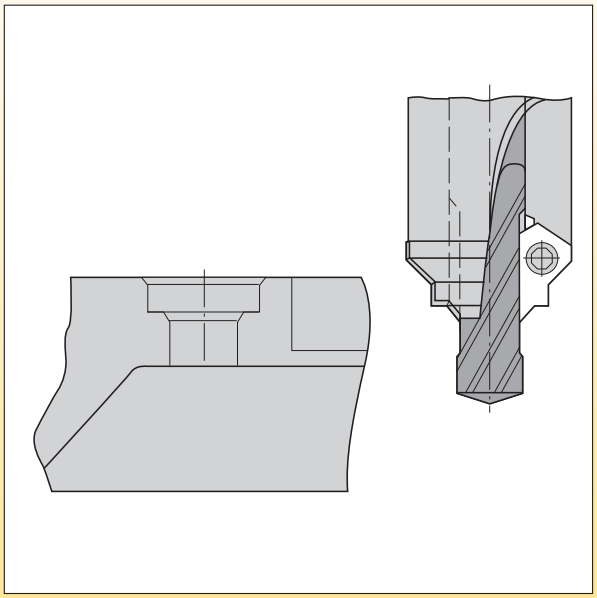
Tapped Hole with Protection Countersinking



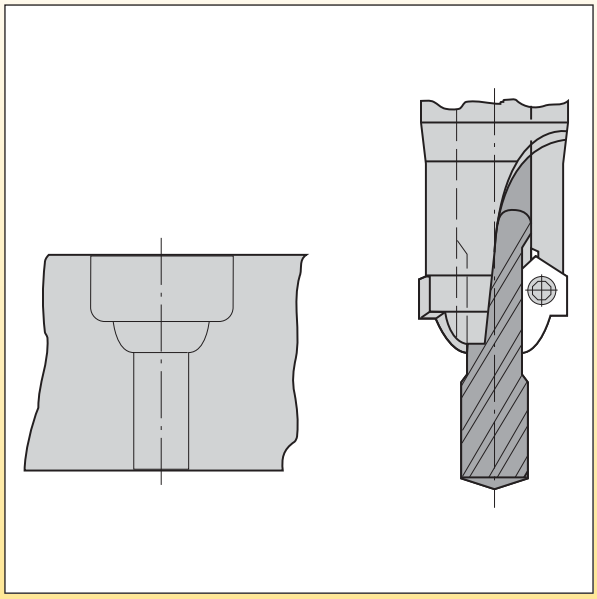
Countersinking for Round Sealing Rings



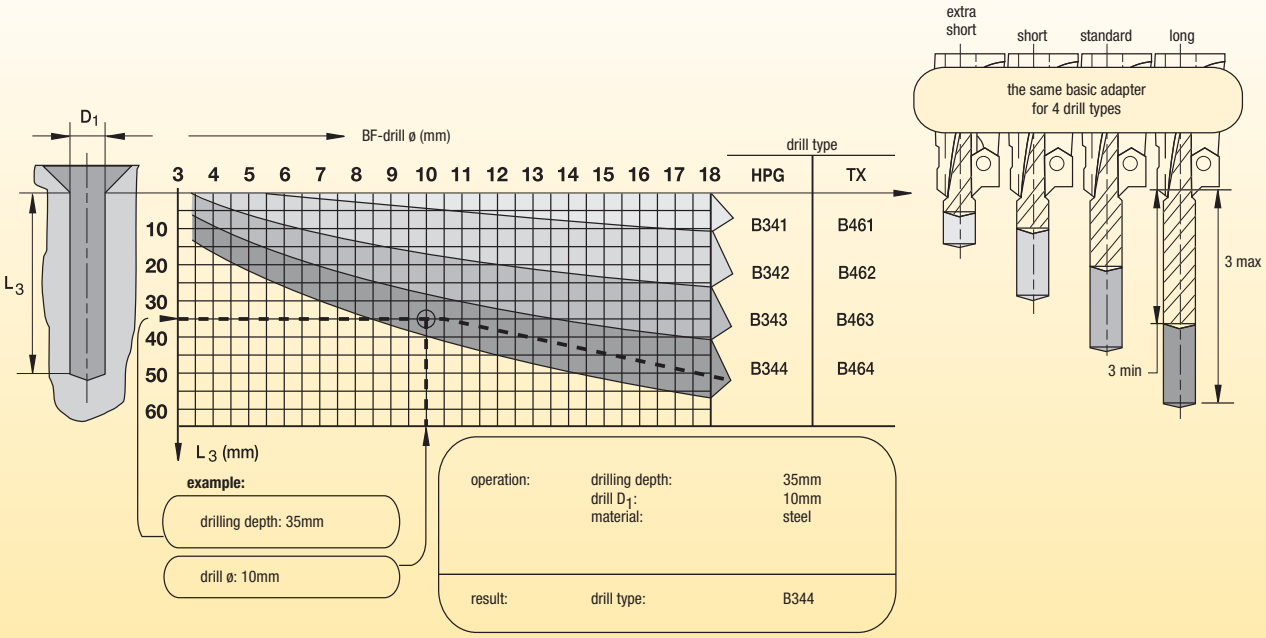
Countersinking for Countersunk Head Screws



Countersinking for Aluminum Rim



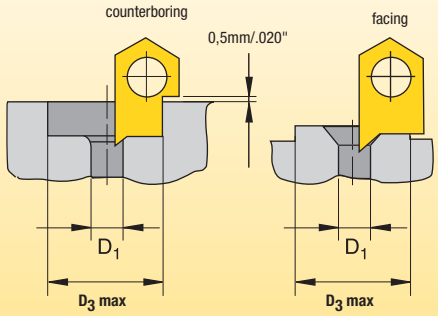
Possible Drilling Depths • Semi-Standard Series

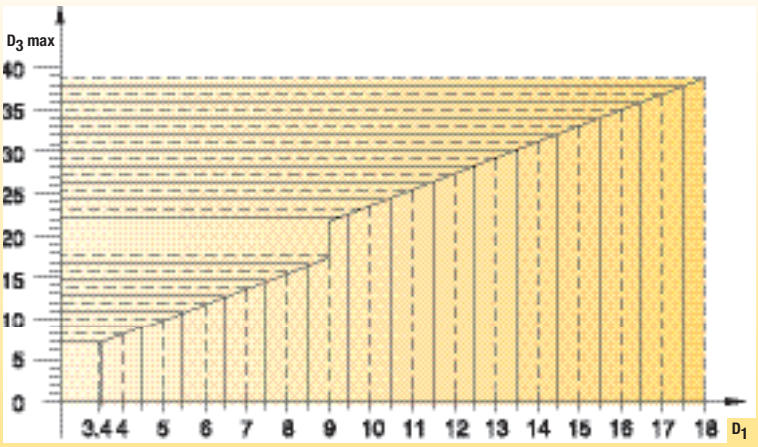


Possible Facing and Counterboring Diameters

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 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	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

HP Drills • B343HPG Series • Grade KC7315 • Through Coolant • Inch



Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max		Inch Recommended Feed Rate (f) by Diameter 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	1	328	**459**	591	IPR	.003–.006	.003–.007	.004–.009	.005–.011	.006–.013	.007–.015	.007–.017	.009–.017
	2	295	**377**	459	IPR	.003–.005	.003–.007	.004–.007	.005–.009	.006–.011	.007–.012	.007–.014	.009–.017
	3	262	**328**	394	IPR	.004–.006	.004–.007	.005–.009	.006–.011	.007–.013	.008–.015	.010–.017	.011–.019
	4	230	**295**	361	IPR	.003–.006	.004–.007	.004–.009	.005–.010	.006–.011	.006–.013	.008–.016	.009–.018
	5	230	**279**	361	IPR	.003–.005	.003–.006	.004–.006	.005–.008	.006–.009	.006–.010	.007–.012	.008–.013
K	1	328	**394**	459	IPR	.004–.007	.004–.008	.005–.011	.005–.010	.007–.014	.008–.015	.009–.018	.010–.020
	2	262	**345**	427	IPR	.004–.006	.004–.007	.005–.008	.006–.010	.007–.012	.008–.013	.009–.015	.010–.017
	3	230	**279**	328	IPR	.003-.005	.004-.006	.004-.007	.006-.009	.006-.010	.007-.012	.008-.014	.009-.015

Centering | Drilling | Chamfering

Three Applications, One Tool

Centering, drilling, and chamfering in a single operation with Kennametal SEFAS™

- Reduce the number of tool changes and cycle time by combining centering, drilling, and chamfering into one operation.
- Uses standard solid carbide drills in HP and TX styles as well as modular KenTIP™ drills.
- Range of insert styles for use in most workpiece materials.



Experience the advantages at your Authorized Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

kennametal.com

SEFAS™ Combination Drilling System

Primary Application

Combines centering, 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.

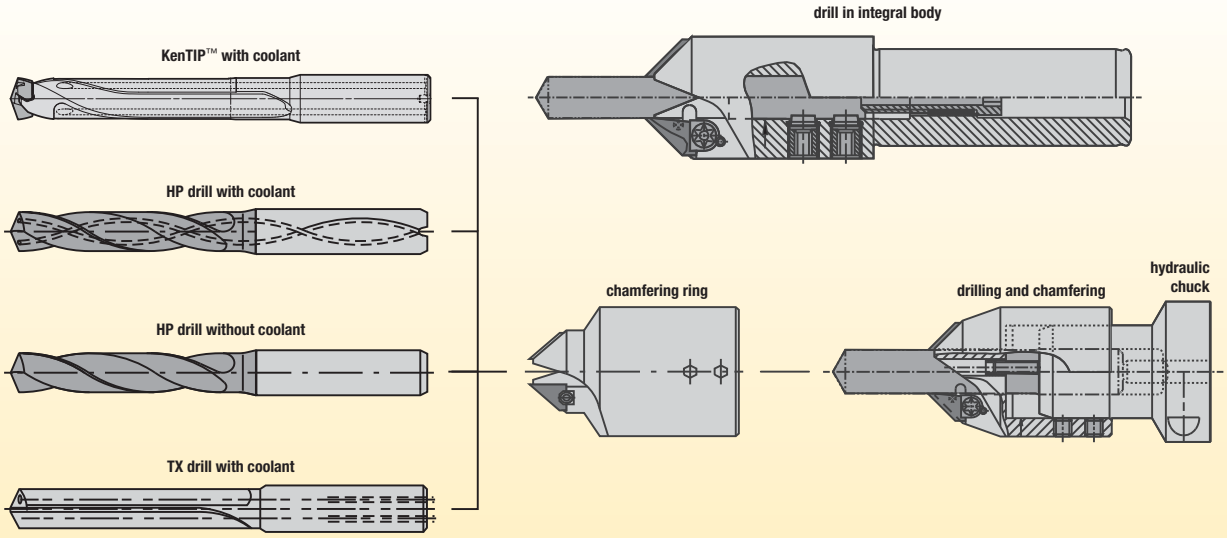
Reduce the number of tool changes and cycle time by combining drilling and countersinking into one operation.



Customization

- Length variations available as engineered solutions.



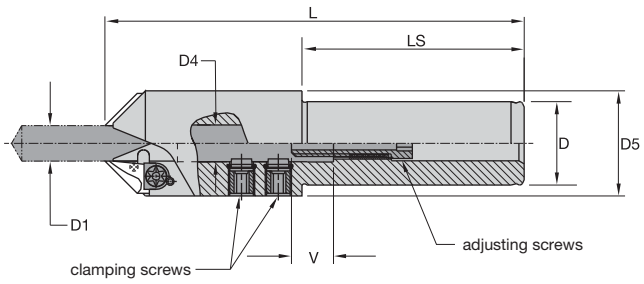


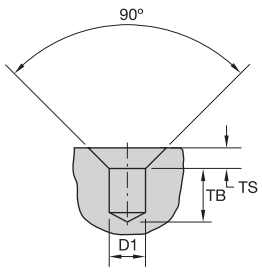
The SEFAS combination drilling system may be used in most workpiece materials. The design and flexibility of the system can be used with a wide variety of solid carbide drills.

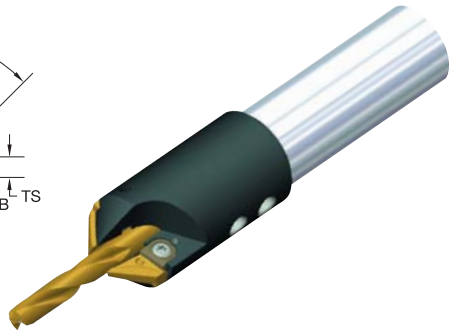
Three types of SEFAS chamfering tools are offered: (1) integral bodies with a compact design that provides additional workpiece and work-holding clearance; (2) chamfering rings that may be mounted to Kennametal hydraulic chucks for optimal drill performance and increased productivity; and (3) high-performance HSK bodies (available as customized 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.







Round Shank • For Use with Inch Drills • Inch

catalog number	D1	D1 max	D	D4	D5	L	LS	V	gage insert	insert clamp	Torx wrench	drill clamp screw	adjusting screw
SEF156187RSS075	0.1560	.188	.75	.19	.94	4.06	2.00	.71	3.42805..	**360.550**	**170.024**	**360.650**	**360.516**
SEF218250RSS075	>0.1880	.250	.75	.25	.97	4.13	2.00	.71	3.42805..	**360.550**	**170.024**	**360.651**	**360.510**
SEF265312RSS075	>0.2500	.313	.75	.31	1.03	4.31	2.00	.71	3.42805..	**360.550**	**170.024**	**360.652**	**360.510**
SEF328375RSS075	>0.3130	.375	.75	.38	1.16	4.63	2.00	.67	3.42805..	**360.550**	**170.024**	**360.653**	**360.510**
SEF390437RSS100	>0.3750	.438	1.00	.44	1.47	5.75	3.00	.75	3.42807..	**360.551**	**170.025**	**360.654**	**360.513**
SEF453500RSS100	>0.4380	.500	1.00	.50	1.53	5.88	3.00	.83	3.42807..	**360.551**	**170.025**	**360.655**	**360.513**
SEF500562RSS100	>0.5000	.563	1.00	.56	1.59	6.06	3.00	.63	3.42807..	**360.551**	**170.025**	**360.656**	**360.511**
SEF562625RSS125	>0.5630	.625	1.25	.63	1.66	6.44	3.25	.75	3.42807..	**360.551**	**170.025**	**360.657**	**360.511**
SEF625687RSS125 *	>0.6250	.688	1.25	.69	1.81	6.50	3.25	.59	3.42807..	**360.551**	**170.025**	**360.658**	**360.511**
SEF687750RSS125	>0.6880	.750	1.25	.75	1.88	6.56	3.25	.67	3.42807..	**360.551**	**170.025**	**360.659**	**360.511**
SEF750812RSS125	>0.7500	.813	1.25	.81	1.94	6.63	3.25	.67	3.42807..	**360.551**	**170.025**	**360.679**	**360.511**
SEF812875RSS150	>0.8130	.875	1.50	.88	2.09	7.25	3.75	.63	3.42807..	**360.551**	**170.025**	**360.680**	**360.511**
SEF875937RSS150 *	>0.8750	.938	1.50	.94	2.16	7.38	3.75	.71	3.42807..	**360.551**	**170.025**	**360.681**	**360.511**
SEF9371010RSS150	>0.9380	1.010	1.50	1.00	2.25	7.50	3.75	.71	3.42807..	**360.551**	**170.025**	**360.682**	**360.511**

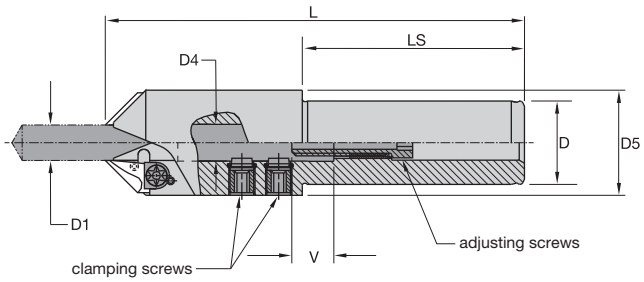
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

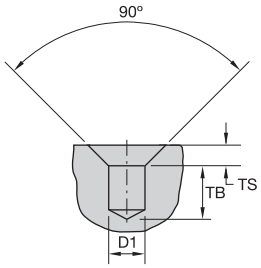
Achievable Drilling (TB) and Sink Depths (TS)

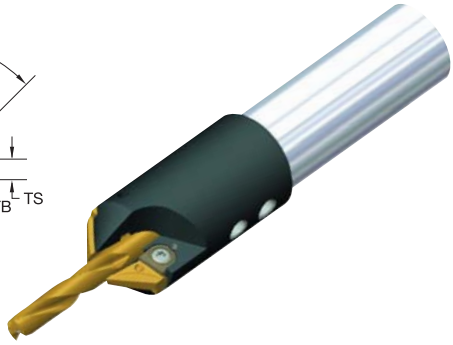
drill diameter D1	K210, K254, K284		K211, K222, K255, K285, K411		K212, K256		unalloyed and low-alloy steel, unalloyed and alloy steel, and cast iron, high-alloy steel and stainless steel		
	TB_{min}	TB_{max}	TB_{min}	TB_{max}	TB_{min}	TB_{max}	TS_{100}	TS_{80}	TS_{max}
.156-.188	.236	.866	.472	1.102	.866	1.102	.047	.071	.098
>.188-.250	.354	1.024	.709	1.378	1.220	1.890	.059	.087	.118
>.250-.266	.433	1.102	.906	1.575	1.654	2.323	.079	.118	.157
>.266-.313	.433	1.102	.906	1.575	1.654	2.323	.098	.157	.197
>.313.-.375	.512	1.142	1.063	1.693	1.929	2.559	.118	.197	.236
>.375-.438	.551	1.260	1.142	1.850	2.008	2.717	.138	.197	.276
>.438-.500	.591	1.378	1.220	2.008	2.205	2.992	.157	.236	.315
>.500-.563	.827	1.417	1.496	2.087	2.717	3.307	.157	.236	.315
>.563-.625	.866	1.575	1.575	2.283	3.071	3.780	.157	.236	.315
>.625-.688	1.299	1.850	2.087	2.638	3.740	4.291	.157	.236	.315
>.688-.750	1.378	2.008	2.126	2.756	4.055	4.685	.157	.236	.315
>.750-.813	1.552	2.181	2.260	2.890	4.386	5.016	.157	.236	.315
>.813-.875	1.702	2.293	2.726	3.317	4.694	5.285	.157	.236	.315
>.875-.938	1.735	2.404	2.876	3.546	4.884	5.554	.157	.236	.315
>.938-1.010	1.846	2.515	3.067	3.736	5.193	5.862	.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.

- Drill body shipped with all screws, clamps, and wrenches.
- Order the inserts and drills separately.
- Two chamfer inserts required per body.







Round Shank • For Use with Metric Drills • Metric

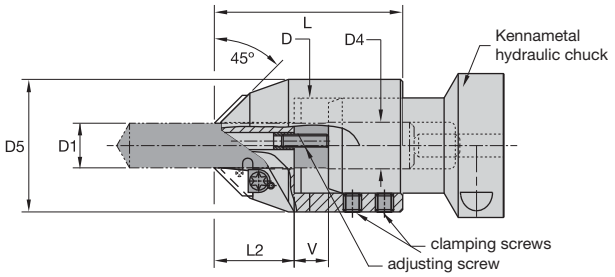
catalog number	D1	D1 max	D	D4	D5	L	LS	V	gage insert	insert clamp	Torx wrench	drill clamp screw	adjusting screw
SEF040060RSS075M	4,000	6,0	19,1	6,0	24,0	103,1	50,8	18,0	3.42805..	**360.550**	**170.024**	**360.630**	**360.510**
SEF060080RSS075M	>6,000	8,0	19,1	8,0	26,0	109,5	50,8	18,0	3.42805..	**360.550**	**170.024**	**360.634**	**360.510**
SEF080100RSS100M	>8,000	10,0	25,4	10,0	29,0	143,0	76,2	17,0	3.42805..	**360.550**	**170.024**	**360.631**	**360.510**
SEF100120RSS125M	>10,000	12,0	31,8	12,0	38,0	155,7	82,6	21,0	3.42807..	**360.551**	**170.025**	**360.635**	**360.513**
SEF120140RSS125M	>12,000	14,0	31,8	14,0	40,0	160,3	82,6	16,0	3.42807..	**360.551**	**170.025**	**360.636**	**360.511**
SEF140160RSS125M	>14,000	16,0	31,8	16,0	41,5	163,6	82,6	19,0	3.42807..	**360.551**	**170.025**	**360.632**	**360.511**
SEF160180RSS125M	>16,000	18,0	31,8	18,0	47,0	166,4	82,6	15,0	3.42807..	**360.551**	**170.025**	**360.633**	**360.511**
SEF180200RSS125M *	>18,000	20,0	31,8	20,0	49,0	170,0	82,6	17,0	3.42807..	**360.551**	**170.025**	**360.637**	**360.511**

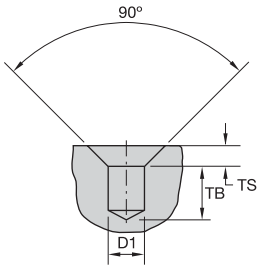
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

2° Whistle Notch (WN) Shank • For Use with Metric Drills • Metric

catalog 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

catalog 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)

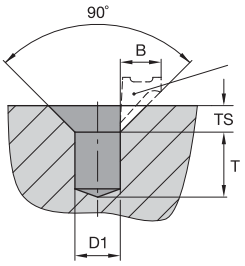
	B210, B221, B224, B254, B284, B291, B707, B966, B976		B211, B222, B225, B285, B292, B411, B708, B977		B212, B256, B709, B978		B269		unalloyed and low-alloy steel; unalloyed and alloy steel, and cast iron, high-alloy steel and stainless steel		
drill diameter D1	**TB_{min}**	**TB_{max}**	**TB_{min}**	**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 >.250–.313	not applicable (drill shank diameter > chamfer ring inside diameter), not applicable (metric ring and hydraulic chuck are not interchangeable)								
>.313–.375	.748	1.339	1.229	1.890	2.165	2.756	.098	.157	.197
>.375–.500 >.500–.563	not applicable (drill shank diameter > chamfer ring inside diameter), not applicable (metric ring and hydraulic chuck are not interchangeable)								
>.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.

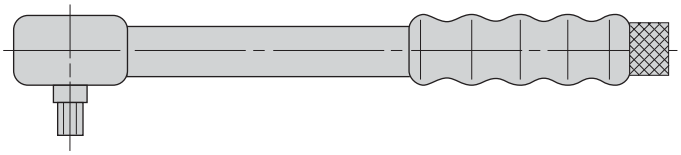




Achievable Drilling (T) and Sink Depths (TS) with KenTIP Tool Bodies

D1 mm	D1 in	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	.3125–.3343	11	19	21	37	47	63	11	22	22	40	48	66	2,5	4,0	5,0
8,50–8,99	.3346–.3539	12	21	24	40	51	67	12	24	25	43	52	70	2,5	4,0	5,0
9,00–9,49	.3543–.3736	12	23	27	43	56	72	12	26	28	46	57	75	2,5	4,0	5,0
9,50–9,99	.3740–.3933	13	25	31	47	61	77	13	28	32	50	62	80	2,5	4,0	5,0
10,00–10,49	.3937–.4130	13	26	28	49	60	81	13	28	29	51	61	83	3,5	5,0	7,0
10,50–10,99	.4134–.4327	14	28	31	52	64	85	14	30	32	54	65	87	3,5	5,0	7,0
11,00–11,49	.4331–.4524	14	30	34	55	69	90	14	32	35	57	70	92	3,5	5,0	7,0
11,50–11,99	.4528–.4720	15	32	37	58	73	94	15	34	38	60	74	96	3,5	5,0	7,0
12,00–12,49	.4724–.4917	15	30	41	56	79	94	15	32	36	58	74	96	4,0	6,0	8,0
12,50–12,99	.4921–.5114	17	32	44	59	83	98	16	34	39	61	78	100	4,0	6,0	8,0
13,00–13,49	.5118–.5311	19	34	47	62	88	103	16	36	42	64	83	105	4,0	6,0	8,0
13,50–13,99	.5315–.5508	21	36	51	66	93	108	17	38	46	68	88	110	4,0	6,0	8,0
14,00–14,49	.5512–.5705	19	37	50	68	94	112	18	40	49	71	93	115	4,0	6,0	8,0
14,50–14,99	.5709–.5902	21	39	53	71	98	116	20	42	52	74	97	119	4,0	6,0	8,0
15,00–15,99	.5906–.6295	25	43	59	77	107	125	24	46	58	80	106	128	4,0	6,0	8,0
16,00–16,99	.6299–6689	29	47	65	83	117	135	28	50	64	85	115	136	4,0	6,0	8,0
17,00–17,99	.6693–.7083	35	49	73	87	127	141	30	54	68	92	122	146	4,0	6,0	8,0
18,00–18,99	.7087–.7476	36	52	76	92	133	149	33	57	73	97	130	154	4,0	6,0	8,0
19,00–19,99	.7480–.7870	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.



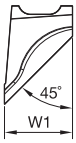
Torque Wrench • Metric

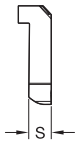
drill diameter D1	torque wrench	tightening torque Nm	SW	drill clamp screw	wrench adapter
4,0–6,0	**170.190**	7	3	**360.630**	**170.240**
>6,0–8,0	**170.190**	8	3	**360.635**	**170.240**
>8,0–10,0	**170.190**	10	4	**360.631**	**170.232**
>10,0–12,0	**170.190**	15	4	**360.635**	**170.232**
>12,0–14,0	**170.190**	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**

Torque Wrench • Inch

drill diameter D1	torque wrench	tightening torque ft. lbs.	SW	drill clamp screw	wrench adapter
.156–.188	**170.190**	5.2	3	**360.650**	**170.240**
>.188–.250	**170.190**	5.9	3	**360.651**	**170.240**
>.250–.313	**170.190**	5.9	3	**360.652**	**170.240**
>.313.–.375	**170.190**	7.4	4	**360.653**	**170.232**
>.375–.438	**170.190**	11.1	4	**360.654**	**170.232**
>.438–.500	**170.190**	11.1	4	**360.655**	**170.232**
>.500–.563	**170.190**	14.8	5	**360.656**	**170.233**
>.563–.625	**170.190**	22.1	5	**360.657**	**170.233**
>.625–.688	**170.190**	33.2	6	**360.658**	**170.234**
>.688–.750	**170.190**	33.2	6	**360.659**	**170.234**
>.750–.813	**170.190**	35.4	6	**360.679**	**170.234**
>.813–.875	**170.190**	44.3	8	**360.680**	**170.229**
>.875–.938	**170.190**	47.9	8	**360.681**	**170.229**
>.938–1.010	**170.190**	51.6	8	**360.682**	**170.229**







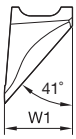
● first choice
○ alternate choice

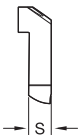
P	●
M	
K	●
N	●
S	
H	

SEFAS Chamfering Inserts for Solid Carbide Drills • 45°

		S		W1				
catalog number	angle	mm	in	mm	in	CS5	KC7215	KMF
3.42805R001	45	2,83	.111	8,00	.315	●	●	●
3.42807R001	45	3,98	.157	12,00	.472	●	●	●







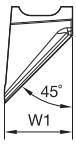
● first choice
○ alternate choice

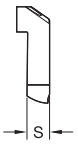
P	
M	
K	●
N	●
S	
H	

SEFAS Chamfering Inserts for Solid Carbide Drills • 41°

		S		W1		
catalog number	angle	mm	in	mm	in	KC7215
3.42805R081	41	2,83	.111	8,00	.315	●
3.42807R081	41	3,98	.157	12,00	.472	●







● first choice
○ alternate choice

P	●
M	●
K	●
N	●
S	
H	

SEFAS Chamfering Inserts for KenTIP™ Drills • 45°

		S		W1						
catalog number	angle	mm	in	mm	in	CS5	KC7015	KC7215	KC7315	KMF
3.42805R001	45	2,83	.111	8,00	.315	●	–	●	–	●
3.42805R021	45	2,83	.111	8,00	.315	–	●	–	●	–
3.42807R001	45	3,98	.157	12,00	.472	●	–	●	–	●
3.42807R021	45	3,98	.157	12,00	.472	–	●	–	●	–

Cost Reduction Targets Giving You Headaches?

Save time and money with Kennametal SEFAS™ COMBINATION DRILLING SYSTEM:

- Combine centering, drilling, and chamfering into a single operation, increasing productivity by reducing cycle time and number of tool changes.
- Reduce inventory and avoid reconditioning by using KenTIP™ blades.
- Easily change tool within the machine by using KenTIP drills.



Experience the advantages at your Authorized Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

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Indexable Drills

Tool Selection Guide **J2–J3**

Drill Fix DFR, DFSP, and DFT **J4–J59**

Drill Fix DFR J4, J8–J21

Drill Fix DFSP J4, J22–J45

Drill Fix DFT J5, J46–J59

HTS Series Indexable Deep-Hole Drilling System **J60–J96**

HTS and HTS-R Indexable Drill System J60–J96

Indexable Drill Inserts **J97–J111**

Drill Fix DFR Inserts J97–J99

Drill Fix DFT Inserts J98, J100–J102

Drill Fix DFSP Inserts J103–J104

CTR Counterboring Tools **J112–J117**

Counterboring Inserts J115–J117



		standard							standard range			customized solution range			
		● first choice ○ alternate choice							diameter range			diameter range			
		P	M	K	N	S	H	hole tolerance	D1 mm min–max	D1 inch min–max	drilling depth L/D1	D1 mm min–max	D1 inch min–max	drilling depth	
	**DFR**™ Indexable Drill Body *Short-Hole Drilling*	●	●	●	●	●		IT9–11	12,5–25	.500–1.039	2 x D 3 x D 4 x D	12,5–26	.500–1.023	1–5 x D	
	**DFSP**™ Indexable Drill Body *Short-Hole Drilling*	●	●	●	●	●		IT9–11	14–55	.551–2.165	2 x D 3 x D 4 x D 5 x D	14–85	.551–3.350	1–5 x D	
	**DFT**™ Indexable Drill Body *Short-Hole Drilling*	●	●	●	●	●		IT9–11	16–83	.625–3.250	2.5 x D 4 x D	15,8–83	.622–3.350	1–5 x D	
	**HTS-R** Indexable Drilling Tool *Deep-Hole Drilling*	●	●	●	●	●		IT9–11	40–55	1.574–2.165	10 x D	40–55	1.574–2.165	1–10 x D	
	**HTS** Indexable Drilling Tool *Deep-Hole Drilling*	●	●	●	●	●		IT9–11	45–270	1.772–10.630	10 x D	45–540	1.772–21.259	1–10 x D	
	**S2 S Countersinking** Countersinking Tool	●	●	●	●	●		IT9–11	15,1–46,2	.813–3.125	1 x D	11,5–150	.451–5.905	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 customized solution.

	■ standard capabilities [1]							■ standard and □ customized solution capabilities									
	coolant		2°		TS	XMZ	DV	BT									page(s)
		■		■	■				■	■	■	■	■	□	□		J10–J21
		■		■	■	■			■	■	■	■	■*	□	□		□	J24–J45
		■		■	■	■			■	■	■	■	■	□	□			J48–J59
		■			■		■	■	■									J75–J80
		■			■		■	■	■									J82–J96
		■	■												■	□		J114–J117

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 optimize tolerances on machining centers.

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 optimize tolerances on machining centers.
- Beyond™ grades to achieve highest productivity and outstanding results in steel, stainless steel, and cast iron.

Use where speed and economy are prime considerations.

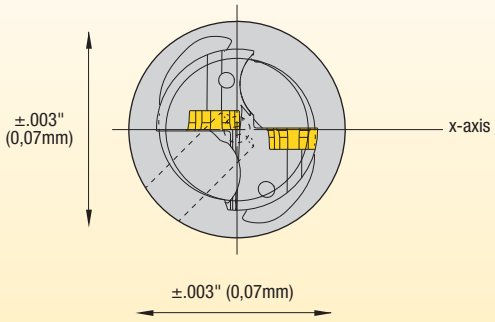


Drill Fix™ DFT™

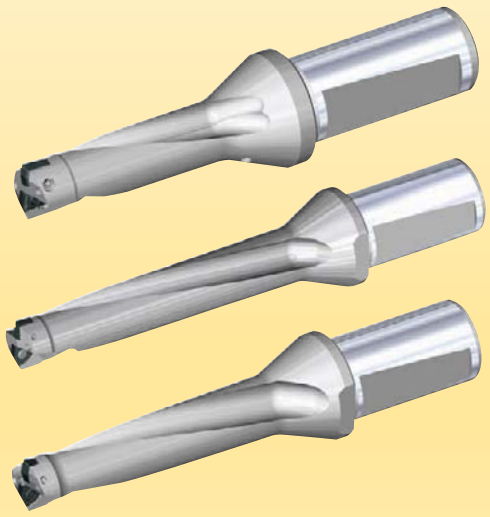
- One drill system that covers a large diameter range, from 24–82mm (1.000–3.250") in 2.5 x D and 4 x D.
- Best centering capabilities due to trigon-shaped inserts used as inboard and outboard inserts.
- Various insert grades and geometries available.
- Balanced cutting forces in the shank center for highest tool body stability.
- X-offset design to adjust diameter size on turning machines and optimize tolerances on machining centers.
- The Drill Fix DFT system has an inner insert for best centering capabilities.

Stationary Applications

Metric Drill Bodies with 2° Whistle Notch



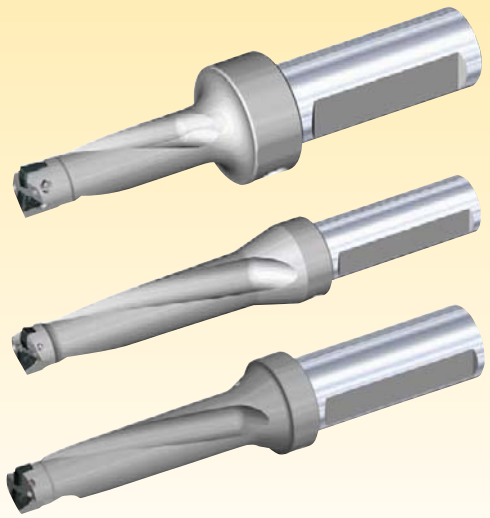
Metric shank drills with a 2° Whistle Notch shank are easily mounted into inch turrets using a WD adapter. Align the X-axis of the drill with the X-axis of the machine tool as described above. Accurate alignment is absolutely essential for good performance. The drill must be on center within the tolerance shown above. Angularity must not exceed .003" (0,07mm).



Inch Bodies • Flange

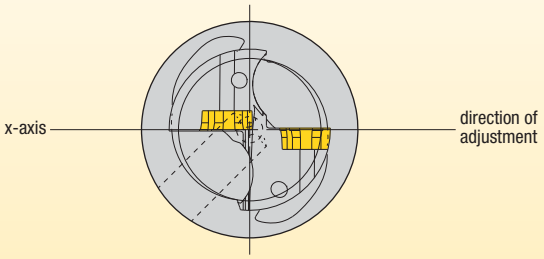
Drill Fix™ inch drills, with a flange, were designed for use on lathes or any machine where the tool remains stationary and the workpiece rotates. An “x” is marked on the flat of the X-axis of the drill to aid insert orientation on the machine tool.

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 center, within the tolerance shown here. Angularity must not exceed .003" (0,07mm) within the designated drill depth.



Drill Fix™ X-Adjustment

Application Examples

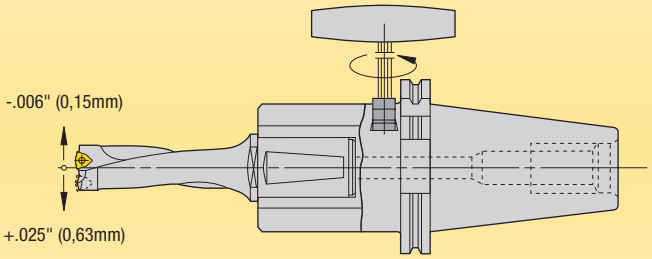


Stationary Tool

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 center.

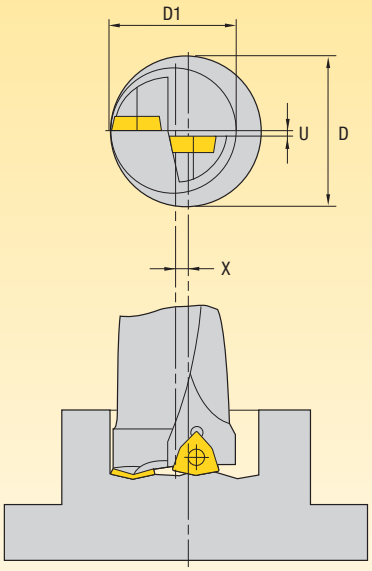


X-Adjustment Description

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 ± .002" (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 centers to reach tolerance optimization.
- 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.



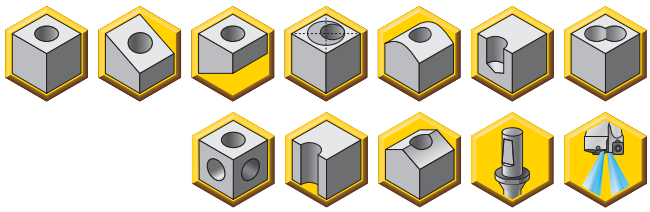
Reliability

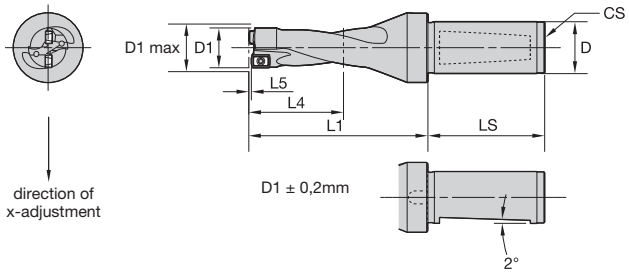
- High stability in smaller sizes due to rectangular-shaped insert.
- Same insert can be used as inboard or outboard insert. No risk of mixing up inner and outer inserts.
- Low cutting forces result in long body tool life.

Customization

- 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 J97–J98 for inserts.







WN/WD Shank • 2 x D • Metric

D		D1						
20	32	mm	in	D1 max	L1	L4 max	L5	gage insert
DFR125R2WD20M	–	12,50	.492	13,50	47,4	25,0	0,5	DFR0202..
DFR127R2WD20M	–	12,70	.500	13,70	47,8	25,4	0,5	DFR0202..
DFR130R2WD20M	–	13,00	.512	14,00	48,4	26,0	0,5	DFR0202..
DFR135R2WD20M	–	13,50	.532	14,50	49,4	27,0	0,5	DFR0202..
DFR140R2WD20M	–	14,00	.551	15,00	50,4	28,0	0,5	DFR0202..
DFR145R2WD20M	–	14,50	.571	15,50	53,4	29,0	0,5	DFR0202..
DFR150R2WD20M	–	15,00	.591	16,00	54,4	30,0	0,5	DFR0202..
DFR155R2WD20M	–	15,50	.610	16,50	55,4	31,0	0,5	DFR0202..
DFR160R2WD20M	–	16,00	.630	17,00	56,4	32,0	0,5	DFR0202..
–	**DFR165R2WD32M**	16,50	.650	17,50	62,4	33,0	0,6	DFR0302..
–	**DFR170R2WD32M**	17,00	.669	18,00	63,4	34,0	0,6	DFR0302..
–	**DFR175R2WD32M**	17,50	.689	18,50	64,4	35,0	0,6	DFR0302..
–	**DFR180R2WD32M**	18,00	.709	19,00	65,4	36,0	0,6	DFR0302..
–	**DFR185R2WD32M**	18,50	.728	19,50	66,4	37,0	0,6	DFR0302..
–	**DFR190R2WD32M**	19,00	.748	20,00	67,4	38,0	0,6	DFR0302..
–	**DFR195R2WD32M**	19,50	.768	20,50	68,4	39,0	0,6	DFR0302..
–	**DFR200R2WD32M**	20,00	.787	21,00	72,4	40,0	0,6	DFR0302..
–	**DFR205R2WD32M**	20,50	.807	21,50	73,6	41,0	0,8	DFR0403..
–	**DFR210R2WD32M**	21,00	.827	22,00	74,6	42,0	0,8	DFR0403..
–	**DFR220R2WD32M**	22,00	.866	23,00	76,6	44,0	0,8	DFR0403..
–	**DFR230R2WD32M**	23,00	.906	24,00	78,6	46,0	0,8	DFR0403..
–	**DFR240R2WD32M**	24,00	.945	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.

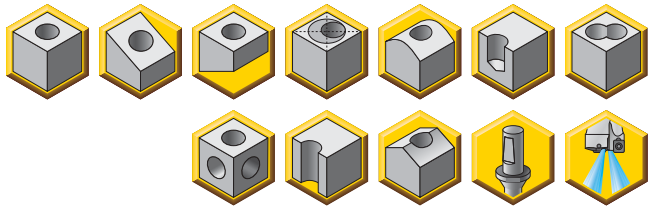


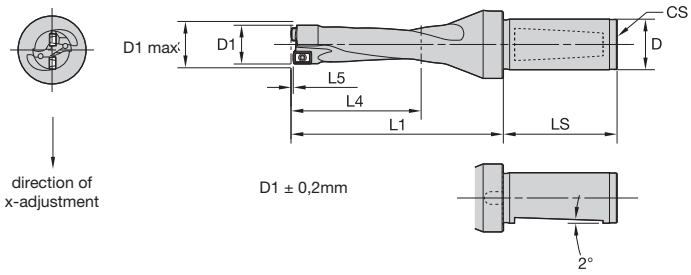


gage insert	insert screw	Torx wrench	Torx size
DFR0202..	**193.281**	**170.027**	6
DFR0302..	**192.416**	**170.023**	7
DFR0403..	**192.432**	**170.028**	8

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 J97–J98 for inserts.







WN/WD Shank • 3 x D • Metric

D			D1						
20	25	32	mm	in	D1 max	L1	L4 max	L5	gage insert
DFR125R3WD20M	–	–	12,50	.492	13,50	59,9	37,5	0,5	DFR0202..
DFR127R3WD20M	–	–	12,70	.500	13,70	60,5	38,1	0,5	DFR0202..
DFR130R3WD20M	–	–	13,00	.512	14,00	61,4	39,0	0,5	DFR0202..
DFR135R3WD20M	–	–	13,50	.532	14,50	62,9	40,5	0,5	DFR0202..
DFR140R3WD20M	–	–	14,00	.551	15,00	64,4	42,0	0,5	DFR0202..
DFR145R3WD20M	–	–	14,50	.571	15,50	67,9	43,5	0,5	DFR0202..
DFR150R3WD20M	–	–	15,00	.591	16,00	69,4	45,0	0,5	DFR0202..
DFR155R3WD20M	–	–	15,50	.610	16,50	70,9	46,5	0,5	DFR0202..
DFR160R3WD20M	–	–	16,00	.630	17,00	72,4	48,0	0,5	DFR0202..
–	–	**DFR165R3WD32M**	16,50	.650	17,50	78,9	49,5	0,6	DFR0302..
–	–	**DFR170R3WD32M**	17,00	.669	18,00	80,4	51,0	0,6	DFR0302..
–	**DFR175R3WD25M**	**DFR175R3WD32M**	17,50	.689	18,50	81,9	52,5	0,6	DFR0302..
–	**DFR180R3WD25M**	**DFR180R3WD32M**	18,00	.709	19,00	83,4	54,0	0,6	DFR0302..
–	**DFR185R3WD25M**	**DFR185R3WD32M**	18,50	.728	19,50	84,9	55,5	0,6	DFR0302..
–	**DFR190R3WD25M**	**DFR190R3WD32M**	19,00	.748	20,00	86,4	57,0	0,6	DFR0302..
–	**DFR195R3WD25M**	**DFR195R3WD32M**	19,50	.768	20,50	87,9	58,5	0,6	DFR0302..
–	**DFR200R3WD25M**	**DFR200R3WD32M**	20,00	.787	21,00	92,4	60,0	0,6	DFR0302..
–	**DFR205R3WD25M**	**DFR205R3WD32M**	20,50	.807	21,50	94,1	61,5	0,8	DFR0403..
–	**DFR210R3WD25M**	**DFR210R3WD32M**	21,00	.827	22,00	95,6	63,0	0,8	DFR0403..
–	**DFR220R3WD25M**	**DFR220R3WD32M**	22,00	.866	23,00	98,6	66,0	0,8	DFR0403..
–	**DFR230R3WD25M**	**DFR230R3WD32M**	23,00	.906	24,00	101,6	69,0	0,8	DFR0403..
–	**DFR240R3WD25M**	**DFR240R3WD32M**	24,00	.945	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.

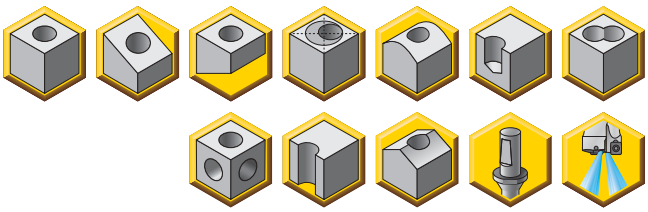


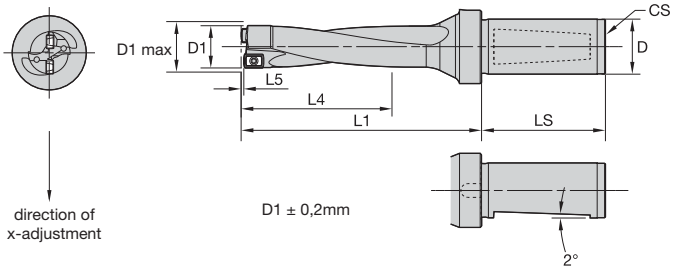


gage insert	insert screw	Torx wrench	Torx size
DFR0202..	**193.281**	**170.027**	6
DFR0302..	**192.416**	**170.023**	7
DFR0403..	**192.432**	**170.028**	8

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 J97–J98 for inserts.







WN/WD Shank • 4 x D • Metric

D		D1						
20	32	mm	in	D1 max	L1	L4 max	L5	gage insert
DFR125R4WD20M	–	12,50	.492	13,50	72,4	50,0	0,5	DFR0202..
DFR127R4WD20M	–	12,70	.500	13,70	73,2	50,8	0,5	DFR0202..
DFR130R4WD20M	–	13,00	.512	14,00	74,4	52,0	0,5	DFR0202..
DFR135R4WD20M	–	13,50	.532	14,50	76,4	54,0	0,5	DFR0202..
DFR140R4WD20M	–	14,00	.551	15,00	78,4	56,0	0,5	DFR0202..
DFR145R4WD20M	–	14,50	.571	15,50	82,4	58,0	0,5	DFR0202..
DFR150R4WD20M	–	15,00	.591	16,00	84,4	60,0	0,5	DFR0202..
DFR155R4WD20M	–	15,50	.610	16,50	86,4	62,0	0,5	DFR0202..
DFR160R4WD20M	–	16,00	.630	17,00	88,4	64,0	0,5	DFR0202..
–	**DFR165R4WD32M**	16,50	.650	17,50	95,4	66,0	0,6	DFR0302..
–	**DFR170R4WD32M**	17,00	.669	18,00	97,4	68,0	0,6	DFR0302..
–	**DFR175R4WD32M**	17,50	.689	18,50	99,4	70,0	0,6	DFR0302..
–	**DFR180R4WD32M**	18,00	.709	19,00	101,4	72,0	0,6	DFR0302..
–	**DFR185R4WD32M**	18,50	.728	19,50	103,4	74,0	0,6	DFR0302..
–	**DFR190R4WD32M**	19,00	.748	20,00	105,4	76,0	0,6	DFR0302..
–	**DFR195R4WD32M**	19,50	.768	20,50	107,4	78,0	0,6	DFR0302..
–	**DFR200R4WD32M**	20,00	.787	21,00	109,4	80,0	0,6	DFR0302..
–	**DFR205R4WD32M**	20,50	.807	21,50	111,6	82,0	0,8	DFR0403..
–	**DFR210R4WD32M**	21,00	.827	22,00	113,6	84,0	0,8	DFR0403..
–	**DFR220R4WD32M**	22,00	.866	23,00	117,6	88,0	0,8	DFR0403..
–	**DFR230R4WD32M**	23,00	.906	24,00	121,6	92,0	0,8	DFR0403..
–	**DFR240R4WD32M**	24,00	.945	25,00	125,6	96,0	0,8	DFR0403..

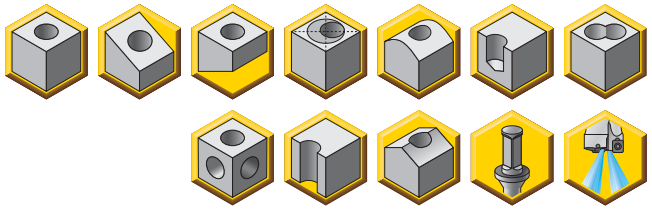
WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

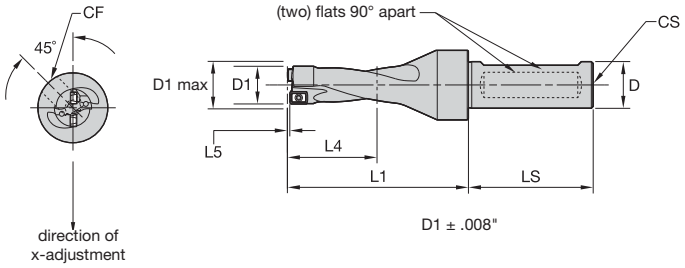


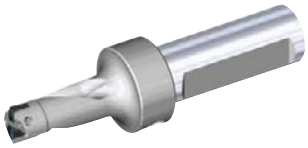

gage insert	insert screw	Torx wrench	Torx size
DFR0202..	**193.281**	**170.027**	6
DFR0302..	**192.416**	**170.023**	7
DFR0403..	**192.432**	**170.028**	8

D	LS	CS
20	45	R 1/8 BSP
32	58	R 1/4 BSP

- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- See pages J97–J98 for inserts.







Flange Shank • 2 x D • Inch

D		D1 diameter						
0.750	1.000	mm	in	D1 max	L1	L4 max	L5	gage insert
DFR0500R2SSF075	**–**	12,70	.500	.539	1.95	1.00	.02	DFR0202..
DFR0563R2SSF075	**–**	14,30	.563	.602	2.08	1.13	.02	DFR0202..
DFR0625R2SSF075	**–**	15,88	.625	.664	2.20	1.25	.02	DFR0202..
DFR0688R2SSF075	**–**	17,48	.688	.727	2.33	1.38	.02	DFR0302..
–	**DFR0750R2SSF100**	19,05	.750	.789	2.52	1.50	.02	DFR0302..
–	**DFR0813R2SSF100**	20,65	.813	.852	2.65	1.63	.03	DFR0403..
–	**DFR0875R2SSF100**	22,23	.875	.914	2.87	1.75	.03	DFR0403..
–	**DFR0938R2SSF100**	23,83	.938	.977	2.99	1.88	.03	DFR0403..
–	**DFR1000R2SSF100**	25,40	1.000	1.039	3.12	2.00	.03	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.

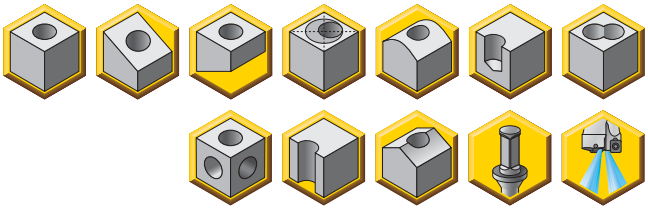


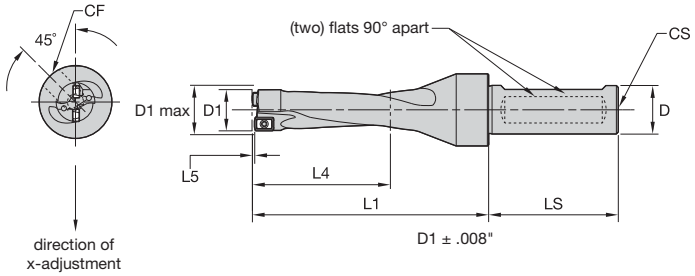

gage insert	insert screw	Torx wrench	Torx size
DFR0202..	**193.281**	**170.027**	6
DFR0302..	**192.416**	**170.023**	7
DFR0403..	**192.432**	**170.028**	8

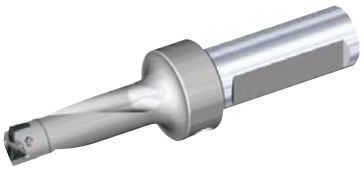


D	LS	CF	CS	pipe plug
0.75	2.00	1/8-27 NPT	1/8-27 NPT	**HSFS0125**
1.00	3.00	1/8-27 NPT	1/4-18 NPT	**HSFS0125**

- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- See pages J97–J98 for inserts.







Flange Shank • 3 x D • Inch

D			D1 diameter						
0.750	1.000	1.250	mm	in	D1 max	L1	L4 max	L5	gage insert
DFR0500R3SSF075	–	–	12,70	.500	.539	2.44	1.59	.02	DFR0202..
DFR0531R3SSF075	–	–	13,49	.531	.570	2.50	1.69	.02	DFR0202..
DFR0563R3SSF075	–	–	14,30	.563	.602	2.64	1.69	.02	DFR0202..
DFR0594R3SSF075	–	–	15,09	.594	.633	2.70	1.78	.02	DFR0202..
DFR0625R3SSF075	DFR0625R3SSF100	–	15,88	.625	.664	2.83	1.88	.02	DFR0202..
DFR0656R3SSF075	DFR0656R3SSF100	–	16,66	.656	.695	2.92	1.97	.02	DFR0302..
DFR0688R3SSF075	DFR0688R3SSF100	–	17,48	.688	.727	3.02	2.06	.02	DFR0302..
DFR0703R3SSF075	DFR0703R3SSF100	–	17,86	.703	.742	3.13	2.11	.02	DFR0302..
DFR0734R3SSF075	DFR0734R3SSF100	–	18,64	.734	.773	3.22	2.20	.02	DFR0302..
DFR0750R3SSF075	DFR0750R3SSF100	–	19,05	.750	.789	3.27	2.25	.02	DFR0302..
DFR0781R3SSF075	DFR0781R3SSF100	–	19,84	.781	.820	3.36	2.34	.02	DFR0302..
DFR0813R3SSF075	DFR0813R3SSF100	–	20,65	.813	.852	3.46	2.44	.03	DFR0403..
DFR0844R3SSF075 *	DFR0844R3SSF100	–	21,44	.844	.883	3.65	2.53	.03	DFR0403..
DFR0875R3SSF075	DFR0875R3SSF100	–	22,23	.875	.914	3.74	2.63	.03	DFR0403..
–	DFR0906R3SSF100	–	23,01	.906	.945	3.83	2.72	.03	DFR0403..
–	DFR0938R3SSF100	–	23,83	.938	.977	3.93	2.81	.03	DFR0403..
–	DFR0969R3SSF100	–	24,61	.969	1.008	4.02	2.91	.03	DFR0403..
–	DFR0984R3SSF100	–	24,99	.984	1.023	4.07	2.95	.03	DFR0403..
–	DFR1000R3SSF100	DFR1000R3SSF125	25,40	1.000	1.039	4.12	3.00	.03	DFR0403..

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.

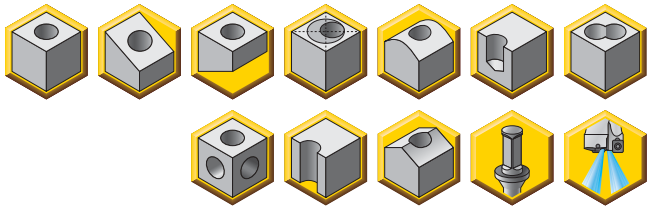


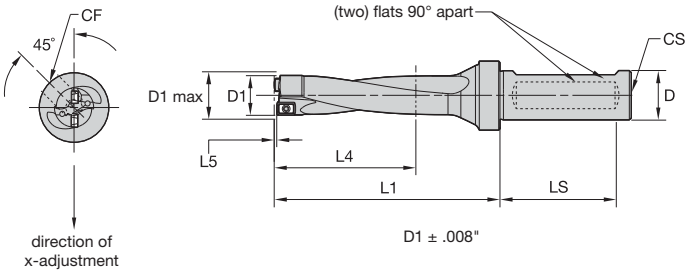
gage insert	insert screw	Torx wrench	Torx size
DFR0202..	**193.281**	**170.027**	6
DFR0302..	**192.416**	**170.023**	7
DFR0403..	**192.432**	**170.028**	8



D	LS	CF	CS	pipe plug
0.75	2.00	1/8-27 NPT	1/8-27 NPT	**HSFS0125**
1.00	3.00	1/8-27 NPT	1/4-18 NPT	**HSFS0125**
1.25	3.25	1/8-27 NPT	1/4-18 NPT	**HSFS0125**

- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- See pages J97–J98 for inserts.







Flange Shank • 4 x D • Inch

D			D1 diameter						
0.750	1.000	1.250	mm	in	D1 max	L1	L4 max	L5	gage insert
DFR0500R4SSF075	–	–	12,70	.500	.540	2.95	2.00	.02	DFR0202..
DFR0531R4SSF075	–	–	13,49	.531	.571	3.05	2.12	.02	DFR0202..
DFR0563R4SSF075	–	–	14,30	.563	.603	3.21	2.25	.02	DFR0202..
DFR0594R4SSF075	–	–	15,09	.594	.633	3.30	2.38	.02	DFR0202..
DFR0625R4SSF075	DFR0625R4SSF100	–	15,88	.625	.664	3.45	2.50	.02	DFR0202..
–	DFR0656R4SSF100	–	16,66	.656	.695	3.58	2.62	.02	DFR0302..
–	DFR0688R4SSF100	–	17,48	.688	.727	3.71	2.75	.02	DFR0302..
–	DFR0703R4SSF100	–	17,86	.703	.742	3.83	2.81	.02	DFR0302..
–	DFR0734R4SSF100	–	18,64	.734	.773	3.95	2.94	.02	DFR0302..
–	DFR0750R4SSF100	–	19,05	.750	.789	4.02	3.00	.02	DFR0302..
–	DFR0781R4SSF100	–	19,84	.781	.820	4.14	3.12	.02	DFR0302..
–	DFR0813R4SSF100	–	20,65	.813	.852	4.27	3.25	.03	DFR0403..
–	DFR0844R4SSF100	–	21,44	.844	.883	4.49	3.38	.03	DFR0403..
–	DFR0875R4SSF100	–	22,23	.875	.914	4.62	3.50	.03	DFR0403..
–	DFR0906R4SSF100	–	23,01	.906	.945	4.74	3.62	.03	DFR0403..
–	DFR0938R4SSF100	–	23,83	.938	.977	4.87	3.75	.03	DFR0403..
–	DFR0969R4SSF100	–	24,61	.969	1.008	4.99	3.88	.03	DFR0403..
–	DFR0984R4SSF100	–	24,99	.984	1.023	5.05	3.84	.03	DFR0403..
–	DFR1000R4SSF100	DFR1000R4SSF125	25,40	1.000	1.039	5.12	4.00	.03	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	CF	CS	pipe plug
0.75	2.00	1/8-27 NPT	1/8-27 NPT	**HSFS0125**
1.00	3.00	1/8-27 NPT	1/4-18 NPT	**HSFS0125**
1.25	3.25	1/8-27 NPT	1/4-18 NPT	**HSFS0125**

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

Drill Fix™ DFR™ • Inch

Inch											
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (fz) by Diameter			
						min	Starting Value	max	Ø	DFR02... .500–.625"	DFR03... .688–.750"	DFR04... .813–1.00"
P	1	S	O	MD	KCU25	1017	**1066**	1181	SFM	.004–.006	.004–.007	.006–.010
			I	MD	KC7140							
		U	O	MD	KCU40	656	**705**	754	SFM	.004–.006	.004–.007	.006–.010
			I	MD	KC7140							
		I	O	MD	KC7140	426	**443**	492	SFM	.004–.006	.004–.007	.006–.010
			I	MD	KC7140							
	2	S	O	GD	KCPK10	1017	**1066**	1181	SFM	.004–.006	.004–.007	.006–.010
			I	LD	KC7140							
		U	O	GD	KCU40	656	**705**	754	SFM	.004–.006	.004–.007	.006–.010
			I	LD	KC7140							
		I	O	MD	KC7140	426	**443**	492	SFM	.004–.006	.004–.007	.006–.010
			I	LD	KC7140							
	3	S	O	GD	KCPK10	853	**935**	1050	SFM	.004–.006	.004–.007	.006–.010
			I	LD	KC7140							
		U	O	GD	KCU40	590	**640**	722	SFM	.004–.006	.004–.007	.006–.010
			I	LD	KC7140							
		I	O	GD	KC7140	361	**394**	459	SFM	.004–.006	.004–.007	.006–.010
			I	LD	KC7140							
	4	S	O	GD	KCU25	722	**820**	984	SFM	.004–.006	.004–.007	.006–.010
			I	LD	KC7140							
		U	O	GD	KCU40	492	**590**	722	SFM	.004–.006	.004–.007	.006–.010
			I	LD	KC7140							
		I	O	GD	KC7140	295	**361**	459	SFM	.004–.006	.004–.007	.006–.010
			I	LD	KC7140							
	5	S	O	GD	KCU25	590	**656**	722	SFM	.003–.005	.004–.006	.004–.007
			I	LD	KC7140							
		U	O	GD	KCU40	394	**443**	492	SFM	.003–.005	.004–.006	.004–.007
			I	LD	KC7140							
		I	O	GD	KC7140	230	**279**	328	SFM	.003–.005	.004–.006	.004–.007
			I	LD	KC7140							
	6	S	O	GD	KCU25	590	**656**	722	SFM	.004–.006	.004–.007	.006–.010
			I	LD	KC7140							
		U	O	GD	KCU40	394	**443**	492	SFM	.004–.006	.004–.007	.006–.010
			I	LD	KC7140							
		I	O	GD	KC7140	230	**279**	328	SFM	.004–.006	.004–.007	.006–.010
			I	LD	KC7140							
M	1	S	O	MD	KC7140	492	**623**	754	SFM	.003–.005	.003–.006	.004–.007
			I	MD	KC7140							
		U	O	MD	KC7140	328	**426**	525	SFM	.003–.005	.003–.006	.004–.007
			I	MD	KC7140							
		I	O	MD	KC7140	197	**262**	328	SFM	.003–.005	.003–.006	.004–.007
			I	MD	KC7140							
	2	S	O	MD	KC7140	492	**590**	689	SFM	.003–.005	.003–.006	.004–.007
			I	MD	KC7140							
		U	O	MD	KC7140	328	**426**	525	SFM	.003–.005	.003–.006	.004–.007
			I	MD	KC7140							
		I	O	MD	KC7140	197	**262**	328	SFM	.003–.005	.003–.006	.004–.007
			I	MD	KC7140							
	3	S	O	MD	KC7140	328	**426**	525	SFM	.003–.005	.003–.006	.004–.007
			I	MD	KC7140							
		U	O	MD	KC7140	262	**361**	459	SFM	.003–.005	.003–.006	.004–.007
			I	MD	KC7140							
		I	O	MD	KC7140	164	**230**	295	SFM	.003–.005	.003–.006	.004–.007
			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™ • Inch

Inch												
Material Group		Pocket Seat	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (fz) by Diameter			
						min	Starting Value	max	Ø	DFR02... .500–.625"	DFR03... .688–.750"	DFR04... .813–1.00"
K	1	S	O	GD	KCPK10	656	**787**	984	SFM	.004–.007	.005–.008	.006–.009
			I	LD	KCU40							
		U	O	GD	KCU25	394	**508**	656	SFM	.004–.007	.005–.008	.006–.009
			I	LD	KC7140							
		I	O	GD	KCU40	262	**328**	410	SFM	.004–.007	.005–.008	.005–.009
			I	LD	KC7140							
	2	S	O	GD	KCPK10	590	**722**	853	SFM	.004–.007	.005–.008	.006–.009
			I	LD	KCU40							
		U	O	GD	KCU25	361	**459**	558	SFM	.004–.007	.005–.008	.005–.009
			I	LD	KC7140							
		I	O	GD	KCU40	262	**328**	394	SFM	.004–.007	.005–.008	.006–.009
			I	LD	KC7140							
	3	S	O	GD	KCPK10	590	**722**	853	SFM	.004–.007	.005–.008	.005–.009
			I	LD	KCU40							
		U	O	GD	KCU25	361	**459**	558	SFM	.004–.007	.005–.008	.006–.009
			I	LD	KC7140							
		I	O	GD	KCU40	262	**328**	394	SFM	.004–.007	.005–.008	.005–.009
			I	LD	KC7140							
N	1	S	O	ST	KD1425	1312	**1968**	2624	SFM	.003–.004	.004–.006	.005–.006
			I	ST	KD1425							
		U	O	LD	KCU40	984	**1312**	1640	SFM	.003–.004	.004–.006	.005–.006
			I	LD	KCU40							
		I	O	LD	KCU40	656	**984**	1312	SFM	.003–.004	.004–.006	.005–.006
			I	LD	KCU40							
	2	S	O	ST	KD1425	1230	**1804**	2542	SFM	.003–.004	.004–.006	.005–.006
			I	ST	KD1425							
		U	O	LD	KCU40	820	**1148**	1476	SFM	.003–.004	.004–.006	.005–.006
			I	LD	KCU40							
		I	O	LD	KCU40	574	**820**	1066	SFM	.003–.004	.004–.006	.005–.006
			I	LD	KCU40							
	3	S	O	ST	KD1425	1148	**1640**	2132	SFM	.003–.004	.004–.006	.005–.006
			I	ST	KD1425							
		U	O	LD	KCU40	820	**1148**	1476	SFM	.003–.004	.004–.006	.005–.006
			I	LD	KCU40							
		I	O	LD	KCU40	492	**820**	1148	SFM	.003–.004	.004–.006	.005–.006
			I	LD	KCU40							
	4	S	O	ST	KD1425	1312	**1968**	2624	SFM	.003–.004	.004–.006	.005–.006
			I	ST	KD1425							
		U	O	LD	KCU40	820	**1148**	1486	SFM	.003–.004	.004–.006	.005–.006
			I	LD	KCU40							
		I	O	LD	KCU40	656	**984**	1312	SFM	.003–.004	.004–.006	.005–.006
			I	LD	KCU40							
	5	S	O	HP	KD1425	1312	**1968**	2624	SFM	.003–.004	.004–.006	.005–.006
			I	HP	KD1425							
		U	O	HP	KCU40	820	**1148**	1476	SFM	.003–.004	.004–.006	.005–.006
			I	HP	KCU40							
		I	O	HP	KCU40	656	**984**	1312	SFM	.003–.004	.004–.006	.005–.006
			I	HP	KCU40							
	6	S	O	ST	KD1425	1312	**1968**	2624	SFM	.003–.004	.004–.006	.005–.006
			I	ST	KD1425							
		U	O	GD	KCU40	820	**1148**	1476	SFM	.003–.004	.004–.006	.005–.006
			I	GD	KCU40							
		I	O	GD	KMF	656	**984**	1312	SFM	.003–.004	.004–.006	.005–.006
			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™ • Inch

Inch												
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (fz) by Diameter			
						min	Starting Value	max	Ø	DFR02... .500–.625"	DFR03... .688–.750"	DFR04... .813–1.00"
S	1	S	O	GD	KCU40	197	**230**	246	SFM	.002–.002	.002–.003	.002–.004
			I	LD	KCU40							
		U	O	GD	KCU40	131	**164**	197	SFM	.002–.002	.002–.003	.002–.004
			I	LD	KC7140							
		I	O	MD	KC7140	82	**98**	131	SFM	.002–.002	.002–.003	.002–.004
			I	MD	KC7140							
	2	S	O	GD	KCU40	164	**197**	230	SFM	.002–.002	.002–.003	.002–.004
			I	LD	KCU40							
		U	O	GD	KCU40	98	**131**	164	SFM	.002–.002	.002–.003	.002–.004
			I	LD	KC7140							
		I	O	MD	KC7140	82	**98**	131	SFM	.002–.002	.002–.003	.002–.004
			I	MD	KC7140							
	3	S	O	GD	KCU40	230	**262**	295	SFM	.002–.004	.002–.003	.002–.004
			I	LD	KCU40							
		U	O	GD	KCU40	164	**197**	230	SFM	.002–.003	.002–.004	.002–.004
			I	LD	KC7140							
		I	O	MD	KC7140	98	**131**	164	SFM	.002–.003	.002–.004	.002–.004
			I	MD	KC7140							
	4	S	O	GD	KCU40	230	**262**	295	SFM	.002–.003	.002–.004	.002–.004
			I	LD	KCU40							
		U	O	GD	KCU40	164	**197**	230	SFM	.002–.003	.002–.004	.002–.004
			I	LD	KC7140							
		I	O	MD	KC7140	98	**131**	164	SFM	.002–.003	.002–.004	.002–.004
			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™ 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 centering 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 centers to reach tolerance optimization.
- 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.



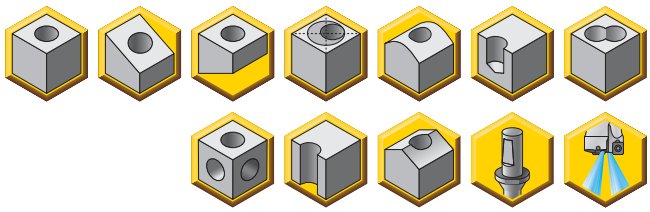
Reliability

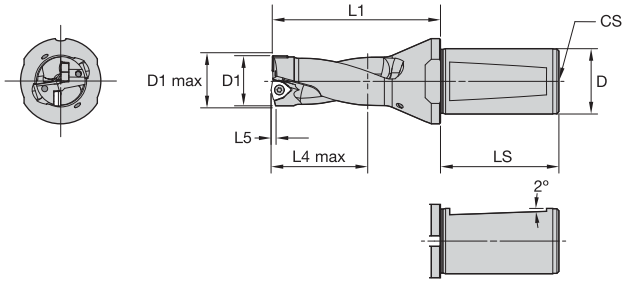
- High accuracy holes in any feed rates.
- Gain outstanding results using Beyond grades for DFT™ and SPGX/SPPX inserts.
- High wear resistance in interrupted cuts due to squared outboard insert.

Customization

- 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 centering capabilities of the trigon inboard insert.
- Drill shipped with insert screws and Torx wrench.
- Order inserts for DFSP separately.
  See pages J103–J104 for inserts.







WD Shank • 2 x D • Metric

D				D1 diameter							
20	32	40	50	mm	in	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
DFSP140R2WD20M	–	–	–	14,00	.550	15,00	50,0	28,0	0,3	SPGX0502..	DFTX202..
DFSP145R2WD20M *	–	–	–	14,50	.570	15,50	53,0	29,0	0,4	SPGX0502..	DFTX202..
DFSP150R2WD20M	–	–	–	15,00	.590	16,00	54,0	30,0	0,4	SPGX0502..	DFTX202..
DFSP155R2WD20M	–	–	–	15,50	.610	16,50	55,0	31,0	0,4	SPGX0502..	DFTX202..
DFSP160R2WD20M	–	–	–	16,00	.630	17,00	56,0	32,0	0,4	SPGX0502..	DFTX202..
–	DFSP165R2WD32M	–	–	16,50	.650	17,50	62,0	33,0	0,5	SPGX0502..	DFTX202..
–	DFSP170R2WD32M	–	–	17,00	.670	18,00	63,0	34,0	0,5	SPGX0502..	DFTX202..
–	DFSP175R2WD32M	–	–	17,50	.690	18,50	64,0	35,0	0,5	SPGX0603..	DFT0303..
–	DFSP180R2WD32M	–	–	18,00	.710	19,00	65,0	36,0	0,5	SPGX0603..	DFT0303..
–	DFSP185R2WD32M	–	–	18,50	.730	19,50	66,0	37,0	0,6	SPGX0603..	DFT0303..
–	DFSP190R2WD32M	–	–	19,00	.750	20,00	67,0	38,0	0,6	SPGX0603..	DFT0303..
–	DFSP195R2WD32M	–	–	19,50	.770	20,50	68,0	39,0	0,6	SPGX0603..	DFT0303..
–	DFSP200R2WD32M	–	–	20,00	.790	21,00	72,0	40,0	0,6	SPGX0603..	DFT0303..
–	DFSP210R2WD32M	–	–	21,00	.830	22,00	74,0	42,0	0,7	SPGX0603..	DFT0303..
–	DFSP220R2WD32M	–	–	22,00	.870	23,00	76,0	44,0	0,5	SPGX0703..	DFT05T3..
–	DFSP230R2WD32M	–	–	23,00	.910	24,00	78,0	46,0	0,6	SPGX0703..	DFT05T3..
–	DFSP240R2WD32M	–	–	24,00	.945	25,00	80,0	48,0	0,6	SPGX0703..	DFT05T3..
–	DFSP250R2WD32M	–	–	25,00	.984	26,00	83,0	50,0	0,7	SPGX0703..	DFT05T3..
–	DFSP260R2WD32M	–	–	26,00	1.024	27,00	86,0	52,0	0,7	SPPX09T3..	DFT05T3..
–	DFSP265R2WD32M	–	–	26,50	1.043	27,50	87,0	53,0	0,7	SPPX09T3..	DFT05T3..
–	DFSP270R2WD32M	–	–	27,00	1.063	28,00	89,0	54,0	0,8	SPPX09T3..	DFT05T3..
–	DFSP280R2WD32M	–	–	28,00	1.102	29,00	91,0	56,0	0,8	SPPX09T3..	DFT05T3..
–	DFSP290R2WD32M	–	–	29,00	1.142	30,00	94,0	58,0	0,9	SPPX09T3..	DFT05T3..
–	DFSP300R2WD32M	–	–	30,00	1.181	31,00	97,0	60,0	0,9	SPPX09T3..	DFT05T3..
–	DFSP310R2WD32M	–	–	31,00	1.221	32,00	100,0	62,0	0,9	SPPX09T3..	DFT05T3..
–	DFSP320R2WD32M	–	–	32,00	1.260	33,00	103,0	64,0	1,0	SPPX09T3..	DFT05T3..
–	DFSP330R2WD32M	–	–	33,00	1.299	34,00	105,0	66,0	0,9	SPPX1204..	DFT06T3..
–	DFSP340R2WD32M	–	–	34,00	1.339	35,00	108,0	68,0	0,9	SPPX1204..	DFT06T3..
–	DFSP350R2WD32M	–	–	35,00	1.378	36,00	111,0	70,0	1,0	SPPX1204..	DFT06T3..
–	DFSP360R2WD32M	–	–	36,00	1.417	37,00	114,0	72,0	1,0	SPPX1204..	DFT06T3..
–	DFSP370R2WD32M	–	–	37,00	1.457	38,00	117,0	74,0	1,1	SPPX1204..	DFT06T3..
–	DFSP375R2WD32M *	–	–	37,50	1.476	38,50	118,0	75,0	1,1	SPPX1204..	DFT06T3..
–	DFSP380R2WD32M	–	–	38,00	1.496	39,00	119,0	76,0	1,1	SPPX1204..	DFT06T3..
–	DFSP390R2WD32M	–	–	39,00	1.535	40,00	122,0	78,0	1,2	SPPX1204..	DFT06T3..
–	DFSP400R2WD32M	–	–	40,00	1.575	41,00	125,0	80,0	1,2	SPPX1204..	DFT06T3..
–	DFSP410R2WD32M	–	–	41,00	1.614	42,00	128,0	82,0	1,2	SPPX1204..	DFT0704..

(continued)

(WD Shank • 2 x D • Metric — continued)

D				D1 diameter							
20	32	40	50	mm	in	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
—	**DFSP420R2WD32M**	—	—	42,00	1.654	43,00	131,0	84,0	1,3	SPPX1204..	DFT0704..
—	**DFSP430R2WD32M**	—	—	43,00	1.693	44,00	133,0	86,0	1,3	SPPX1204..	DFT0704..
—	**DFSP440R2WD32M**	—	—	44,00	1.732	45,00	135,0	88,0	1,4	SPPX15T5..	DFT0704..
—	—	**DFSP450R2WD40M**	—	45,00	1.772	46,00	137,0	90,0	1,4	SPPX15T5..	DFT0704..
—	—	**DFSP460R2WD40M**	—	46,00	1.811	47,00	140,0	92,0	1,5	SPPX15T5..	DFT0704..
—	—	**DFSP470R2WD40M**	—	47,00	1.850	48,00	142,0	94,0	1,5	SPPX15T5..	DFT0704..
—	—	**DFSP480R2WD40M**	—	48,00	1.890	49,00	144,0	96,0	1,5	SPPX15T5..	DFT0704..
—	—	**DFSP490R2WD40M**	—	49,00	1.929	50,00	146,0	98,0	1,4	SPPX15T5..	DFT0905..
—	—	**DFSP500R2WD40M**	—	50,00	1.969	51,00	148,0	100,0	1,5	SPPX15T5..	DFT0905..
—	—	**DFSP505R2WD40M**	—	50,50	1.988	51,50	148,0	100,0	1,5	SPPX15T5..	DFT0905..
—	—	**DFSP510R2WD40M**	—	51,00	2.008	52,00	150,0	102,0	1,6	SPPX15T5..	DFT0905..
—	—	**DFSP520R2WD40M**	—	52,00	2.047	53,00	152,0	104,0	1,6	SPPX15T5..	DFT0905..
—	—	**DFSP530R2WD40M**	—	53,00	2.087	54,00	154,0	106,0	1,7	SPPX15T5..	DFT0905..
—	—	**DFSP540R2WD40M**	—	54,00	2.126	55,00	156,0	108,0	1,7	SPPX15T5..	DFT0905..
—	—	—	**DFSP550R2WD50M**	55,00	2.165	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 +.039" (+1mm).
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts



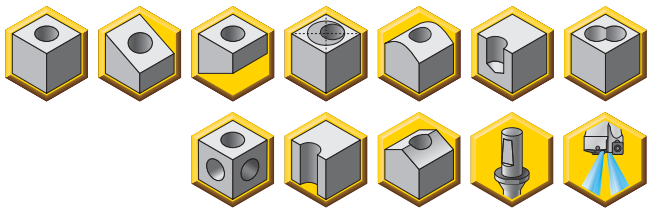

diameter range	gage insert inside	inboard insert screw	tightening torque Nm	tightening torque ft. lbs	gage insert outside	outboard insert screw	tightening torque Nm	tightening torque ft. lbs	Torx driver	Torx size
14.00–17.00	DFTX202..	**193.281**	0,6	.44	SPGX0502..	**193.281**	0,6	.44	**170.370**	T6
17.50–21.00	DFT0303..	**MS1152**	0,9	.66	SPGX0603..	**MS1152**	0,9	.66	**170.023**	T7
22.00–25.00	DFT05T3..	**193.491**	2,1	1.55	SPGX0703..	**192.432**	1,3	.96	**170.028**	T8
26.00–32.00	DFT05T3..	**191.924**	2,1	1.55	SPPX09T3..	**191.924**	2,1	1.55	**170.024**	T9
33.00–40.00	DFT06T3..	**191.916**	4	2.95	SPPX1204..	**191.916**	4	2.95	**170.025**	T15
41.00–43.00	DFT0704..	**191.916**	6	4.43	SPPX1204..	**191.916**	3	2.21	**170.025**	T15
44.00–48.00	DFT0704..	**191.698**	6	4.43	SPPX15T5..	**192.433**	3	2.21	**170.025**	T15
49.00–55.00	DFT0905..	**192.433**	6	4.43	SPPX15T5..	**192.433**	6	4.43	**170.025**	T15

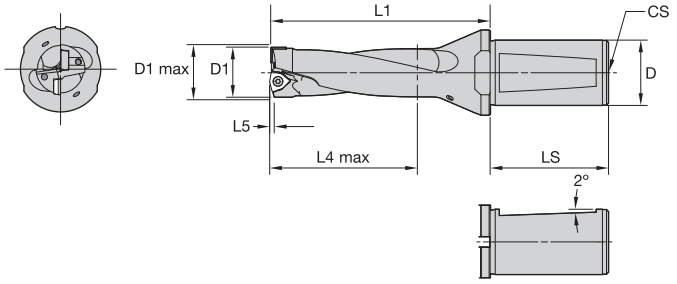
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges .875–1.000" (22–25,5mm) and 1.750–1.875" (41–48mm) are necessary. Both screws have the same Torx size.

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 centering capabilities of the trigon inboard insert.
- Drill shipped with insert screws and Torx wrench.
- Order inserts for DFSP separately.
  See pages J103–J104 for inserts.







WD Shank • 3 x D • Metric

D				D1 diameter							
20	32	40	50	mm	in	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
DFSP140R3WD20M	–	–	–	14,00	.550	15,00	64,0	42,0	0,3	SPGX0502..	DFTX202..
DFSP145R3WD20M	–	–	–	14,50	.570	15,50	67,5	43,5	0,4	SPGX0502..	DFTX202..
DFSP150R3WD20M	–	–	–	15,00	.590	16,00	69,0	45,0	0,4	SPGX0502..	DFTX202..
DFSP155R3WD20M	–	–	–	15,50	.610	16,50	70,5	46,5	0,4	SPGX0502..	DFTX202..
DFSP160R3WD20M	–	–	–	16,00	.630	17,00	72,0	48,0	0,4	SPGX0502..	DFTX202..
–	**DFSP165R3WD32M**	–	–	16,50	.650	17,50	78,5	49,5	0,5	SPGX0502..	DFTX202..
–	**DFSP170R3WD32M**	–	–	17,00	.670	18,00	80,0	51,0	0,5	SPGX0502..	DFTX202..
–	**DFSP175R3WD32M**	–	–	17,50	.690	18,50	81,5	52,5	0,5	SPGX0603..	DFT0303..
–	**DFSP180R3WD32M**	–	–	18,00	.710	19,00	83,0	54,0	0,5	SPGX0603..	DFT0303..
–	**DFSP185R3WD32M**	–	–	18,50	.730	19,50	84,5	55,5	0,6	SPGX0603..	DFT0303..
–	**DFSP190R3WD32M**	–	–	19,00	.750	20,00	86,0	57,0	0,6	SPGX0603..	DFT0303..
–	**DFSP195R3WD32M**	–	–	19,50	.770	20,50	87,5	58,5	0,6	SPGX0603..	DFT0303..
–	**DFSP200R3WD32M**	–	–	20,00	.790	21,00	92,0	60,0	0,6	SPGX0603..	DFT0303..
–	**DFSP210R3WD32M**	–	–	21,00	.830	22,00	95,0	63,0	0,7	SPGX0603..	DFT0303..
–	**DFSP220R3WD32M**	–	–	22,00	.870	23,00	98,0	66,0	0,5	SPGX0703..	DFT05T3..
–	**DFSP230R3WD32M**	–	–	23,00	.910	24,00	101,0	69,0	0,6	SPGX0703..	DFT05T3..
–	**DFSP240R3WD32M**	–	–	24,00	.945	25,00	104,0	72,0	0,6	SPGX0703..	DFT05T3..
–	**DFSP250R3WD32M**	–	–	25,00	.984	26,00	108,0	75,0	0,7	SPGX0703..	DFT05T3..
–	**DFSP260R3WD32M**	–	–	26,00	1.024	27,00	112,0	78,0	0,7	SPPX09T3..	DFT05T3..
–	**DFSP265R3WD32M**	–	–	26,50	1.043	27,50	113,5	79,5	0,7	SPPX09T3..	DFT05T3..
–	**DFSP270R3WD32M**	–	–	27,00	1.063	28,00	116,0	81,0	0,8	SPPX09T3..	DFT05T3..
–	**DFSP280R3WD32M**	–	–	28,00	1.102	29,00	119,0	84,0	0,8	SPPX09T3..	DFT05T3..
–	**DFSP290R3WD32M**	–	–	29,00	1.142	30,00	123,0	87,0	0,9	SPPX09T3..	DFT05T3..
–	**DFSP300R3WD32M**	–	–	30,00	1.181	31,00	127,0	90,0	0,9	SPPX09T3..	DFT05T3..
–	**DFSP310R3WD32M**	–	–	31,00	1.221	32,00	131,0	93,0	0,9	SPPX09T3..	DFT05T3..
–	**DFSP320R3WD32M**	–	–	32,00	1.260	33,00	135,0	96,0	1,0	SPPX09T3..	DFT05T3..
–	**DFSP330R3WD32M**	–	–	33,00	1.299	34,00	138,0	99,0	0,9	SPPX1204..	DFT06T3..
–	**DFSP340R3WD32M**	–	–	34,00	1.339	35,00	142,0	102,0	0,9	SPPX1204..	DFT06T3..
–	**DFSP350R3WD32M**	–	–	35,00	1.378	36,00	146,0	105,0	1,0	SPPX1204..	DFT06T3..
–	**DFSP360R3WD32M**	–	–	36,00	1.417	37,00	150,0	108,0	1,0	SPPX1204..	DFT06T3..
–	**DFSP370R3WD32M**	–	–	37,00	1.457	38,00	154,0	111,0	1,1	SPPX1204..	DFT06T3..
–	**DFSP375R3WD32M**	–	–	37,50	1.476	38,50	155,5	112,5	1,1	SPPX1204..	DFT06T3..
–	**DFSP380R3WD32M**	–	–	38,00	1.496	39,00	157,0	114,0	1,1	SPPX1204..	DFT06T3..
–	**DFSP390R3WD32M**	–	–	39,00	1.535	40,00	161,0	117,0	1,2	SPPX1204..	DFT06T3..
–	**DFSP400R3WD32M**	–	–	40,00	1.575	41,00	165,0	120,0	1,2	SPPX1204..	DFT06T3..
–	**DFSP410R3WD32M**	–	–	41,00	1.614	42,00	169,0	123,0	1,2	SPPX1204..	DFT0704..

(continued)

(WD Shank • 3 x D • Metric — continued)

D				D1 diameter							
20	32	40	50	mm	in	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
—	**DFSP420R3WD32M**	—	—	42,00	1.654	43,00	173,0	126,0	1,3	SPPX1204..	DFT0704..
—	**DFSP430R3WD32M**	—	—	43,00	1.693	44,00	176,0	129,0	1,3	SPPX1204..	DFT0704..
—	**DFSP440R3WD32M**	—	—	44,00	1.732	45,00	179,0	132,0	1,4	SPPX15T5..	DFT0704..
—	—	**DFSP450R3WD40M**	—	45,00	1.772	46,00	182,0	135,0	1,4	SPPX15T5..	DFT0704..
—	—	**DFSP460R3WD40M**	—	46,00	1.811	47,00	186,0	138,0	1,5	SPPX15T5..	DFT0704..
—	—	**DFSP470R3WD40M**	—	47,00	1.850	48,00	189,0	141,0	1,5	SPPX15T5..	DFT0704..
—	—	**DFSP480R3WD40M**	—	48,00	1.890	49,00	192,0	144,0	1,5	SPPX15T5..	DFT0704..
—	—	**DFSP490R3WD40M**	—	49,00	1.929	50,00	195,0	147,0	1,4	SPPX15T5..	DFT0905..
—	—	**DFSP500R3WD40M**	—	50,00	1.969	51,00	198,0	150,0	1,5	SPPX15T5..	DFT0905..
—	—	**DFSP505R3WD40M**	—	50,50	1.988	51,50	199,5	151,5	1,5	SPPX15T5..	DFT0905..
—	—	**DFSP510R3WD40M**	—	51,00	2.008	52,00	201,0	153,0	1,6	SPPX15T5..	DFT0905..
—	—	**DFSP520R3WD40M**	—	52,00	2.047	53,00	204,0	156,0	1,6	SPPX15T5..	DFT0905..
—	—	**DFSP530R3WD40M**	—	53,00	2.087	54,00	207,0	159,0	1,7	SPPX15T5..	DFT0905..
—	—	**DFSP540R3WD40M**	—	54,00	2.126	55,00	210,0	162,0	1,7	SPPX15T5..	DFT0905..
—	—	—	**DFSP550R3WD50M**	55,00	2.165	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 +.039" (+1mm).

Spare Parts



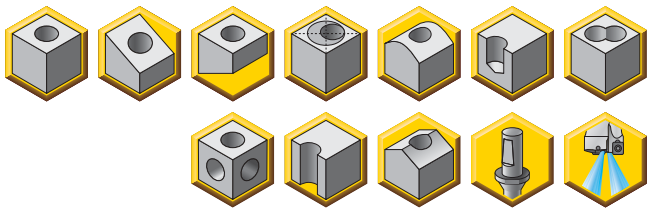
diameter range	gage insert inside	inboard insert screw	tightening torque Nm	tightening torque ft. lbs	gage insert outside	outboard insert screw	tightening torque Nm	tightening torque ft. lbs	Torx driver	Torx size
14.00–17.00	DFTX202..	**193.281**	0,6	.44	SPGX0502..	**193.281**	0,6	.44	**170.370**	T6
17.50–21.00	DFT0303..	**MS1152**	0,9	.66	SPGX0603..	**MS1152**	0,9	.66	**170.023**	T7
22.00–25.00	DFT05T3..	**193.491**	2,1	1.55	SPGX0703..	**192.432**	1,3	.96	**170.028**	T8
26.00–32.00	DFT05T3..	**191.924**	2,1	1.55	SPPX09T3..	**191.924**	2,1	1.55	**170.024**	T9
33.00–40.00	DFT06T3..	**191.916**	4	2.95	SPPX1204..	**191.916**	4	2.95	**170.025**	T15
41.00–43.00	DFT0704..	**191.916**	6	4.43	SPPX1204..	**191.916**	3	2.21	**170.025**	T15
44.00–48.00	DFT0704..	**191.698**	6	4.43	SPPX15T5..	**192.433**	3	2.21	**170.025**	T15
49.00–55.00	DFT0905..	**192.433**	6	4.43	SPPX15T5..	**192.433**	6	4.43	**170.025**	T15

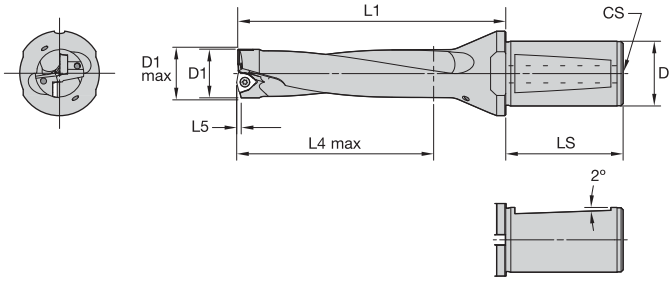
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges .875–1.000" (22–25,5mm) and 1.750–1.875" (41–48mm) are necessary. Both screws have the same Torx size.

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 centering capabilities of the trigon inboard insert.
- Drill shipped with insert screws and Torx wrench.
- Order inserts for DFSP separately.
  See pages J103–J104 for inserts.







WD Shank • 4 x D • Metric

D				D1 diameter							
20	32	40	50	mm	in	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
DFSP140R4WD20M	–	–	–	14,00	.551	15,00	78,0	56,0	0,3	SPGX0502..	DFTX202..
DFSP145R4WD20M	–	–	–	14,50	.571	15,50	82,0	58,0	0,4	SPGX0502..	DFTX202..
DFSP150R4WD20M	–	–	–	15,00	.591	16,00	84,0	60,0	0,4	SPGX0502..	DFTX202..
DFSP155R4WD20M *	–	–	–	15,50	.610	16,50	86,0	62,0	0,4	SPGX0502..	DFTX202..
DFSP160R4WD20M	–	–	–	16,00	.630	17,00	88,0	64,0	0,4	SPGX0502..	DFTX202..
DFSP165R4WD20M *	–	–	–	16,50	.650	17,50	95,0	66,0	0,5	SPGX0502..	DFTX202..
DFSP170R4WD20M	–	–	–	17,00	.669	18,00	97,0	68,0	0,5	SPGX0502..	DFTX202..
–	DFSP175R4WD32M	–	–	17,50	.690	18,50	99,0	70,0	0,5	SPGX0603..	DFT0303..
–	DFSP180R4WD32M	–	–	18,00	.710	19,00	101,0	72,0	0,5	SPGX0603..	DFT0303..
–	DFSP185R4WD32M	–	–	18,50	.730	19,50	103,0	74,0	0,6	SPGX0603..	DFT0303..
–	DFSP190R4WD32M	–	–	19,00	.750	20,00	105,0	76,0	0,6	SPGX0603..	DFT0303..
–	DFSP195R4WD32M	–	–	19,50	.770	20,50	107,0	78,0	0,6	SPGX0603..	DFT0303..
–	DFSP200R4WD32M	–	–	20,00	.790	21,00	112,0	80,0	0,6	SPGX0603..	DFT0303..
–	DFSP210R4WD32M	–	–	21,00	.830	22,00	96,0	64,0	0,7	SPGX0603..	DFT0303..
–	DFSP220R4WD32M	–	–	22,00	.870	23,00	120,0	88,0	0,5	SPGX0703..	DFT05T3..
–	DFSP230R4WD32M	–	–	23,00	.910	24,00	124,0	92,0	0,6	SPGX0703..	DFT05T3..
–	DFSP240R4WD32M	–	–	24,00	.945	25,00	128,0	96,0	0,6	SPGX0703..	DFT05T3..
–	DFSP250R4WD32M	–	–	25,00	.984	26,00	133,0	100,0	0,7	SPGX0703..	DFT05T3..
–	DFSP260R4WD32M	–	–	26,00	1.024	27,00	138,0	104,0	0,7	SPPX09T3..	DFT05T3..
–	DFSP265R4WD32M	–	–	26,50	1.043	27,50	140,0	106,0	0,7	SPPX09T3..	DFT05T3..
–	DFSP270R4WD32M	–	–	27,00	1.063	28,00	143,0	108,0	0,8	SPPX09T3..	DFT05T3..
–	DFSP280R4WD32M	–	–	28,00	1.102	29,00	147,0	112,0	0,8	SPPX09T3..	DFT05T3..
–	DFSP290R4WD32M	–	–	29,00	1.142	30,00	152,0	116,0	0,9	SPPX09T3..	DFT05T3..
–	DFSP300R4WD32M	–	–	30,00	1.181	31,00	157,0	120,0	0,9	SPPX09T3..	DFT05T3..
–	DFSP310R4WD32M	–	–	31,00	1.221	32,00	162,0	124,0	0,9	SPPX09T3..	DFT05T3..
–	DFSP320R4WD32M	–	–	32,00	1.260	33,00	167,0	128,0	1,0	SPPX09T3..	DFT05T3..
–	DFSP330R4WD32M	–	–	33,00	1.299	34,00	171,0	132,0	0,9	SPPX1204..	DFT06T3..
–	DFSP340R4WD32M	–	–	34,00	1.339	35,00	176,0	136,0	0,9	SPPX1204..	DFT06T3..
–	DFSP350R4WD32M	–	–	35,00	1.378	36,00	181,0	140,0	1,0	SPPX1204..	DFT06T3..
–	DFSP360R4WD32M	–	–	36,00	1.417	37,00	186,0	144,0	1,0	SPPX1204..	DFT06T3..
–	DFSP370R4WD32M	–	–	37,00	1.457	38,00	191,0	148,0	1,1	SPPX1204..	DFT06T3..
–	DFSP375R4WD32M	–	–	37,50	1.476	38,50	193,0	150,0	1,1	SPPX1204..	DFT06T3..
–	DFSP380R4WD32M	–	–	38,00	1.496	39,00	195,0	152,0	1,1	SPPX1204..	DFT06T3..
–	DFSP390R4WD32M	–	–	39,00	1.535	40,00	200,0	156,0	1,2	SPPX1204..	DFT06T3..
–	DFSP400R4WD32M	–	–	40,00	1.575	41,00	205,0	160,0	1,2	SPPX1204..	DFT06T3..
–	DFSP410R4WD32M	–	–	41,00	1.614	42,00	210,0	164,0	1,2	SPPX1204..	DFT0704..

(continued)

(WD Shank • 4 x D • Metric — continued)

D				D1 diameter							
20	32	40	50	mm	in	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
–	**DFSP420R4WD32M**	–	–	42,00	1.654	43,00	215,0	168,0	1,3	SPPX1204..	DFT0704..
–	**DFSP430R4WD32M**	–	–	43,00	1.693	44,00	219,0	172,0	1,3	SPPX1204..	DFT0704..
–	**DFSP440R4WD32M**	–	–	44,00	1.732	45,00	223,0	176,0	1,4	SPPX15T5..	DFT0704..
–	–	**DFSP450R4WD40M**	–	45,00	1.772	46,00	227,0	180,0	1,4	SPPX15T5..	DFT0704..
–	–	**DFSP460R4WD40M**	–	46,00	1.811	47,00	232,0	184,0	1,5	SPPX15T5..	DFT0704..
–	–	**DFSP470R4WD40M**	–	47,00	1.850	48,00	236,0	188,0	1,5	SPPX15T5..	DFT0704..
–	–	**DFSP480R4WD40M**	–	48,00	1.890	49,00	240,0	192,0	1,5	SPPX15T5..	DFT0704..
–	–	**DFSP490R4WD40M**	–	49,00	1.929	50,00	244,0	196,0	1,4	SPPX15T5..	DFT0905..
–	–	**DFSP500R4WD40M**	–	50,00	1.969	51,00	248,0	200,0	1,5	SPPX15T5..	DFT0905..
–	–	**DFSP510R4WD40M**	–	51,00	2.008	52,00	252,0	204,0	1,6	SPPX15T5..	DFT0905..
–	–	**DFSP520R4WD40M**	–	52,00	2.047	53,00	256,0	208,0	1,6	SPPX15T5..	DFT0905..
–	–	**DFSP530R4WD40M**	–	53,00	2.087	54,00	260,0	212,0	1,7	SPPX15T5..	DFT0905..
–	–	**DFSP540R4WD40M**	–	54,00	2.126	55,00	264,0	216,0	1,7	SPPX15T5..	DFT0905..
–	–	–	**DFSP550R4WD50M**	55,00	2.165	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 +.039" (+1mm).
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts



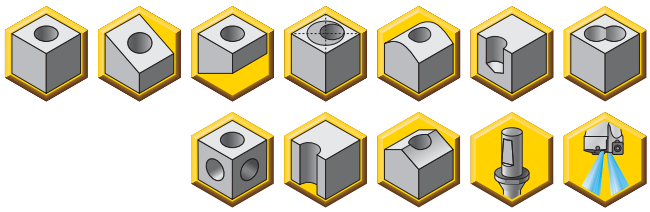
diameter range	gage insert inside	inboard insert screw	tightening torque Nm	tightening torque ft. lbs	gage insert outside	outboard insert screw	tightening torque Nm	tightening torque ft. lbs	Torx driver	Torx size
–	DFTX202..	–	–	–	SPGX0502..	–	–	–	–	T6
17.50–21.00	DFT0303..	**MS1152**	0,9	.66	SPGX0603..	**MS1152**	0,9	.66	**170.023**	T7
22.00–25.00	DFT05T3..	**193.491**	2,1	1.55	SPGX0703..	**192.432**	1,3	.96	**170.028**	T8
26.00–32.00	DFT05T3..	**191.924**	2,1	1.55	SPPX09T3..	**191.924**	2,1	1.55	**170.024**	T9
33.00–40.00	DFT06T3..	**191.916**	4	2.95	SPPX1204..	**191.916**	4	2.95	**170.025**	T15
41.00–43.00	DFT0704..	**192.433**	6	4.43	SPPX1204..	**191.698**	3	2.21	**170.025**	T15
44.00–48.00	DFT0704..	**191.698**	6	4.43	SPPX15T5..	**191.698**	3	2.21	**170.025**	T15
49.00–55.00	DFT0905..	**192.433**	6	4.43	SPPX15T5..	**192.433**	6	4.43	**170.025**	T15

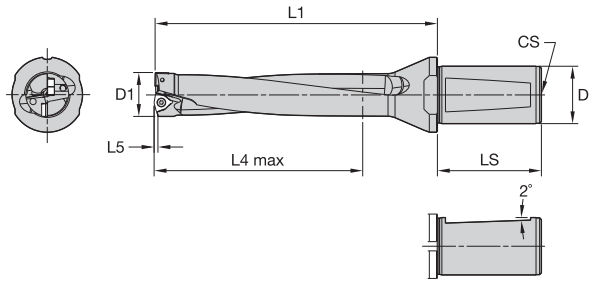
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges .875–1.000" (22–25,5mm) and 1.750–1.875" (41–48mm) are necessary. Both screws have the same Torx size.

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 centering capabilities of the trigon inboard insert.
- Drill shipped with insert screws and Torx wrench.
- Order inserts for DFSP separately.
  See pages J103–J104 for inserts.







WD Shank • 5 x D • Metric

D			D1							
			D1 diameter							
32	40	50	mm	in	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
DFSP200R5WD32M	–	–	20,00	.787	–	132,0	100,0	0,6	SPGX0603..	DFT0303..
DFSP210R5WD32M	–	–	21,00	.827	–	137,0	105,0	0,7	SPGX0603..	DFT0303..
DFSP220R5WD32M	–	–	22,00	.866	–	142,0	110,0	0,5	SPGX0703..	DFT05T3..
DFSP230R5WD32M	–	–	23,00	.906	–	147,0	115,0	0,6	SPGX0703..	DFT05T3..
DFSP240R5WD32M	–	–	24,00	.945	–	152,0	120,0	0,6	SPGX0703..	DFT05T3..
DFSP250R5WD32M	–	–	25,00	.984	–	158,0	125,0	0,7	SPGX0703..	DFT05T3..
DFSP260R5WD32M	–	–	26,00	1.024	–	164,0	130,0	0,7	SPPX09T3..	DFT05T3..
DFSP265R5WD32M	–	–	26,50	1.043	–	166,5	132,5	0,7	SPPX09T3..	DFT05T3..
DFSP270R5WD32M	–	–	27,00	1.063	–	170,0	135,0	0,8	SPPX09T3..	DFT05T3..
DFSP280R5WD32M	–	–	28,00	1.102	–	175,0	140,0	0,8	SPPX09T3..	DFT05T3..
DFSP290R5WD32M	–	–	29,00	1.142	–	181,0	145,0	0,9	SPPX09T3..	DFT05T3..
DFSP300R5WD32M	–	–	30,00	1.181	–	187,0	150,0	0,9	SPPX09T3..	DFT05T3..
DFSP310R5WD32M	–	–	31,00	1.221	–	193,0	155,0	0,9	SPPX09T3..	DFT05T3..
DFSP320R5WD32M	–	–	32,00	1.260	–	199,0	160,0	1,0	SPPX09T3..	DFT05T3..
DFSP330R5WD32M	–	–	33,00	1.299	–	204,0	165,0	0,9	SPPX1204..	DFT06T3..
DFSP340R5WD32M	–	–	34,00	1.339	–	210,0	170,0	0,9	SPPX1204..	DFT06T3..
DFSP350R5WD32M	–	–	35,00	1.378	–	216,0	175,0	1,0	SPPX1204..	DFT06T3..
DFSP360R5WD32M	–	–	36,00	1.417	–	222,0	180,0	1,0	SPPX1204..	DFT06T3..
DFSP370R5WD32M	–	–	37,00	1.457	–	228,0	185,0	1,1	SPPX1204..	DFT06T3..
DFSP375R5WD32M	–	–	37,50	1.476	–	230,5	187,5	1,1	SPPX1204..	DFT06T3..
DFSP380R5WD32M	–	–	38,00	1.496	–	233,0	190,0	1,1	SPPX1204..	DFT06T3..
DFSP390R5WD32M	–	–	39,00	1.535	–	239,0	195,0	1,2	SPPX1204..	DFT06T3..
DFSP400R5WD32M	–	–	40,00	1.575	–	245,0	200,0	1,2	SPPX1204..	DFT06T3..
DFSP410R5WD32M	–	–	41,00	1.614	–	251,0	205,0	1,2	SPPX1204..	DFT0704..
DFSP420R5WD32M	–	–	42,00	1.654	–	257,0	210,0	1,3	SPPX1204..	DFT0704..
DFSP430R5WD32M	–	–	43,00	1.693	–	262,0	215,0	1,3	SPPX1204..	DFT0704..
DFSP440R5WD32M	–	–	44,00	1.732	–	267,0	220,0	1,4	SPPX15T5..	DFT0704..
–	DFSP450R5WD40M	–	45,00	1.772	–	272,0	225,0	1,4	SPPX15T5..	DFT0704..
–	DFSP460R5WD40M	–	46,00	1.811	–	278,0	230,0	1,5	SPPX15T5..	DFT0704..
–	DFSP470R5WD40M	–	47,00	1.850	–	283,0	235,0	1,5	SPPX15T5..	DFT0704..
–	DFSP480R5WD40M	–	48,00	1.890	–	288,0	240,0	1,5	SPPX15T5..	DFT0704..
–	DFSP490R5WD40M	–	49,00	1.929	–	293,0	245,0	1,4	SPPX15T5..	DFT0905..
–	DFSP500R5WD40M	–	50,00	1.969	–	298,0	250,0	1,5	SPPX15T5..	DFT0905..
–	DFSP510R5WD40M *	–	51,00	2.008	–	303,0	255,0	1,6	SPPX15T5..	DFT0905..
–	DFSP520R5WD40M	–	52,00	2.047	–	308,0	260,0	1,6	SPPX15T5..	DFT0905..
–	DFSP530R5WD40M	–	53,00	2.087	–	313,0	265,0	1,7	SPPX15T5..	DFT0905..
–	DFSP540R5WD40M	–	54,00	2.126	–	318,0	270,0	1,7	SPPX15T5..	DFT0905..
–	–	DFSP550R5WD50M	55,00	2.165	–	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



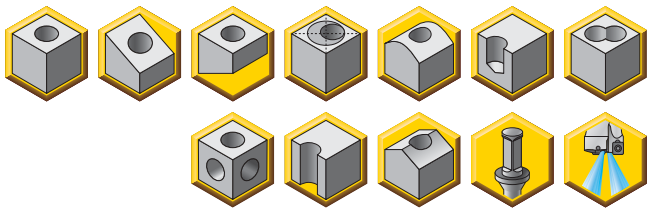
diameter range	gage insert inside	inboard insert screw	tightening torque Nm	tightening torque ft. lbs	gage insert outside	outboard insert screw	tightening torque Nm	tightening torque ft. lbs	Torx driver	Torx size
17.50–21.00	DFT0303..	**MS1152**	0,9	.66	SPGX0603..	**MS1152**	0,9	.66	**170.023**	T7
22.00–25.00	DFT05T3..	**193.491**	2,1	1.55	SPGX0703..	**192.432**	1,3	.96	**170.028**	T8
26.00–32.00	DFT05T3..	**191.924**	2,1	1.55	SPPX09T3..	**191.924**	2,1	1.55	**170.024**	T9
33.00–40.00	DFT06T3..	**191.916**	4	2.95	SPPX1204..	**191.916**	4	2.95	**170.025**	T15
41.00–43.00	DFT0704..	**192.433**	6	4.43	SPPX1204..	**191.698**	3	2.21	**170.025**	T15
44.00–48.00	DFT0704..	**191.698**	6	4.43	SPPX15T5..	**192.433**	3	2.21	**170.025**	T15
49.00–55.00	DFT0905..	**192.433**	6	4.43	SPPX15T5..	**192.433**	6	4.43	**170.025**	T15

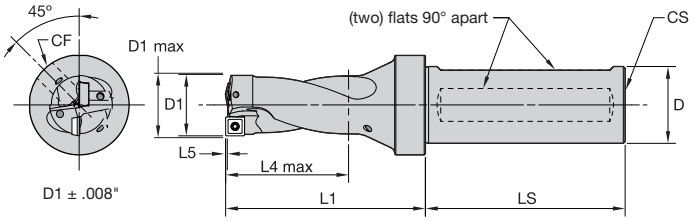
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges .875–1.000" (22–25,5mm) and 1.750–1.875" (41–48mm) are necessary. Both screws have the same Torx size.

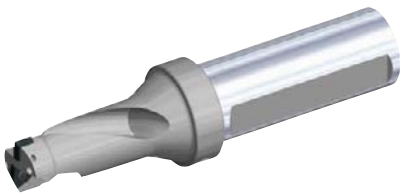
WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

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 centering capabilities of the trigon inboard insert.
- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- Order inserts for DFSP separately.
See pages J103–J104 for inserts.







Flange Shank • 2 x D • Inch

D					D1 diameter							
0.750	1.000	1.250	1.500	2.000	mm	in	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
DFSP0563R2SSF075	–	–	–	–	14,30	.563	.602	2.06	1.13	.01	SPGX0502..	DFTX202..
DFSP0594R2SSF075	–	–	–	–	15,09	.594	.633	2.13	1.19	.02	SPGX0502..	DFTX202..
DFSP0625R2SSF075	–	–	–	–	15,88	.625	.664	2.19	1.25	.02	SPGX0502..	DFTX202..
DFSP0656R2SSF075 *	–	–	–	–	16,66	.656	.695	2.25	1.31	.02	SPGX0502..	DFTX202..
DFSP0688R2SSF075	–	–	–	–	17,48	.688	.727	2.31	1.38	.02	SPGX0502..	DFTX202..
DFSP0703R2SSF075	–	–	–	–	17,86	.703	.742	2.34	1.41	.02	SPGX0603..	DFT0303..
DFSP0734R2SSF075	–	–	–	–	18,64	.734	.773	2.42	1.47	.02	SPGX0603..	DFT0303..
–	DFSP0750R2SSF100	–	–	–	19,05	.750	.789	2.46	1.50	.02	SPGX0603..	DFT0303..
–	DFSP0781R2SSF100	–	–	–	19,84	.781	.820	2.54	1.56	.02	SPGX0603..	DFT0303..
–	DFSP0813R2SSF100	–	–	–	20,65	.813	.852	2.62	1.63	.03	SPGX0603..	DFT0303..
–	DFSP0844R2SSF100 *	–	–	–	21,44	.844	.883	2.70	1.69	.03	SPGX0603..	DFT0303..
–	DFSP0875R2SSF100	–	–	–	22,23	.875	.914	2.77	1.75	.02	SPGX0703..	DFT05T3..
–	DFSP0906R2SSF100	–	–	–	23,01	.906	.945	2.84	1.81	.02	SPGX0703..	DFT05T3..
–	DFSP0938R2SSF100	–	–	–	23,83	.938	.977	2.93	1.88	.02	SPGX0703..	DFT05T3..
–	DFSP0969R2SSF100	–	–	–	24,61	.969	1.008	3.01	1.94	.03	SPGX0703..	DFT05T3..
–	DFSP0984R2SSF100	–	–	–	24,99	.984	1.023	3.04	1.97	.03	SPGX0703..	DFT05T3..
–	DFSP1000R2SSF100	DFSP1000R2SSF125	–	–	25,40	1.000	1.040	3.25	2.00	.03	SPGX0703..	DFT05T3..
–	–	–	DFSP1000R2SSF150 *	–	25,40	1.000	1.039	3.25	2.00	.03	SPGX0703..	DFT05T3..
–	–	DFSP1031R2SSF125	–	–	26,19	1.031	1.071	3.44	2.06	.03	SPPX09T3..	DFT05T3..
–	–	DFSP1063R2SSF125	–	–	27,00	1.063	1.103	3.50	2.13	.03	SPPX09T3..	DFT05T3..
–	–	DFSP1094R2SSF125	–	–	27,79	1.094	1.134	3.56	2.19	.03	SPPX09T3..	DFT05T3..
–	–	DFSP1125R2SSF125	–	–	28,58	1.125	1.165	3.75	2.25	.03	SPPX09T3..	DFT05T3..
–	–	DFSP1156R2SSF125	–	–	29,36	1.156	1.196	3.81	2.31	.03	SPPX09T3..	DFT05T3..
–	–	DFSP1188R2SSF125	–	–	30,18	1.188	1.228	3.88	2.38	.04	SPPX09T3..	DFT05T3..
–	–	DFSP1219R2SSF125	–	–	30,96	1.219	1.259	4.06	2.44	.04	SPPX09T3..	DFT05T3..
–	–	DFSP1250R2SSF125	–	–	31,75	1.250	1.290	4.12	2.50	.04	SPPX09T3..	DFT05T3..
–	–	DFSP1313R2SSF125	DFSP1313R2SSF150	–	33,35	1.313	1.353	4.25	2.63	.04	SPPX1204..	DFT06T3..
–	–	DFSP1375R2SSF125	DFSP1375R2SSF150	–	34,93	1.375	1.415	4.37	2.75	.04	SPPX1204..	DFT06T3..
–	–	DFSP1438R2SSF125	–	–	36,53	1.438	1.478	4.63	2.88	.04	SPPX1204..	DFT06T3..
–	–	DFSP1469R2SSF125	–	–	37,31	1.469	1.509	4.69	2.94	.04	SPPX1204..	DFT06T3..
–	–	DFSP1500R2SSF125	DFSP1500R2SSF150	–	38,10	1.500	1.540	4.75	3.00	.04	SPPX1204..	DFT06T3..
–	–	DFSP1563R2SSF125	DFSP1563R2SSF150	–	39,70	1.563	1.603	4.88	3.13	.05	SPPX1204..	DFT06T3..
–	–	DFSP1625R2SSF125	DFSP1625R2SSF150	–	41,28	1.625	1.665	5.00	3.25	.05	SPPX1204..	DFT0704..
–	–	–	DFSP1656R2SSF150	–	42,06	1.656	1.696	5.06	3.31	.05	SPPX1204..	DFT0704..
–	–	–	DFSP1688R2SSF150	–	42,88	1.688	1.728	5.13	3.38	.05	SPPX1204..	DFT0704..
–	–	–	DFSP1750R2SSF150	–	44,45	1.750	1.790	5.25	3.50	.05	SPPX15T5..	DFT0704..
–	–	–	DFSP1813R2SSF150	–	46,05	1.813	1.853	5.50	3.63	.06	SPPX15T5..	DFT0704..
–	–	–	DFSP1875R2SSF150	–	47,63	1.875	1.915	5.63	3.75	.06	SPPX15T5..	DFT0704..
–	–	–	DFSP1938R2SSF150	–	49,23	1.938	1.978	5.88	3.88	.06	SPPX15T5..	DFT0905..
–	–	–	DFSP2000R2SSF150	DFSP2000R2SSF200	50,80	2.000	2.040	6.00	4.00	.06	SPPX15T5..	DFT0905..
–	–	–	DFSP2125R2SSF150	DFSP2125R2SSF200	53,98	2.125	2.165	6.37	4.25	.07	SPPX15T5..	DFT0905..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +.039" (+1mm).
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

(continued)

(Flange Shank • 2 x D • Inch — continued)

Spare Parts









diameter range	gage insert inside	inboard insert screw	tightening torque Nm	tightening torque ft. lbs	gage insert outside	outboard insert screw	tightening torque Nm	tightening torque ft. lbs	Torx driver	Torx size
.563–.688	DFTX202..	**193.281**	0,6	.44	SPGX0502..	**193.281**	0,6	.44	**170.370**	T6
.703–.844	DFT0303..	**MS1152**	0,9	.66	SPGX0603..	**MS1152**	0,9	.66	**170.023**	T7
.875–1.000	DFT05T3..	**193.491**	2,1	1.55	SPGX0703..	**192.432**	1,3	.96	**170.028**	T8
1.031–1.281	DFT05T3..	**191.924**	2,1	1.55	SPPX09T3..	**191.924**	2,1	1.55	**170.024**	T9
1.313–1.563	DFT06T3..	**191.916**	4	2.95	SPPX1204..	**191.916**	4	2.95	**170.025**	T15
1.625–1.688	DFT0704..	**191.916**	4	2.95	SPPX1204..	**191.916**	4	2.95	**170.025**	T15
1.750–1.875	DFT0704..	**191.698**	6	4.43	SPPX15T5..	**191.698**	3	2.21	**170.025**	T15
1.938–2.125	DFT0905..	**192.433**	6	4.43	SPPX15T5..	**192.433**	6	4.43	**170.025**	T15

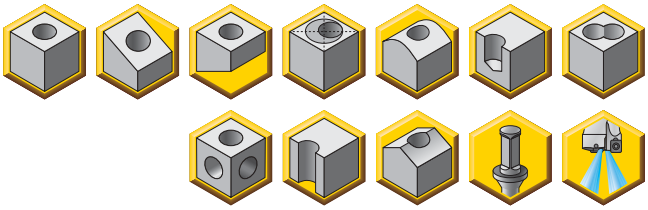
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges .875–1.000" (22–25,5mm) and 1.750–1.875" (41–48mm) are necessary. Both screws have the same Torx size.

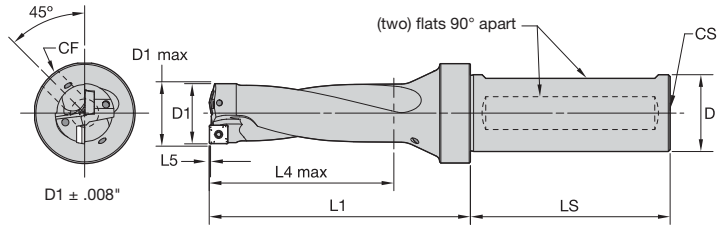
WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

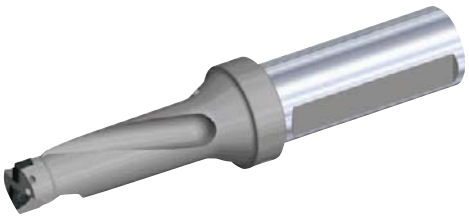


D	LS	CF	CS	pipe plug
0.750	2.00	1/8-27 NPT	R 1/8-27 NPT	**1025612**
1.000	3.00	1/8-27 NPT	R 1/4-18 NPT	**1025612**
1.250	3.25	1/8-27 NPT	R 1/4-18 NPT	**1025612**
1.500	3.75	1/8-27 NPT	R 1/4-18 NPT	**1025612**
2.000	4.00	1/8-27 NPT	R 1/4-18 NPT	**1025612**

- DFSP combines the economical squared outboard insert with the superior centering capabilities of the trigon inboard insert.
- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- Order inserts for DFSP separately.
See pages J103–J104 for inserts.







Flange Shank • 3 x D • Inch

D					D1 diameter						gage insert	gage insert
0.750	1.000	1.250	1.500	2.000	mm	in	D1 max	L1	L4 max	L5	outside	inside
DFSP0563R3SSF075	–	–	–	–	14,30	.563	.602	2.62	1.69	.01	SPGX0502..	DFTX202..
DFSP0594R3SSF075	–	–	–	–	15,09	.594	.633	2.72	1.78	.02	SPGX0502..	DFTX202..
DFSP0625R3SSF075	–	–	–	–	15,88	.625	.664	2.81	1.88	.02	SPGX0502..	DFTX202..
DFSP0656R3SSF075	–	–	–	–	16,66	.656	.695	2.91	1.97	.02	SPGX0502..	DFTX202..
DFSP0688R3SSF075	–	–	–	–	17,48	.688	.727	3.00	2.06	.02	SPGX0502..	DFTX202..
DFSP0703R3SSF075	–	–	–	–	17,86	.703	.742	3.05	2.11	.02	SPGX0603..	DFT0303..
DFSP0734R3SSF075	–	–	–	–	18,64	.734	.773	3.18	2.20	.02	SPGX0603..	DFT0303..
–	DFSP0750R3SSF100	–	–	–	19,05	.750	.789	3.21	2.25	.02	SPGX0603..	DFT0303..
–	DFSP0781R3SSF100	–	–	–	19,84	.781	.820	3.32	2.34	.02	SPGX0603..	DFT0303..
–	DFSP0813R3SSF100	–	–	–	20,65	.813	.852	3.43	2.44	.03	SPGX0603..	DFT0303..
–	DFSP0844R3SSF100	–	–	–	21,44	.844	.883	3.53	2.53	.03	SPGX0603..	DFT0303..
–	DFSP0875R3SSF100	–	–	–	22,23	.875	.914	3.65	2.63	.02	SPGX0703..	DFT05T3..
–	DFSP0906R3SSF100 *	–	–	–	23,01	.906	.945	3.75	2.72	.02	SPGX0703..	DFT05T3..
–	DFSP0938R3SSF100	–	–	–	23,83	.938	.977	3.86	2.81	.02	SPGX0703..	DFT05T3..
–	DFSP0969R3SSF100	–	–	–	24,61	.969	1.008	3.98	2.91	.03	SPGX0703..	DFT05T3..
–	DFSP0984R3SSF100	–	–	–	24,99	.984	1.023	4.03	2.95	.03	SPGX0703..	DFT05T3..
–	DFSP1000R3SSF100	DFSP1000R3SSF125	DFSP1000R3SSF150	–	25,40	1.000	1.040	4.25	3.00	.03	SPGX0703..	DFT05T3..
–	–	DFSP1031R3SSF125	–	–	26,19	1.031	1.071	4.47	3.09	.03	SPPX09T3..	DFT05T3..
–	–	DFSP1063R3SSF125	–	–	27,00	1.063	1.103	4.56	3.19	.03	SPPX09T3..	DFT05T3..
–	–	DFSP1094R3SSF125	–	–	27,79	1.094	1.134	4.66	3.28	.03	SPPX09T3..	DFT05T3..
–	–	DFSP1125R3SSF125	–	–	28,58	1.125	1.165	4.87	3.38	.03	SPPX09T3..	DFT05T3..
–	–	DFSP1156R3SSF125	–	–	29,36	1.156	1.196	4.97	3.47	.03	SPPX09T3..	DFT05T3..
–	–	DFSP1188R3SSF125	–	–	30,18	1.188	1.228	5.06	3.56	.04	SPPX09T3..	DFT05T3..
–	–	DFSP1219R3SSF125	–	–	30,96	1.219	1.259	5.28	3.66	.04	SPPX09T3..	DFT05T3..
–	–	DFSP1250R3SSF125	–	–	31,75	1.250	1.290	5.37	3.75	.04	SPPX09T3..	DFT05T3..
–	–	DFSP1281R3SSF125	–	–	32,54	1.281	1.321	5.47	3.84	.04	SPPX09T3..	DFT05T3..
–	–	DFSP1313R3SSF125	DFSP1313R3SSF150	–	33,35	1.313	1.353	5.56	3.94	.04	SPPX1204..	DFT06T3..
–	–	DFSP1375R3SSF125	DFSP1375R3SSF150	–	34,93	1.375	1.415	5.75	4.13	.04	SPPX1204..	DFT06T3..
–	–	DFSP1438R3SSF125	–	–	36,53	1.438	1.478	6.06	4.31	.04	SPPX1204..	DFT06T3..
–	–	DFSP1469R3SSF125	–	–	37,31	1.509	1.509	6.16	4.41	.04	SPPX1204..	DFT06T3..
–	–	DFSP1500R3SSF125	DFSP1500R3SSF150	–	38,10	1.500	1.540	6.25	4.50	.04	SPPX1204..	DFT06T3..
–	–	–	DFSP1563R3SSF150	–	39,70	1.563	1.603	6.44	4.69	.05	SPPX1204..	DFT06T3..
–	–	DFSP1625R3SSF125	DFSP1625R3SSF150	–	41,28	1.625	1.664	6.62	4.88	.05	SPPX1204..	DFT0704..
–	–	–	DFSP1656R3SSF150 *	–	42,06	1.656	1.695	6.70	4.97	.05	SPPX1204..	DFT0704..
–	–	–	DFSP1688R3SSF150	–	42,88	1.688	1.727	6.81	5.06	.05	SPPX1204..	DFT0704..
–	–	–	DFSP1750R3SSF150	–	44,45	1.750	1.789	7.00	5.25	.05	SPPX15T5..	DFT0704..
–	–	–	DFSP1813R3SSF150	–	46,05	1.813	1.852	7.31	5.44	.06	SPPX15T5..	DFT0704..
–	–	–	DFSP1875R3SSF150	–	47,63	1.875	1.914	7.50	5.63	.06	SPPX15T5..	DFT0704..
–	–	–	DFSP1938R3SSF150	–	49,23	1.938	1.977	7.81	5.81	.06	SPPX15T5..	DFT0905..
–	–	–	DFSP2000R3SSF150	DFSP2000R3SSF200	50,80	2.000	2.039	8.00	6.00	.06	SPPX15T5..	DFT0905..
–	–	–	DFSP2125R3SSF150	DFSP2125R3SSF200	53,98	2.125	2.164	8.50	6.38	.07	SPPX15T5..	DFT0905..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +.039" (+1mm).
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

(continued)

(Flange Shank • 3 x D • Inch — continued)

Spare Parts



diameter range	gage insert inside	inboard insert screw	tightening torque Nm	tightening torque ft. lbs	gage insert outside	outboard insert screw	tightening torque Nm	tightening torque ft. lbs	Torx driver	Torx size
.563–.688	DFTX202..	**193.281**	0,6	.44	SPGX0502..	**193.281**	0,6	.44	**170.370**	T6
.703–.844	DFT0303..	**MS1152**	0,9	.66	SPGX0603..	**MS1152**	0,9	.66	**170.023**	T7
.875–1.000	DFT05T3..	**193.491**	2,1	1.55	SPGX0703..	**192.432**	1,3	.96	**170.028**	T8
1.031–1.281	DFT05T3..	**191.924**	2,1	1.55	SPPX09T3..	**191.924**	2,1	1.55	**170.024**	T9
1.313–1.563	DFT06T3..	**191.916**	4	2.95	SPPX1204..	**191.916**	4	2.95	**170.025**	T15
1.625–1.688	DFT0704..	**191.916**	4	2.95	SPPX1204..	**191.916**	3	2.21	**170.025**	T15
1.750–1.875	DFT0704..	**191.698**	6	4.43	SPPX15T5..	**191.698**	3	2.21	**170.025**	T15
1.938–2.125	DFT0905..	**192.433**	6	4.43	SPPX15T5..	**192.433**	6	4.43	**170.025**	T15

NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges .875–1.000" (22–25,5mm) and 1.750–1.875" (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	CF	CS	pipe plug
0.750	2.00	1/8-27 NPT	R 1/8-27 NPT	**1025612**
1.000	3.00	1/8-27 NPT	R 1/4-18 NPT	**1025612**
1.250	3.25	1/8-27 NPT	R 1/4-18 NPT	**1025612**
1.500	3.75	1/8-27 NPT	R 1/4-18 NPT	**1025612**
2.000	4.00	1/8-27 NPT	R 1/4-18 NPT	**1025612**

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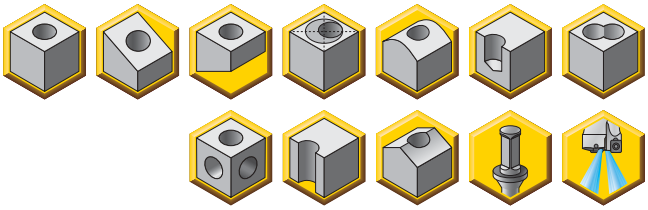
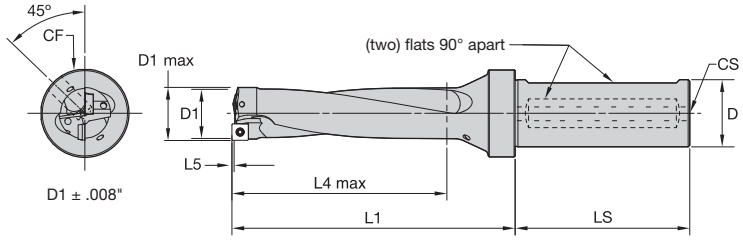
- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- Order inserts for DFSP separately.
  See pages J103–J104 for inserts.







Flange Shank • 4 x D • Inch

D				D1 diameter							
1.000	1.250	1.500	2.000	mm	in	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
DFSP0750R4SSF100	–	–	–	19,05	.750	.789	3.96	3.00	.02	SPGX0603..	DFT0303..
DFSP0781R4SSF100	–	–	–	19,84	.781	.820	4.10	3.12	.02	SPGX0603..	DFT0303..
DFSP0813R4SSF100	–	–	–	20,65	.813	.852	4.24	3.25	.03	SPGX0603..	DFT0303..
DFSP0844R4SSF100	–	–	–	21,44	.844	.883	4.38	3.38	.03	SPGX0603..	DFT0303..
DFSP0875R4SSF100	–	–	–	22,23	.875	.914	4.52	3.50	.02	SPGX0703..	DFT05T3..
DFSP0906R4SSF100	–	–	–	23,01	.805	.945	4.66	3.62	.02	SPGX0703..	DFT05T3..
DFSP0938R4SSF100	–	–	–	23,83	.938	.977	4.80	3.75	.02	SPGX0703..	DFT05T3..
DFSP0969R4SSF100	–	–	–	24,61	.969	1.008	4.94	3.88	.03	SPGX0703..	DFT05T3..
DFSP0984R4SSF100	–	–	–	24,99	.984	1.023	5.01	3.94	.03	SPGX0703..	DFT05T3..
DFSP1000R4SSF100	**DFSP1000R4SSF125**	**DFSP1000R4SSF150** *	–	25,40	1.000	1.040	5.25	4.00	.03	SPGX0703..	DFT05T3..
–	**DFSP1031R4SSF125**	–	–	26,19	1.031	1.071	5.50	4.12	.03	SPPX09T3..	DFT05T3..
–	**DFSP1063R4SSF125**	–	–	27,00	1.063	1.103	5.62	4.25	.03	SPPX09T3..	DFT05T3..
–	**DFSP1094R4SSF125** *	–	–	27,79	1.094	1.134	5.75	4.38	.03	SPPX09T3..	DFT05T3..
–	**DFSP1125R4SSF125**	–	–	28,58	1.125	1.165	6.00	4.50	.03	SPPX09T3..	DFT05T3..
–	**DFSP1156R4SSF125**	–	–	29,36	1.156	1.196	6.12	4.62	.03	SPPX09T3..	DFT05T3..
–	**DFSP1188R4SSF125**	–	–	30,18	1.188	1.228	6.25	4.75	.04	SPPX09T3..	DFT05T3..
–	**DFSP1219R4SSF125**	–	–	30,96	1.219	1.259	6.50	4.88	.04	SPPX09T3..	DFT05T3..
–	**DFSP1250R4SSF125**	**DFSP1250R4SSF150**	–	31,75	1.250	1.290	6.62	5.00	.04	SPPX09T3..	DFT05T3..
–	**DFSP1313R4SSF125**	–	–	33,35	1.313	1.353	6.88	5.25	.04	SPPX1204..	DFT06T3..
–	**DFSP1375R4SSF125**	**DFSP1375R4SSF150** *	–	34,93	1.375	1.415	7.12	5.50	.04	SPPX1204..	DFT06T3..
–	–	**DFSP1406R4SSF150**	–	35,71	1.406	1.446	7.25	5.62	.04	SPPX1204..	DFT06T3..
–	**DFSP1438R4SSF125**	–	–	36,53	1.438	1.478	7.50	5.75	.04	SPPX1204..	DFT06T3..
–	**DFSP1500R4SSF125**	**DFSP1500R4SSF150**	–	38,10	1.500	1.540	7.75	6.00	.04	SPPX1204..	DFT06T3..
–	–	**DFSP1563R4SSF150**	–	39,70	1.563	1.603	8.00	6.25	.05	SPPX1204..	DFT06T3..
–	–	**DFSP1625R4SSF150**	–	41,28	1.625	1.665	8.25	6.50	.05	SPPX1204..	DFT0704..
–	–	**DFSP1656R4SSF150**	–	42,06	1.656	1.696	8.36	6.62	.05	SPPX1204..	DFT0704..
–	–	**DFSP1750R4SSF150**	–	44,45	1.750	1.790	8.75	7.00	.05	SPPX15T5..	DFT0704..
–	–	**DFSP1813R4SSF150**	–	46,05	1.813	1.853	9.13	7.25	.04	SPPX15T5..	DFT0704..
–	–	**DFSP1875R4SSF150**	–	47,63	1.875	1.914	9.37	7.50	.06	SPPX15T5..	DFT0704..
–	–	**DFSP1938R4SSF150**	–	49,23	1.938	1.977	9.75	7.75	.06	SPPX15T5..	DFT0905..
–	–	**DFSP2000R4SSF150**	**DFSP2000R4SSF200**	50,80	2.000	2.039	10.00	8.00	.06	SPPX15T5..	DFT0905..
–	–	**DFSP2125R4SSF150**	**DFSP2125R4SSF200**	53,98	2.125	2.164	10.62	8.50	.07	SPPX15T5..	DFT0905..

NOTE for D1 max: Diameter can be adjusted. It is highly recommended to not adjust the diameter more than +.039" (+1mm).
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

(continued)

(Flange Shank • 4 x D • Inch — continued)

Spare Parts



diameter range	gage insert inside	inboard insert screw	tightening torque Nm	tightening torque ft. lbs	gage insert outside	outboard insert screw	tightening torque Nm	tightening torque ft. lbs	Torx driver	Torx size
.703–.844	DFT0303..	**MS1152**	0,9	.66	SPGX0603..	**MS1152**	0,9	.66	**170.023**	T7
.875–1.000	DFT05T3..	**193.491**	2,1	1.55	SPGX0703..	**192.432**	1,3	.96	**170.028**	T8
1.031–1.281	DFT05T3..	**191.924**	2,1	1.55	SPPX09T3..	**191.924**	2,1	1.55	**170.024**	T9
1.313–1.563	DFT06T3..	**191.916**	4	2.95	SPPX1204..	**191.916**	4	2.95	**170.025**	T15
1.625–1.688	DFT0704..	**191.916**	4	2.95	SPPX1204..	**191.916**	4	2.95	**170.025**	T15
1.750–1.875	DFT0704..	**191.698**	6	4.43	SPPX15T5..	**191.698**	3	2.21	**170.025**	T15
1.938–2.125	DFT0905..	**192.433**	6	4.43	SPPX15T5..	**192.433**	6	4.43	**170.025**	T15

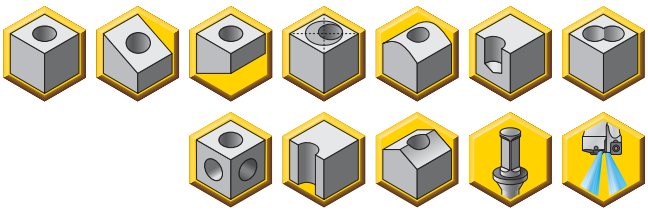
NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges .875–1.000" (22–25,5mm) and 1.750–1.875" (41–48mm) are necessary. Both screws have the same Torx size.

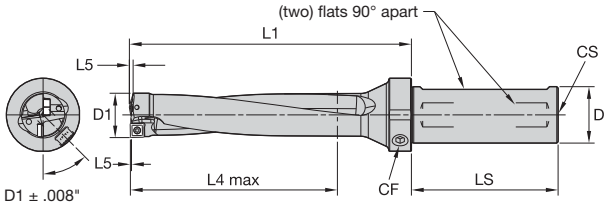
WARNING
During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.



D	LS	CF	CS	pipe plug
1.000	3.00	1/8-27 NPT	R 1/4-18 NPT	**1025612**
1.250	3.25	1/8-27 NPT	R 1/4-18 NPT	**1025612**
1.500	3.75	1/8-27 NPT	R 1/4-18 NPT	**1025612**
2.000	4.00	1/8-27 NPT	R 1/4-18 NPT	**1025612**

- DFSP combines the economical squared outboard insert with the superior centering capabilities of the trigon inboard insert.
- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- Order inserts for DFSP separately. See pages J103–J104 for inserts.







Flange Shank • 5 x D • Inch

D				D1 diameter							
1.000	1.250	1.500	2.000	mm	in	D1 max	L1	L4 max	L5	gage insert outside	gage insert inside
DFSP0813R5SSF100	–	–	–	20,65	.813	.852	5.06	4.07	.03	SPGX0603..	DFT0303..
DFSP0844R5SSF100	–	–	–	21,44	.844	.883	5.22	4.22	.03	SPGX0603..	DFT0303..
DFSP0875R5SSF100	–	–	–	22,23	.875	.914	5.39	4.38	.02	SPGX0703..	DFT05T3..
DFSP0906R5SSF100 *	–	–	–	23,01	.906	.945	5.57	4.53	.02	SPGX0703..	DFT05T3..
DFSP0938R5SSF100	–	–	–	23,83	.938	.977	5.74	4.69	.02	SPGX0703..	DFT05T3..
DFSP0969R5SSF100 *	–	–	–	24,61	.969	1.008	5.91	4.85	.03	SPGX0703..	DFT05T3..
DFSP0984R5SSF100 *	–	–	–	24,99	.984	1.023	5.99	4.92	.03	SPGX0703..	DFT05T3..
DFSP1000R5SSF100	–	–	–	25,40	1.000	–	6.25	5.00	.02	SPGX0703..	DFT05T3..
–	DFSP1000R5SSF125	DFSP1000R5SSF150	–	25,40	1.000	–	6.25	5.00	.03	SPGX0703..	DFT05T3..
–	DFSP1031R5SSF125	–	–	26,19	1.031	–	6.53	5.16	.03	SPPX09T3..	DFT05T3..
–	DFSP1063R5SSF125	–	–	27,00	1.063	–	6.69	5.32	.03	SPPX09T3..	DFT05T3..
–	DFSP1094R5SSF125	–	–	27,79	1.094	–	6.84	5.47	.03	SPPX09T3..	DFT05T3..
–	DFSP1125R5SSF125	–	–	28,58	1.125	–	7.12	5.63	.03	SPPX09T3..	DFT05T3..
–	DFSP1156R5SSF125 *	–	–	29,36	1.156	–	7.28	5.78	.03	SPPX09T3..	DFT05T3..
–	DFSP1188R5SSF125	–	–	30,18	1.188	–	7.44	5.94	.04	SPPX09T3..	DFT05T3..
–	DFSP1219R5SSF125 *	–	–	30,96	1.219	–	7.55	5.92	.04	SPPX09T3..	DFT05T3..
–	DFSP1250R5SSF125	DFSP1250R5SSF150	–	31,75	1.250	–	7.87	6.25	.04	SPPX09T3..	DFT05T3..
–	DFSP1313R5SSF125	–	–	33,35	1.313	–	8.19	6.57	.04	SPPX1204..	DFT06T3..
–	DFSP1375R5SSF125	DFSP1375R5SSF150	–	34,93	1.375	–	8.50	6.88	.04	SPPX1204..	DFT06T3..
–	DFSP1438R5SSF125	–	–	36,53	1.438	–	8.94	7.19	.04	SPPX1204..	DFT06T3..
–	DFSP1500R5SSF125	DFSP1500R5SSF150	–	38,10	1.500	–	9.25	7.50	.04	SPPX1204..	DFT06T3..
–	–	DFSP1563R5SSF150	–	39,70	1.563	–	9.57	7.82	.05	SPPX1204..	DFT06T3..
–	–	DFSP1625R5SSF150	–	41,28	1.625	–	9.87	8.13	.05	SPPX1204..	DFT0704..
–	–	DFSP1656R5SSF150	–	42,06	1.656	–	10.03	8.28	.05	SPPX1204..	DFT0704..
–	–	DFSP1750R5SSF150	–	44,45	1.750	–	10.50	8.75	.05	SPPX15T5..	DFT0704..
–	–	DFSP1813R5SSF150 *	–	46,05	1.813	–	10.94	9.07	.06	SPPX15T5..	DFT0704..
–	–	DFSP1875R5SSF150	–	47,63	1.875	–	11.25	9.38	.06	SPPX15T5..	DFT0704..
–	–	DFSP1938R5SSF150 *	–	49,23	1.938	–	11.69	9.69	.06	SPPX15T5..	DFT0905..
–	–	DFSP2000R5SSF150	DFSP2000R5SSF200	50,80	2.000	–	12.00	10.00	.06	SPPX15T5..	DFT0905..
–	–	DFSP2125R5SSF150	DFSP2125R5SSF200	53,98	2.125	–	12.75	10.63	.07	SPPX15T5..	DFT0905..

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

(continued)

(Flange Shank • 5 x D • Inch — continued)

Spare Parts



diameter range	gage insert inside	inboard insert screw	tightening torque Nm	tightening torque ft. lbs	gage insert outside	outboard insert screw	tightening torque Nm	tightening torque ft. lbs	Torx driver	Torx size
.703–.844	DFT0303..	**MS1152**	0,9	.66	SPGX0603..	**MS1152**	0,9	.66	**170.023**	T7
.875–1.000	DFT05T3..	**193.491**	2,1	1.55	SPGX0703..	**192.432**	1,3	.96	**170.028**	T8
1.031–1.281	DFT05T3..	**191.924**	2,1	1.55	SPPX09T3..	**191.924**	2,1	1.55	**170.024**	T9
1.313–1.563	DFT06T3..	**191.916**	4	2.95	SPPX1204..	**191.916**	4	2.95	**170.025**	T15
1.625–1.688	DFT0704..	**191.916**	4	2.95	SPPX1204..	**191.916**	4	2.95	**170.025**	T15
1.750–1.875	DFT0704..	**191.698**	6	4.43	SPPX15T5..	**191.698**	3	2.21	**170.025**	T15
1.938–2.125	DFT0905..	**192.433**	6	4.43	SPPX15T5..	**192.433**	6	4.43	**170.025**	T15

NOTE: To ensure proper clamping, two different screws for DFT™ inserts with different threads for diameter ranges .875–1.000" (22–25,5mm) and 1.750–1.875" (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	CF	CS	pipe plug
1.000	3.00	1/8-27 NPT	R 1/4-18 NPT	**1025612**
1.250	3.25	1/8-27 NPT	R 1/4-18 NPT	**1025612**
1.500	3.75	1/8-27 NPT	R 1/4-18 NPT	**1025612**
2.000	4.00	1/8-27 NPT	R 1/4-18 NPT	**1025612**

Drill Fix™ DFSP™ • Metric

Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min min	Starting Value	max	Recommended Feed Rate (fz) by Diameter 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
									Metric						
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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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
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										

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™ • Inch

Inch															
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM min	Starting Value	max	Recommended Feed Rate (fz) by Diameter Ø	SPGX05 DFTX2 .551–.708"	SPGX06 DFT03 .709–.865"	SPGX07 DFT05 .866–1.023"	SPGX09 DFT05 1.024–1.299"	SPGX12 DFT06/..07 1.300–1.732"	SPGX15 DFT07/..09 1.733–2.165"
P	0	S	O	LP	KCU40	1017	**1066**	1181	SFM	0.0024–0.0039	0.0024–0.0043	0.0031–0.0055	0.0047–0.0083	0.0055–0.0102	0.0063–0.0102
			I	DS	KCU40										
		U	O	LP	KCU40	656	**705**	754	SFM	0.0020–0.00284	0.0024–0.0031	0.0028–0.0039	0.0028–0.0047	0.0035–0.0059	0.0043–0.0081
			I	HP	KCU40										
		I	O	HP	KCU40	426	**443**	492	SFM	0.0020–0.00284	0.0024–0.0031	0.0028–0.0039	0.0028–0.0047	0.0035–0.0059	0.0043–0.0081
			I	HP	KCU40										
	1	S	O	FP	KCPK10	1017	**1066**	1181	SFM	0.0024–0.0043	0.0031–0.0055	0.0039–0.0071	0.0055–0.0098	0.0063–0.0118	0.0071–0.0118
			I	HP	KC7140										
		U	O	FP	KCU25	656	**705**	754	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
		I	O	HP	KCU40	426	**443**	492	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	2	S	O	FP	KCPK10	1017	**1066**	1181	SFM	0.0024–0.0043	0.0031–0.0055	0.0039–0.0071	0.0055–0.0098	0.0063–0.0118	0.0071–0.0118
			I	HP	KC7140										
		U	O	FP	KCU25	656	**705**	754	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
		I	O	HP	KCU40	426	**443**	492	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	3	S	O	FP	KCPK10	853	**935**	1050	SFM	0.0024–0.0043	0.0031–0.0055	0.0039–0.0071	0.0055–0.0098	0.0063–0.0118	0.0071–0.0118
			I	HP	KC7140										
		U	O	HP	KCU25	590	**640**	722	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
		I	O	HP	KCU40	361	**394**	459	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	4	S	O	FP	KCPK10	722	**820**	984	SFM	0.0024–0.0043	0.0031–0.0055	0.0039–0.0071	0.0055–0.0098	0.0063–0.0118	0.0071–0.0118
			I	HP	KC7140										
		U	O	HP	KCU25	492	**590**	722	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
		I	O	HP	KCU40	295	**361**	459	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	5	S	O	HP	KCU25	590	**656**	722	SFM	0.0024–0.0043	0.0031–0.0055	0.0039–0.0071	0.0055–0.0098	0.0063–0.0118	0.0071–0.0118
			I	HP	KC7140										
		U	O	HP	KCU40	394	**443**	492	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
		I	O	HP	KC7140	230	**279**	328	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	6	S	O	HP	KCU25	590	**656**	722	SFM	0.0024–0.0043	0.0031–0.0055	0.0039–0.0071	0.0055–0.0098	0.0063–0.0118	0.0071–0.0118
			I	HP	KC7140										
		U	O	HP	KCU40	394	**443**	492	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
		I	O	HP	KC7140	230	**279**	328	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
M	1	S	O	LP	KCU40	492	**623**	754	SFM	0.0020–0.0031	0.0024–0.0039	0.0028–0.0047	0.0039–0.0063	0.0047–0.0083	0.0055–0.0094
			I	DS	KCU40										
		U	O	LP	KCU40	328	**426**	525	SFM	0.0020–0.0028	0.0024–0.0031	0.0028–0.0039	0.0020–0.0039	0.0024–0.0051	0.0031–0.0063
			I	DS	KCU40										
		I	O	MD	KC7140	197	**262**	328	SFM	0.0012–0.0020	0.0016–0.0028	0.0020–0.0035	0.0028–0.0051	0.0031–0.0063	0.0039–0.0071
			I	MD	KC7140										
	2	S	O	LP	KCU40	492	**590**	689	SFM	0.0020–0.0031	0.0024–0.0039	0.0028–0.0047	0.0039–0.0063	0.0047–0.0083	0.0055–0.0094
			I	DS	KCU40										
		U	O	MD	KCU40	328	**426**	525	SFM	0.0012–0.0020	0.0016–0.0028	0.0020–0.0035	0.0028–0.0051	0.0031–0.0063	0.0039–0.0079
			I	MD	KC7140										
		I	O	MD	KC7140	197	**262**	328	SFM	0.0012–0.0020	0.0016–0.0028	0.0020–0.0035	0.0028–0.0051	0.0031–0.0063	0.0039–0.0071
			I	MD	KC7140										
	3	S	O	LP	KCU40	328	**426**	525	SFM	0.0020–0.0028	0.0024–0.0031	0.0028–0.0039	0.0020–0.0039	0.0024–0.0051	0.0031–0.0063
			I	DS	KCU40										
		U	O	HP	KCU40	262	**361**	459	SFM	0.0012–0.0020	0.0016–0.0028	0.0020–0.0035	0.0028–0.0051	0.0031–0.0063	0.0039–0.0079
			I	HP	KC7140										
		I	O	MD	KC7140	164	**230**	295	SFM	0.0012–0.0020	0.0016–0.0028	0.0020–0.0035	0.0028–0.0051	0.0031–0.0063	0.0039–0.0071
			I	MD	KC7140										

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Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

Drill Fix™ DFSP™ • Inch

Inch															
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (fz) by Diameter						
						min	Starting Value	max	Ø	SPGX05 DFTX2 .551–.708"	SPGX06 DFT03 .709–.865"	SPGX07 DFT05 .866–1.023"	SPGX09 DFT05 1.024–1.299"	SPGX12 DFT06/..07 1.300–1.732"	SPGX15 DFT07/..09 1.733–2.165"
K	1	S	O	FP	KCPK10	656	**787**	984	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KCU40										
		U	O	FP	KCU25	394	**508**	656	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KC7140										
		I	O	FP	KC7140	262	**328**	410	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	2	S	O	FP	KCPK10	590	**722**	853	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KCU40										
		U	O	HP	KCU25	361	**459**	558	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KC7140										
		I	O	HP	KC7140	262	**328**	394	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	3	S	O	HP	KCPK10	590	**722**	853	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KCU40										
		U	O	HP	KCU25	361	**459**	558	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KC7140										
		I	O	HP	KC7140	262	**328**	394	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
N	1	S	O	HP	KCPK10	1148	**1640**	2132	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KMF										
		U	O	HP	KCU40	984	**1312**	1640	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KMF										
		I	O	HP	KCU40	656	**984**	1312	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KMF										
	2	S	O	HP	KCPK10	984	**1312**	1640	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KMF										
		U	O	HP	KCU40	820	**1148**	1476	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KMF										
		I	O	HP	KCU40	574	**820**	1066	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KMF										
	3	S	O	HP	KCPK10	984	**1312**	1640	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KMF										
		U	O	HP	KCU40	820	**1148**	1476	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KMF										
		I	O	HP	KCU40	492	**820**	1148	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KMF										
	4	S	O	HP	KCU25	984	**1312**	1640	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KC7140										
		U	O	HP	KCU40	820	**1148**	1476	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KC7140										
		I	O	HP	KCU40	656	**984**	1312	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	5	S	O	HP	KCU40	1312	**1476**	1640	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KMF										
		U	O	HP	KCU40	820	**1148**	1476	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KMF										
		I	O	HP	KCU40	656	**984**	1312	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KMF										
	6	S	O	HP	KCU40	1312	**1476**	1640	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KMF										
		U	O	HP	KCU40	820	**1148**	1476	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KMF										
		I	O	HP	KCU40	656	**984**	1312	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KMF										

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.

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I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

Drill Fix™ DFSP™ • Inch

Inch														
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (fz) by Diameter					
						min	Starting Value	max	Ø	SPGX05 DFTX2 .551–.708"	SPGX06 DFT03 .709–.865"	SPGX07 DFT05 .866–1.023"	SPGX09 DFT05 1.024–1.299"	SPGX12 DFT06/..07 1.300–1.732"	SPGX15 DFT07/..09 1.733–2.165"
S	1	S	O	HP	KCU40	197	**230**	246	SFM	0.0012–0.0024	0.0016–0.0031	0.0020–0.0039	0.0031–0.0047	0.0039–0.0059	0.0047–0.0071
			I	MD	KC7140										
		U	O	HP	KCU40	131	**164**	197	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
		I	O	HP	KCU40	82	**98**	131	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
	2	S	O	HP	KCU40	164	**197**	230	SFM	0.0012–0.0024	0.0016–0.0031	0.0020–0.0039	0.0031–0.0047	0.0039–0.0059	0.0047–0.0071
			I	MD	KC7140										
		U	O	HP	KCU40	98	**131**	164	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
		I	O	HP	KCU40	82	**98**	131	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
	3	S	O	HP	KCU40	230	**262**	295	SFM	0.0012–0.0024	0.0016–0.0031	0.0020–0.0039	0.0031–0.0047	0.0039–0.0059	0.0047–0.0071
			I	MD	KC7140										
		U	O	HP	KCU40	164	**197**	230	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
		I	O	HP	KCU40	98	**131**	164	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
	4	S	O	HP	KCU40	230	**262**	295	SFM	0.0012–0.0024	0.0016–0.0031	0.0020–0.0039	0.0031–0.0047	0.0039–0.0059	0.0047–0.0071
			I	MD	KC7140										
		U	O	HP	KCU40	164	**197**	230	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
		I	O	HP	KCU40	98	**131**	164	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										

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I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

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 centering 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 centering capabilities.
- Use X-offset on turning machines to adjust the drill diameter and eliminate the need for specials in many applications, and on machining centers to reach tolerance optimization.
- 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.



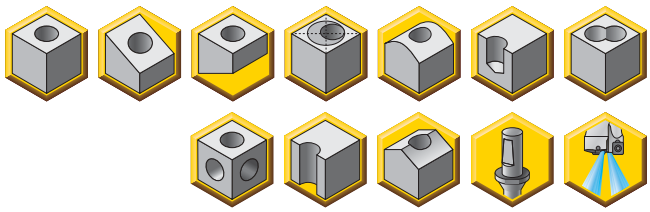
Reliability

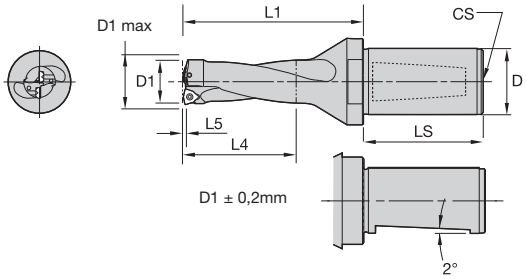
- Highest centering capabilities due to trigon-shaped insert.
- Same insert can be used as inboard or outboard insert — no risk of mixing up inner and outer inserts.
- Improved chip flute and coolant-channel design result in long tool body life and excellent chip evacuation.

Customization

- 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 J98 and J101–J102 for inserts.







WN/WD Shank • 2,5 x D • Metric

D			D1 diameter						
32	40	50	mm	in	D1 max	L1	L4 max	L5	gage insert
DFT250R2WD32M	DFT250R2WD40M	–	25,00	.984	27,00	90,0	58,9	0,9	DFT05T3..
DFT260R2WD32M	DFT260R2WD40M	–	26,00	1.024	27,00	90,0	59,1	1,1	DFT05T3..
DFT270R2WD32M	DFT270R2WD40M	–	27,00	1.063	29,00	100,0	66,1	1,1	DFT05T3..
DFT280R2WD32M	DFT280R2WD40M	–	28,00	1.102	29,00	100,0	66,3	1,3	DFT05T3..
DFT290R2WD32M	DFT290R2WD40M	–	29,00	1.142	31,00	100,0	66,3	1,3	DFT05T3..
DFT300R2WD32M	DFT300R2WD40M	–	30,00	1.181	31,00	115,0	76,4	1,4	DFT05T3..
DFT310R2WD32M	DFT310R2WD40M	–	31,00	1.221	33,00	115,0	76,4	1,4	DFT05T3..
DFT320R2WD32M	DFT320R2WD40M	–	32,00	1.260	33,00	115,0	76,5	1,5	DFT05T3..
DFT330R2WD32M	DFT330R2WD40M	–	33,00	1.299	35,00	115,0	76,4	1,4	DFT06T3..
DFT340R2WD32M	DFT340R2WD40M	–	34,00	1.339	35,00	115,0	76,5	1,5	DFT06T3..
DFT350R2WD32M	DFT350R2WD40M	–	35,00	1.378	38,00	115,0	76,6	1,6	DFT06T3..
DFT360R2WD32M	DFT360R2WD40M	–	36,00	1.417	37,00	115,0	76,8	1,8	DFT06T3..
DFT370R2WD32M	DFT370R2WD40M	–	37,00	1.457	38,00	135,0	96,7	1,7	DFT06T3..
DFT380R2WD32M	DFT380R2WD40M	–	38,00	1.496	41,00	135,0	96,8	1,8	DFT06T3..
DFT390R2WD32M	DFT390R2WD40M	–	39,00	1.535	40,00	135,0	96,9	1,9	DFT06T3..
DFT400R2WD32M	DFT400R2WD40M	–	40,00	1.575	41,00	135,0	97,0	2,0	DFT06T3..
DFT410R2WD32M	DFT410R2WD40M	–	41,00	1.614	44,00	135,0	96,9	1,9	DFT0704..
DFT420R2WD32M	DFT420R2WD40M	–	42,00	1.654	43,00	135,0	96,9	2,0	DFT0704..
DFT430R2WD32M	DFT430R2WD40M	–	43,00	1.693	44,00	150,0	112,1	2,1	DFT0704..
DFT440R2WD32M	DFT440R2WD40M	–	44,00	1.732	47,00	150,0	112,1	2,1	DFT0704..
–	DFT450R2WD40M	DFT450R2WD50M	45,00	1.772	46,00	150,0	112,2	2,2	DFT0704..
–	DFT460R2WD40M	DFT460R2WD50M	46,00	1.811	47,00	150,0	112,0	2,3	DFT0704..
–	DFT470R2WD40M	DFT470R2WD50M *	47,00	1.850	50,00	150,0	111,5	2,4	DFT0704..
–	DFT480R2WD40M	DFT480R2WD50M	48,00	1.890	49,00	150,0	111,0	2,4	DFT0704..
–	DFT490R2WD40M	DFT490R2WD50M	49,00	1.929	50,00	165,0	117,2	2,2	DFT0905..
–	DFT500R2WD40M	DFT500R2WD50M	50,00	1.969	54,00	165,0	117,2	2,2	DFT0905..
–	DFT510R2WD40M	DFT510R2WD50M	51,00	2.008	52,00	165,0	117,4	2,5	DFT0905..
–	DFT520R2WD40M	DFT520R2WD50M	52,00	2.047	53,00	165,0	117,5	2,6	DFT0905..
–	DFT530R2WD40M	DFT530R2WD50M	53,00	2.087	54,00	165,0	117,6	2,6	DFT0905..
–	DFT540R2WD40M	DFT540R2WD50M	54,00	2.126	58,00	165,0	117,7	2,7	DFT0905..
–	–	DFT550R2WD50M	55,00	2.165	56,00	180,0	125,0	2,7	DFT0905..
–	–	DFT560R2WD50M	56,00	2.205	57,00	180,0	125,0	2,8	DFT0905..
–	–	DFT570R2WD50M	57,00	2.244	58,00	180,0	125,0	2,9	DFT0905..
–	–	DFT580R2WD50M	58,00	2.284	62,00	180,0	125,0	3,0	DFT0905..
–	–	DFT590R2WD50M	59,00	2.323	60,00	180,0	125,0	3,0	DFT0905..
–	–	DFT600R2WD50M	60,00	2.362	61,00	180,0	125,0	3,1	DFT0905..

(continued)

(WN/WD Shank • 2,5 x D • Metric — continued)

D			D1 diameter						
32	40	50	mm	in	D1 max	L1	L4 max	L5	gage insert
–	–	**DFT610R2WD50M**	61,00	2.402	62,00	180,0	125,0	3,2	DFT0905..
–	–	**DFT620R2WD50M**	62,00	2.441	65,00	180,0	125,0	3,2	DFT0905..
–	–	**DFT630R2WD50M**	63,00	2.480	64,00	180,0	125,0	3,3	DFT0905..
–	–	**DFT640R2WD50M**	64,00	2.520	65,00	180,0	125,0	3,4	DFT0905..
–	–	**DFT650R2WD50M**	65,00	2.559	66,00	180,0	125,0	3,4	DFT0905..
–	–	**DFT660R2WD50M**	66,00	2.598	69,00	180,0	125,0	3,5	DFT0905..
–	–	**DFT670R2WD50M**	67,00	2.638	67,00	180,0	125,0	3,5	DFT0905..
–	–	**DFT680R2WD50M**	68,00	2.677	69,00	180,0	125,0	3,6	DFT0905..
–	–	**DFT690R2WD50M**	69,00	2.717	73,00	205,0	140,0	3,6	DFT1105..
–	–	**DFT700R2WD50M**	70,00	2.756	71,00	205,0	140,0	3,6	DFT1105..
–	–	**DFT710R2WD50M**	71,00	2.795	72,00	205,0	140,0	3,9	DFT1105..
–	–	**DFT720R2WD50M**	72,00	2.835	73,00	205,0	140,0	3,9	DFT1105..
–	–	**DFT730R2WD50M**	73,00	2.874	79,00	205,0	140,0	4,0	DFT1105..
–	–	**DFT740R2WD50M**	74,00	2.913	75,00	205,0	140,0	4,1	DFT1105..
–	–	**DFT750R2WD50M**	75,00	2.953	76,00	205,0	140,0	4,2	DFT1105..
–	–	**DFT760R2WD50M**	76,00	2.992	77,00	205,0	140,0	4,2	DFT1105..
–	–	**DFT770R2WD50M**	77,00	3.032	78,00	205,0	140,0	4,3	DFT1105..
–	–	**DFT780R2WD50M**	78,00	3.071	79,00	205,0	140,0	4,3	DFT1105..
–	–	**DFT790R2WD50M**	79,00	3.110	82,00	205,0	140,0	4,4	DFT1105..
–	–	**DFT800R2WD50M**	80,00	3.150	81,00	205,0	140,0	4,5	DFT1105..
–	–	**DFT810R2WD50M** *	81,00	3.189	82,00	205,0	140,0	4,5	DFT1105..
–	–	**DFT820R2WD50M**	82,00	3.228	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.

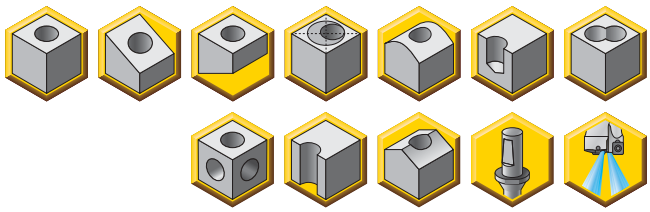


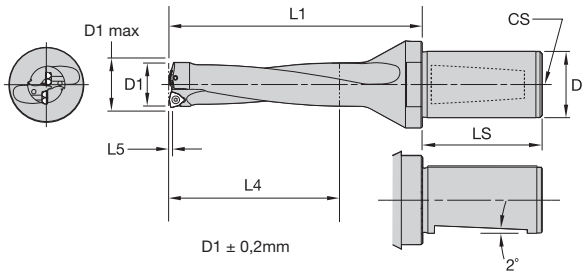


gage insert	insert screw	Torx wrench	Torx size
DFT05T3..	**191.924**	**170.024**	9
DFT06T3..	**191.848**	**170.025**	15
DFT0704..	**191.698**	**170.025**	15
DFT0905..	**191.726**	**170.026**	20
DFT1105..	**191.375**	**170.026**	20

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 J98 and J101–J102 for inserts.







WN/WD Shank • 4 x D • Metric

D		D1 diameter						
32	40	mm	in	D1 max	L1	L4 max	L5	gage insert
DFT250R4WD32M	DFT250R4WD40M	25,00	.984	27,00	135,0	100,0	0,8	DFT05T3..
DFT260R4WD32M	DFT260R4WD40M	26,00	1.024	27,00	139,0	104,0	0,9	DFT05T3..
DFT270R4WD32M	DFT270R4WD40M	27,00	1.063	29,00	143,0	108,0	1,0	DFT05T3..
DFT280R4WD32M	DFT280R4WD40M	28,00	1.102	29,00	156,0	112,0	1,1	DFT05T3..
DFT290R4WD32M	DFT290R4WD40M	29,00	1.142	31,00	151,0	116,0	1,1	DFT05T3..
DFT300R4WD32M	DFT300R4WD40M	30,00	1.181	31,00	160,0	120,0	1,2	DFT05T3..
DFT310R4WD32M	DFT310R4WD40M	31,00	1.221	33,00	164,0	124,0	1,3	DFT05T3..
DFT320R4WD32M	DFT320R4WD40M	32,00	1.260	33,00	168,0	128,0	1,3	DFT05T3..
–	DFT330R4WD40M	33,00	1.299	35,00	177,0	132,0	1,1	DFT06T3..
–	DFT340R4WD40M	34,00	1.339	35,00	181,0	136,0	1,3	DFT06T3..
–	DFT350R4WD40M	35,00	1.378	38,00	185,0	140,0	1,3	DFT06T3..
–	DFT360R4WD40M	36,00	1.417	37,00	189,0	144,0	1,4	DFT06T3..
–	DFT370R4WD40M	37,00	1.457	38,00	198,0	148,0	1,5	DFT06T3..
–	DFT380R4WD40M	38,00	1.496	41,00	202,0	152,0	1,5	DFT06T3..
–	DFT390R4WD40M	39,00	1.535	40,00	206,0	156,0	1,6	DFT06T3..
–	DFT400R4WD40M	40,00	1.575	41,00	210,0	160,0	1,7	DFT06T3..
–	DFT410R4WD40M	41,00	1.614	44,00	214,0	164,0	1,6	DFT0704..
–	DFT420R4WD40M	42,00	1.654	43,00	223,0	168,0	1,7	DFT0704..
–	DFT430R4WD40M	43,00	1.693	44,00	227,0	172,0	1,7	DFT0704..
–	DFT440R4WD40M	44,00	1.732	47,00	231,0	176,0	1,8	DFT0704..
–	DFT450R4WD40M	45,00	1.772	46,00	240,0	180,0	1,9	DFT0704..
–	DFT460R4WD40M	46,00	1.811	47,00	244,0	184,0	1,9	DFT0704..
–	DFT470R4WD40M	47,00	1.850	50,00	248,0	188,0	2,0	DFT0704..
–	DFT480R4WD40M	48,00	1.890	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.

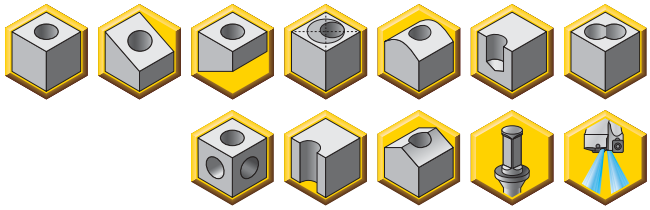


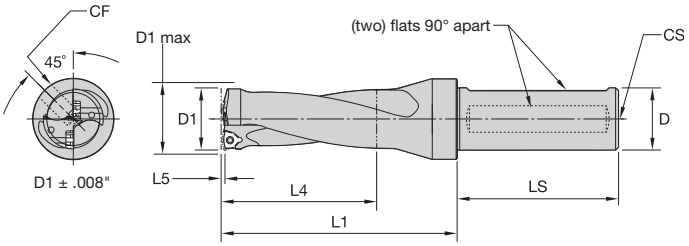


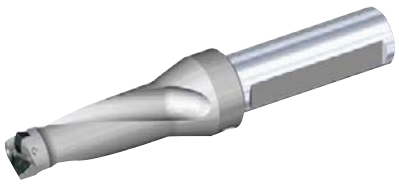
gage insert	insert screw	Torx wrench	Torx size
DFT05T3..	**191.924**	**170.024**	9
DFT06T3..	**191.848**	**170.025**	15
DFT0704..	**191.698**	**170.025**	15

D	LS	CS
32	58	R 1/4 BSP
40	68	R 1/4 BSP

- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- See pages J98 and J101–J102 for inserts.







Flange Shank • 2.5 x D • Inch

D			D1 diameter						
1.250	1.500	2.000	mm	in	D1 max	L1	L4 max	L5	gage insert
DFT0875R2SSF125	–	–	22,23	.875	.950	3.63	2.19	.04	DFT0303..
DFT0906R2SSF125	–	–	23,01	.906	.981	3.63	2.27	.04	DFT0303..
DFT0938R2SSF125	–	–	23,81	.938	1.000	3.75	2.35	.04	DFT0303..
DFT0969R2SSF125	–	–	24,61	.969	1.019	3.75	2.40	.04	DFT0303..
DFT0984R2SSF125	–	–	25,00	.984	1.109	3.88	2.50	.04	DFT05T3..
DFT1000R2SSF125	DFT1000R2SSF150	–	25,40	1.000	1.125	4.00	2.50	.04	DFT05T3..
DFT1031R2SSF125	–	–	26,20	1.031	1.156	4.00	2.60	.04	DFT05T3..
DFT1063R2SSF125	–	–	26,99	1.063	1.188	4.13	2.65	.04	DFT05T3..
DFT1094R2SSF125	–	–	27,79	1.094	1.219	4.13	2.70	.05	DFT05T3..
DFT1125R2SSF125	–	–	28,58	1.125	1.250	4.38	2.85	.05	DFT05T3..
DFT1156R2SSF125	–	–	29,36	1.156	1.281	4.38	2.89	.05	DFT05T3..
DFT1188R2SSF125	–	–	30,16	1.188	1.288	4.50	3.00	.05	DFT05T3..
DFT1219R2SSF125	DFT1219R2SSF150	–	30,96	1.219	1.319	4.63	3.05	.06	DFT05T3..
DFT1250R2SSF125	DFT1250R2SSF150	–	31,75	1.250	1.325	4.75	3.13	.06	DFT05T3..
DFT1281R2SSF125	DFT1281R2SSF150 *	–	32,55	1.281	1.345	4.75	3.20	.06	DFT05T3..
DFT1313R2SSF125	DFT1313R2SSF150	–	33,34	1.313	1.438	4.88	3.30	.05	DFT06T3..
DFT1375R2SSF125	DFT1375R2SSF150	–	34,93	1.375	1.500	5.13	3.45	.06	DFT06T3..
DFT1406R2SSF125	DFT1406R2SSF150	–	35,71	1.406	1.531	5.13	3.50	.06	DFT06T3..
DFT1438R2SSF125	DFT1438R2SSF150	–	36,51	1.438	1.563	5.25	3.60	.07	DFT06T3..
DFT1469R2SSF125	DFT1469R2SSF150	–	37,31	1.469	1.594	5.38	3.70	.07	DFT06T3..
DFT1500R2SSF125	DFT1500R2SSF150	–	38,10	1.500	1.625	5.50	3.75	.07	DFT06T3..
DFT1531R2SSF125	DFT1531R2SSF150	–	38,89	1.531	1.656	5.50	3.85	.07	DFT06T3..
DFT1563R2SSF125	DFT1563R2SSF150	–	39,69	1.563	1.688	5.63	3.90	.07	DFT06T3..
DFT1625R2SSF125	DFT1625R2SSF150	–	41,28	1.625	1.750	5.88	4.10	.07	DFT0704..
DFT1688R2SSF125	DFT1688R2SSF150	–	42,86	1.688	1.813	6.00	4.25	.08	DFT0704..
–	DFT1750R2SSF150	–	44,45	1.750	1.875	6.25	4.38	.08	DFT0704..
–	DFT1813R2SSF150	–	46,04	1.813	1.938	6.38	4.55	.09	DFT0704..
–	DFT1875R2SSF150	–	47,63	1.875	2.000	6.63	4.70	.09	DFT0704..

(continued)

(Flange Shank • 2.5 x D • Inch — continued)

D			D1 diameter						
1.250	1.500	2.000	mm	in	D1 max	L1	L4 max	L5	gage insert
—	**DFT1938R2SSF150**	—	49,21	1.938	2.188	6.75	4.85	.08	DFT0905..
—	**DFT2000R2SSF150**	**DFT2000R2SSF200**	50,80	2.000	2.250	7.00	5.00	.09	DFT0905..
—	**DFT2125R2SSF150**	**DFT2125R2SSF200**	53,98	2.125	2.375	7.38	5.35	.10	DFT0905..
—	—	**DFT2250R2SSF200**	57,15	2.250	2.500	7.75	5.63	.11	DFT0905..
—	—	**DFT2375R2SSF200**	60,33	2.375	2.590	8.13	5.95	.12	DFT0905..
—	—	**DFT2500R2SSF200**	63,50	2.500	2.650	8.50	6.25	.12	DFT0905..
—	—	**DFT2750R2SSF200**	69,85	2.750	3.050	9.13	6.88	.15	DFT1105..
—	—	**DFT3000R2SSF200**	76,20	3.000	3.150	10.00	7.50	.15	DFT1105..
—	—	**DFT3250R2SSF200**	82,55	3.250	3.260	10.26	8.13	.16	DFT1105..

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

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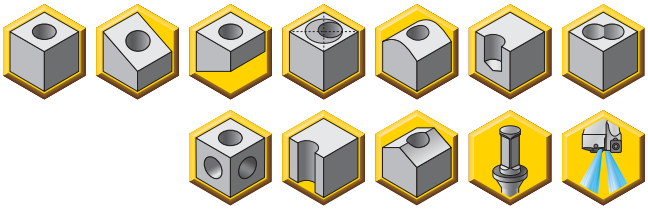
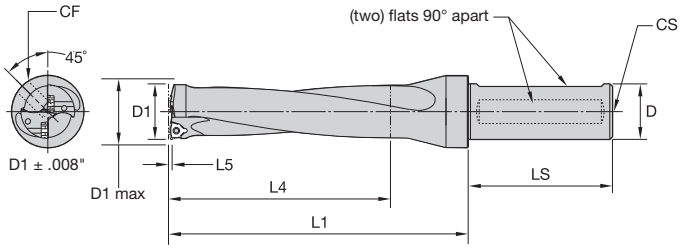
gage insert	insert screw	Torx wrench	Torx size
DFT05T3..	**191.924**	**170.024**	9
DFT06T3..	**191.848**	**170.025**	15
DFT0704..	**191.698**	**170.025**	15
DFT0905..	**191.726**	**170.026**	20
DFT1105..	**191.375**	**170.026**	20

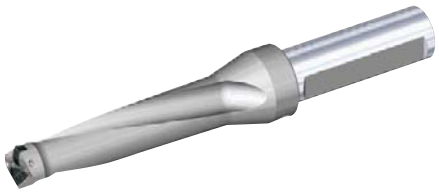


D	LS	CF	CS	pipe plug
1.25	3.25	1/8-27 NPT	R 1/4-18 NPT	**HSFS0125**
1.50	3.75	1/8-27 NPT	R 1/4-18 NPT	**HSFS0125**
2.00	4.00	1/8-27 NPT	R 1/4-18 NPT	**HSFS0125**

- Drill shipped with insert screws, side pipe plug, and Torx wrench.
- See pages J98 and J101–J102 for inserts.







Flange Shank • 4 x D • Inch

D				D1 diameter						
1.000	1.250	1.500	2.000	mm	in	D1 max	L1	L4 max	L5	gage insert
DFT0984R4SSF100	**–**	**–**	**–**	25,00	.984	1.109	5.50	3.94	.03	DFT05T3..
DFT1000R4SSF100	**DFT1000R4SSF125**	**DFT1000R4SSF150**	**–**	25,40	1.000	1.125	5.63	4.00	.03	DFT05T3..
–	**DFT1031R4SSF125**	**–**	**–**	26,20	1.031	1.156	5.75	4.13	.04	DFT05T3..
–	**DFT1063R4SSF125**	**–**	**–**	26,99	1.063	1.188	5.88	4.25	.04	DFT05T3..
–	**DFT1094R4SSF125**	**–**	**–**	27,78	1.094	1.219	5.88	4.38	.04	DFT05T3..
–	**DFT1125R4SSF125**	**DFT1125R4SSF150**	**–**	28,58	1.125	1.250	6.13	4.50	.04	DFT05T3..
–	**DFT1156R4SSF125**	**–**	**–**	29,37	1.156	1.281	6.13	4.63	.05	DFT05T3..
–	**DFT1188R4SSF125**	**–**	**–**	30,16	1.188	1.288	6.50	4.75	.05	DFT05T3..
–	**DFT1219R4SSF125**	**–**	**–**	30,96	1.219	1.319	6.63	4.88	.05	DFT05T3..
–	**DFT1250R4SSF125**	**DFT1250R4SSF150**	**–**	31,75	1.250	1.325	6.75	5.00	.05	DFT05T3..
–	**DFT1281R4SSF125**	**–**	**–**	32,55	1.281	1.345	6.88	5.13	.05	DFT05T3..
–	**DFT1313R4SSF125**	**–**	**–**	33,34	1.313	1.438	7.00	5.25	.05	DFT06T3..
–	**DFT1375R4SSF125**	**DFT1375R4SSF150**	**–**	34,93	1.375	1.500	7.25	5.50	.05	DFT06T3..
–	**DFT1406R4SSF125 ***	**–**	**–**	35,72	1.406	1.531	7.25	5.63	.05	DFT06T3..
–	**DFT1438R4SSF125**	**DFT1438R4SSF150**	**–**	36,51	1.438	1.563	7.63	5.75	.06	DFT06T3..
–	**DFT1469R4SSF125**	**–**	**–**	37,31	1.469	1.594	7.75	5.88	.06	DFT06T3..
–	**DFT1500R4SSF125**	**DFT1500R4SSF150**	**–**	38,10	1.500	1.625	7.88	6.00	.06	DFT06T3..
–	**DFT1531R4SSF125**	**DFT1531R4SSF150 ***	**–**	38,90	1.531	1.656	7.88	6.13	.06	DFT06T3..
–	**DFT1563R4SSF125**	**DFT1563R4SSF150**	**–**	39,69	1.563	1.688	8.13	6.25	.06	DFT06T3..
–	**DFT1625R4SSF125**	**DFT1625R4SSF150**	**–**	41,28	1.625	1.750	8.38	6.50	.06	DFT0704..
–	**DFT1688R4SSF125**	**DFT1688R4SSF150**	**–**	42,86	1.688	1.813	8.75	6.75	.07	DFT0704..
–	**–**	**DFT1750R4SSF150**	**–**	44,45	1.750	1.875	9.00	7.00	.07	DFT0704..
–	**–**	**DFT1813R4SSF150**	**–**	46,04	1.813	1.938	9.25	7.25	.08	DFT0704..
–	**–**	**DFT1875R4SSF150**	**–**	47,63	1.875	2.000	9.50	7.50	.08	DFT0704..
–	**–**	**DFT1938R4SSF150**	**–**	49,21	1.938	2.188	9.88	7.75	.07	DFT0905..
–	**–**	**DFT2000R4SSF150**	**DFT2000R4SSF200**	50,80	2.000	2.250	10.13	8.00	.07	DFT0905..
–	**–**	**DFT2125R4SSF150**	**DFT2125R4SSF200**	53,98	2.125	2.375	10.63	8.50	.09	DFT0905..

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



D	LS	CF	CS	pipe plug
1.00	3.00	1/8-27 NPT	R 1/4-18 NPT	**HSFS0125**
1.25	3.25	1/8-27 NPT	R 1/4-18 NPT	**HSFS0125**
1.50	3.75	1/8-27 NPT	R 1/4-18 NPT	**HSFS0125**
2.00	4.00	1/8-27 NPT	R 1/4-18 NPT	**HSFS0125**

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;
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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

Drill Fix™ DFT™ • Inch

Inch															
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 .625–.969"	DFT05 .984–1.250"	DFT06 1.313–1.563"	DFT07 1.625–1.875"	DFT09 1.938–2.125"	DFT11 2.750–3.250"
P	0	S	O	DS	KCU40	918	**984**	1050	SFM	.0020–.0031	.0028–.0047	.0035–.0059	.0051–.0083	.0067–.0106	.0067–.0106
			I	DS	KCU40										
		U	O	DS	KCU40	656	**705**	754	SFM	.0020–.0031	.0028–.0047	.0035–.0059	.0051–.0083	.0067–.0106	.0067–.0106
			I	DS	KCU40										
		I	O	DS	KCU40	426	**443**	492	SFM	.0020–.0031	.0028–.0047	.0035–.0059	.0051–.0083	.0067–.0106	.0075–.0122
			I	DS	KCU40										
	1	S	O	MD	KCU25	1017	**1066**	1181	SFM	.0020–.0031	.0028–.0047	.0035–.0059	.0051–.0083	.0067–.0106	.0075–.0122
			I	MD	KC7140										
		U	O	MD	KCU25	656	**705**	754	SFM	.0024–.0039	.0035–.0059	.0043–.0071	.0059–.0098	.0075–.0122	.0075–.0122
			I	MD	KC7140										
		I	O	MD	KCU40	426	**443**	492	SFM	.0024–.0039	.0035–.0059	.0043–.0071	.0059–.0098	.0075–.0122	.0075–.0122
			I	MD	KC7140										
	2	S	O	HP	KCPK10	1017	**1066**	1181	SFM	.0024–.0039	.0035–.0059	.0043–.0071	.0059–.0098	.0075–.0122	.0075–.0122
			I	HP	KC7140										
		U	O	HP	KCU25	656	**705**	754	SFM	.0024–.0039	.0035–.0059	.0043–.0071	.0059–.0098	.0075–.0122	.0075–.0122
			I	HP	KC7140										
		I	O	HP	KCU40	426	**443**	492	SFM	.0024–.0039	.0035–.0059	.0043–.0071	.0059–.0098	.0075–.0122	.0075–.0122
			I	HP	KC7140										
	3	S	O	HP	KCPK10	853	**935**	1050	SFM	.0024–.0039	.0035–.0059	.0043–.0071	.0059–.0098	.0075–.0122	.0075–.0122
			I	HP	KC7140										
		U	O	HP	KCU25	590	**640**	722	SFM	.0024–.0039	.0035–.0059	.0043–.0071	.0059–.0098	.0075–.0122	.0075–.0122
			I	HP	KC7140										
		I	O	HP	KCU40	361	**394**	459	SFM	.0024–.0039	.0035–.0059	.0043–.0071	.0059–.0098	.0075–.0122	.0075–.0122
			I	HP	KC7140										
	4	S	O	HP	KCU25	722	**820**	984	SFM	.0024–.0039	.0035–.0059	.0043–.0071	.0059–.0098	.0075–.0122	.0075–.0122
			I	HP	KC7140										
		U	O	HP	KCU40	492	**590**	722	SFM	.0024–.0039	.0035–.0059	.0043–.0071	.0059–.0098	.0075–.0122	.0075–.0122
			I	HP	KC7140										
		I	O	HP	KC7140	295	**361**	459	SFM	.0024–.0039	.0035–.0059	.0043–.0071	.0059–.0098	.0075–.0122	.0075–.0122
			I	HP	KC7140										
	5	S	O	HP	KCU25	590	**656**	722	SFM	.0024–.0039	.0028–.0051	.0035–.0059	.0043–.0071	.0047–.0091	.0047–.0091
			I	HP	KC7140										
		U	O	HP	KCU40	394	**443**	492	SFM	.0024–.0039	.0028–.0051	.0035–.0059	.0043–.0071	.0047–.0091	.0047–.0091
			I	HP	KC7140										
		I	O	HP	KC7140	230	**279**	328	SFM	.0020–.0039	.0028–.0051	.0035–.0059	.0043–.0071	.0047–.0091	.0047–.0091
			I	HP	KC7140										
	6	S	O	HP	KCU25	590	**656**	722	SFM	.0020–.0039	.0028–.0051	.0035–.0059	.0043–.0071	.0047–.0091	.0047–.0091
			I	HP	KC7140										
		U	O	HP	KCU40	394	**443**	492	SFM	.0020–.0039	.0028–.0051	.0035–.0059–	.0047–.0091	.0047–.0091	.0043–.0071
			I	HP	KC7140										
		I	O	HP	KC7140	230	**279**	328	SFM	.0020–.0039	.0028–.0051	.0035–.0059	.0043–.0071	.0047–.0091	.0047–.0091
			I	HP	KC7140										
M	1	S	O	DS	KCU40	492	**623**	754	SFM	.0020–.0031	.0020–.0039	.0024–.0051	.0031–.0055	.0035–.0067	.0035–.0067
			I	DS	KCU40										
		U	O	DS	KCU40	328	**426**	525	SFM	.0020–.0031	.0020–.0039	.0024–.0051	.0031–.0055	.0035–.0067	.0035–.0067
			I	DS	KCU40										
		I	O	MD	KC7140	197	**262**	328	SFM	.0020–.0031	.0020–.0039	.0024–.0051	.0031–.0055	.0035–.0067	.0035–.0067
			I	MD	KC7140										
	2	S	O	DS	KCU40	492	**590**	689	SFM	.0020–.0031	.0020–.0039	.0024–.0051	.0031–.0055	.0035–.0067	.0035–.0067
			I	DS	KCU40										
		U	O	MD	KCU40	328	**426**	525	SFM	.0020–.0031	.0020–.0039	.0024–.0051	.0031–.0055	.0035–.0067	.0035–.0067
			I	MD	KC7140										
		I	O	MD	KC7140	197	**262**	328	SFM	.0020–.0031	.0020–.0039	.0024–.0051	.0031–.0055	.0035–.0067	.0035–.0067
			I	MD	KC7140										
	3	S	O	DS	KCU40	328	**426**	525	SFM	.0020–.0031	.0020–.0039	.0024–.0051	.0031–.0055	.0035–.0067	.0035–.0067
			I	DS	KCU40										
		U	O	HP	KCU40	262	**361**	459	SFM	.0020–.0031	.0020–.0039	.0024–.0051	.0031–.0055	.0035–.0067	.0035–.0067
			I	HP	KC7140										
		I	O	MD	KC7140	164	**230**	295	SFM	.0020–.0031	.0020–.0039	.0024–.0051	.0031–.0055	.0035–.0067	.0035–.0067
			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™ • Inch

Inch															
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (f) by Diameter						
						min	Starting Value	max	Ø	DFT03 .625–.969"	DFT05 .984–1.250"	DFT06 1.313–1.563"	DFT07 1.625–1.875"	DFT09 1.938–2.125"	DFT11 2.750–3.250"
K	1	S	O	HP	KCPK10	656	**787**	984	SFM	.0031–.0051	.0039–.0071	.0055–.0102	.0071–.0130	.0083–.0154	.0083–.0154
			I	HP	KCU40										
		U	O	HP	KCU25	394	**508**	656	SFM	.0031–.0051	.0039–.0071	.0055–.0102	.0071–.0130	.0083–.0154	.0083–.0154
			I	HP	KC7140										
		I	O	HP	KC7140	262	**328**	410	SFM	.0031–.0051	.0039–.0071	.0055–.0102	.0071–.0130	.0083–.0154	.0083–.0154
			I	HP	KC7140										
	2	S	O	HP	KCPK10	590	**722**	853	SFM	.0031–.0051	.0039–.0071	.0055–.0102	.0071–.0130	.0083–.0154	.0083–.0154
			I	HP	KCU40										
		U	O	HP	KCU25	361	**459**	558	SFM	.0031–.0051	.0039–.0071	.0055–.0102	.0071–.0130	.0083–.0154	.0083–.0154
			I	HP	KC7140										
		I	O	HP	KC7140	262	**328**	394	SFM	.0031–.0051	.0039–.0071	.0055–.0102	.0071–.0130	.0083–.0154	.0083–.0154
			I	HP	KC7140										
	3	S	O	HP	KCPK10	590	**722**	853	SFM	.0031–.0051	.0039–.0071	.0055–.0102	.0071–.0130	.0083–.0154	.0083–.0154
			I	HP	KCU40										
		U	O	HP	KCU25	361	**459**	558	SFM	.0031–.0051	.0039–.0071	.0055–.0102	.0071–.0130	.0083–.0154	.0083–.0154
			I	HP	KC7140										
		I	O	HP	KC7140	262	**328**	394	SFM	.0031–.0051	.0039–.0071	.0055–.0102	.0071–.0130	.0083–.0154	.0083–.0154
			I	HP	KC7140										
N	1	S	O	ST	KD1425	1312	**1968**	2624	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	ST	KD1425										
		U	O	HP	KCU40	984	**1312**	1640	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	HP	KCU40										
		I	O	HP	KMF	656	**984**	1312	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	HP	KMF										
	2	S	O	ST	KD1425	1230	**1804**	2542	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	ST	KD1425										
		U	O	HP	KCU40	820	**1148**	1476	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	HP	KCU40										
		I	O	HP	KMF	574	**820**	1066	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	HP	KMF										
	3	S	O	ST	KD1425	1148	**1640**	2132	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	ST	KD1425										
		U	O	HP	KCU40	820	**1148**	1476	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	HP	KCU40										
		I	O	HP	KMF	492	**820**	1148	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	HP	KMF										
	4	S	O	ST	KD1425	1312	**1968**	2624	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	ST	KD1425										
		U	O	HP	KCU40	820	**1148**	1476	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	HP	KCU40										
		I	O	HP	KMF	656	**984**	1312	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	HP	KMF										
	5	S	O	ST	KD1425	1312	**1968**	2624	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	ST	KD1425										
		U	O	HP	KCU40	820	**1148**	1476	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	HP	KCU40										
		I	O	HP	KMF	656	**984**	1312	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	HP	KMF										
	6	S	O	ST	KD1425	1312	**1968**	2624	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	ST	KD1425										
		U	O	HP	KCU40	820	**1148**	1476	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			I	HP	KCU40										
		I	O	HP	KMF	656	**984**	1312	SFM	.0020–.0028	.0028–.0035	.0039–.0055	.0047–.0063	.0055–.0071	.0055–.0071
			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™ • Inch

Inch														
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (f) by Diameter					
						min	Starting Value	max	Ø	DFT03 .625–.969"	DFT05 .984–1.250"	DFT06 1.313–1.563"	DFT07 1.625–1.875"	DFT09 1.938–2.125"	DFT11 2.750–3.250"
S	1	S	O	HP	KCU40	197	**230**	246	SFM	.0012–.0020	.0016–.0024	.0020–.0031	.0024–.0039	.0031–.0051	.0031–.0051
			I	HP	KCU40										
		U	O	HP	KCU40	131	**164**	197	SFM	.0012–.0020	.0016–.0024	.0020–.0031	.0024–.0039	.0031–.0051	.0031–.0051
			I	HP	KC7140										
		I	O	MD	KC7140	82	**98**	131	SFM	.0012–.0020	.0016–.0024	.0020–.0031	.0024–.0039	.0031–.0051	.0031–.0051
			I	MD	KC7140										
	2	S	O	HP	KCU40	164	**197**	230	SFM	.0020–.0028	.0020–.0028	.0020–.0031	.0024–.0039	.0028–.0047	.0028–.0047
			I	HP	KCU40										
		U	O	HP	KCU40	98	**131**	164	SFM	.0016–.0024	.0020–.0031	.0024–.0039	.0024–.0039	.0035–.0059	.0035–.0059
			I	HP	KC7140										
		I	O	MD	KC7140	82	**98**	131	SFM	.0020–.0028	.0020–.0028	.0020–.0031	.0024–.0039	.0028–.0047	.0028–.0047
			I	MD	KC7140										
	3	S	O	HP	KCU40	230	**262**	295	SFM	.0012–.0020	.0016–.0024	.0020–.0031	.0024–.0039	.0031–.0051	.0031–.0051
			I	HP	KCU40										
		U	O	HP	KCU40	164	**197**	230	SFM	.0012–.0020	.0016–.0024	.0020–.0031	.0024–.0039	.0031–.0051	.0031–.0051
			I	HP	KCU40										
		I	O	MD	KC7140	98	**131**	164	SFM	.0012–.0020	.0016–.0024	.0020–.0031	.0024–.0039	.0031–.0051	.0031–.0051
			I	MD	KC7140										
	4	S	O	HP	KCU40	230	**262**	295	SFM	.0020–.0028	.0020–.0028	.0020–.0031	.0024–.0039	.0028–.0047	.0028–.0047
			I	HP	KCU40										
		U	O	HP	KCU40	164	**197**	230	SFM	.0016–.0024	.0020–.0031	.0024–.0039	.0024–.0039	.0035–.0059	.0035–.0059
			I	HP	KCU40										
		I	O	MD	KC7140	98	**131**	164	SFM	.0020–.0028	.0020–.0028	.0020–.0031	.0024–.0039	.0028–.0047	.0028–.0047
			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 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 centering 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.
- Customized 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.

Customization

- 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.

Customization

- Wear pads can be added for increased stability.
- Fully engineered solutions available.



HTS-R


inner cartridge


pilot drill


outer cartridge

HTS Ø 1.77–4.02"/45–102mm


inner cartridge*


pilot drill


outer cartridge*

HTS Ø 4.02–6.69"/102–170mm


inner cartridge


pilot drill


outer cartridge

HTS Ø 7.68–10.63"/195–270mm


inner cartridge


pilot drill


outer cartridge

HTS with SPHX outboard insert


inner cartridge


pilot drill


outer cartridge**

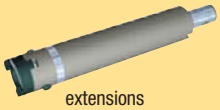
* for Ø 7.09–7.32"/180–186mm: 2 inner and outer cartridges are used

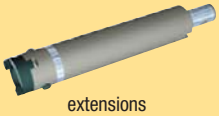
HTS-R head

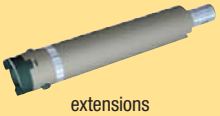


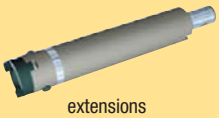
HTS head




extensions


extensions


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

** for Ø 4.02–6.69"/102–170mm & Ø 7.68–9.45"/195–240mm: the outer cartridge uses 3 inserts

HTS-R


inner cartridge


pilot drill


outer cartridge

HTS-R head



HTS Ø 1.77–4.02"/45–102mm


inner cartridge*


pilot drill


outer cartridge*

* for Ø 7.09–7.32"/180–186mm: 2 inner and outer cartridges are used

HTS Ø 4.02–6.69"/102–170mm


inner cartridge


pilot drill


outer cartridge

HTS Ø 7.68–10.63"/195–270mm


inner cartridge


pilot drill


outer cartridge

HTS with SPHX outboard insert


inner cartridge


pilot drill


outer cartridge**

** for Ø 4.02–6.69"/102–170mm & Ø 7.68–9.45"/195–240mm: the outer cartridge uses 3 inserts


extensions reducer


extensions


reducer


basic shanks


DV


BT


BT with coolant ring


CV

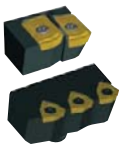
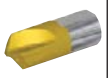

CV with coolant ring


HSK

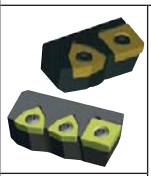
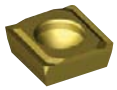
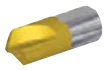
HTS head



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.

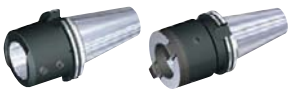
						HTS(-R) head with DFR™/DFT™ inserts								
						inner cartridge				outer cartridge				
	drilling range			L1										
	mm	in	HTS head	mm	in	cartridge	n	insert	n	cartridge	n	insert	n	pilot drill
HTS heads with DFR inserts	40–43	1.57–1.69	HTSR040R025M	60	2.36	HTSR10CI	1	DFR0302.	2	HTSR10CE	1	DFR0302.	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 adapter 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.
** Adapter 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 adapter			L1		
	80	metric	mm	inch	in		mm	in	coolant adapter	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

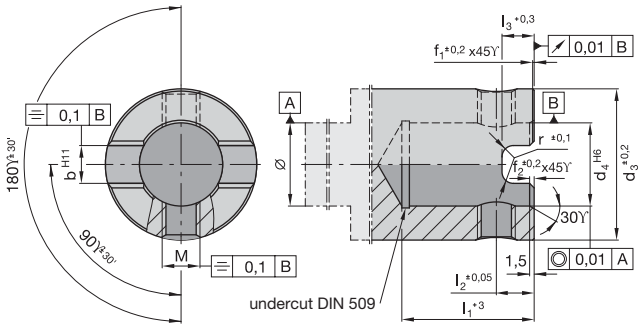
- Select your appropriate drill diameter range.
- Choose the appropriate adapter and shank size.
- Follow the columns to the right, and select the appropriate components from each column to complete your HTS(-R) tool.

	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	customized solutions available upon request									
	230–240 260–270	9.06–9.45 10.24–10.63	customized solutions available upon request									

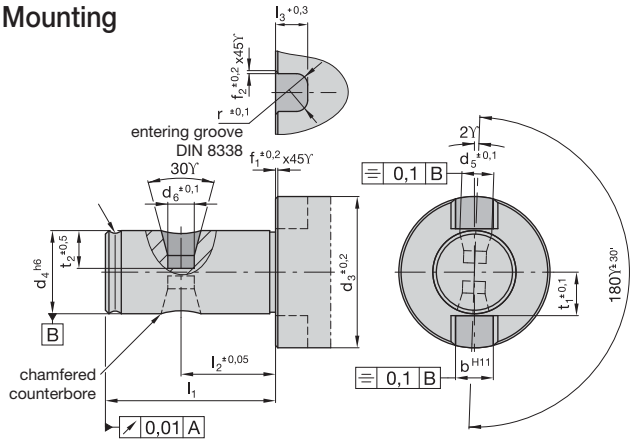
* HTS drilling head with reinforced body for short-chipping materials.
** Adapter with coolant ring.
The shown combinations are not complete. Ask your Kennametal representative to get the most reasonable solution for your application.
Please note that the assembled total length of the drilling tool is not necessarily the total achievable drilling depth.

	KM	basic shank				reducer					extension			HTS head
														
	assembly details		L4		L4		L1		for use with coolant adapter			L1		
	80	metric	mm	inch	in		mm	in	coolant adapter	shell mill DV/BT		mm	in	
	–	5.34050–048168 5.34050–048300 5.34050–048450 5.34050–048600	160 267 417 567	–	–	–	–	–	–	–				
	–	–	–	SSF200HTS270297 SSF200HTS271122 SSF200HTS271922 SSF200HTS273122	1.47 9.22 17.22 29.22	–	–	–	–	–	5.34140R048200	212	8.35	**3.76078R048V*** 3.76084R048V 3.76090R048V 3.76096R048V
	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	–	–	–	–	–	–	–				
	–	–	–	SSF200HTS160239 SSF200HTS160714 SSF200HTS161214 SSF200HTS161964	.39 5.14 10.14 17.64	–	–	–	–	–	5.34158R058300	314	12.36	**3.76096R058V*** 3.76102R058V 3.76108R058V
	KM80ATCHTS50085M KM80ATCHTS50100M	–	–	–	–	5.34280R058080	94	3.70	5.34350–090100	DV50SM60070M BT50SM60090M				
	–	–	–	SSF250HTS400355 SSF250HTS401055 SSF250HTS401555 SSF250HTS402555	1.63 8.21 13.21 23.21	–	–	–	–	–	–	–	–	
	KM80ATCHTS40085M KM80ATCHTS40100M	–	–	–	–	5.34280R070150	164	6.45	5.34350–090100	DV50SM60070M BT50SM60090M	5.34170R070300 5.34170R070500	314 514	12.36 20.24	3.76115R070V 3.76122R070V 3.76130R070V
	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
customized solution available upon request														3.76180R110 3.76195R110 3.76213R125
customized solution available upon request														3.76230R160 3.76260R160

Adapter



Mounting



Adapter Dimensions

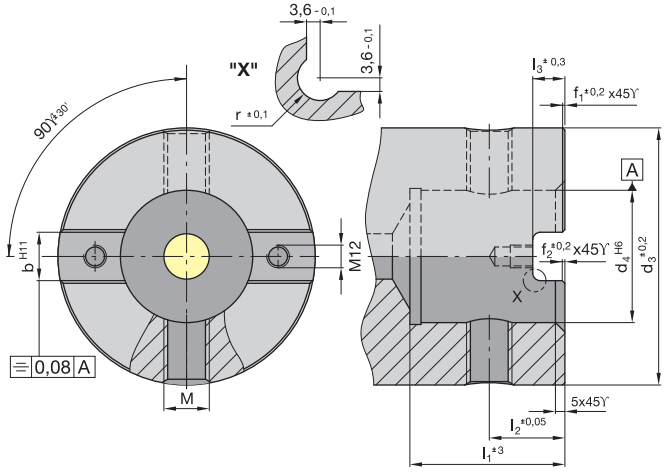


d3	d4	l1	l2	l3	M	b	r	f1	f2	drive ring	clamping screw	thread	MAn* Nm	sliding block	clamping screw M 12 x 25 for sliding block
25	13	28	12,4	7,0	M8 x 1,0	8,0	3	0,5	0,5	**193.371**	**193.372**	M8 x 1,0	10	–	–
28	13	28	12,4	7,0	M8 x 1,0	8,0	3	0,5	0,5	**192.419**	**193.372**	M8 x 1,0	10	–	–
32	16	32	14,4	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

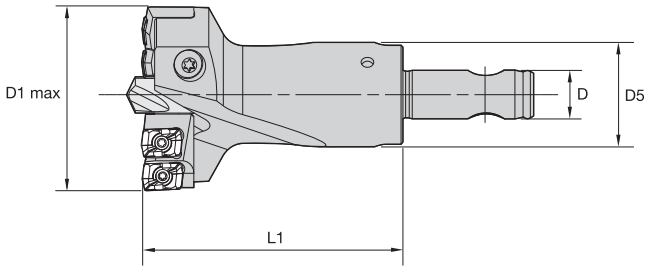
d3	d4	d5	d6	l1	l2	l3	t1	t2	b	r	f1	f2
25	13	8,50	6,5	35	22,0	7,00	6,7	6,50	8,0	3	0,5	0,5
28	13	8,50	6,5	35	22,0	7,00	7,0	6,50	8,0	3	0,5	0,5
32	16	8,30	6,5	40	24,0	7,50	8,5	7,50	8,0	3	0,5	0,5
40	22	10,50	7,0	45	25,0	8,50	11,5	10,00	10,0	3	0,5	0,5
48	27	12,75	9,0	50	27,0	9,00	14,0	12,00	12,0	3	1,0	1,0
58	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) Adapter for d3 = 125, 140, and 160

- Head shipped with clamping and adjusting screws.
- Order pilot drill and cartridges separately; see page J76 for pilot drill.





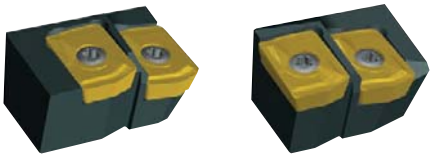


HTS Adjustable Heads with DFR™ Inserts

	D1		D1 max		D5			L1									
catalog number	mm	in	mm	in	mm	in	D	mm	in	pilot drill HSS	pilot drill carbide	cartridge interior	n	cartridge exterior	n	gage insert	ni
HTSR040R025M	40	1.57	43	1.69	25	0.98	13A	60	2	B513S08..	B514S08..	**HTSR10CI**	1	**HTSR10CE**	1	DFR0302..	4
HTSR043R025M	43	1.69	46	1.81	25	0.98	13A	70	3	B513S10..	B514S10..	**HTSR11CI**	1	**HTSR11CE**	1	DFR0302..	4
HTSR046R028M	46	1.81	49	1.93	28	1.10	13B	70	3	B513S10..	B514S10..	**HTSR12CI**	1	**HTSR12CE**	1	DFR0403..	4
HTSR049R028M	49	1.93	52	2.05	28	1.10	13B	70	3	B513S10..	B514S10..	**HTSR13CI**	1	**HTSR13CE**	1	DFR0403..	4
HTSR052R028M	52	2.05	55	2.17	28	1.10	13B	70	3	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			
mm	in	clamping screw	adjusting screw
40–42	1.57–1.68	**190.116**	**128.610**
43–52	1.69 - 2.05	**193.397**	**190.458**

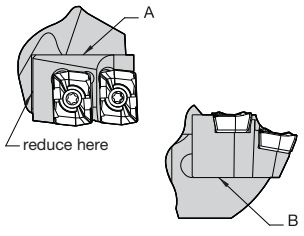


HTS DFR Cartridges

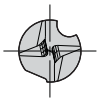


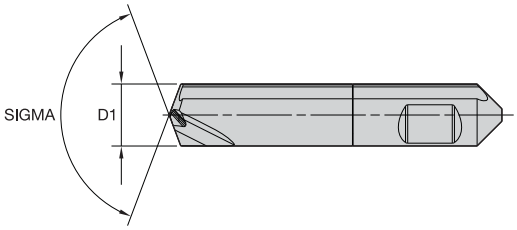
catalog number	gage insert	Nm	ft. lbs.	insert screw	cartridge screw	washer
HTSR10CE	DFR0302..	5,0	3.69	**192.416**	**192.592**	**192.902**
HTSR10CI	DFR0302..	5,0	3.69	**192.416**	**192.592**	**192.902**
HTSR11CE	DFR0302..	5,0	3.69	**192.416**	**192.592**	**192.902**
HTSR11CI	DFR0302..	5,0	3.69	**192.416**	**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.



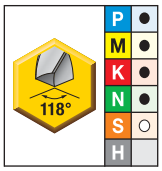
- Choose between HSS and solid carbide.

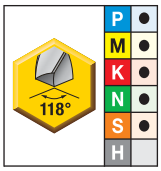


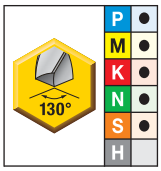




HTS DFR™ • Pilot Drills

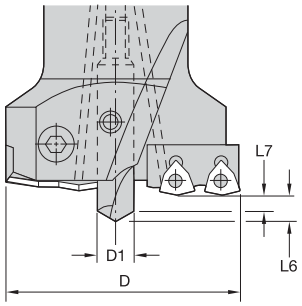






● first choice
○ alternate choice

high-speed steel uncoated	high-speed steel coated	solid carbide coated	D1	
A30	AS3	KC7030	mm	in
B513S08000 A30	B513S08000 AS3	B514S08000 KC7030	8	.32
B513S10000 A30	B513S10000 AS3	B514S10000 KC7030	10	.39



HTS DFR • Pilot Drills

		118° high-speed steel				130° 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

HTS DFR™ • Inch

Inch											
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (fz) by Diameter		
						min	Starting Value	max	Ø	DFR03... .688–.750"	DFR04... .813–1.00"
P	1	S	O	MD	KCU25	260	**623**	750	IPR	.004–.006	.005–.007
			I	MD	KCU25						
		U	O	MD	KCU40	231	**427**	561	IPR	.004–.006	.005–.007
			I	MD	KCU40						
		I	O	MD	KC7140	143	**262**	348	IPR	.003–.006	.004–.008
			I	MD	KC7140						
	2	S	O	GD	KCU25	247	**591**	712	IPR	.004–.006	.005–.007
			I	GD	KCU25						
		U	O	GD	KCU40	231	**394**	561	IPR	.004–.006	.005–.007
			I	GD	KCU40						
		I	O	GD	KC7140	143	**230**	348	IPR	.004–.006	.005–.007
			I	GD	KC7140						
	3	S	O	GD	KCU25	197	**459**	555	IPR	.004–.006	.005–.007
			I	GD	KCU25						
		U	O	GD	KCU40	163	**328**	396	IPR	.004–.006	.005–.007
			I	GD	KCU40						
		I	O	GD	KC7140	98	**197**	238	IPR	.004–.006	.005–.007
			I	GD	KC7140						
	4	S	O	GD	KCU25	260	**394**	750	IPR	.004–.006	.005–.007
			I	GD	KCU25						
		U	O	GD	KCU40	231	**328**	561	IPR	.004–.006	.005–.007
			I	GD	KCU40						
		I	O	GD	KC7140	143	**262**	348	IPR	.004–.006	.005–.007
			I	GD	KC7140						
	5	S	O	GD	KCU40	205	**328**	622	IPR	.002–.004	.003–.006
			I	GD	KCU40						
		U	O	GD	KC7140	154	**197**	373	IPR	.002–.004	.003–.006
			I	GD	KC7140						
		I	O	GD	KC7140	103	**131**	250	IPR	.002–.004	.003–.006
			I	GD	KC7140						
	6	S	O	GD	KCU40	195	**312**	591	IPR	.003–.004	.003–.005
			I	GD	KCU40						
		U	O	GD	KC7140	146	**187**	355	IPR	.003–.004	.003–.005
			I	GD	KC7140						
		I	O	GD	KC7140	98	**125**	238	IPR	.003–.004	.003–.005
			I	GD	KC7140						
M	1	S	O	MD	KCU40	130	**361**	439	IPR	.003–.004	.005–.007
			I	MD	KC7140						
		U	O	MD	KC7140	101	**230**	281	IPR	.003–.004	.005–.007
			I	MD	KC7140						
		I	O	MD	KC7140	72	**164**	199	IPR	.003–.004	.005–.007
			I	MD	KC7140						
	2	S	O	MD	KCU40	124	**325**	417	IPR	.003–.004	.005–.007
			I	MD	KC7140						
		U	O	MD	KC7140	101	**207**	281	IPR	.003–.004	.005–.007
			I	MD	KC7140						
		I	O	MD	KC7140	72	**148**	199	IPR	.003–.004	.005–.007
			I	MD	KC7140						
	3	S	O	MD	KCU40	104	**289**	351	IPR	.003–.004	.005–.007
			I	MD	KC7140						
		U	O	MD	KC7140	101	**184**	281	IPR	.003–.004	.005–.007
			I	MD	KC7140						
		I	O	MD	KC7140	72	**131**	199	IPR	.003–.004	.005–.007
			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™ • Inch

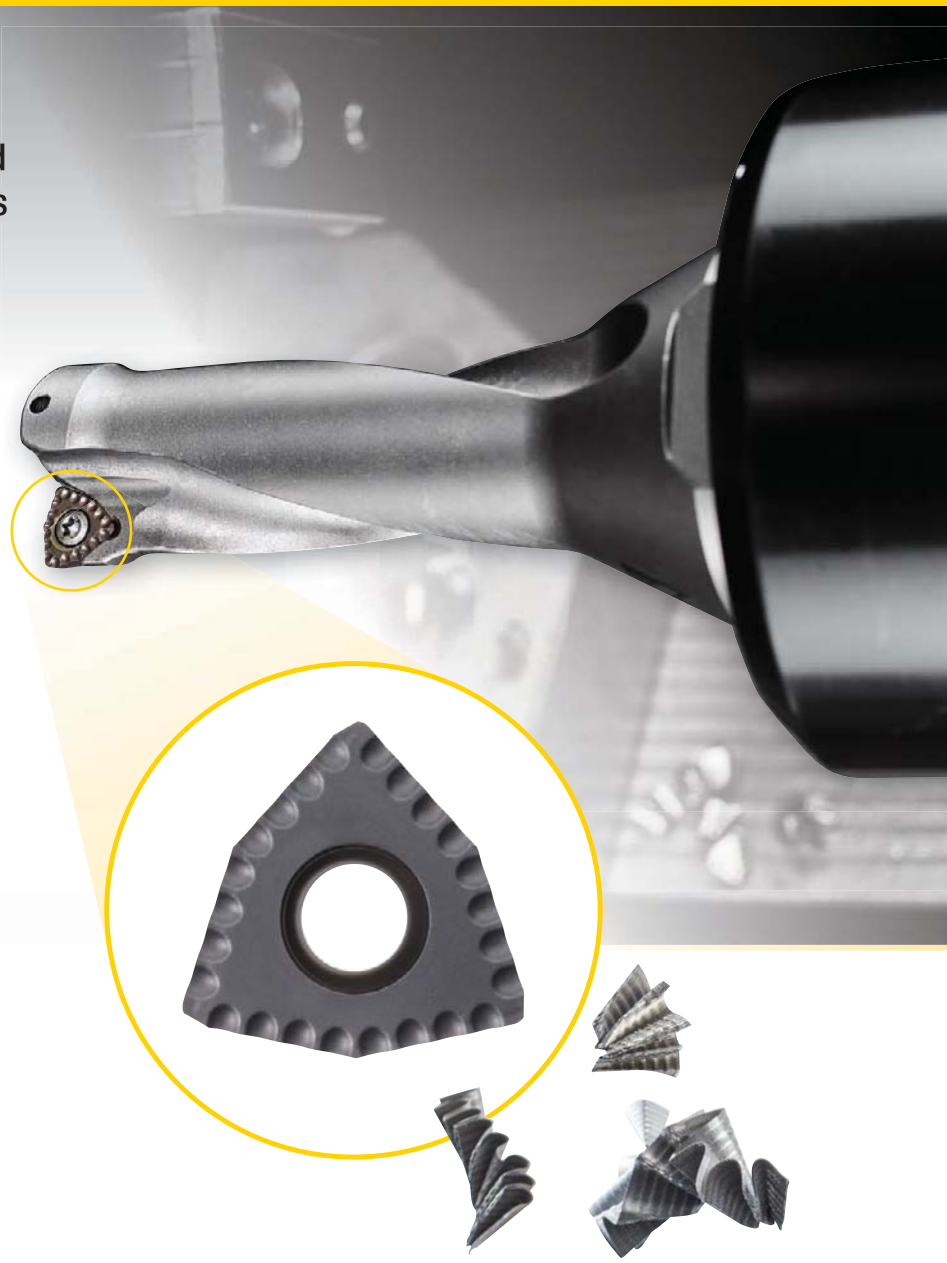
Inch											
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (fz) by Diameter		
						min	Starting Value	max	Ø	DFR03... .688–.750"	DFR04... .813–1.00"
K	1	S	O	GD	KCPK10	260	**561**	750	IPR	.004–.008	.005–.011
			I	GD	KCPK10						
		U	O	LD	KCU25	211	**384**	510	IPR	.004–.008	.005–.011
			I	LD	KCU25						
		I	O	LD	KCU40	131	**236**	316	IPR	.004–.008	.005–.011
			I	LD	KCU40						
	2	S	O	GD	KCPK10	247	**533**	712	IPR	.004–.008	.005–.011
			I	GD	KCPK10						
		U	O	GD	KCU25	211	**365**	510	IPR	.004–.008	.005–.011
			I	GD	KCU25						
		I	O	LD	KCU40	131	**224**	316	IPR	.004–.008	.005–.011
			I	LD	KCU40						
	3	S	O	GD	KCPK10	222	**480**	641	IPR	.004–.008	.005–.011
			I	GD	KCPK10						
		U	O	GD	KCU25	195	**328**	473	IPR	.004–.008	.005–.011
			I	GD	KCU25						
		I	O	GD	KCU40	113	**202**	274	IPR	.004–.008	.005–.011
			I	GD	KCU40						
N	1	S	O	ST	KD1425	420	**787**	1176	IPR	.002–.004	.004–.007
			I	ST	KD1425						
		U	O	LD	KCU40	336	**525**	784	IPR	.002–.004	.004–.007
			I	LD	KCU40						
		I	O	LD	KCU40	218	**341**	510	IPR	.002–.004	.004–.007
			I	LD	KCU40						
	2	S	O	ST	KD1425	391	**732**	1094	IPR	.002–.004	.004–.007
			I	ST	KD1425						
		U	O	LD	KCU40	336	**488**	784	IPR	.002–.004	.004–.007
			I	LD	KCU40						
		I	O	LD	KCU40	218	**317**	510	IPR	.002–.004	.004–.007
			I	LD	KCU40						
	3	S	O	ST	KD1425	361	**677**	1011	IPR	.002–.004	.004–.007
			I	ST	KD1425						
		U	O	LD	KCU40	336	**451**	784	IPR	.002–.004	.004–.007
			I	LD	KCU40						
		I	O	LD	KCU40	218	**293**	510	IPR	.002–.004	.004–.007
			I	LD	KCU40						
	4	S	O	ST	KD1425	391	**732**	1094	IPR	.002–.004	.004–.007
			I	ST	KD1425						
		U	O	LD	KCU40	336	**488**	784	IPR	.002–.004	.004–.007
			I	LD	KCU40						
		I	O	LD	KCU40	218	**317**	510	IPR	.002–.004	.004–.007
			I	LD	KCU40						
	5	S	O	ST	KD1425	302	**722**	858	IPR	.002–.004	.004–.007
			I	ST	KD1425						
		U	O	LD	KCU40	235	**459**	549	IPR	.002–.004	.004–.007
			I	LD	KCU40						
		I	O	LD	KCU40	151	**295**	351	IPR	.002–.004	.004–.007
			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–J59 for Drill Fix indexable drills.

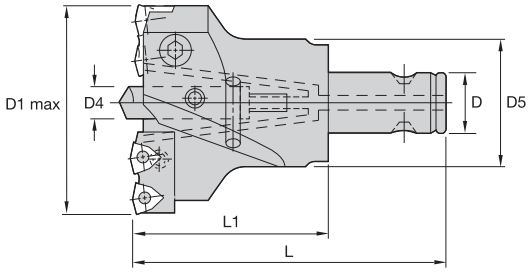
See pages H102–H106, H108–H125, and H133 for KSEM PLUS A1 and B1 head systems.

Experience the advantages at your Authorized Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

kennametal.com

- Head shipped with clamping and adjusting screws.
- Order pilot drill separately; see page J86.
- Order cartridges separately; see page J84.



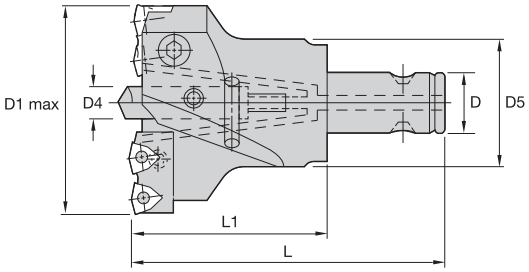


HTS Adjustable Heads with DFT™ Inserts

	D1		D1 max														
catalog number	mm	in	mm	in	D5	D	L	L1	pilot drill	cartridge interior	n	cartridge exterior	n	gage insert	ni	kg	lbs
3.76045R028V	45	1.770	50	1.970	28	13	85	50	B510S08.	3.77000R050V	1	3.77000R051V	1	DFT0303.	4	0.3	0.66
3.76050R028V	50	1.970	55	2.170	28	13	85	50	B510S08.	3.77000R052V	1	3.77000R053V	1	DFT0303.	4	0.4	0.88
3.76055R032V	55	2.170	58	2.280	33	16	100	60	B510S08.	3.77000R038V	1	3.77000R039V	1	DFT05T3.	4	0.4	0.88
3.76058R032V	58	2.280	63	2.480	33	16	100	60	B510S10.	3.77000R023V	1	3.77000R024V	1	DFT05T3.	4	0.4	0.88
3.76063R032V	63	2.480	68	2.680	33	16	100	60	B510S10.	3.77000R025V	1	3.77000R024V	1	DFT05T3.	4	0.4	0.88
3.76063R040V	63	2.480	68	2.680	41	22	115	70	B510S10.	3.77000R025V	1	3.77000R024V	1	DFT05T3.	4	0.5	1.10
3.76068R040V	68	2.680	73	2.870	41	22	115	70	B510S10.	3.77000R026V	1	3.77000R027V	1	DFT05T3.	4	0.8	1.76
3.76073R040V	73	2.870	78	3.070	41	22	115	70	B510S15.	3.77000R026V	1	3.77000R027V	1	DFT05T3.	4	0.8	1.76
3.76078R040V	78	3.070	84	3.310	41	22	115	70	B510S15.	3.77000R028V	1	3.77000R029V	1	DFT06T3.	4	0.8	1.76
3.76078R048V	78	3.070	84	3.310	49	27	120	70	B510S15.	3.77000R028V	1	3.77000R029V	1	DFT06T3.	4	0.9	1.98
3.76084R048V	84	3.310	90	3.540	49	27	120	70	B510S15.	3.77000R028V	1	3.77000R029V	1	DFT06T3.	4	1.0	2.20
3.76090R048V	90	3.540	96	3.780	49	27	120	70	B510S15.	3.77000R030V	1	3.77000R031V	1	DFT06T3.	4	1.0	2.20
3.76096R048V	96	3.780	102	4.020	49	27	120	70	B510S20.	3.77000R030V	1	3.77000R031V	1	DFT06T3.	4	1.1	2.43
3.76096R058V	96	3.780	102	4.020	59	32	130	80	B510S20.	3.77000R030V	1	3.77000R031V	1	DFT06T3.	4	1.2	2.65
3.76102R058V	102	4.020	108	4.250	59	32	130	80	B510S20.	3.77000R081V	1	3.77000R082V	1	DFT05T3.	6	1.7	3.75
3.76108R058V	108	4.250	115	4.530	59	32	130	80	B510S20.	3.77000R083V	1	3.77000R084V	1	DFT06T3.	6	1.8	3.97
3.76115R070V	115	4.530	122	4.800	71	40	145	90	B510S20.	3.77000R085V	1	3.77000R086V	1	DFT06T3.	6	2.9	6.39
3.76122R070V	122	4.800	130	5.120	71	40	145	90	B510S25.	3.77000R079V	1	3.77000R080V	1	DFT06T3.	6	2.9	6.39
3.76130R070V	130	5.120	140	5.510	71	40	145	90	B510S25.	3.77000R087V	1	3.77000R088V	1	DFT06T3.	6	3.0	6.61
3.76140R080V	140	5.510	150	5.910	81	50	160	100	B510S25.	3.77000R077V	1	3.77000R078V	1	DFT0704.	6	4.3	9.48
3.76150R080V	150	5.910	158	6.220	81	50	160	100	B510S25.	3.77000R075V	1	3.77000R076V	1	DFT0704.	6	4.5	9.92
3.76158R080V	158	6.220	162	6.380	81	50	160	100	B510S25.	3.77000R073V	1	3.77000R074V	1	DFT0704.	6	4.5	9.92
3.76162R080V	162	6.380	170	6.690	80	50	160	100	B510S30.	3.77000R048V	1	3.77000R049V	1	DFT0704.	6	4.5	9.92
3.76180R110	180	7.090	186	7.320	110	60	185	125	B510S30.	3.77000R030V	3	3.77000R031V	1	DFT06T3.	8	6.0	13.23
3.76195R110	195	7.680	201	7.910	110	60	185	125	B510S30.	3.77000R081V	3	3.77000R082V	1	DFT05T3.	12	6.5	14.33
3.76213R125	213	8.390	220	8.660	125	60	200	125	B510S30.	3.77000R083V	3	3.77000R084V	1	DFT06T3.	12	7.5	16.53
3.76230R160	230	9.060	240	9.450	160	80	230	150	B510S30.	3.77000R079V	2	3.77000R080V	2	DFT06T3.	12	8.5	18.74
3.76260R160 *	260	10.240	270	10.630	160	80	230	150	B510S30.	3.77000R077V	2	3.77000R078V	2	DFT06T3.	12	9.0	19.84

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 J86.
- Order cartridges separately; see pages J84–J85.





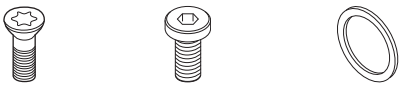
HTS Adjustable Heads • DFT™ and SPHX Inserts

catalog number	D1 mm	D1 in	D1 max mm	D1 max in	pilot drill	cartridge interior	n	cartridge interior 2	n	gage insert	ni	cartridge exterior SPHX	n	gage insert	ni
3.76045R028V	45	1.770	50	1.970	B510S08.	**3.77000R250V**	1	–	–	DFT0303.	3	3.77000R251V	1	SPHX0703.	1
3.76050R028V	50	1.970	55	2.170	B510S08.	**3.77000R252V**	1	–	–	DFT0303.	3	3.77000R253V	1	SPHX0703.	1
3.76055R032V	55	2.170	58	2.280	B510S08.	**3.77000R038V**	1	–	–	DFT05T3.	3	3.77000R239V	1	SPHX0903.	1
3.76058R032V	58	2.280	63	2.480	B510S10.	**3.77000R023V**	1	–	–	DFT05T3.	3	3.77000R224V	1	SPHX0903.	1
3.76063R032V	63	2.480	68	2.680	B510S10.	**3.77000R025V**	1	–	–	DFT05T3.	3	3.77000R224V	1	SPHX0903.	1
3.76063R040V	63	2.480	68	2.680	B510S10.	**3.77000R025V**	1	–	–	DFT05T3.	3	3.77000R224V	1	SPHX0903.	1
3.76068R040V	68	2.680	73	2.870	B510S10.	**3.77000R026V**	1	–	–	DFT05T3.	3	3.77000R227V	1	SPHX0903.	1
3.76073R040V	73	2.870	78	3.070	B510S15.	**3.77000R026V**	1	–	–	DFT05T3.	3	3.77000R227V	1	SPHX0903.	1
3.76078R040V	78	3.070	84	3.310	B510S15.	**3.77000R028V**	1	–	–	DFT06T3.	3	3.77000R229V	1	SPHX0903.	1
3.76078R048V	78	3.070	84	3.310	B510S15.	**3.77000R028V**	1	–	–	DFT06T3.	3	3.77000R229V	1	SPHX0903.	1
3.76084R048V	84	3.310	90	3.540	B510S15.	**3.77000R228V**	1	–	–	DFT06T3.	3	3.77000R229V	1	SPHX0903.	1
3.76090R048V	90	3.540	96	3.780	B510S15.	**3.77000R230V**	1	–	–	DFT06T3.	3	3.77000R231V	1	SPHX0903.	1
3.76096R048V	96	3.780	102	4.020	B510S20.	**3.77000R230V**	1	–	–	DFT06T3.	3	3.77000R231V	1	SPHX0903.	1
3.76096R058V	96	3.780	102	4.020	B510S20.	**3.77000R230V**	1	–	–	DFT06T3.	3	3.77000R231V	1	SPHX0903.	1
3.76102R058V	102	4.020	108	4.250	B510S20.	**3.77000R081V**	1	–	–	DFT05T3.	5	3.77000R282V	1	SPHX0903.	1
3.76108R058V	108	4.250	115	4.530	B510S20.	**3.77000R083V**	1	–	–	DFT06T3.	5	3.77000R284V	1	SPHX1204.	1
3.76115R070V	115	4.530	122	4.800	B510S20.	**3.77000R085V**	1	–	–	DFT06T3.	5	3.77000R286V	1	SPHX1204.	1
3.76122R070V	122	4.800	130	5.120	B510S25.	**3.77000R079V**	1	–	–	DFT06T3.	5	3.77000R280V	1	SPHX1204.	1
3.76130R070V	130	5.120	140	5.510	B510S25.	**3.77000R087V**	1	–	–	DFT06T3.	5	3.77000R288V	1	SPHX1204.	1
3.76140R080V	140	5.510	150	5.910	B510S25.	**3.77000R077V**	1	–	–	DFT0704.	5	3.77000R278V	1	SPHX1505.	1
3.76150R080V	150	5.910	158	6.220	B510S25.	**3.77000R075V**	1	–	–	DFT0704.	5	3.77000R276V	1	SPHX1204.	1
3.76158R080V	158	6.220	162	6.380	B510S25.	**3.77000R073V**	1	–	–	DFT0704.	5	3.77000R274V	1	SPHX1204.	1
3.76162R08`0V	162	6.380	170	6.690	B510S30.	**3.77000R248V**	1	–	–	DFT0704.	5	3.77000R249V	1	SPHX1505.	1
3.76180R110	180	7.090	186	7.320	B510S30.	**3.77000R230V**	3	–	–	DFT06T3.	7	3.77000R231V	1	SPHX0903.	1
3.76195R110	195	7.680	201	7.910	B510S30.	**3.77000R081V**	3	–	–	DFT05T3.	11	3.77000R282V	1	SPHX0903.	1
3.76213R125	213	8.390	220	8.660	B510S30.	**3.77000R083V**	3	–	–	DFT06T3.	11	3.77000R284V	1	SPHX1204.	1
3.76230R160	230	9.060	240	9.450	B510S30.	**3.77000R079V**	2	**3.77000R080V**	1	DFT06T3.	11	3.77000R280V	1	SPHX1204.	1
3.76260R160 *	260	10.240	270	10.630	B510S30.	–	2	–	1	DFT06T3.	11	3.77000R078V	1	SPHX1204.	1

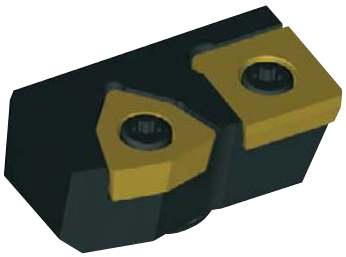
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
n: number of cartridges required by head.
ni: number of inserts required by head.



HTS Interior and Exterior Cartridges • DFT™ Inserts



catalog 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




catalog 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.

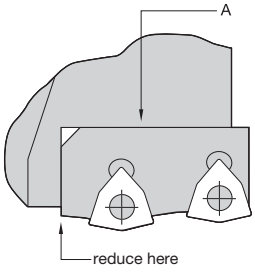
HTS Finishing Exterior Cartridges • SPHX Inserts

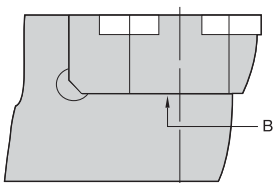


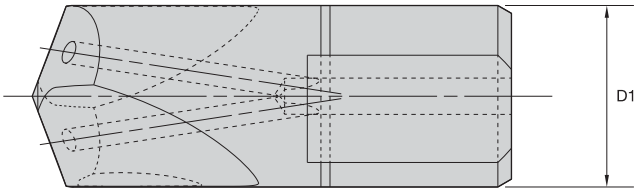


catalog number	gage insert inside	number of inserts	gage insert outside	number of inserts	insert screw	screw	washer	Nm	ft. lbs.
3.77000R224V	DFT05T3..	2	SPHX0903..	1	**191.924**	**193.451**	**192.903**	5,0	3.69
3.77000R227V	DFT05T3..	2	SPHX0903..	1	**191.924**	**192.593**	**192.903**	5,0	3.69
3.77000R229V	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

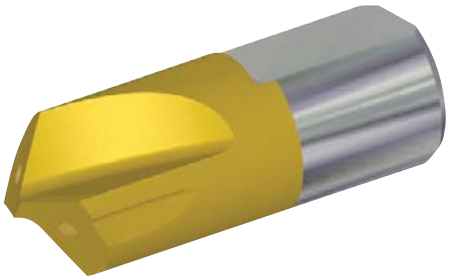
- Change drill diameter by shortening the outer cartridge.
- Shorten at 90° to the contact face A and the support face B.
- Shortening reduces the effective drill diameter by two times the amount removed.



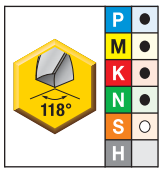


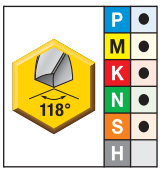


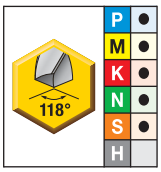
8–10mm sizes are without coolant.



HTS DFT™ • Pilot Drills

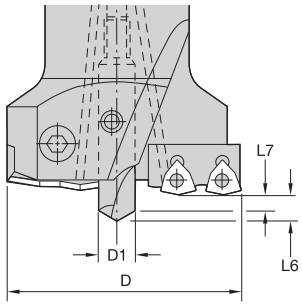






● first choice
○ alternate choice

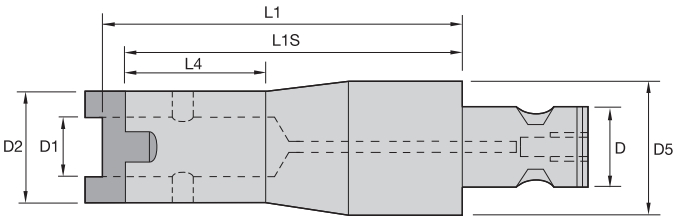
high-speed steel uncoated	high-speed steel coated	carbide drills	D1	
A30	AS3	KC7315	mm	in
B510S08000 A30	**B510S08000 AS3**	**B511S08000 KC7315**	8,00	0.315
B510S10000 A30	**B510S10000 AS3**	**B511S10000 KC7315**	10,00	0.394
B510S15000 A30	**B510S15000 AS3**	**B511S15000 KC7315**	15,00	0.591
B510S20000 A30	**B510S20000 AS3**	**B511S20000 KC7315**	20,00	0.787
B510S25000 A30	**B510S25000 AS3**	**B511S25000 KC7315**	25,00	0.984
B510S30000 A30	**B510S30000 AS3**	**B511S30000 KC7315**	30,00	1.181

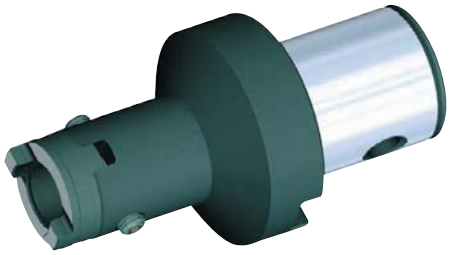


Pilot Drill Setting Lengths

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.



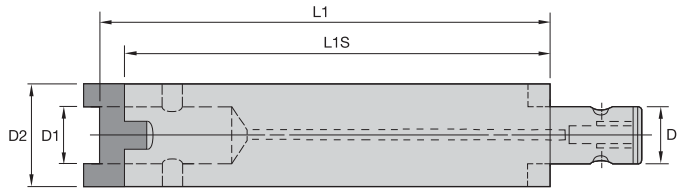


Reducers

			D2		D5		L1		L1S		L4					
catalog number	D1 coupling size	D coupling size	mm	in	mm	in	mm	in	mm	in	mm	in	drive ring	clamping screw	Nm	ft. lbs.
5.34280R028080	13B	50	27,6	1.09	80,0	3.15	90,0	3.54	80,0	3.15	50,0	1.97	**192.419**	**192.156**	10,2	7.5
5.34280R032080	16	50	31,6	1.24	80,0	3.15	90,0	3.54	80,0	3.15	55,0	2.17	**192.420**	**192.156**	10,2	7.5
5.34280R040080	22	50	39,6	1.56	80,0	3.15	92,0	3.62	80,0	3.15	57,0	2.24	**192.421**	**192.157**	16,3	12.0
5.34280R048080	27	50	47,6	1.87	80,0	3.15	92,0	3.62	80,0	3.15	57,0	2.24	**192.422**	**191.727**	20,3	15.0
5.34280R058080	32	50	57,6	2.27	80,0	3.15	93,9	3.70	80,0	3.15	58,9	2.32	**192.423**	**191.727**	20,3	15.0
5.34240R032100	16	22	31,6	1.24	40,0	1.57	110,0	4.33	100,0	3.94	55,0	2.17	**192.420**	**192.156**	10,2	7.5
5.34248R040100	22	27	39,6	1.56	48,0	1.89	112,0	4.41	100,0	3.94	57,0	2.24	**192.421**	**192.157**	16,3	12.0
5.34258R048100	27	32	47,6	1.87	58,0	2.28	112,0	4.41	100,0	3.94	57,0	2.24	**192.422**	**191.727**	20,3	15.0
5.34270R058100	32	40	57,6	2.27	70,0	2.76	113,9	4.48	100,0	3.94	58,9	2.32	**192.423**	**191.727**	20,3	15.0
5.34280R070150	40	50	69,6	2.74	80,0	3.15	163,9	6.45	150,0	5.91	68,9	2.71	**192.424**	**191.728**	33,9	25.0

NOTE: Assemble components using recommended torque values.

- Extensions are shipped with drive ring and clamping screws.





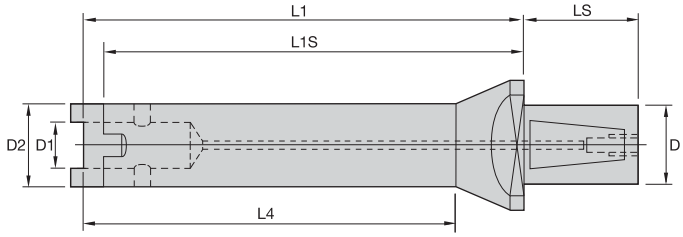
Extensions

			D2		L1		L1S					
catalog number	D1 coupling size	D coupling size	mm	in	mm	in	mm	in	drive ring	clamping screw	Nm	ft. lbs.
5.34132R032100	16	16	32,0	1.26	110,0	4.33	100,0	3.94	**192.420**	**192.156**	10,2	7.5
5.34125R025150	13A	13A	25,0	0.98	160,0	6.30	150,0	5.91	**193.371**	**193.372**	10,2	7.5
5.34128R028150	13B	13B	28,0	1.10	160,0	6.30	150,0	5.91	**192.419**	**192.156**	10,2	7.5
5.34170R070186	40	40	70,0	2.76	200,0	7.87	186,0	7.32	**192.424**	**191.728**	33,9	25.0
5.34132R032200	16	16	32,0	1.26	210,0	8.27	200,0	7.87	**192.420**	**192.156**	10,2	7.5
5.34140R040200	22	22	40,0	1.57	212,0	8.35	200,0	7.87	**192.421**	**192.157**	16,3	12.0
5.34148R048200	27	27	48,0	1.89	212,0	8.35	200,0	7.87	**192.422**	**191.727**	20,3	15.0
5.34180R080204	50	50	80,0	3.15	220,0	8.66	204,0	8.03	**192.425**	**191.728**	33,9	25.0
5.34158R058300	32	32	58,0	2.28	314,0	12.36	300,0	11.81	**192.423**	**191.727**	33,9	25.0
5.34170R070300	40	40	70,0	2.76	314,0	12.36	300,0	11.81	**192.424**	**191.728**	33,9	25.0
5.34180R080300	50	50	80,0	3.15	316,0	12.44	300,0	11.81	**192.425**	**191.728**	33,9	25.0
5.34170R070500	40	40	70,0	2.76	514,0	20.24	500,0	19.69	**192.424**	**191.728**	33,9	25.0
5.34180R080500	50	50	80,0	3.15	516,0	20.32	500,0	19.69	**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

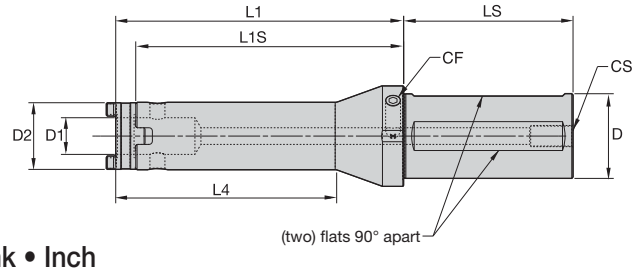




catalog number	D1 coupling size	D	D2	L1	L1S	L4	LS	drive ring	clamping screw	Nm
5.34032-025115	13A	32,0	25,0	125,0	115,0	110,0	58,0	**193.371**	**193.372**	10,2
5.34032-028115	13B	32,0	28,0	125,0	115,0	110,0	58,0	**192.419**	**192.156**	10,2
5.34032-032125	16	32,0	32,0	135,0	125,0	120,0	58,0	**192.420**	**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.





Flanged Shank • Inch




catalog number	D1 coupling size	D	D2	L1	L1S	L4	LS	drive ring	clamping screw	ft. lbs.
SSF150HTS130239 *	13A	1.50	0.98	2.39	2.00	0.39	3.75	**193.371**	**193.372**	7.5
SSF150HTS130450	13A	1.50	0.98	4.50	4.11	2.50	3.75	**193.371**	**193.372**	7.5
SSF150HTS130664	13A	1.50	0.98	6.64	6.25	4.65	3.75	**193.371**	**193.372**	7.5
SSF150HTS131114	13A	1.50	0.98	11.14	10.75	9.14	3.75	**193.371**	**193.372**	7.5
SSF150HTS131764	13A	1.50	0.98	17.64	17.25	15.64	3.75	**193.371**	**193.372**	7.5
SSF200HTS130239	13B	2.00	1.10	2.39	2.00	0.39	4.00	**192.419**	**192.156**	7.5
SSF200HTS130450 *	13B	2.00	1.10	4.50	4.11	2.50	4.00	**192.419**	**192.156**	7.5
SSF200HTS130664	13B	2.00	1.10	6.64	6.25	4.65	4.00	**192.419**	**192.156**	7.5
SSF200HTS131114	13B	2.00	1.10	11.14	10.75	9.14	4.00	**192.419**	**192.156**	7.5
SSF200HTS131764	13B	2.00	1.10	17.64	17.25	15.64	4.00	**192.419**	**192.156**	7.5
SSF200HTS160239	16	2.00	1.26	2.39	2.00	0.39	4.00	**192.420**	**192.156**	7.5
SSF200HTS160450 *	16	2.00	1.26	4.50	4.11	2.50	4.00	**192.420**	**192.156**	7.5
SSF200HTS160714	16	2.00	1.26	7.14	6.75	5.14	4.00	**192.420**	**192.156**	7.5
SSF200HTS161214	16	2.00	1.26	12.14	11.75	10.14	4.00	**192.420**	**192.156**	7.5
SSF200HTS161964	16	2.00	1.26	19.64	19.25	17.64	4.00	**192.420**	**192.156**	7.5
SSF200HTS220297	22	2.00	1.57	2.97	2.50	0.47	4.00	**192.421**	**192.157**	12.0
SSF200HTS220550	22	2.00	1.58	5.50	5.03	3.50	4.00	**192.421**	**192.157**	12.0
SSF200HTS220922	22	2.00	1.57	9.22	8.75	7.22	4.00	**192.421**	**192.157**	12.0
SSF200HTS221572	22	2.00	1.57	15.72	15.25	13.72	4.00	**192.421**	**192.157**	12.0
SSF200HTS222572	22	2.00	1.57	25.72	25.25	23.72	4.00	**192.421**	**192.157**	12.0
SSF200HTS270297	27	2.00	1.89	2.97	2.50	1.47	4.00	**192.422**	**191.727**	15.0
SSF200HTS270550	27	2.00	1.89	5.50	5.03	3.50	4.00	**192.422**	**191.727**	15.0
SSF200HTS271122	27	2.00	1.89	11.22	10.75	9.22	4.00	**192.422**	**191.727**	15.0
SSF200HTS271922	27	2.00	1.89	19.22	18.75	17.22	4.00	**192.422**	**191.727**	15.0
SSF200HTS273122	27	2.00	1.89	31.22	30.75	29.22	4.00	**192.422**	**191.727**	15.0
SSF200HTS320305 *	32	2.00	2.28	3.05	2.50	1.55	4.00	**192.423**	**191.727**	15.0
SSF200HTS320550	32	2.00	2.28	5.50	4.95	3.50	4.00	**192.423**	**191.727**	15.0
SSF200HTS320805	32	2.00	2.28	8.05	7.50	6.05	4.00	**192.423**	**191.727**	15.0
SSF200HTS321305	32	2.00	2.28	13.05	12.50	11.05	4.00	**192.423**	**191.727**	15.0
SSF200HTS321805	32	2.00	2.28	18.05	17.50	16.05	4.00	**192.423**	**191.727**	15.0
SSF250HTS400355	40	2.50	2.76	3.55	3.00	1.63	4.25	**192.424**	**191.728**	26.0
SSF250HTS400650 *	40	2.50	2.76	6.50	5.95	4.50	4.25	**192.424**	**191.728**	26.0
SSF250HTS401055	40	2.50	2.76	10.55	10.00	8.21	4.25	**192.424**	**191.728**	26.0
SSF250HTS401555	40	2.50	2.76	15.55	15.00	13.21	4.25	**192.424**	**191.728**	26.0
SSF250HTS402555	40	2.50	2.76	25.55	25.00	23.21	4.25	**192.424**	**191.728**	26.0
SSF300HTS500413 *	50	3.00	3.15	4.13	3.50	1.87	4.50	**192.425**	**191.728**	26.0
SSF300HTS500700 *	50	3.00	3.15	7.00	6.37	5.00	4.50	**192.425**	**191.728**	26.0
SSF300HTS501313	50	3.00	3.15	13.13	12.50	10.55	4.50	**192.425**	**191.728**	26.0
SSF300HTS502113	50	3.00	3.15	21.13	20.50	18.55	4.50	**192.425**	**191.728**	26.0
SSF300HTS503113	50	3.00	3.15	31.13	30.50	28.55	4.50	**192.425**	**191.728**	26.0

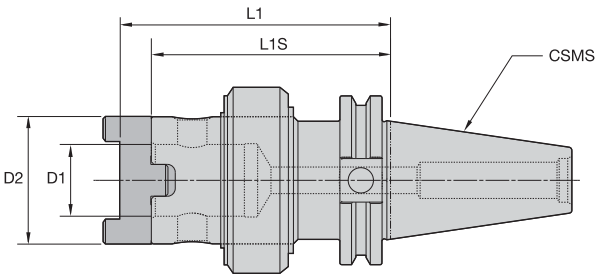
NOTE: Assemble components using recommended torque values.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.



D	CF	CS	side pipe plug
1.500	1/8-27 NPT	1/4-18 NPT	**HSFS0125**
2.000	1/8-27 NPT	1/4-18 NPT	**HSFS0125**
2.500	1/8-27 NPT	1/4-18 NPT	**HSFS0125**
3.000	1/8-27 NPT	1/4-18 NPT	**HSFS0125**

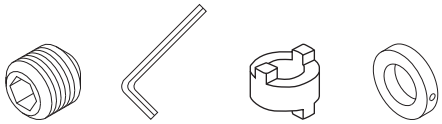
- Shanks are shipped with drive ring and clamping screws.







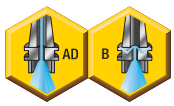
CV Taper Shank • Form AD • Rotary Coolant Ring

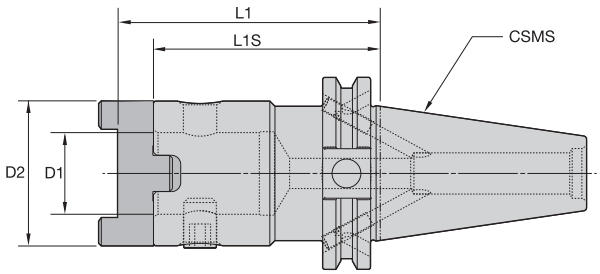


catalog number	CSMS system size	D1 coupling size	D2	L1	L1S	clamping screw	hex wrench	drive ring	coolant ring	ft. lbs.
CV50RMHTS13M394	CV50	13B	1.09	4.33	3.94	**192.156**	**170.004**	**192.419**	**302.011**	7.5
CV50RMHTS16M394	CV50	16	1.25	4.33	3.94	**192.156**	**170.004**	**192.420**	**302.011**	7.5
CV50RMHTS22M394	CV50	22	1.54	4.41	3.94	**192.157**	**170.004**	**192.421**	**302.011**	12.0
CV50RMHTS27M394	CV50	27	1.88	4.41	3.94	**191.727**	**170.006**	**192.422**	**302.011**	15.0
CV50RMHTS32M394 *	CV50	32	2.27	4.49	3.94	**191.727**	**170.006**	**192.423**	**302.011**	15.0
CV50RMHTS40M413	CV50	40	2.74	4.69	4.13	**191.728**	**170.008**	**192.424**	**302.009**	26.0
CV50RMHTS50M413	CV50	50	3.13	4.76	4.13	**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.

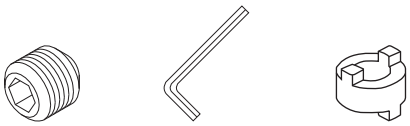
- Shanks are shipped with drive ring and clamping screws.







CV Taper Shank • Form B/AD Coolant

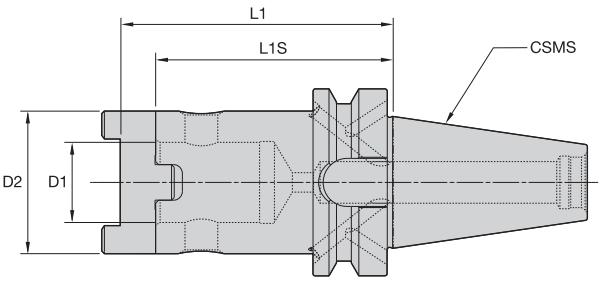


catalog number	CSMS system size	D1 coupling size	D2	L1	L1S	clamping screw	hex wrench	drive ring	ft. lbs.
CV50BHTS13M295	CV50	13B	1.10	3.35	2.95	**192.156**	**170.004**	**192.419**	7.5
CV50BHTS16M295	CV50	16	1.26	3.35	2.95	**192.156**	**170.004**	**192.420**	7.5
CV50BHTS22M295	CV50	22	1.57	3.43	2.95	**192.157**	**170.004**	**192.421**	12.0
CV50BHTS27M295	CV50	27	1.89	3.43	2.95	**191.727**	**170.006**	**192.422**	15.0
CV50BHTS32M314	CV50	32	2.28	3.70	3.15	**191.727**	**170.006**	**192.423**	15.0
CV50BHTS40M314	CV50	40	2.76	3.70	3.15	**191.728**	**170.008**	**192.424**	26.0
CV50BHTS50M314	CV50	50	3.15	3.78	3.15	**191.728**	**170.008**	**192.425**	26.0

NOTE: Assemble components using recommended torque values.

- Shanks are shipped with drive ring and clamping screw.





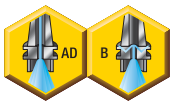


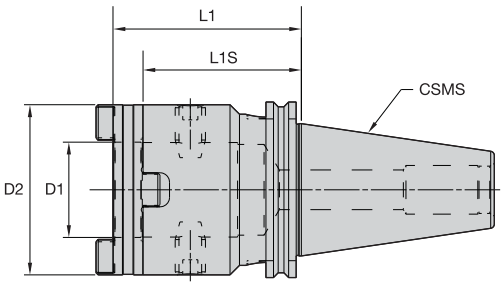
BT Taper Shank • Form B/AD Coolant

catalog number	CSMS system size	D1 coupling size	D2	L1 mm	L1 in	L1S mm	L1S in	clamping screw	hex wrench	drive ring	Nm	ft. lbs.
BT50BHTS22075M	BT50	22	40,0	87,0	3.43	75,0	2.95	**192.157**	**170.005**	**192.421**	16,0	12.0
BT50BHTS32080M	BT50	32	58,0	94,0	3.70	80,0	3.15	**MS1276**	**170.006**	**192.423**	20,0	15.0
BT50BHTS40080M	BT50	40	70,0	94,0	3.70	80,0	3.15	**191.728**	**170.008**	**192.424**	34,0	26.0
BT50BHTS50080M	BT50	50	80,0	96,0	3.78	80,0	3.15	**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.



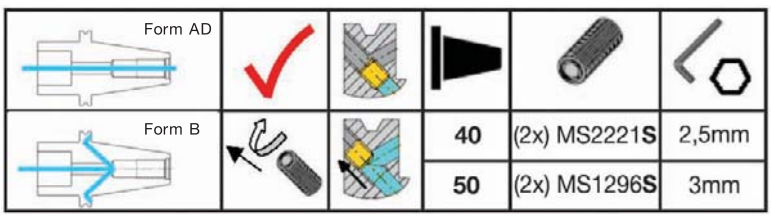




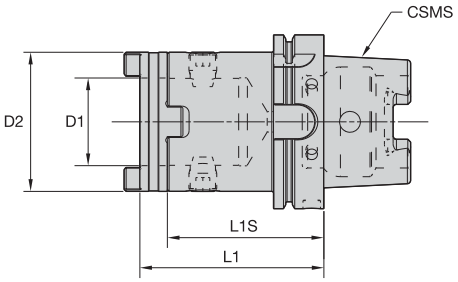
DV Taper Shank • Form B/AD Coolant

catalog number	CSMS system size	D1 coupling size	D2	L1 mm	L1 in	L1S mm	L1S in	clamping screw	hex wrench	drive ring
5.36050-154040	DV50	40	70,0	100,0	3.94	84,0	3.31	**191.728**	**170.008**	**192.424**
5.36050-154050	DV50	50	90,0	100,0	3.94	84,0	3.31	**191.729**	**170.008**	**192.426**

NOTE: Assemble components using recommended torque values.

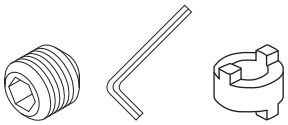


- Shanks are shipped with drive ring and clamping screw.





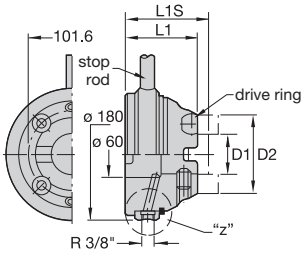
HSK100A Taper Shank

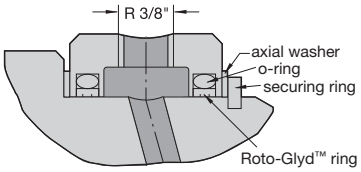


catalog number	CSMS system size	D1 coupling size	D2 mm	D2 in	L1 mm	L1 in	L1S mm	L1S in	clamping screw	hex wrench	drive ring	Nm	ft. lbs.
HSK100AHTS40085M	HSK100A	40	70,0	2.8	99,0	3.9	85,0	3.3	**191.728**	**170.008**	**192.424**	35,0	25.0
HSK100AHTS50090M	HSK100A	50	80,0	3.1	106,0	4.2	90,0	3.5	**191.728**	**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 Adapter (Including Drive Ring)

catalog number	D1	D2 mm	D2 in	L1 mm	L1 in	L1S mm	L1S in	kg	lbs
5.34350-090100	50,00	90,0	3.54	116,0	4.57	100,0	3.94	10,0	21.94

NOTE: Adapter 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



catalog number	drive ring	clamping screw	coolant ring	O-ring	securing ring	axial washer	ROTO-GLYD ring	stop bar	nipple
5.34350-090100	**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

HTS DFT™ • Inch

Inch												
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (f) by Diameter			
						min	Starting Value	max	Ø	DFT03... 1.77–2.17"	DFT05... 2.17–3.07"	DFT06... 3.07–5.51"	DFT07... 5.51–10.63"
P	1	S	O	MD	KCU25	309	**623**	750	IPR	.002–.004	.003–.005	.004–.006	.005–.007
			I	MD	KCU40								
		U	O	MD	KCU40	231	**427**	561	IPR	.002–.004	.003–.005	.004–.006	.005–.007
			I	MD	KC7140								
		I	O	MD	KCU40	143	**262**	348	IPR	.002–.004	.003–.005	.004–.006	.005–.007
			I	MD	KC7140								
	2	S	O	HP	KCU25	309	**591**	750	IPR	.004–.006	.005–.007	.005–.007	.005–.008
			I	HP	KCU40								
		U	O	HP	KCU40	231	**394**	561	IPR	.004–.006	.005–.007	.005–.007	.005–.008
			I	HP	KC7140								
		I	O	HP	KCU40	143	**230**	348	IPR	.004–.006	.005–.007	.005–.007	.005–.008
			I	HP	KC7140								
	3	S	O	HP	KCU25	229	**459**	555	IPR	.004–.006	.005–.007	.005–.007	.005–.008
			I	HP	KCU40								
		U	O	HP	KCU40	163	**328**	396	IPR	.004–.006	.005–.007	.005–.007	.005–.008
			I	HP	KC7140								
		I	O	HP	KCU40	98	**197**	238	IPR	.004–.006	.005–.007	.005–.007	.005–.008
			I	HP	KC7140								
	4	S	O	HP	KCU25	309	**394**	750	IPR	.004–.006	.005–.007	.005–.007	.005–.008
			I	HP	KCU40								
		U	O	HP	KCU40	231	**328**	561	IPR	.004–.006	.005–.007	.005–.007	.005–.008
			I	HP	KC7140								
		I	O	HP	KCU40	143	**262**	348	IPR	.004–.006	.005–.007	.005–.007	.005–.008
			I	HP	KC7140								
	5	S	O	HP	KCU25	257	**328**	622	IPR	.002–.003	.002–.003	.002–.004	.003–.005
			I	HP	KCU40								
		U	O	HP	KCU40	154	**197**	373	IPR	.002–.003	.002–.003	.002–.004	.003–.005
			I	HP	KC7140								
		I	O	HP	KCU40	103	**131**	250	IPR	.002–.003	.002–.003	.002–.004	.003–.005
			I	HP	KC7140								
	6	S	O	HP	KCU25	244	**312**	591	IPR	.002–.003	.002–.003	.002–.004	.003–.005
			I	HP	KCU40								
		U	O	HP	KCU40	146	**187**	355	IPR	.002–.003	.002–.003	.002–.004	.003–.005
			I	HP	KC7140								
		I	O	HP	KCU40	98	**125**	238	IPR	.002–.003	.002–.003	.002–.004	.003–.005
			I	HP	KC7140								
M	1	S	O	MD	KCU25	159	**361**	439	IPR	.003–.004	.005–.007	.006–.008	.006–.009
			I	MD	KCU40								
		U	O	MD	KCU40	101	**230**	281	IPR	.003–.004	.005–.007	.006–.008	.006–.009
			I	MD	KC7140								
		I	O	MD	KC7140	72	**164**	199	IPR	.003–.004	.005–.007	.006–.008	.006–.009
			I	MD	KC7140								
	2	S	O	MD	KCU25	159	**325**	439	IPR	.003–.004	.005–.007	.006–.008	.006–.009
			I	MD	KCU40								
		U	O	MD	KCU40	101	**207**	281	IPR	.003–.004	.005–.007	.006–.008	.006–.009
			I	MD	KC7140								
		I	O	MD	KC7140	72	**148**	199	IPR	.003–.004	.005–.007	.006–.008	.006–.009
			I	MD	KC7140								
	3	S	O	MD	KCU25	159	**289**	439	IPR	.003–.004	.005–.007	.006–.008	.006–.009
			I	MD	KCU40								
		U	O	MD	KCU40	101	**184**	281	IPR	.003–.004	.005–.007	.006–.008	.006–.009
			I	MD	KC7140								
		I	O	MD	KC7140	72	**131**	199	IPR	.003–.004	.005–.007	.006–.008	.006–.009
			I	MD	KC7140								

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

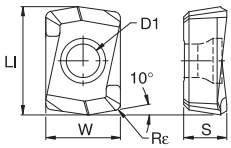
HTS DFT™ • Inch

Inch													
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (f) by Diameter				
						min	Starting Value	max	Ø	DFT03... 1.77–2.17"	DFT05... 2.17–3.07"	DFT06... 3.07–5.51"	DFT07... 5.51–10.63"
K	1	S	O	HP	KCPK10	309	**561**	750	IPR	.004–.008	.005–.011	.006–.012	.007–.013
			I	HP	KCPK10								
		U	O	HP	KCU25	211	**384**	510	IPR	.004–.008	.005–.011	.006–.012	.007–.013
			I	HP	KCU25								
		I	O	HP	KCU40	131	**236**	316	IPR	.004–.008	.005–.011	.006–.012	.007 –.013
			I	HP	KCU40								
	2	S	O	HP	KCPK10	309	**533**	750	IPR	.004–.008	.005–.011	.006–.012	.007 –.013
			I	HP	KCPK10								
		U	O	HP	KCU25	211	**365**	510	IPR	.004–.008	.005–.011	.006–.012	.007 –.013
			I	HP	KCU25								
		I	O	HP	KCU40	131	**224**	316	IPR	.004–.008	.005–.011	.006–.012	.007 –.013
			I	HP	KCU40								
	3	S	O	HP	KCPK10	294	**480**	712	IPR	.004–.008	.005–.011	.006–.012	.007 –.013
			I	HP	KCPK10								
		U	O	HP	KCU25	195	**328**	473	IPR	.004–.008	.005–.011	.006–.012	.007 –.013
			I	HP	KCU25								
		I	O	HP	KCU40	113	**202**	274	IPR	.004–.008	.005–.011	.006–.012	.007 –.013
			I	HP	KCU40								
N	1	S	O	ST	KD1425	504	**787**	1176	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	ST	KD1425								
		U	O	HP	KC7140	336	**525**	784	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	HP	KC7140								
		I	O	HP	KC7140	218	**341**	510	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	HP	KC7140								
	2	S	O	ST	KD1425	504	**732**	1176	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	ST	KD1425								
		U	O	HP	KCU40	336	**488**	784	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	HP	KCU40								
		I	O	HP	KCU40	218	**317**	510	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	HP	KCU40								
	3	S	O	ST	KD1425	504	**677**	1176	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	ST	KD1425								
		U	O	HP	KCU40	336	**451**	784	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	HP	KCU40								
		I	O	HP	KCU40	218	**293**	510	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	HP	KCU40								
	4	S	O	ST	KD1425	504	**732**	1176	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	ST	KD1425								
		U	O	LD	KC7140	336	**488**	784	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	LD	KC7140								
		I	O	LD	KC7140	218	**317**	510	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	LD	KC7140								
	5	S	O	ST	KD1425	368	**722**	858	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	ST	KD1425								
		U	O	HP	KC7140	235	**459**	549	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	HP	KC7140								
		I	O	HP	KC7140	151	**295**	351	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I	HP	KC7140								
S	1	S	O	HP	KC7140	80	**131**	160	IPR	.002–.003	.002–.003	.003–.004	.003–.004
			I	HP	KC7140								
		U	O	HP	KC7140	60	**98**	120	IPR	.002–.003	.002–.003	.003–.004	.003–.004
			I	HP	KC7140								
		I	O	HP	KC7140	50	**82**	100	IPR	.002–.003	.002–.003	.003–.004	.003–.004
			I	HP	KC7140								
	2	S	O	HP	KC7140	82	**115**	158	IPR	.002–.003	.002–.003	.003–.004	.003–.004
			I	HP	KC7140								
		U	O	HP	KC7140	58	**82**	112	IPR	.002–.003	.002–.003	.003–.004	.003–.004
			I	HP	KC7140								
		I	O	HP	KC7140	46	**66**	90	IPR	.002–.003	.002–.003	.003–.004	.003–.004
			I	HP	KC7140								

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert



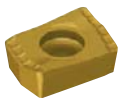


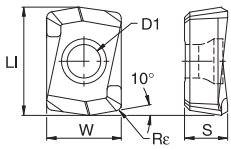
● first choice
○ alternate choice

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

DFR-GD

	LI		W		D1		S		Rε					
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	KCPK10	KCU25	KCU40	KC7140
DFR020204GD	7,12	.280	4,90	.193	2,30	.091	2,79	.110	0,40	.016	●	●	●	●
DFR030204GD	8,71	.343	6,00	.236	2,50	.098	2,88	.113	0,40	.016	●	●	●	●
DFR040304GD	10,76	.424	7,38	.291	2,85	.112	3,79	.149	0,40	.016	●	●	●	●



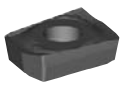


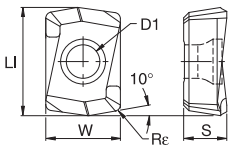
● first choice
○ alternate choice

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

DFR-MD

	LI		W		D1		S		Rε				
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	KCU25	KCU40	KC7140
DFR020204MD	7,12	.280	4,90	.193	2,30	.091	2,79	.110	0,40	.016	●	●	●
DFR030204MD	8,71	.343	6,00	.236	2,50	.098	2,88	.113	0,40	.016	●	●	●
DFR040304D28MD	10,76	.424	7,26	.286	2,85	.112	3,79	.149	0,40	.016	–	–	●
DFR040304MD	10,76	.424	7,38	.291	2,85	.112	3,79	.149	0,40	.016	●	●	●





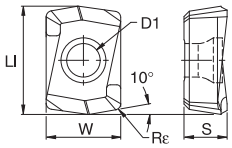
● first choice
○ alternate choice

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

DFR-LD

	LI		W		D1		S		Rε					
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	KCPK10	KCU25	KCU40	KC7140
DFR020204LD	7,12	.280	4,90	.193	2,30	.091	2,79	.110	0,40	.016	●	●	●	●
DFR030204LD	8,71	.343	6,00	.236	2,50	.098	2,86	.113	0,40	.016	●	●	●	●
DFR040304LD	10,76	.424	7,38	.291	2,85	.112	3,76	.148	0,40	.016	●	●	●	●



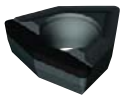


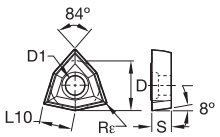
● first choice
○ alternate choice

P	
M	
K	
N	●
S	
H	

DFR • PCD • Single-Tipped

	LI		W		D1		S		Rε		KD1425
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	
DFR040304ST	10,50	.413	7,40	.291	2,85	.112	3,18	.125	0,40	.015	●





DFT • PCD • Single-Tipped

	L10		D		D1		S		Rε		KD1425
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	
DFT05T308ST	5,19	.205	8,00	.315	3,40	.134	3,75	.148	0,80	.031	●
DFT06T308ST	6,52	.257	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●
DFT070408ST	7,84	.309	12,00	.472	4,40	.173	4,75	.187	0,80	.031	●
DFT090508ST	9,83	.387	15,00	.591	5,50	.217	5,19	.204	0,80	.031	●
DFT110508ST	11,53	.454	17,60	.693	5,85	.230	4,81	.189	0,80	.031	●

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					

DFR™ • PCD • Inch

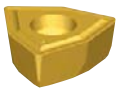
Inch										
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (fz) by Diameter	
						min	Starting Value	max	Ø	DFR04 .813–1.00"
N	1	S	O	ST	KD1425	1300	**2362**	2760	IPR	.002–.003
			I	ST	KD1425					
	2	S	O	ST	KD1425	1209	**2197**	2567	IPR	.005–.007
			I	ST	KD1425					
	3	S	O	ST	KD1425	1118	**2032**	2374	IPR	.005–.007
			I	ST	KD1425					
	4	S	O	ST	KD1425	1560	**2362**	2760	IPR	.005–.007
			I	ST	KD1425					
	5	S	O	ST	KD1425	1575	**2362**	2834	IPR	.002–.003
			I	ST	KD1425					

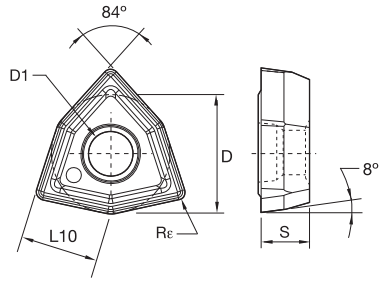
DFT™ • PCD • Metric

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										

DFT™ • PCD • Inch

Inch														
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (f) by Diameter					
						min	Starting Value	max	Ø	DFT03 .625–.969"	DFT05 .984–1.250"	DFT06 1.313–1.563"	DFT07 1.625–1.875"	DFT09 1.938–2.125"	DFT11 2.750–3.250"
N	1	S	O	ST/C	KD1425	1575	**2362**	2834	IPR	.002–.003	.003–.004	.004–.006	.005–.006	.006–.007	.006–.007
			I	ST/C	KD1425										
	2	S	O	ST/C	KD1425	1465	**2197**	2636	IPR	.002–.003	.003–.004	.004–.006	.005–.006	.006–.007	.006–.007
			I	ST/C	KD1425										
	3	S	O	ST/C	KD1425	1355	**2032**	2438	IPR	.002–.003	.003–.004	.004–.006	.005–.006	.006–.007	.006–.007
			I	ST/C	KD1425										
	4	S	O	ST/C	KD1425	1465	**2197**	2636	IPR	.002–.003	.003–.004	.004–.006	.005–.006	.006–.007	.006–.007
			I	ST/C	KD1425										
	5	S	O	ST/C	KD1425	1575	**2362**	2834	IPR	.002–.003	.003–.004	.004–.006	.005–.006	.006–.007	.006–.007
			I	ST/C	KD1425										





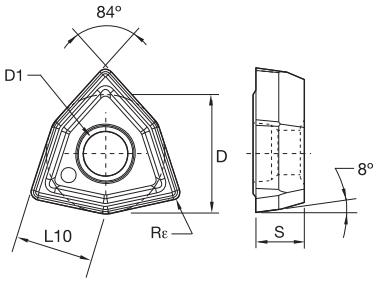
● first choice
○ alternate choice

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

DFT-GD

	L10		D		D1		S		Rε					
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	KCPK10	KCU25	KCU40	KC7140
DFT030204GD	3,97	.156	6,00	.236	2,25	.089	2,45	.096	0,40	.016	●	●	●	–
DFT030304GD	3,97	.156	6,00	.236	2,65	.104	2,95	.116	0,40	.016	●	●	●	●
DFT05T308GD	5,29	.208	8,00	.315	3,40	.134	3,75	.148	0,80	.031	●	●	●	●
DFT06T308GD	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●	●	●	●
DFT070408GD	7,94	.313	12,00	.472	4,40	.173	4,75	.187	0,80	.031	●	●	●	●
DFT090508GD	9,92	.391	15,00	.591	5,50	.217	5,25	.207	0,85	.034	●	●	●	●





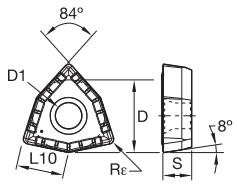
● first choice
○ alternate choice

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

DFT-HP

	L10		D		D1		S		Rε						
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	KCPK10	KCU25	KCU40	KC7140	KMF
DFTX20204HP	3,31	.130	5,00	.197	2,25	.089	2,45	.097	0,40	.015	–	●	●	●	–
DFT030204HP	3,97	.156	6,00	.236	2,25	.089	2,45	.096	0,40	.016	●	●	●	●	●
DFT030304HP	3,97	.156	6,00	.236	2,65	.104	2,95	.116	0,40	.016	●	●	●	●	●
DFT05T308HP	5,29	.208	8,00	.315	3,50	.137	3,75	.148	0,80	.031	●	●	●	●	●
DFT06T308HP	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●	●	●	●	●
DFT070408HP	7,94	.313	12,00	.472	4,40	.173	4,75	.187	0,80	.031	●	●	●	●	●
DFT090508HP	9,92	.391	15,00	.591	5,50	.217	5,25	.207	0,85	.033	●	●	●	●	●





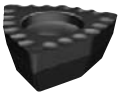
● first choice
○ alternate choice

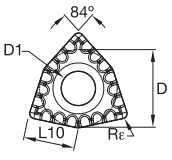
P	●	●	●	●	
M	○	○	○	●	
K	●	●	●	○	
N			○	○	
S			●	○	
H			○		

DFT-MD

	L10		D		D1		S		Rε				
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	KCU25	KCU40	KC7140
DFTX20204MD	3,31	.130	5,00	.197	2,25	.089	2,45	.097	0,40	.015	●	●	●
DFT030204MD	3,97	.156	6,00	.236	2,25	.089	2,45	.096	0,40	.016	●	●	●
DFT030304MD	3,97	.156	6,00	.236	2,65	.104	2,95	.116	0,40	.016	●	●	●
DFT05T308MD	5,29	.208	8,00	.315	3,40	.134	3,75	.148	0,80	.031	●	●	●
DFT06T308MD	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●	●	●
DFT070408MD	7,94	.313	12,00	.472	4,40	.173	4,75	.187	0,80	.031	●	●	●
DFT090508MD	9,92	.391	15,00	.591	5,50	.217	5,25	.207	0,80	.031	●	●	●
DFT110508MD	11,64	.458	17,60	.693	5,85	.230	4,88	.192	0,80	.031	–	–	●

- 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

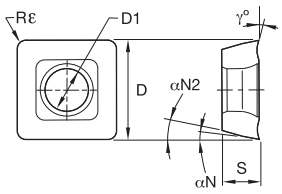
P	●
M	○
K	
N	○
S	○
H	

NEW!

DFT • DS

	L10		D		D1		S		Rε		KCU40
catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	
DFTX20204DS	3,31	.130	5,00	.197	2,25	.089	2,45	.097	0,40	.016	●
DFT030304DS	3,97	.156	6,00	.236	2,65	.104	2,95	.116	0,40	.016	●
DFT05T308DS	5,29	.208	8,00	.315	3,40	.134	3,75	.148	0,80	.031	●
DFT06T308DS	6,62	.260	10,00	.394	4,40	.173	3,75	.148	0,80	.031	●
DFT070408DS	7,94	.313	12,00	.472	4,40	.173	4,75	.187	0,80	.031	●
DFT090508DS	9,92	.391	15,00	.591	5,50	.217	5,25	.207	0,80	.031	●





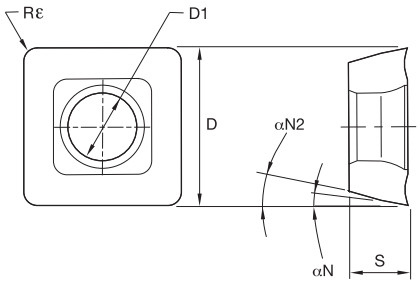
● first choice
○ alternate choice

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

SP..X..(R)HP

	D		D1		S		Rε					KCPK10	KCU25	KCU40	KC7140
catalog number	mm	in	mm	in	mm	in	mm	in	γ°	αN	αN2				
SPGX050204HP	5,56	.219	2,25	.089	2,38	.094	0,40	.016	10	7	11	–	●	●	●
SPGX060304RHP	6,35	.250	2,65	.104	3,18	.125	0,40	.016	10	7	11	–	●	●	●
SPGX070304RHP	7,94	.313	2,85	.112	3,18	.125	0,40	.016	10	7	11	–	●	●	●
SPGX070308HP	7,94	.313	2,85	.112	3,18	.125	0,80	.031	10	7	11	●	●	●	–
SPPX09T308RHP	9,53	.375	3,60	.142	3,97	.156	0,80	.031	10	7	11	–	●	●	●
SPPX09T310HP	9,53	.375	3,60	.142	3,97	.156	1,00	.039	10	7	11	●	●	●	–
SPPX120408RHP	12,70	.500	4,60	.181	4,76	.188	0,80	.031	10	7	11	–	●	●	●
SPPX120412HP	12,70	.500	4,60	.181	4,76	.188	1,20	.047	10	7	11	●	●	●	–
SPPX15T508RHP	15,73	.625	5,50	.234	5,95	.234	0,80	.031	10	7	11	–	●	●	●
SPPX15T512HP	15,73	.625	5,50	.217	5,95	.234	1,20	.047	10	7	11	●	●	●	–

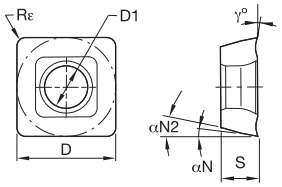




SP..X..MD

	D		D1		S		Rε					KCPK10	KCU25	KCU40	KC7140
catalog number	mm	in	mm	in	mm	in	mm	in	γ°	αN	αN2				
SPGX050204MD	5,56	.219	2,25	.089	2,38	.094	0,40	.016	16	7	11	–	●	●	●
SPGX060304MD	6,35	.250	2,65	.104	3,18	.125	0,40	.016	20	7	11	●	●	●	●
SPGX070304MD	7,94	.313	2,85	.112	3,18	.125	0,40	.016	16	7	11	●	●	●	●
SPGX070308MD	7,94	.313	2,85	.112	3,18	.125	0,80	.031	16	7	11	●	●	●	–
SPPX09T308MD	9,53	.375	3,60	.142	3,97	.156	0,80	.031	16	7	11	–	●	●	●
SPPX09T310MD	9,53	.375	3,60	.142	3,97	.156	1,00	.039	16	7	11	●	●	●	–
SPPX120408MD	12,70	.500	4,60	.181	4,76	.188	0,80	.031	16	7	11	–	●	●	●
SPPX120412MD	12,70	.500	4,60	.181	4,76	.188	1,20	.047	16	7	11	●	●	●	–
SPPX15T508MD	15,73	.625	5,50	.234	5,95	.234	0,80	.031	16	7	11	–	●	●	●
SPPX15T512MD	15,73	.625	5,50	.217	5,95	.234	1,20	.047	16	7	11	●	●	●	–





● first choice
○ alternate choice

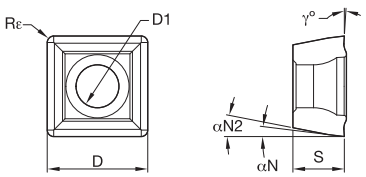
		KCPK10	KCU25	KCU40
P		●	●	●
M			○	●
K		●	●	●
N			○	○
S			○	●
H				

SP..X..FP

	D		D1		S		Rε							
catalog number	mm	in	mm	in	mm	in	mm	in	γ°	αN	αN2	KCPK10	KCU25	KCU40
SPGX060304FP	6,35	.250	2,85	.112	3,18	.125	0,40	.016	6	7	11	●	●	●
SPGX070304FP	7,94	.313	2,85	.112	3,18	.125	0,40	.016	6	7	11	●	●	●
SPGX070308FP	7,94	.313	2,85	.112	3,18	.125	0,80	.031	6	7	11	●	●	●
SPPX09T308FP	9,53	.375	3,60	.142	3,97	.156	0,80	.031	6	7	11	●	●	●
SPPX09T310FP	9,53	.375	3,60	.142	3,97	.156	1,00	.039	6	7	11	●	●	●
SPPX120408FP	12,70	.500	4,60	.181	4,76	.188	0,80	.031	6	7	11	●	●	●
SPPX120412FP	12,70	.500	4,60	.181	4,76	.188	1,20	.047	6	7	11	●	●	●
SPPX15T508FP	15,73	.625	5,50	.234	5,95	.234	0,80	.031	6	7	11	●	●	●
SPPX15T512FP	15,73	.625	5,50	.217	5,95	.234	1,20	.047	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.





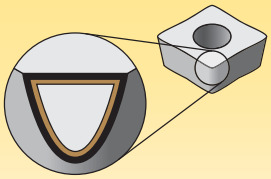
● first choice
○ alternate choice

		KCU40
P		●
M		○
K		
N		○
S		○
H		

NEW!

SP..X..LP

	D		D1		S		Rε					
catalog number	mm	in	mm	in	mm	in	mm	in	γ°	αN	αN2	KCU40
SPGX050204LP	5,42	.213	2,25	.089	2,38	.094	0,40	.016	4	7	11	●
SPGX060304LP	6,35	.250	2,65	.104	3,18	.125	0,40	.016	4	7	11	●
SPPX070304LP	7,80	.307	2,85	.112	3,18	.125	0,40	.016	4	7	11	●
SPPX09T308LP	9,38	.369	3,60	.142	3,97	.156	0,80	.031	4	7	11	●
SPPX120408LP	12,56	.494	4,60	.181	4,76	.187	0,80	.031	4	7	11	●

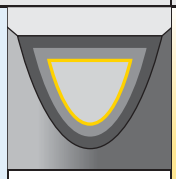
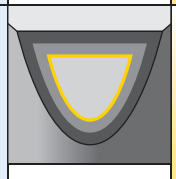
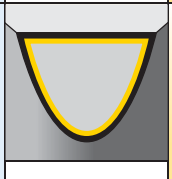


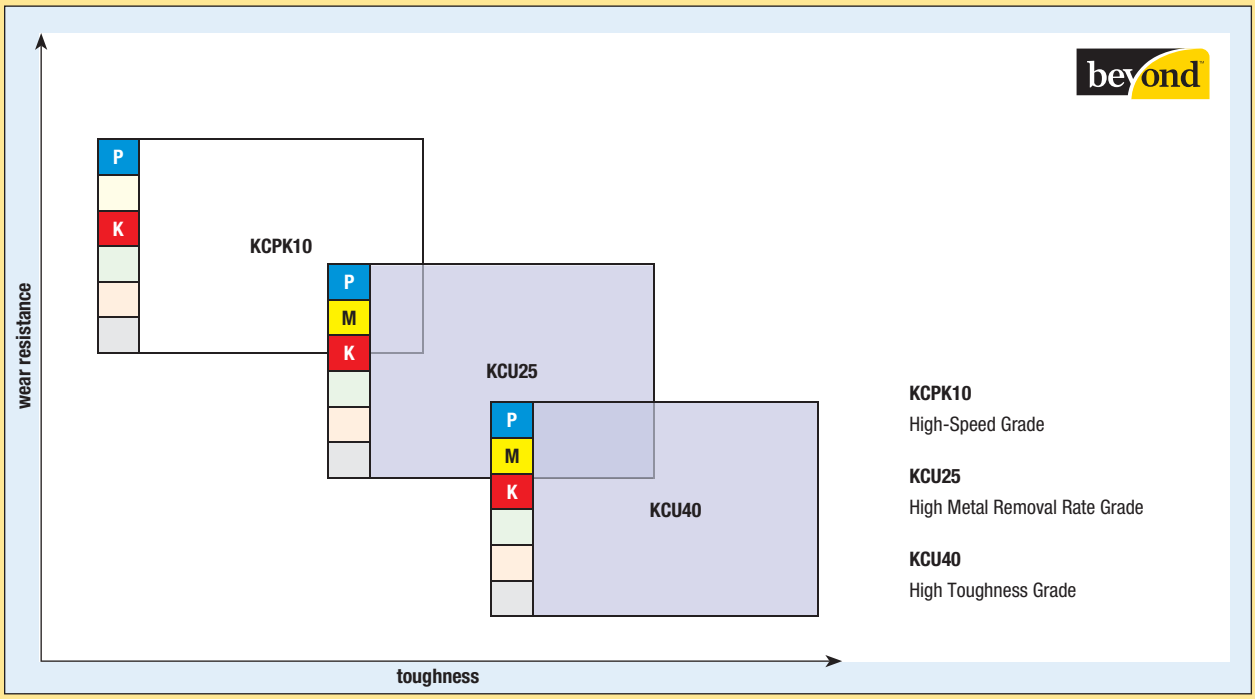
Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

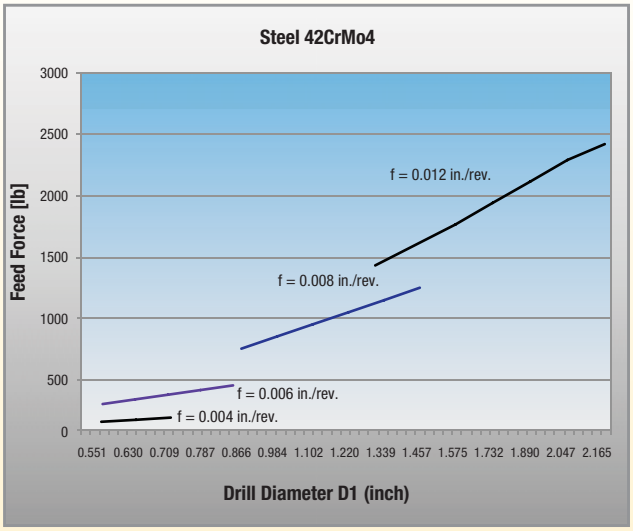
wear resistance ⟷ toughness

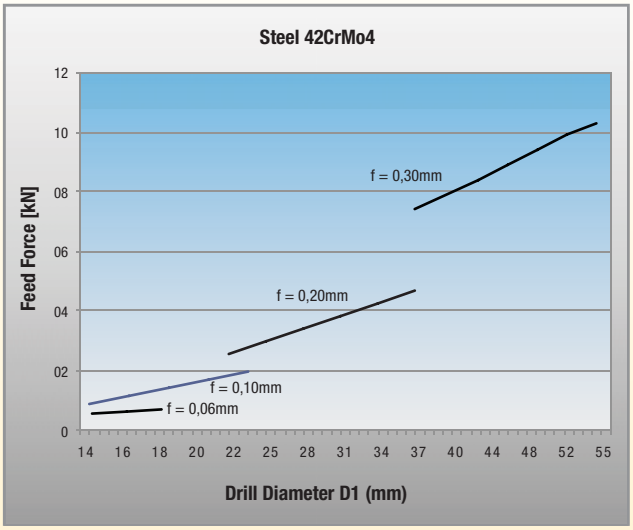
Grade

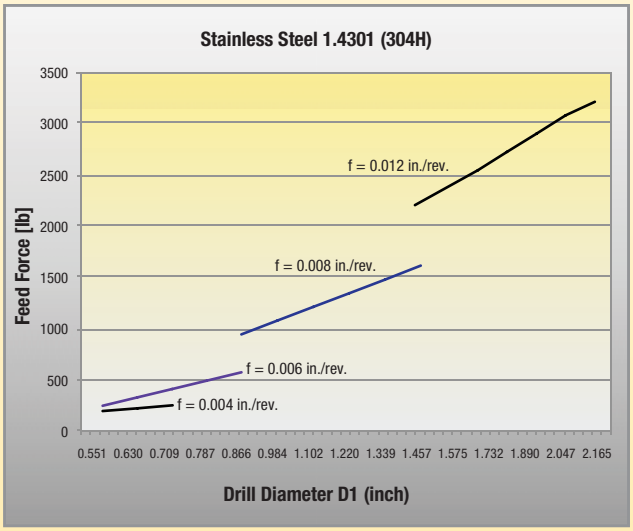
Coating	Grade Description	05	10	15	20	25	30	35	40	45
KCPK10  Al_2O_3 TiCN	**Composition:** With an advanced CVD TiCN-Al_2O_3 coating combined with a cobalt-enriched carbide substrate, this grade offers a balanced combination of deformation-resistance and edge toughness. **Application:** The KCPK10™ grade 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		
		M		M	M	M	M			
		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
		M				M	M	M	M	
		K			K	K	K	K		

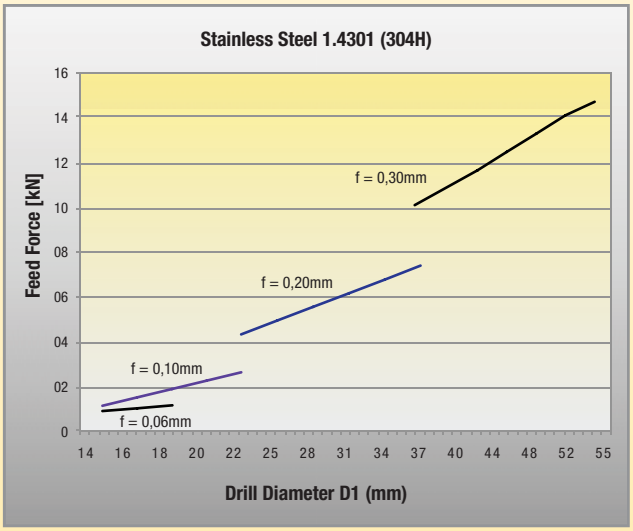


Feed Force Requirement

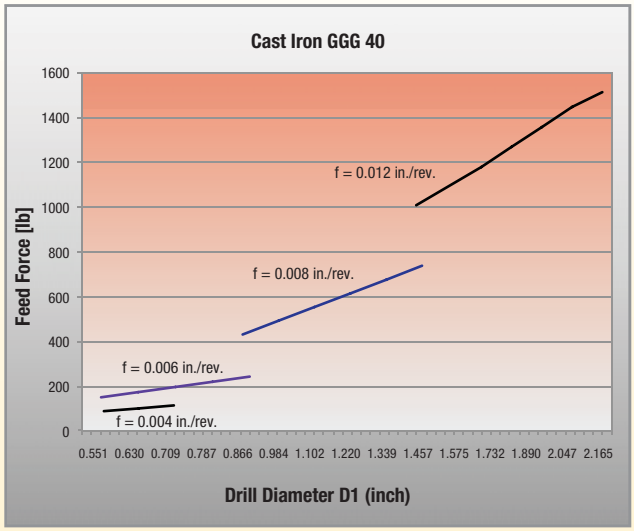


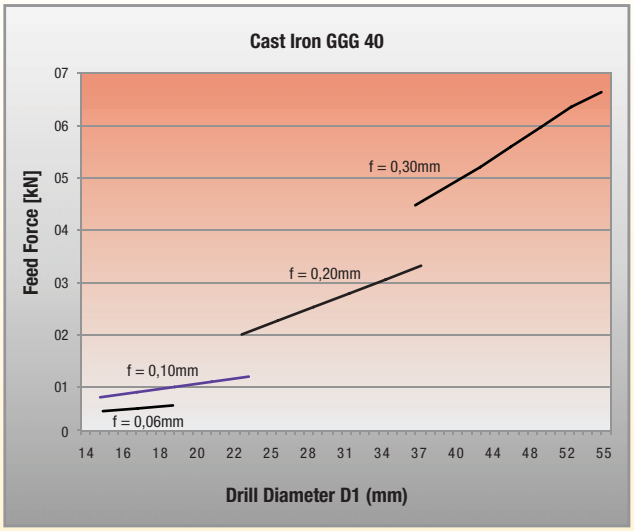


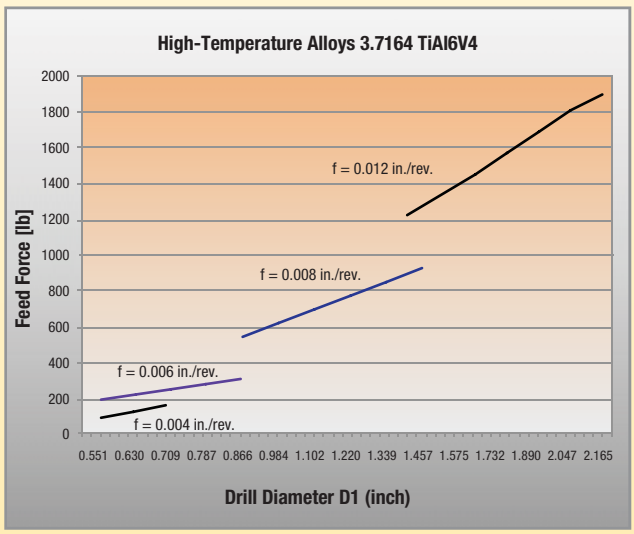


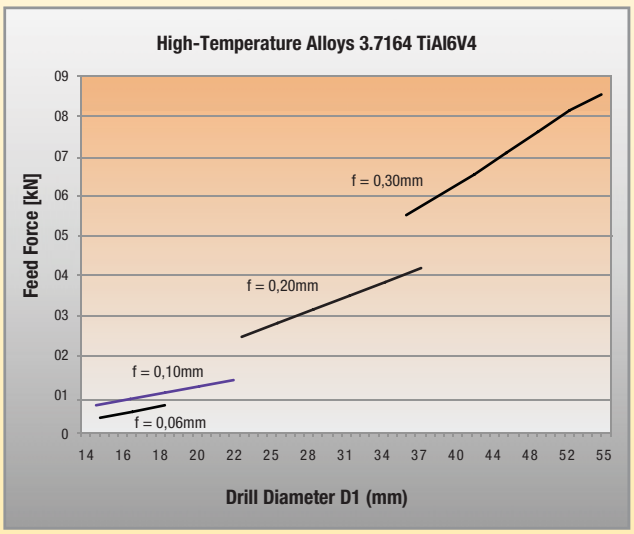


Feed Force Requirement

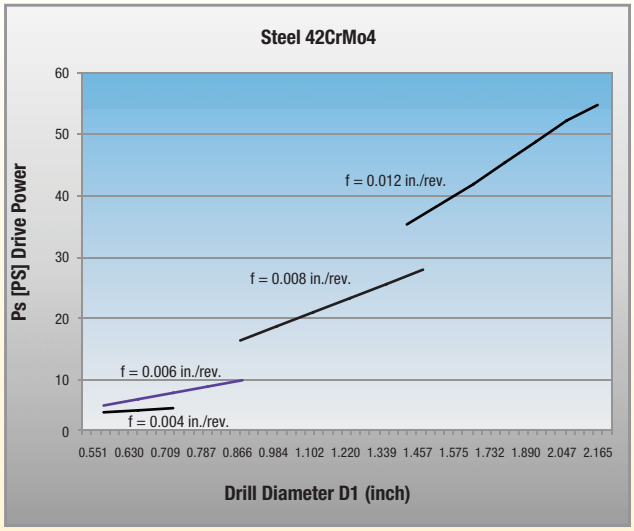


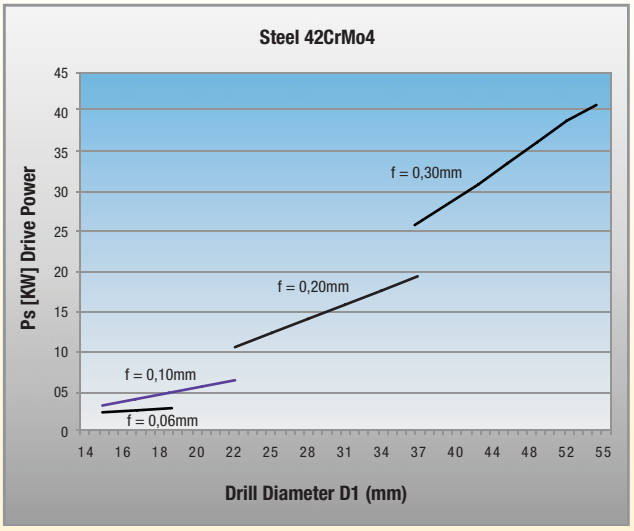


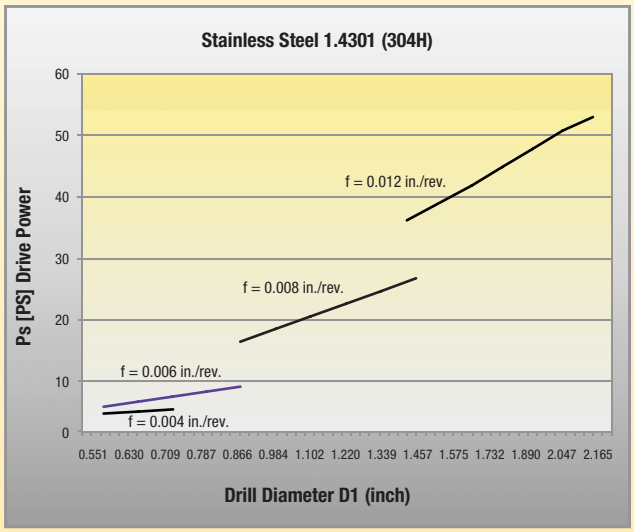


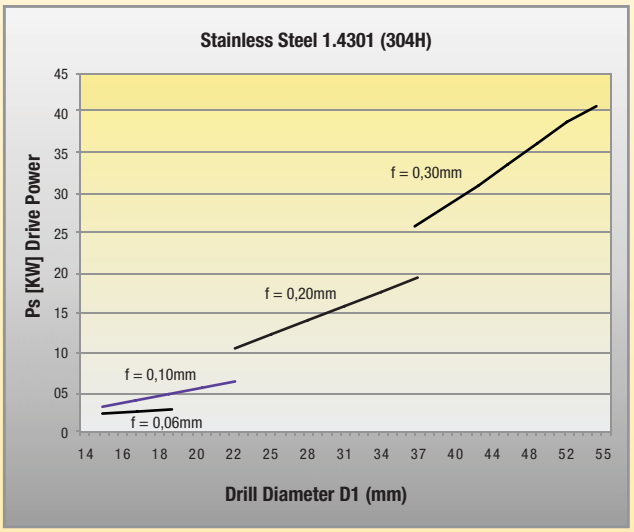


Power Recommendation

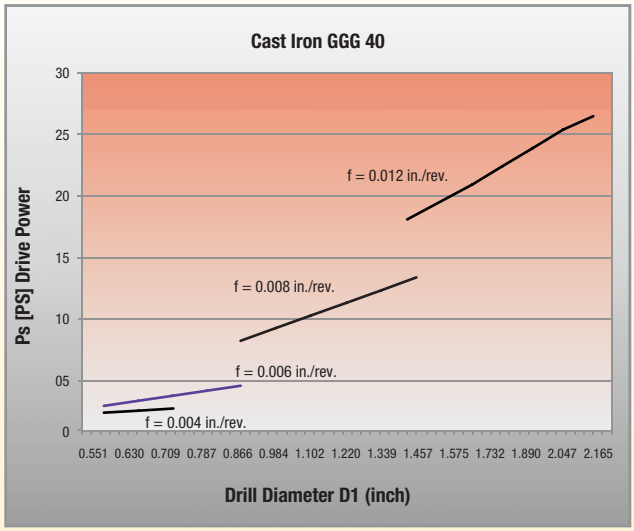


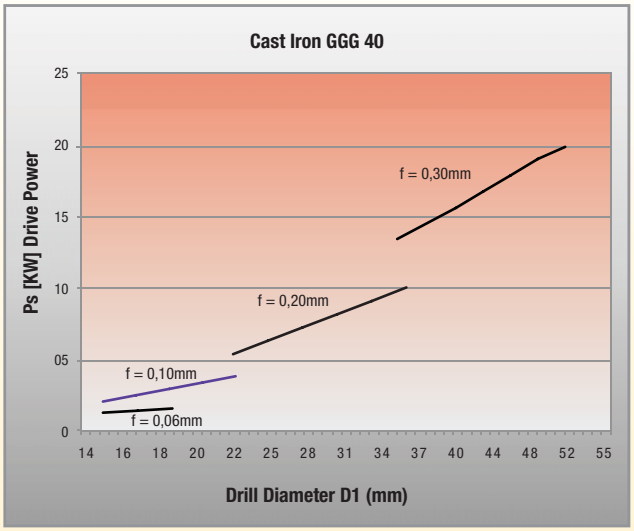


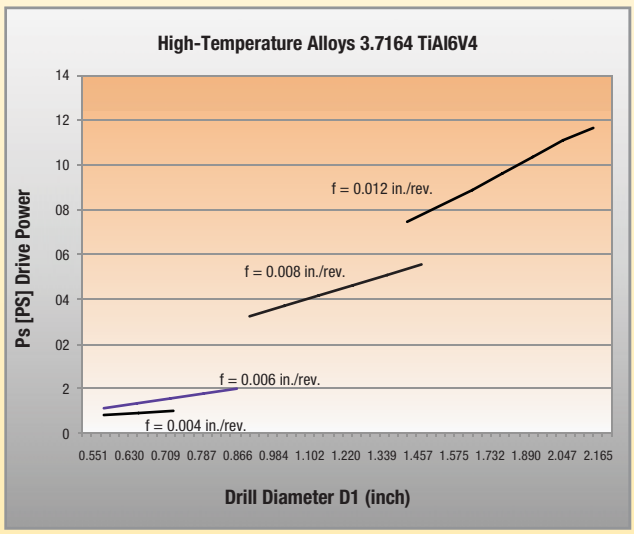


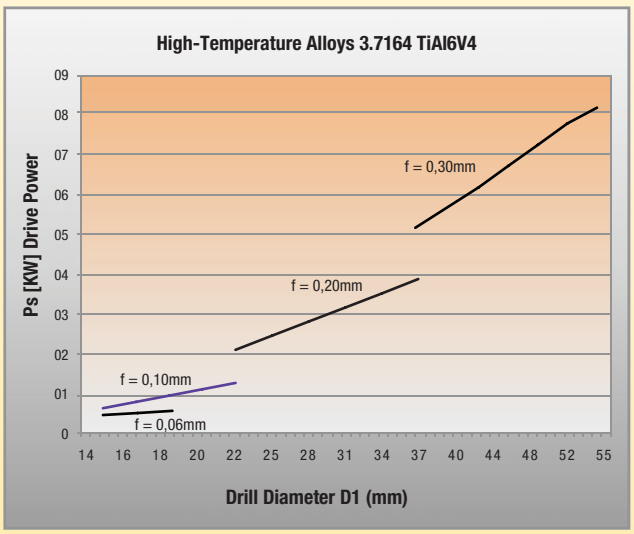


Power Recommendation

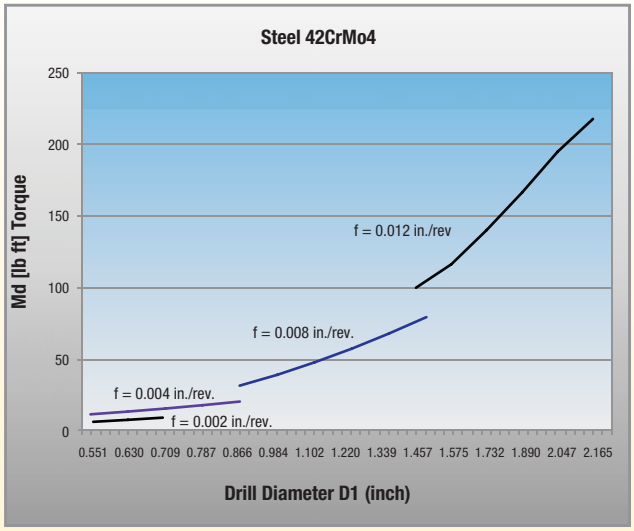


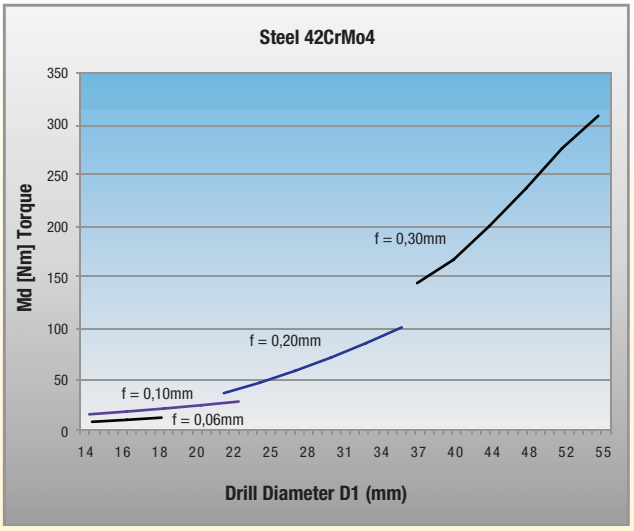


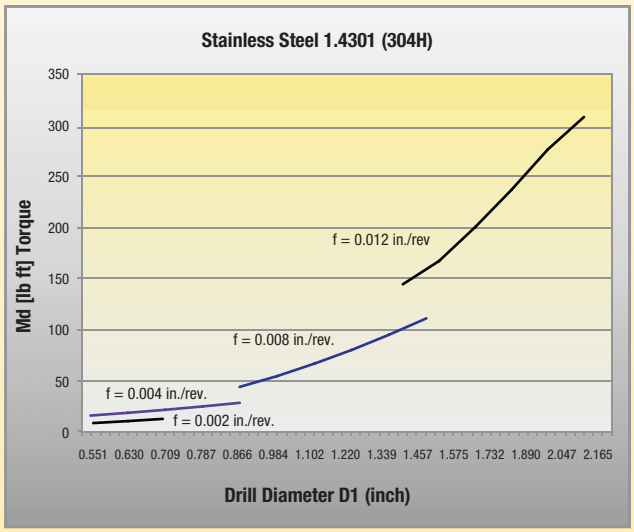


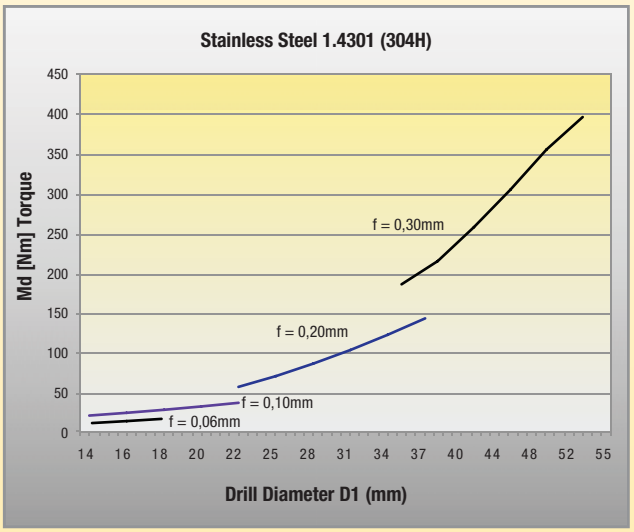


Torque Recommendation

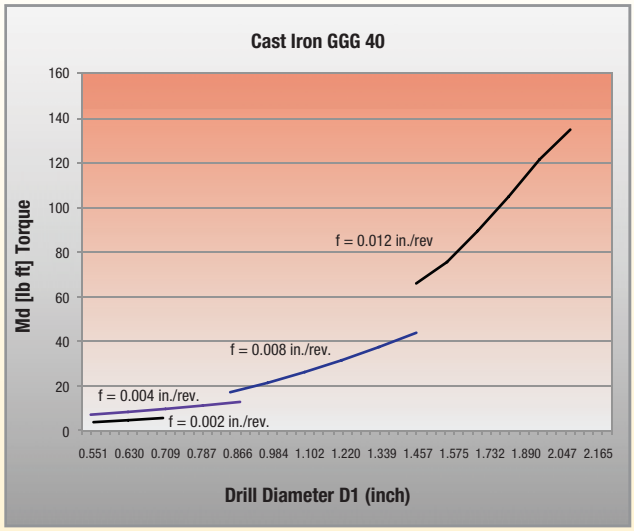


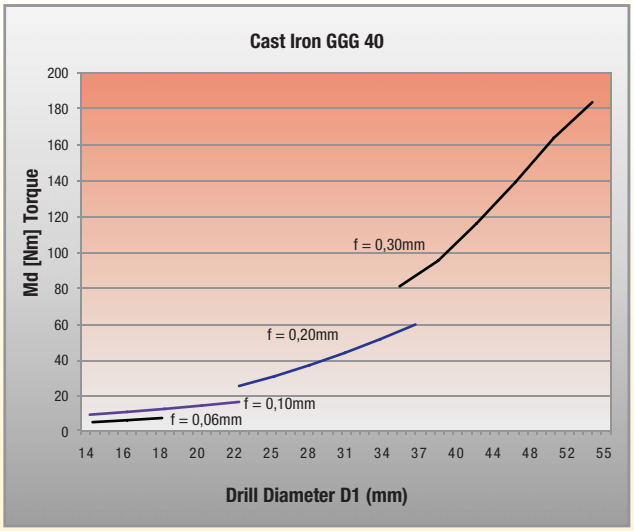


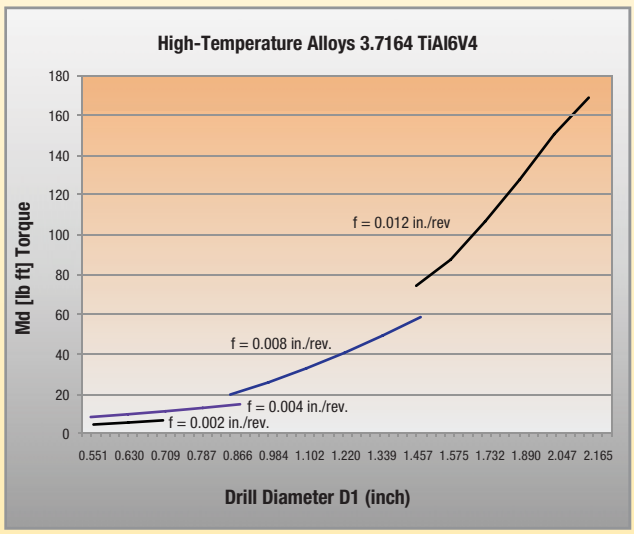


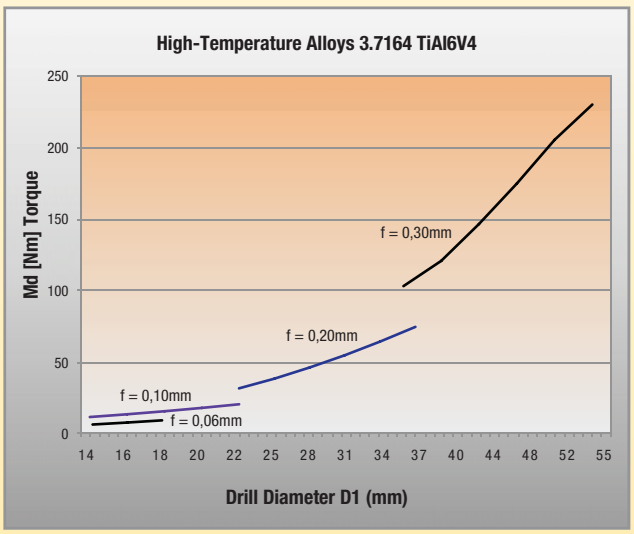


Torque Recommendation









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.

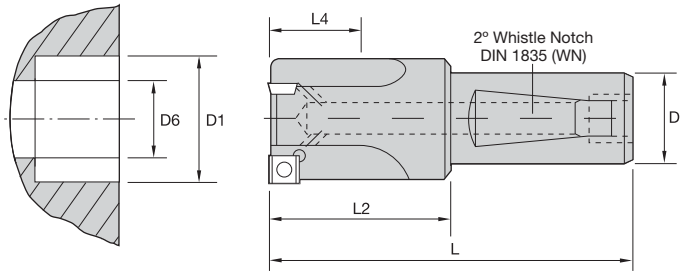


Customization

- 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 customized grades available upon request.

- Counterboring tool shipped with insert screws and Torx wrench.
- Order inserts separately; see pages J115–J117.







S2 S Whistle Notch WN Shank • Metric

catalog number	D1 mm	D1 in	tol min D1 mm	tol min D1 in	tol max D1 mm	tol max D1 in	D	D6	L	L2	L4 max	gage insert	number of inserts
CBTF150R2WD20N2M	15,14	0.596	-0,120	-0.005	0,120	0.005	20	6,0	81	31	8,5	SPHX060204R..	2
CBTF160R2WD20N2M	16,14	0.635	-0,120	-0.005	0,120	0.005	20	7,0	81	31	8,5	SPHX060204R..	2
CBTF170R2WD20N2M	17,14	0.675	-0,120	-0.005	0,120	0.005	20	8,0	86	36	13,5	SPHX060204R..	2
CBTF180R2WD20N2M	18,14	0.714	-0,120	-0.005	0,120	0.005	20	8,4	86	36	13,5	SPHX070304R..	2
CBTF180R2WD20N3M	18,14	0.714	-0,120	-0.005	0,120	0.005	20	8,4	86	36	13,5	SPHX060204R..	3
CBTF200R2WD20N2M	20,17	0.794	-0,120	-0.005	0,120	0.005	20	8,5	86	36	16,0	SPHX070304R..	2
CBTF200R2WD20N3M	20,17	0.794	-0,120	-0.005	0,120	0.005	20	8,5	86	36	16,0	SPHX060204R..	3
CBTF210R2WD20N2M	21,17	0.833	-0,120	-0.005	0,120	0.005	20	8,5	86	36	16,0	SPHX070304R..	2
CBTF210R2WD20N3M	21,17	0.833	-0,120	-0.005	0,120	0.005	20	10,5	86	36	11,0	SPHX060204R..	3
CBTF220R2WD20N2M	22,17	0.873	-0,120	-0.005	0,120	0.005	20	10,4	86	36	16,0	SPHX070304R..	2
CBTF220R2WD20N3M	22,17	0.873	-0,120	-0.005	0,120	0.005	20	10,5	86	36	16,0	SPHX060204R..	3
CBTF230R2WD20N2M	23,17	0.912	-0,120	-0.005	0,120	0.005	20	10,5	91	41	21,0	SPHX090304R..	2
CBTF230R2WD20N3M	23,17	0.912	-0,120	-0.005	0,120	0.005	20	10,5	91	41	16,0	SPHX070304R..	3
CBTF240R2WD20N2M	24,17	0.951	-0,120	-0.005	0,120	0.005	20	10,5	91	41	18,5	SPHX090304R..	2
CBTF240R2WD20N3M	24,17	0.951	-0,120	-0.005	0,120	0.005	20	10,5	91	41	16,0	SPHX070304R..	3
CBTF250R2WD20N2M	25,17	0.991	-0,120	-0.005	0,120	0.005	20	12,0	96	46	23,5	SPHX090304R..	2
CBTF250R2WD20N3M	25,17	0.991	-0,120	-0.005	0,120	0.005	20	10,5	96	46	21,0	SPHX070304R..	3
CBTF260R2WD20N2M	26,17	1.030	-0,120	-0.005	0,120	0.005	20	13,0	96	46	23,5	SPHX090304R..	2
CBTF270R2WD20N3M	27,17	1.070	-0,120	-0.005	0,120	0.005	20	10,5	96	46	21,0	SPHX090304R..	3
CBTF280R2WD20N3M	28,17	1.109	-0,120	-0.005	0,120	0.005	20	15,0	101	51	23,5	SPHX090304R..	3
CBTF300R2WD20N3M	30,17	1.188	-0,120	-0.005	0,120	0.005	20	15,0	101	51	23,0	SPHX090304R..	3
CBTF320R2WD20N3M	32,20	1.268	-0,120	-0.005	0,120	0.005	20	17,0	101	51	23,0	SPHX090304R..	3
CBTF330R2WD20N3M	33,20	1.307	-0,120	-0.005	0,120	0.005	20	17,0	101	51	25,5	SPHX090304R..	3
CBTF340R2WD32N3M	34,20	1.346	-0,120	-0.005	0,120	0.005	32	18,0	111	51	25,5	SPHX090304R..	3
CBTF350R2WD32N3M	35,20	1.386	-0,120	-0.005	0,120	0.005	32	19,0	111	51	25,5	SPHX090304R..	3
CBTF360R2WD32N3M	36,20	1.425	-0,120	-0.005	0,120	0.005	32	19,0	116	56	27,5	SPHX090304R..	3
CBTF380R2WD32N3M	38,20	1.504	-0,120	-0.005	0,120	0.005	32	22,0	121	61	30,0	SPHX120404R..	3
CBTF400R2WD32N3M	40,20	1.582	-0,120	-0.005	0,120	0.005	32	21,0	121	61	30,5	SPHX120404R..	3
CBTF420R2WD32N3M	42,20	1.661	-0,120	-0.005	0,120	0.005	32	22,0	126	66	33,5	SPHX120404R..	3
CBTF460R2WD32N3M	46,20	1.819	-0,120	-0.005	0,120	0.005	32	25,0	126	66	33,5	SPHX120404R..	3

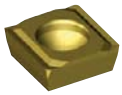
Spare Parts

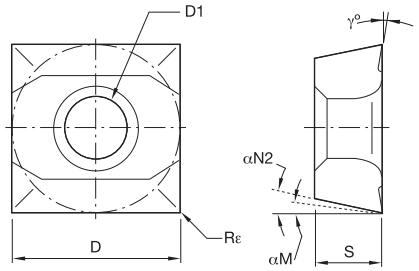




gage insert	insert screw	wrench	Torx size
SPHX060204R..	**192.432**	**170.028**	T8
SPHX070304R..	**192.432**	**170.028**	T8
SPHX090304R..	**191.924**	**170.024**	T9
SPHX120404R..	**191.916**	**170.025**	T15

- Double-sided insert style.





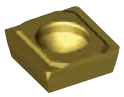
● first choice
○ alternate choice

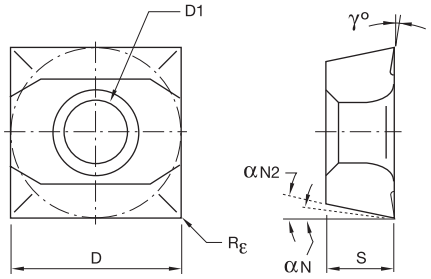
P		●	●	●	●
M		○	○	○	●
K		○	○	○	○
N					○
S					○
H					

SPHX..R-20

	D		D1		S		Rε							
catalog number	mm	in	mm	in	mm	in	mm	in	γ°	αN2	αN M	KCU25	KCU40	KC7215	KC7140
SPHX060202R20	6,35	.250	2,85	.112	2,38	.094	0,20	.008	12	11	7	–	–	●	–
SPHX060204R20	6,35	.250	2,85	.112	2,38	.094	0,40	.016	12	11	7	●	●	–	●
SPHX060206R20	6,35	.250	2,85	.112	2,38	.094	0,60	.024	12	11	7	–	–	●	–
SPHX060208R20	6,35	.250	2,85	.112	2,38	.094	0,80	.031	12	11	7	–	–	●	–
SPHX070302R20	7,94	.313	2,85	.112	3,18	.125	0,20	.008	12	11	7	–	–	●	–
SPHX070304R20	7,94	.313	2,85	.112	3,18	.125	0,40	.016	12	11	7	●	●	–	●
SPHX070306R20	7,94	.313	2,85	.112	3,18	.125	0,60	.024	12	11	7	–	–	●	–
SPHX070308R20	7,94	.313	2,85	.112	3,18	.125	0,80	.031	12	11	7	–	–	●	–
SPHX070310R20	7,94	.313	2,85	.112	3,18	.125	1,00	.039	12	11	7	–	–	●	–
SPHX070312R20	7,94	.313	2,85	.112	3,18	.125	1,20	.047	12	11	7	–	–	●	–
SPHX090304R20	9,53	.375	3,50	.138	3,18	.125	0,40	.016	12	11	7	●	●	●	●
SPHX090308R20	9,53	.375	3,50	.138	3,18	.125	0,80	.031	12	11	7	●	●	–	–
SPHX090310R20	9,53	.375	3,50	.138	3,18	.125	1,00	.039	12	11	7	–	–	●	–
SPHX090312R20	9,53	.375	3,50	.138	3,18	.125	1,20	.047	12	11	7	–	–	●	–
SPHX090316R20	9,53	.375	3,50	.138	3,18	.125	1,60	.063	12	11	7	–	–	●	–
SPHX120404R20	12,70	.500	4,50	.177	4,76	.187	0,40	.016	12	11	7	●	●	–	●
SPHX120408R20	12,70	.500	4,50	.177	4,76	.187	0,80	.031	12	11	7	●	●	–	–
SPHX120410R20	12,70	.500	4,50	.177	4,76	.187	1,00	.039	12	11	7	–	–	●	–
SPHX120412R20	12,70	.500	4,50	.177	4,76	.187	1,20	.047	12	11	7	–	–	●	–
SPHX120416R20	12,70	.500	4,50	.177	4,76	.187	1,60	.063	12	11	7	–	–	●	–
SPHX120420R20	12,70	.500	4,50	.177	4,76	.187	2,00	.079	12	11	7	–	–	●	–
SPHX150504R20	15,88	.625	5,50	.217	5,95	.234	0,40	.016	12	11	7	●	●	–	–
SPHX150508R20	15,88	.625	5,50	.217	5,95	.234	0,80	.031	12	11	7	●	●	–	–
SPHX150512R20	15,88	.625	5,50	.217	5,95	.234	1,20	.047	12	11	7	–	–	●	–
SPHX150516R20	15,88	.625	5,50	.217	5,95	.234	1,60	.063	12	11	7	–	–	●	–
SPHX150520R20	15,88	.625	5,50	.217	5,95	.234	2,00	.079	12	11	7	–	–	●	–

NOTE: SPHX...R-20: This geometry is first choice for steel applications.





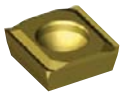
● first choice
○ alternate choice

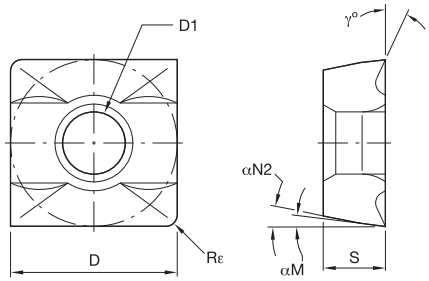
		KCPK10	KCU25	KCU40	KC7215	KM1
P		○	○	○	○	○
M				○	○	○
K		●	●	●	●	●
N						○
S				○	○	
H						

SPHX..R-21

catalog number	D mm	D in	D1 mm	D1 in	S mm	S in	Rε mm	Rε in	γ°	αN2	αN	KCPK10	KCU25	KCU40	KC7215	KM1
SPHX060202R21	6,35	.250	2,85	.112	2,38	.094	0,20	.008	4	11	7	–	–	–	●	–
SPHX060204R21	6,35	.250	2,85	.112	2,38	.094	0,40	.016	4	11	7	●	●	●	–	–
SPHX060204R-21	6,35	.250	2,85	.112	2,38	.094	0,40	.016	4	11	7	–	–	–	–	●
SPHX060206R21	6,35	.250	2,85	.112	2,38	.094	0,60	.024	4	11	7	–	–	–	●	–
SPHX060208R21	6,35	.250	2,85	.112	2,38	.094	0,80	.031	4	11	7	–	–	–	●	–
SPHX070304R21	7,94	.313	2,85	.112	3,18	.125	0,40	.016	4	11	7	●	●	●	–	–
SPHX070304R-21	7,94	.313	2,85	.112	3,18	.125	0,40	.016	4	11	7	–	–	–	–	●
SPHX070306R21	7,94	.313	2,85	.112	3,18	.125	0,60	.024	4	11	7	–	–	–	●	–
SPHX070308R21	7,94	.313	2,85	.112	3,18	.125	0,80	.031	4	11	7	●	–	●	–	–
SPHX070310R21	7,94	.313	2,85	.112	3,18	.125	1,00	.039	4	11	7	–	–	–	●	–
SPHX090304R21	9,53	.375	3,50	.138	3,18	.125	0,40	.016	4	11	7	●	●	●	–	–
SPHX090304R-21	9,53	.375	3,50	.138	3,18	.125	0,40	.016	4	11	7	–	–	–	–	●
SPHX090308R21	9,53	.375	3,50	.138	3,18	.125	0,80	.032	4	11	7	●	●	●	–	–
SPHX090310R21	9,53	.375	3,50	.138	3,18	.125	1,00	.039	4	11	7	–	–	–	●	–
SPHX090312R21	9,53	.375	3,50	.138	3,18	.125	1,20	.047	4	11	7	–	–	–	●	–
SPHX090316R21	9,53	.375	3,50	.138	3,18	.125	1,60	.063	4	11	7	–	–	–	●	–
SPHX120404R21	12,70	.500	4,50	.177	4,76	.187	0,40	.016	4	11	7	●	●	●	–	–
SPHX120404R-21	12,70	.500	4,50	.177	4,76	.187	0,40	.016	4	11	7	–	–	–	–	●
SPHX120408R21	12,70	.500	4,50	.177	4,76	.187	0,80	.031	4	11	7	–	–	–	●	–
SPHX120410R21	12,70	.500	4,50	.177	4,76	.187	1,00	.039	4	11	7	–	–	–	●	–
SPHX120412R21	12,70	.500	4,50	.177	4,76	.187	1,20	.047	4	11	7	–	–	–	●	–
SPHX120416R21	12,70	.500	4,50	.177	4,76	.187	1,60	.063	4	11	7	–	–	–	●	–
SPHX120420R21	12,70	.500	4,50	.177	4,76	.187	2,00	.079	4	11	7	–	–	–	●	–
SPHX150504R-21	15,88	.625	5,50	.217	5,95	.234	0,40	.016	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

	D		D1		S		Rε					
catalog number	mm	in	mm	in	mm	in	mm	in	γ°	αN2	αN M	KM1
SPHX060204R-22	6,35	.250	2,85	.112	2,38	.094	0,40	.016	25	11	–	●
SPHX070304R-22	7,94	.313	2,85	.112	3,18	.125	0,40	.016	25	11	–	●
SPHX090304R-22	9,53	.375	3,50	.138	3,18	.125	0,40	.016	25	11	–	●
SPHX120404R-22	12,70	.500	4,50	.177	4,76	.187	0,40	.016	25	11	–	●
SPHX150504R-22	15,88	.625	5,50	.217	5,95	.234	0,40	.016	25	11	7	●

NOTE: SPHX...R-22: This geometry is first choice for aluminum applications.



Hole Finishing

Introduction **K2–K5**

Tool Selection Guide K4–K5

RMS Solid Carbide Reaming **K6–K11**

RMR, RMB, and RMB-E Tipped Reaming **K12–K25**

RMR Disc Tipped Reaming K12, K15–K16, K22

RMB Cermet Tipped Reaming K13, K17–K18, K23–K24

RMB-E Expansion Reaming K14, K19–K21, K23–K24

RHR, RHM, and RHM-E Modular Reaming **K26–K45**

RHR Disc Tipped Reaming K26, K29–K30, K38

RHM Cermet Tipped Reaming K27, K31–K34, K39–K40

RHM-E Expansion Reaming K28, K35–K37, K39–K40

Modular Reaming Bodies K42–K45

SIF Steerable Toolholder **K46–K52**

RIR and RIQ Guided Reaming **K53–K71**

Romicron High-Performance Boring System **K72–K117**

ModBORE Boring Systems **K118–K153**

PCD Customized Tooling **K154–K158**

Application Examples **K160–K220**

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 customized 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 adapters.



Multi-flute Reaming

- RMR™, RMB™, and RMB-E™ tipped reaming.
- RHR™, RHM™, and RHM-E™ modular reaming.
- Highly productive and easy to use.
- Large, standard, off-the-shelf portfolio of solid carbide, cermet, carbide-tipped, and modular reaming tools, all ground to achieve H7 without customization.
- 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, customized 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 center 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 center 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 styles.
- 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 customized 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	Position	Cylindricity
reaming tools		**RMS™** Solid *Carbide*	●	●	●	●	○		.196–.551" 5–14mm	IT7	.056–1.00" 1,4–25,4mm	IT6 >.39" >10mm	.0004" 10 µm	.0003" 7 µm
		**RMR™** Disc Style *Carbide*	●	●	●	●	○		.551–787" 14–20mm	IT7	.551–1.65" 14–42mm	IT6	.0004" 10 µm	.0003" 7 µm
		**RMB™** Cermet Tipped *Cermet*	●		○	○			.551–.787" 14–20mm	IT7	.551–2.55" 14–65mm	IT6	.0004" 10 µm	.0003" 7 µm
		**RMB-E™** Expandable Reamer *Carbide/Cermet*	●	●	●	●	○		.551–1.65" 14–42mm	IT6	.551–1.65" 14–42mm	IT5–IT6	.0004" 10 µm	.0003" 7 µm
		**RHR™** Modular Disc Style *Carbide*	●	●	●	●	○		.551–1.65" 14–42mm	IT7	.551–1.65" 14–42mm	IT6	.0004" 10 µm	.0003" 7 µm
		**RHM™** Modular Cermet Tipped *Cermet*	●		○	○			.551–1.65" 14–42mm	IT7	.551–1.96" 14–50mm	IT6	.0004" 10 µm	.0003" 7 µm
		**RHM-E™ (Expandable)** Modular Expandable Reamer *Carbide/Cermet*	●	●	●	●	○		.551–1.65" 14–42mm	IT6	.551–1.65" 14–42mm	IT5–IT6	.0004" 10 µm	.0003" 7 µm
		**RIR™** Reamer Insert Rectangular *Carbide*	●	●	●	●	●	○	–	–	.236–11.8" 6–300mm	IT5	.0004" 10 µm	.0002" 4 µm
		**Quattro Cut™ RIQ™** Reamer Insert Quattro Cut *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	○	–	–	.630–11.8" 16–300mm	IT5	.0004" 10 µm	.0002" 4 µm
boring/fine-boring tools		**Romicron™ SVU BB** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	○	.157–3.93" 4–100mm	IT6	.062–3.93" 1,6–100mm	IT6	.0002" 5 µm	.0002–.0004" 5–10 µm
		**Romicron AVS00B—3B/SVS4B—6B** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	●	.984–5.47" 25–139mm	IT6	.984–7.2" 25–183mm	IT6	.0002" 5 µm	.0002–.0004" 5–10 µm
		**Romicron SVU65/92** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	○	2.79–8.38" 71–213mm	IT6	.394–12.83" 10–326mm	IT6	.0002" 5 µm	.0002–.0004" 5–10 µm
		**Romicron SVS M** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	○	●	○	>1.57" >40mm	IT6	1.57–63.0" 40–1600mm	IT6	.0002" 5 µm	.0002–.0004" 5–10 µm
		**ModBORE™ RBHT** Roughing *Carbide/Cermet/PCD/CBN*	●	●	●	●	●		.925–6.024" 23,5–153mm	IT9	.925–6.0" 23,5–153mm	IT9	.0004" 10 µm	>.0008" >20 µm
		**ModBORE FBHO** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	○	.383–3.469" 9,75–88,1mm	IT7	.118–3.4" 3,0–88,1mm	IT7	.0002" 5 µm	.0002–.0004" 5–10 µm
		**ModBORE FBHM** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	○	.383–12.598" 9,75–320mm	IT7	.118–12.5" 3,0–320mm	IT7	.0002" 5 µm	.0002–.0004" 5–10 µm
		**ModBORE FBHS** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●	○	.925–6.024" 23,5–153mm	IT7	.925–6.0" 23,5–153mm	IT7	.0002" 5 µm	.0002–.0004" 5–10 µm
		**ModBORE Bridge Tools** Roughing *Carbide/Cermet/PCD/CBN*	●	●	●	●	●		5.9–86.8" 150–2205mm	IT9	5.9–86.8" 150–2205mm	IT9	.0004" 10 µm	>.0008" >20 µm
		**ModBORE Bridge Tools** Fine Boring *Carbide/Cermet/PCD/CBN*	●	●	●	●	●		5.9–86.8" 150–2205mm	IT7	5.9–86.8" 150–2205mm	IT7	.0002" 5 µm	>.0004" >10 µm
		**Fine Boring Cartridges** Fine Boring *Carbide/Cermet/PCD/CBN*	●	○	●	●	○		>1.10" >28mm	IT7	>1.10" >28mm	IT7	.0002" 5 µm	.0002–.0004" 5–10 µm
PCD		**PCD** Round Tools *Steel Base*				●			–	–	.394–4.00" 10–100mm	IT6	.0004" 10 µm	.0004" 10 µm
		**PCD** Round Tools *Carbide Base*				●			–	–	.197–1.00" 5–25mm	IT6	.0002" 5 µm	.0003" 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								
20–40 µ-in 0,5–1,0 µm	20–40 µ-in 0,5–1,0 µm	20–60 µ-in 0,5–1,5 µm	–	20–40 µ-in 0,5–1,0 µm	–	●	●	●	●	moderate	low	low	K6–K11
8–24 µ-in 0,2–0,6 µm	20–40 µ-in 0,5–1,0 µm	20–40 µ-in 0,5–1,0 µm	–	20–40 µ-in 0,5–1,0 µm	–	●	●	●	●	low	low	low	K12, K15–K16, K22
8–24 µ-in 0,2–0,6 µm	–	20–60 µ-in 0,5–1,5 µm	4–24 µ-in 0,1–0,6 µm	–	–	●	●	●	●	moderate	low	low	K13, K17–K18, K23–K24
20–40 µ-in 0,5–1,0 µm	20–40 µ-in 0,5–1,0 µm	20–60 µ-in 0,5–1,5 µm	–	20–40 µ-in 0,5–1,0 µm	–	●	●	●	●	moderate	low	moderate	K14, K19–K21, K23–K24
8–24 µ-in 0,2–0,6 µm	20–40 µ-in 0,5–1,0 µm	20–40 µ-in 0,5–1,0 µm	–	20–40 µ-in 0,5–1,0 µm	–	●	●	●	●	moderate	low	low	K26, K29–K30, K38
8–24 µ-in 0,2–0,6 µm	–	20–60 µ-in 0,5–1,5 µm	4–24 µ-in 0,1–0,6 µm	–	–	●	●	●	●	moderate	low	low	K27, K31–K34, K39–K40
20–40 µ-in 0,5–1,0 µm	20–40 µ-in 0,5–1,0 µm	20–60 µ-in 0,5–1,5 µm	–	20–40 µ-in 0,5–1,0 µm	–	●	●	●	●	moderate	low	moderate	K28, K35–K37, K39–K40
8–24 µ-in 0,2–0,6 µm	20–63 µ-in 0,5–1,6 µm	20–72 µ-in 0,5–1,8 µm	4–24 µ-in 0,1–0,6 µm	<32 µ-in <08 µm	<32 µ-in <08 µm	●	●	●	●	low	moderate	high	K53–K57, K60–K64
8–24 µ-in 0,2–0,6 µm	20–63 µ-in 0,5–1,6 µm	20–72 µ-in 0,5–1,8 µm	4–24 µ-in 0,1–0,6 µm	<32 µ-in <08 µm	<32 µ-in <08 µm	●	●	●	●	low	moderate	moderate	K53–K55, K57–K65
32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	<48 µ-in <1,2 µm	●	●	○	○	low	moderate	low	K76–K80
32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	<48 µ-in <1,2 µm	●	●	●	●	low	moderate	low	K81–K86
32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	<48 µ-in <1,2 µm	●	●	○	○	low	moderate	low	K87–K90
32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	<48 µ-in <1,2 µm	●	●	●	●	low	moderate	low	please contact us
40–200 µ-in 1,0–5,0 µm	40–200 µ-in 1,0–5,0 µm	40–200 µ-in 1,0–5,0 µm	40–80 µ-in 1,0–2,0 µm	40–200 µ-in 1,0–5,0 µm	–	●	●	●	●	low	low	low–moderate	K122–K126
32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	<48 µ-in <1,2 µm	●	●	●	●	low	moderate	low–moderate	K128–K129, K134–K135
32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	<48 µ-in <1,2 µm	●	●	●	●	low	moderate	low–moderate	K131–K136
32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	<48 µ-in <1,2 µm	●	●	●	●	low	moderate	low–moderate	K137–K141
40–200 µ-in 1,0–5,0 µm	40–200 µ-in 1,0–5,0 µm	40–200 µ-in 1,0–5,0 µm	40–80 µ-in 1,0–2,0 µm	40–200 µ-in 1,0–5,0 µm	–	●	●	●	●	low	low	low–moderate	K141–K145
32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	–	●	●	●	●	low	moderate	low–moderate	K141–K145
32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	32–80 µ-in 0,8–2,0 µm	–	●	●	○	○	low	moderate	low–moderate	K116–K117
–	–	–	4–32 µ-in 0,1–0,8 µm	–	–	●	●	●	●	low	very low	moderate	K154–K158
–	–	–	4–32 µ-in 0,1–0,8 µm	–	–	●	●	●	●	low	very low	moderate	K154–K158

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 adapters 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.

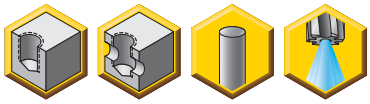
RMS™ multi-flute reaming tools achieve highest metal removal rates from 5–14mm (.197–.551").

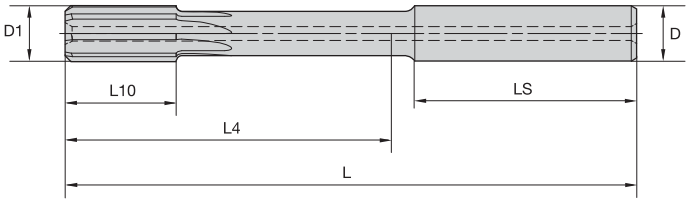


Customization

- Diameters 1,40–14,15mm (.055–.557") available with and without internal coolant in 0,001mm (.00004") steps.
- Intermediate diameters of standard program available as simple specials with short delivery time.
- Solid cermet reaming tools and tooling for heat-resistant materials are available on request.

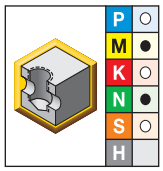
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT7 hole tolerance class available.
- Starting with Ø .393" (10mm) in IT6 hole tolerance available.

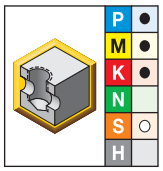






RMS • Blind Hole Solid Carbide Reamer with Internal Coolant





● first choice
○ alternate choice

K605	KC6305	D1		D		L		L4		L10		LS		
		mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	Z
RMS05000H7SF	RMS05000H7SF	5,00	.197	6,00	.236	74,0	2.913	32,0	1.260	12,0	.472	36,0	1.417	4
RMS05500H7SF *	RMS05500H7SF	5,50	.217	6,00	.236	74,0	2.913	32,0	1.260	12,0	.472	36,0	1.417	4
RMS06000H7SF	RMS06000H7SF	6,00	.236	6,00	.236	74,0	2.913	32,0	1.260	12,0	.472	36,0	1.417	4
RMS06500H7SF	RMS06500H7SF	6,50	.256	8,00	.315	91,0	3.583	49,0	1.930	16,0	.630	36,0	1.417	4
RMS07000H7SF	RMS07000H7SF	7,00	.276	8,00	.315	91,0	3.583	49,0	1.930	16,0	.630	36,0	1.417	4
RMS08000H7SF	RMS08000H7SF	8,00	.315	8,00	.315	91,0	3.583	49,0	1.930	16,0	.630	36,0	1.417	6
RMS09000H7SF	RMS09000H7SF	9,00	.354	10,00	.394	103,0	4.055	57,0	2.240	20,0	.787	40,0	1.575	6
RMS10000H7SF	RMS10000H7SF	10,00	.394	10,00	.394	103,0	4.055	57,0	2.240	20,0	.787	40,0	1.575	6
RMS11000H7SF	RMS11000H7SF	11,00	.433	12,00	.472	118,0	4.646	67,0	2.640	24,0	.945	45,0	1.772	6
RMS12000H7SF	RMS12000H7SF	12,00	.472	12,00	.472	118,0	4.646	67,0	2.640	24,0	.945	45,0	1.772	6
RMS13000H7SF	RMS13000H7SF	13,00	.512	14,00	.551	132,0	5.197	81,0	3.190	28,0	1.102	45,0	1.772	6
RMS14000H7SF	RMS14000H7SF	14,00	.551	14,00	.551	132,0	5.197	81,0	3.190	28,0	1.102	45,0	1.772	6

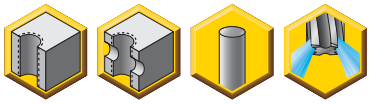
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

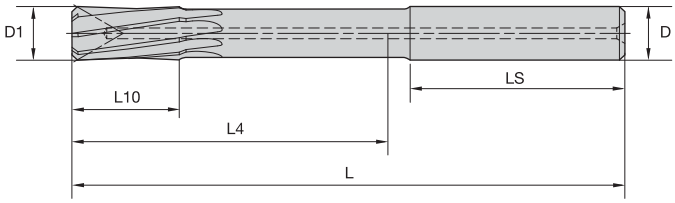
Dimensions for Engineered-Solution Reamers

D1 min		D1 max		D		L		L4		L10		LS		
mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	Z
14,000	0.5512	15,999	0.6299	16	0.630	147,4	5.80	92,4	3.64	7,5	0.30	49	1.93	6
16,000	0.6299	17,999	0.7086	20	0.787	159,4	6.28	102,4	4.03	7,5	0.30	51	2.01	6
18,000	0.7087	20,000	0.7874	20	0.787	173,4	6.83	116,4	4.58	7,5	0.30	51	2.01	6
20,001	0.7874	22,499	0.8858	20	0.787	202,4	7.97	145,4	5.72	7,5	0.30	51	2.01	6
22,500	0.8858	24,999	0.9842	20	0.787	212,4	8.36	155,4	6.12	7,5	0.30	51	2.01	6
25,000	0.9843	27,499	1.0826	25	0.984	232,4	9.15	169,4	6.67	7,5	0.30	57	2.24	8
27,500	1.0827	29,999	1.1811	25	0.984	242,4	9.54	179,4	7.06	7,5	0.30	57	2.24	8
30,000	1.1811	32,499	1.2795	25	0.984	272,4	10.72	209,4	8.24	7,5	0.30	57	2.24	8
32,500	1.2795	34,999	1.3779	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8
35,000	1.3780	37,499	1.4763	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8
37,500	1.4764	39,999	1.5748	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8
40,000	1.5748	42,500	1.6732	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

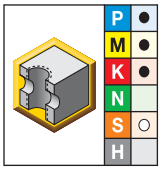
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT7 hole tolerance class available.
- Starting with Ø .393" (10mm) in IT6 hole tolerance available.

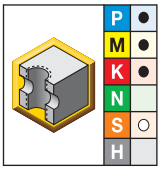






RMS • Through Hole Solid Carbide Reamer with Internal Coolant





● first choice
○ alternate choice

K605	KC6305	D1		D		L		L4		L10		LS		
		mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	Z
RMS05000H7HF	**RMS05000H7HF**	5,00	.197	6,00	.236	74,0	2.913	32,0	1.260	12,0	.472	36,0	1.417	4
RMS05500H7HF	**RMS05500H7HF**	5,50	.217	6,00	.236	74,0	2.913	32,0	1.260	12,0	.472	36,0	1.417	4
RMS06000H7HF	**RMS06000H7HF**	6,00	.236	6,00	.236	74,0	2.913	32,0	1.260	12,0	.472	36,0	1.417	4
RMS06500H7HF	**RMS06500H7HF**	6,50	.256	8,00	.315	91,0	3.583	49,0	1.930	16,0	.630	36,0	1.417	4
RMS07000H7HF	**RMS07000H7HF**	7,00	.276	8,00	.315	91,0	3.583	49,0	1.930	16,0	.630	36,0	1.417	4
RMS08000H7HF	**RMS08000H7HF**	8,00	.315	8,00	.315	91,0	3.583	49,0	1.930	16,0	.630	36,0	1.417	6
RMS09000H7HF *	**RMS09000H7HF**	9,00	.354	10,00	.394	103,0	4.055	57,0	2.240	20,0	.787	40,0	1.575	6
RMS10000H7HF	**RMS10000H7HF**	10,00	.394	10,00	.394	103,0	4.055	57,0	2.240	20,0	.787	40,0	1.575	6
RMS11000H7HF	**RMS11000H7HF**	11,00	.433	12,00	.472	118,0	4.646	67,0	2.640	24,0	.945	45,0	1.772	6
RMS12000H7HF	**RMS12000H7HF**	12,00	.472	12,00	.472	118,0	4.646	67,0	2.640	24,0	.945	45,0	1.772	6
RMS13000H7HF	**RMS13000H7HF**	13,00	.512	14,00	.551	132,0	5.197	81,0	3.190	28,0	1.102	45,0	1.772	6
RMS14000H7HF	**RMS14000H7HF**	14,00	.551	14,00	.551	132,0	5.197	81,0	3.190	28,0	1.102	45,0	1.772	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	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	Z
14,000	0.5512	15,999	0.6299	16	0.630	147,4	5.80	92,4	3.64	7,5	0.30	49	1.93	6
16,000	0.6299	17,999	0.7086	20	0.787	159,4	6.28	102,4	4.03	7,5	0.30	51	2.01	6
18,000	0.7087	20,000	0.7874	20	0.787	173,4	6.83	116,4	4.58	7,5	0.30	51	2.01	6
20,001	0.7874	22,499	0.8858	20	0.787	202,4	7.97	145,4	5.72	7,5	0.30	51	2.01	6
22,500	0.8858	24,999	0.9842	20	0.787	212,4	8.36	155,4	6.12	7,5	0.30	51	2.01	6
25,000	0.9843	27,499	1.0826	25	0.984	232,4	9.15	169,4	6.67	7,5	0.30	57	2.24	8
27,500	1.0827	29,999	1.1811	25	0.984	242,4	9.54	179,4	7.06	7,5	0.30	57	2.24	8
30,000	1.1811	32,499	1.2795	25	0.984	272,4	10.72	209,4	8.24	7,5	0.30	57	2.24	8
32,500	1.2795	34,999	1.3779	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8
35,000	1.3780	37,499	1.4763	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8
37,500	1.4764	39,999	1.5748	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8
40,000	1.5748	42,500	1.6732	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

RMS™ • Metric



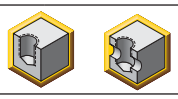
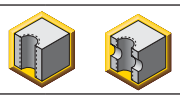
straight flute



helical flute

Material Group		Cutting Speed – vc Range – m/min						Metric Recommended Feed Rate per Tooth						
		K605			KC6305			Tool Diameter (mm)	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

RMS™ • Inch

Material Group		 straight flute			 helical flute									
		K605			KC6305			Inch						
		Cutting Speed — vc			Cutting Speed — vc			Recommended Feed Rate per Tooth						
		Range — SFM			Range — SFM			Tool Diameter (inch)	.164–.281"		.282–.378"		.378–.551"	
		min	Starting Value	max	min	Starting Value	max	Feed/ Tooth	min	max	min	max	min	max
P	1	131	**197**	230	295	**394**	508	inch/z	.002	.004	.002	.005	.002	.006
	2	131	**197**	230	295	**394**	508	inch/z	.002	.004	.002	.005	.002	.006
	3	115	**164**	197	246	**328**	426	inch/z	.002	.004	.002	.005	.002	.006
	4	82	**131**	148	197	**262**	344	inch/z	.002	.004	.002	.005	.002	.006
	5	49	**66**	82	98	**131**	180	inch/z	.002	.003	.002	.004	.002	.005
	6	49	**66**	82	98	**131**	180	inch/z	.002	.003	.002	.004	.002	.005
M	1	26	**33**	49	49	**66**	92	inch/z	.002	.003	.002	.004	.002	.004
	2	26	**33**	49	49	**66**	92	inch/z	.002	.003	.002	.004	.002	.004
	3	26	**33**	49	49	**66**	92	inch/z	.002	.003	.002	.004	.002	.004
K	1	115	**164**	197	246	**328**	426	inch/z	.002	.006	.002	.007	.002	.008
	2	82	**131**	164	197	**295**	361	inch/z	.002	.006	.002	.006	.002	.007
	3	66	**98**	148	197	**262**	344	inch/z	.002	.005	.002	.006	.002	.006
N	1	361	**492**	640	–	**–**	–	inch/z	.002	.006	.002	.007	.002	.008
	2	361	**492**	640	–	**–**	–	inch/z	.002	.006	.002	.007	.002	.008
	3	361	**492**	640	–	**–**	–	inch/z	.002	.006	.002	.007	.002	.008
	4	361	**492**	640	–	**–**	–	inch/z	.002	.006	.002	.007	.002	.008
	5	344	**459**	590	–	**–**	–	inch/z	.002	.006	.002	.007	.002	.008
S	1	26	**33**	49	49	**66**	92	inch/z	.002	.003	.002	.004	.002	.005
	2	26	**33**	49	50	**66**	92	inch/z	.002	.003	.002	.004	.002	.005
	3	49	**66**	98	66	**98**	131	inch/z	.002	.004	.002	.005	.002	.006
	4	49	**66**	98	66	**98**	131	inch/z	.002	.004	.002	.005	.002	.006

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.

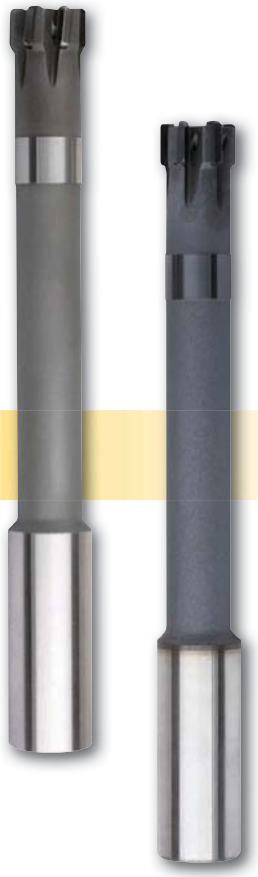
Customization

- All diameters between 14–42,5mm (.5512–1.6732").
- Variation of leads and cylindrical margin for application-specific optimization.

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.

Customization

- 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

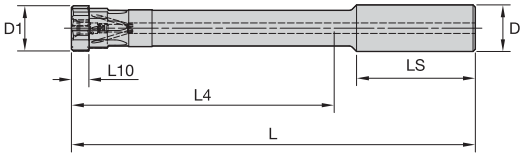
- Longer tool life at smaller tolerances.

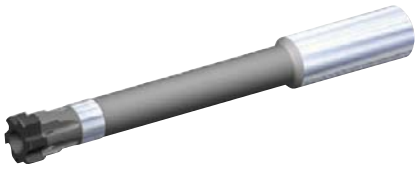
Customization

- Diameters up to 42mm (1.65") available with helical and straight flutes in 0,001mm (.00004") increments.

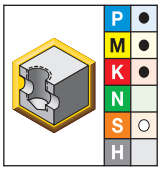
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Adjustment screw to change internal coolant supply from axial to radial.







RMR • Disc Style Reamer • Straight Fluted for Blind Holes with Internal Coolant



● first choice
○ alternate choice

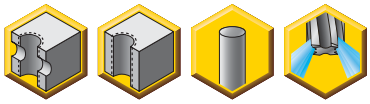
KCU05	D1 mm	D1 in	D mm	D in	L mm	L in	L4 mm	L4 in	L10 mm	L10 in	LS mm	LS in	Z
RMR14000H7SF	14,00	.551	16,000	0.63	147,4	5.8	92,4	3.638	7,50	.295	49,00	1.929	6
RMR15000H7SF	15,00	.591	16,000	0.63	147,4	5.8	92,4	3.638	7,50	.295	49,00	1.929	6
RMR16000H7SF	16,00	.630	20,000	0.79	159,4	6.3	102,4	4.031	7,50	.295	51,00	2.008	6
RMR17000H7SF	17,00	.669	20,000	0.79	159,4	6.3	102,4	4.031	7,50	.295	51,00	2.008	6
RMR18000H7SF	18,00	.709	20,000	0.79	173,4	6.8	116,4	4.583	7,50	.295	51,00	2.008	6
RMR19000H7SF	19,00	.748	20,000	0.79	173,4	6.8	116,4	4.583	7,50	.295	51,00	2.008	6
RMR20000H7SF	20,00	.787	20,000	0.79	173,4	6.8	116,4	4.583	7,50	.295	51,00	2.008	6

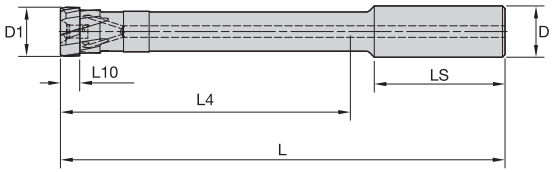
Dimensions for Engineered-Solution Reamers

D1 min mm	D1 min in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L4 mm	L4 in	L10 mm	L10 in	LS mm	LS in	Z
14,000	0.5512	15,999	0.6299	16	0.630	147,4	5.80	92,4	3.64	7,5	0.30	49	1.93	6
16,000	0.6299	17,999	0.7086	20	0.787	159,4	6.28	102,4	4.03	7,5	0.30	51	2.01	6
18,000	0.7087	20,000	0.7874	20	0.787	173,4	6.83	116,4	4.58	7,5	0.30	51	2.01	6
20,001	0.7874	22,499	0.8858	20	0.787	202,4	7.97	145,4	5.72	7,5	0.30	51	2.01	6
22,500	0.8858	24,999	0.9842	20	0.787	212,4	8.36	155,4	6.12	7,5	0.30	51	2.01	6
25,000	0.9843	27,499	1.0826	25	0.984	232,4	9.15	169,4	6.67	7,5	0.30	57	2.24	8
27,500	1.0827	29,999	1.1811	25	0.984	242,4	9.54	179,4	7.06	7,5	0.30	57	2.24	8
30,000	1.1811	32,499	1.2795	25	0.984	272,4	10.72	209,4	8.24	7,5	0.30	57	2.24	8
32,500	1.2795	34,999	1.3779	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8
35,000	1.3780	37,499	1.4763	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8
37,500	1.4764	39,999	1.5748	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8
40,000	1.5748	42,500	1.6732	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

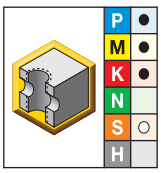
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.







RMR • Disc Style Reamer • Helical Fluted for Through Holes with Internal Coolant



● first choice
○ alternate choice

KCU05	D1 mm	D1 in	D mm	D in	L mm	L in	L4 mm	L4 in	L10 mm	L10 in	LS mm	LS in	Z
RMR14000H7HF	14,00	.551	16,00	0.630	147,4	5.80	92,4	3.638	7,5	0.30	49,00	1.93	6
RMR15000H7HF	15,00	.591	16,00	0.630	147,4	5.80	92,4	3.638	7,5	0.30	49,00	1.93	6
RMR16000H7HF	16,00	.630	20,00	0.787	159,4	6.28	102,4	4.031	7,5	0.30	51,00	2.01	6
RMR17000H7HF	17,00	.669	20,00	0.787	159,4	6.28	102,4	4.031	7,5	0.30	51,00	2.01	6
RMR18000H7HF	18,00	.709	20,00	0.787	173,4	6.83	116,4	4.583	7,5	0.30	51,00	2.01	6
RMR19000H7HF	19,00	.748	20,00	0.787	173,4	6.83	116,4	4.583	7,5	0.30	51,00	2.01	6
RMR20000H7HF	20,00	.787	20,00	0.787	173,4	6.83	116,4	4.583	7,5	0.30	51,00	2.01	6

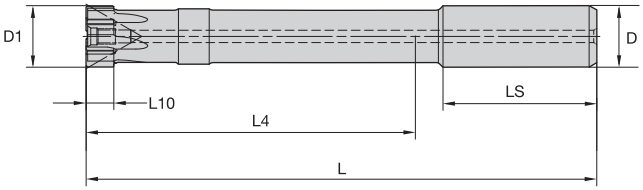
Dimensions for Engineered-Solution Reamers

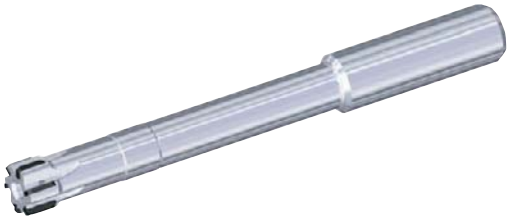
D1 min mm	D1 min in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L4 mm	L4 in	L10 mm	L10 in	LS mm	LS in	Z
14,000	0.5512	15,999	0.6299	16	0.630	147,4	5.80	92,4	3.64	7,5	0.30	49	1.93	6
16,000	0.6299	17,999	0.7086	20	0.787	159,4	6.28	102,4	4.03	7,5	0.30	51	2.01	6
18,000	0.7087	20,000	0.7874	20	0.787	173,4	6.83	116,4	4.58	7,5	0.30	51	2.01	6
20,001	0.7874	22,499	0.8858	20	0.787	202,4	7.97	145,4	5.72	7,5	0.30	51	2.01	6
22,500	0.8858	24,999	0.9842	20	0.787	212,4	8.36	155,4	6.12	7,5	0.30	51	2.01	6
25,000	0.9843	27,499	1.0826	25	0.984	232,4	9.15	169,4	6.67	7,5	0.30	57	2.24	8
27,500	1.0827	29,999	1.1811	25	0.984	242,4	9.54	179,4	7.06	7,5	0.30	57	2.24	8
30,000	1.1811	32,499	1.2795	25	0.984	272,4	10.72	209,4	8.24	7,5	0.30	57	2.24	8
32,500	1.2795	34,999	1.3779	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8
35,000	1.3780	37,499	1.4763	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8
37,500	1.4764	39,999	1.5748	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8
40,000	1.5748	42,500	1.6732	32	1.260	272,4	10.72	205,4	8.09	7,5	0.30	61	2.40	8

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

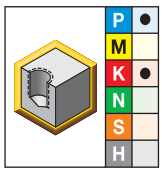
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Adjustment screw to change internal coolant supply from axial to radial.







RMB • Blind Hole Cermet-Tipped Reamer



● first choice
○ alternate choice

KT6215	D1 mm	D1 in	D mm	D in	L mm	L in	L4 mm	L4 in	L10 mm	L10 in	LS mm	LS in	Z
RMB14000H7SF *	14,00	.550	16,00	0.63	145,0	5.7	76,0	2.990	8,0	0.3	49,0	1.9	6
RMB15000H7SF	15,00	.590	16,00	0.63	145,0	5.7	76,0	2.990	8,0	0.3	49,0	1.9	6
RMB16000H7SF	16,00	.630	20,00	0.79	157,0	6.2	86,0	3.390	8,0	0.3	51,0	2.0	6
RMB17000H7SF *	17,00	.670	20,00	0.79	157,0	6.2	86,0	3.390	8,0	0.3	51,0	2.0	6
RMB18000H7SF *	18,00	.710	20,00	0.79	171,0	6.7	100,0	3.940	8,0	0.3	51,0	2.0	6
RMB19000H7SF *	19,00	.750	20,00	0.79	171,0	6.7	100,0	3.940	8,0	0.3	51,0	2.0	6
RMB20000H7SF *	20,00	.790	20,00	0.79	200,0	7.9	129,0	5.080	8,0	0.3	51,0	2.0	6

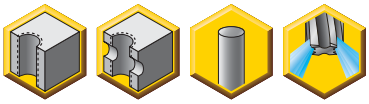
NOTE: Uncoated carbide grade K605™ and uncoated cermet grade KT325™ are available on request.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

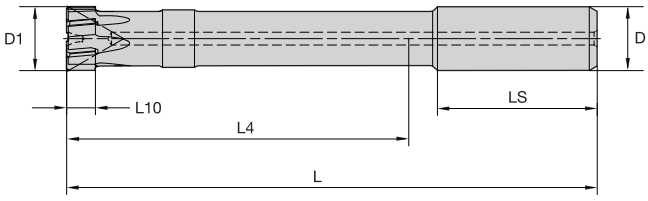
Dimensions for Engineered-Solution Reamers

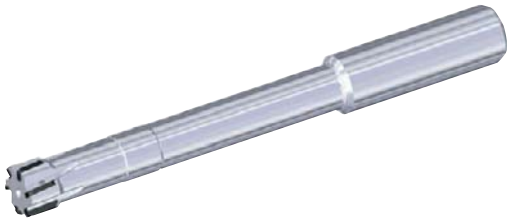
D1 min mm	D1 min in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L4 mm	L4 in	L10 mm	L10 in	LS mm	LS in	Z
14,000	0.5512	15,999	0.6299	16	0.630	145	5.71	76	2.99	8	0.31	49	1.93	6
16,000	0.6299	17,999	0.7086	20	0.787	157	6.18	86	3.39	8	0.31	51	2.01	6
18,000	0.7087	19,999	0.7874	20	0.787	171	6.73	100	3.94	8	0.31	51	2.01	6
20,000	0.7874	21,999	0.8661	20	0.787	200	7.87	129	5.08	8	0.31	51	2.01	6
22,000	0.8661	25,999	1.0236	20	0.787	210	8.27	139	5.47	10	0.39	51	2.01	6
26,000	1.0236	29,999	1.1811	25	0.984	240	9.45	163	6.42	10	0.39	57	2.24	8
30,000	1.1811	32,000	1.2598	25	0.984	270	10.63	193	7.60	12	0.47	57	2.24	8

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

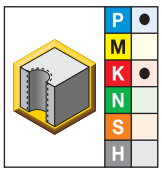
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Adjustment screw to change internal coolant supply from axial to radial.







RMB • Through Hole Cermet-Tipped Reamer



● first choice
○ alternate choice

KT6215	D1 mm	D1 in	D mm	D in	L mm	L in	L4 mm	L4 in	L10 mm	L10 in	LS mm	LS in	Z
RMB14000H7HF *	14,00	.550	16,00	0.63	145,0	5.7	76,0	2.990	7,6	0.3	49,0	1.9	6
RMB15000H7HF *	15,00	.590	16,00	0.63	145,0	5.7	76,0	2.990	7,6	0.3	49,0	1.9	6
RMB16000H7HF	16,00	.630	20,00	0.79	157,0	6.2	86,0	3.390	7,6	0.3	51,0	2.0	6
RMB18000H7HF *	18,00	.710	20,00	0.79	171,0	6.7	100,0	3.940	7,6	0.3	51,0	2.0	6
RMB19000H7HF *	19,00	.750	20,00	0.79	171,0	6.7	100,0	3.940	7,6	0.3	51,0	2.0	6
RMB20000H7HF *	20,00	.790	20,00	0.79	200,0	7.9	129,0	5.080	7,6	0.3	51,0	2.0	6

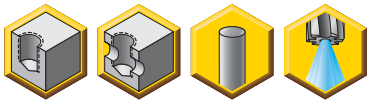
NOTE: Uncoated carbide grade K605™ is available on request.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

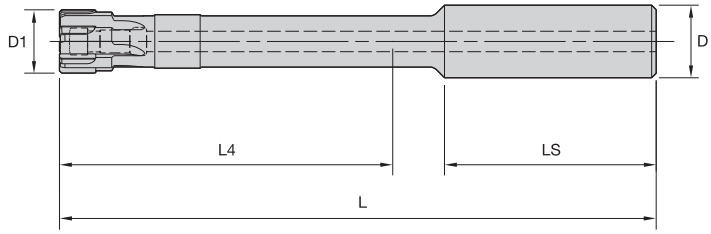
Dimensions for Engineered-Solution Reamers

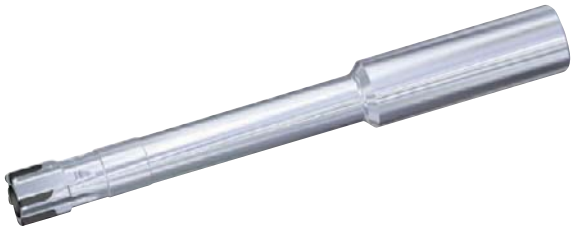
D1 min mm	D1 min in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L4 mm	L4 in	L10 mm	L10 in	LS mm	LS in	Z
14,000	0.5512	15,999	0.6299	16	0.630	145	5.71	76	2.99	8	0.31	49	1.93	6
16,000	0.6299	17,999	0.7086	20	0.787	157	6.18	86	3.39	8	0.31	51	2.01	6
18,000	0.7087	19,999	0.7874	20	0.787	171	6.73	100	3.94	8	0.31	51	2.01	6
20,000	0.7874	21,999	0.8661	20	0.787	200	7.87	129	5.08	8	0.31	51	2.01	6
22,000	0.8661	25,999	1.0236	20	0.787	210	8.27	139	5.47	10	0.39	51	2.01	6
26,000	1.0236	29,999	1.1811	25	0.984	240	9.45	163	6.42	10	0.39	57	2.24	8
30,000	1.1811	32,000	1.2598	25	0.984	270	10.63	193	7.60	12	0.47	57	2.24	8

NOTE: The above dimensions are used when ordering engineered-solution reamers on this page unless otherwise specified.

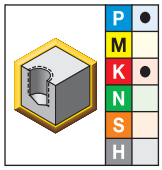
- For hole tolerance H6.
- Intermediate sizes available.
- Allen expansion screw.

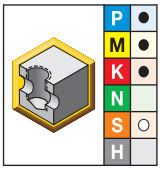






RMB-E • Blind Hole Expansion Reamer





● first choice
○ alternate choice

KC6005	KC6305	D1 mm	D1 in	D mm	D in	L mm	L in	L4 mm	L4 in	LS mm	LS in	Z
RMBE14000H6SF *	RMBE14000H6SF	14,00	.551	16,00	0.63	131,5	5.2	72,5	2.854	49,0	1.9	6
RMBE15000H6SF *	RMBE15000H6SF *	15,00	.591	16,00	0.63	136,5	5.4	77,5	3.051	49,0	1.9	6
RMBE16000H6SF *	RMBE16000H6SF *	16,00	.630	20,00	0.79	143,5	5.7	82,5	3.248	54,4	2.1	6
RMBE17000H6SF *	RMBE17000H6SF *	17,00	.669	20,00	0.79	148,5	5.8	87,5	3.445	51,0	2.0	6
RMBE18000H6SF *	RMBE18000H6SF *	18,00	.709	20,00	0.79	153,5	6.0	92,5	3.642	51,0	2.0	6
RMBE19000H6SF *	RMBE19000H6SF	19,00	.748	20,00	0.79	158,5	6.2	97,5	3.839	51,0	2.0	6
RMBE20000H6SF *	RMBE20000H6SF *	20,00	.787	25,00	0.98	169,8	6.7	102,5	4.035	57,0	2.2	6

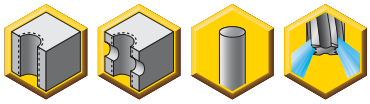
NOTE: Uncoated carbide grade K605™ and uncoated cermet grade KT325™ are available on request.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

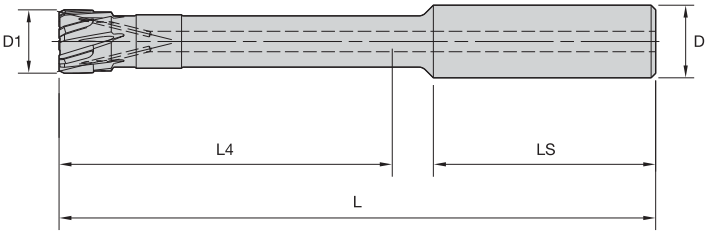
Dimensions for Engineered-Solution Reamers

D1 min mm	D1 min in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L4 mm	L4 in	LS mm	LS in	Z
14,000	0.5512	14,499	0.5708	16	0.630	131,5	5.18	72,5	2.85	49	1.93	6
14,500	0.5709	14,999	0.5905	16	0.630	134,0	5.28	75,0	2.95	49	1.93	6
15,000	0.5906	15,499	0.6102	16	0.630	136,5	5.37	77,5	3.05	49	1.93	6
15,500	0.6102	15,999	0.6299	16	0.630	139,0	5.47	80,0	3.15	49	1.93	6
16,000	0.6299	16,499	0.6496	20	0.787	143,5	5.65	82,5	3.25	51	2.01	6
16,500	0.6496	16,999	0.6693	20	0.787	146,0	5.75	85,0	3.35	51	2.01	6
17,000	0.6693	17,499	0.6889	20	0.787	148,5	5.85	87,5	3.44	51	2.01	6
17,500	0.6890	17,999	0.7086	20	0.787	151,0	5.94	90,0	3.54	51	2.01	6
18,000	0.7087	18,499	0.7283	20	0.787	153,5	6.04	92,5	3.64	51	2.01	6
18,500	0.7283	18,999	0.7480	20	0.787	156,0	6.14	95,0	3.74	51	2.01	6
19,000	0.7480	19,499	0.7677	20	0.787	158,5	6.24	97,5	3.84	51	2.01	6
19,500	0.7677	19,999	0.7874	20	0.787	161,0	6.34	100,0	3.94	51	2.01	6
20,000	0.7874	20,499	0.8070	25	0.984	169,8	6.68	102,5	4.04	57	2.24	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.

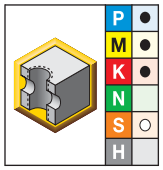
- For hole tolerance H6.
- Intermediate sizes available.
- Allen expansion screw.

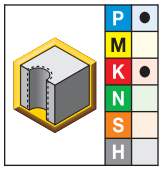






RMB-E • Through Hole Expansion Reamer





● first choice
○ alternate choice

KC6005	KC6305	D1 mm	D1 in	D mm	D in	L mm	L in	L4 mm	L4 in	LS mm	LS in	Z
RMBE14000H6HF	RMBE14000H6HF *	14,00	.551	16,00	0.63	131,5	5.2	72,5	2.854	49,0	1.9	6
RMBE15000H6HF *	RMBE15000H6HF	15,00	.591	16,00	0.63	136,5	5.4	77,5	3.051	49,0	1.9	6
RMBE16000H6HF *	RMBE16000H6HF	16,00	.630	20,00	0.79	143,5	5.7	82,5	3.248	51,0	2.0	6
RMBE17000H6HF *	RMBE17000H6HF *	17,00	.669	20,00	0.79	148,5	5.8	87,5	3.445	51,0	2.0	6
RMBE18000H6HF *	RMBE18000H6HF	18,00	.709	20,00	0.79	153,5	6.0	92,5	3.642	51,0	2.0	6
RMBE19000H6HF *	RMBE19000H6HF *	19,00	.748	20,00	0.79	158,5	6.2	97,5	3.839	51,0	2.0	6
RMBE20000H6HF *	RMBE20000H6HF	20,00	.787	25,00	0.98	169,8	6.7	102,5	4.035	57,0	2.2	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.

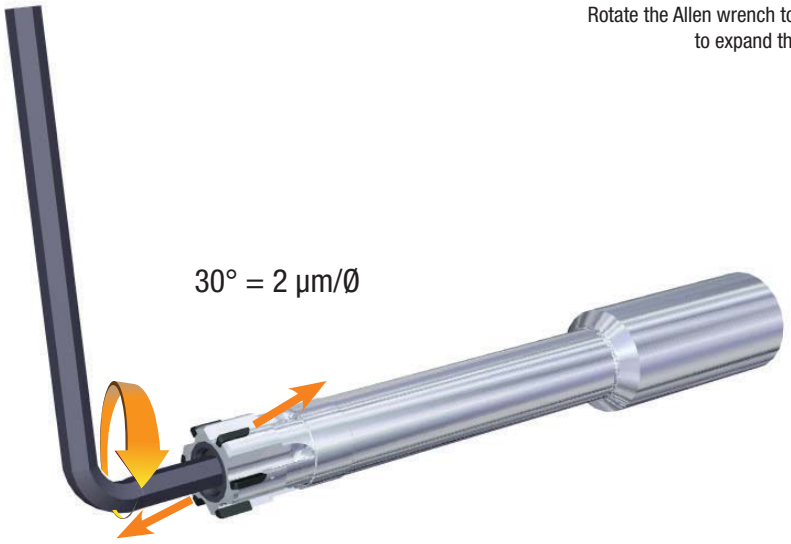
Dimensions for Engineered-Solution Reamers

D1 min mm	D1 min in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L4 mm	L4 in	LS mm	LS in	Z
14,000	0.5512	14,499	0.5708	16	0.630	131,5	5.18	72,5	2.85	49	1.93	6
14,500	0.5709	14,999	0.5905	16	0.630	134,0	5.28	75,0	2.95	49	1.93	6
15,000	0.5906	15,499	0.6102	16	0.630	136,5	5.37	77,5	3.05	49	1.93	6
15,500	0.6102	15,999	0.6299	16	0.630	139,0	5.47	80,0	3.15	49	1.93	6
16,000	0.6299	16,499	0.6496	20	0.787	143,5	5.65	82,5	3.25	51	2.01	6
16,500	0.6496	16,999	0.6693	20	0.787	146,0	5.75	85,0	3.35	51	2.01	6
17,000	0.6693	17,499	0.6889	20	0.787	148,5	5.85	87,5	3.44	51	2.01	6
17,500	0.6890	17,999	0.7086	20	0.787	151,0	5.94	90,0	3.54	51	2.01	6
18,000	0.7087	18,499	0.7283	20	0.787	153,5	6.04	92,5	3.64	51	2.01	6
18,500	0.7283	18,999	0.7480	20	0.787	156,0	6.14	95,0	3.74	51	2.01	6
19,000	0.7480	19,499	0.7677	20	0.787	158,5	6.24	97,5	3.84	51	2.01	6
19,500	0.7677	19,999	0.7874	20	0.787	161,0	6.34	100,0	3.94	51	2.01	6
20,000	0.7874	20,499	0.8070	25	0.984	169,8	6.68	102,5	4.04	57	2.24	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; = 48 µm maximum expansion.
- Hard stop after 720° expansion. You cannot over expand!
- The expansion occurs in the elastic material behavior.
- You cannot reduce the diameter below D1.

RMR • Metric

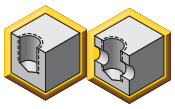
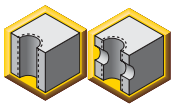
Material Group		KCU05 Cutting Speed — vc Range — m/min			Metric Recommended Feed Rate per Tooth				
					Tool Diameter (mm)	14,00–19,99mm		20,00–32,00mm	
		min	Starting Value	max	Feed/Tooth	min	max	min	max
P	1	90	**120**	155	mm/z	0,10	0,22	0,10	0,25
	2	90	**120**	155	mm/z	0,10	0,22	0,10	0,25
	3	75	**100**	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

Hole Finishing

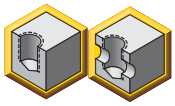
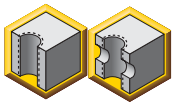
RMR • Inch

Material Group		KCU05 Cutting Speed — vc Range — SFM			Inch Recommended Feed Rate per Tooth				
					Tool Diameter (inch)	.551–.787"		.787–1.260"	
		min	Starting Value	max	Feed/Tooth	min	max	min	max
P	1	295	**394**	509	inch/z	.004	.009	.004	.010
	2	295	**394**	509	inch/z	.004	.009	.004	.010
	3	246	**328**	427	inch/z	.004	.009	.004	.010
	4	164	**262**	344	inch/z	.004	.009	.004	.010
	5	98	**131**	197	inch/z	.004	.009	.004	.010
	6	98	**131**	197	inch/z	.003	.008	.003	.009
M	1	49	**66**	131	inch/z	.003	.007	.003	.008
	2	49	**66**	98	inch/z	.003	.007	.003	.008
	3	49	**66**	98	inch/z	.003	.007	.003	.008
K	1	262	**361**	427	inch/z	.004	.009	.004	.010
	2	213	**295**	361	inch/z	.004	.009	.004	.010
	3	164	**230**	295	inch/z	.004	.008	.004	.010
S	1	49	**66**	98	inch/z	.004	.007	.004	.008
	2	49	**66**	98	inch/z	.004	.007	.004	.008
	3	66	**98**	131	inch/z	.004	.008	.004	.008
	4	66	**98**	131	inch/z	.004	.008	.004	.008

RMB™ and RMB-E™ • Metric

Material Group		RMB™ — Cermet Tipped						RMB-E™						Metric					
																			
		straight flute			helical flute			straight flute			helical flute								
		KT6215			KT6215			K605			KC6305								
		Cutting Speed — vc												Recommended Feed Rate per Tooth					
		Range — m/min												Tool Diameter (mm)	14,00–19,99mm		20,00–32,00mm		
Material Group		min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	Feed/ Tooth	min	max	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	

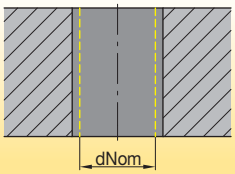
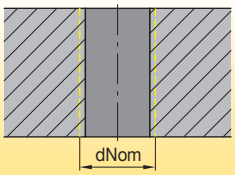
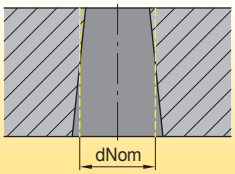
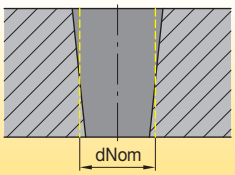
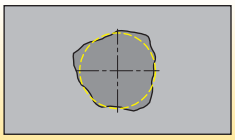
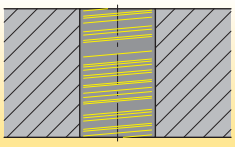
RMB™ and RMB-E™ • Inch

		RMB — Cermet Tipped						RMB-E						Inch				
																		
		straight flute			helical flute			straight flute			helical flute							
		KT6215			KT6215			K605			KC6305							
		Cutting Speed — vc												Recommended Feed Rate per Tooth				
		Range — SFM												Tool Diameter (inch)	.551–.787"		.787–1.260"	
Material Group		min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	Feed/ Tooth	min	max	min	max
P	1	492	**590**	689	590	**689**	787	131	**197**	230	295	**394**	508	inch/z	.004	.009	.004	.010
	2	492	**590**	689	590	**689**	787	131	**197**	230	295	**394**	508	inch/z	.004	.009	.004	.010
	3	426	**525**	590	492	**590**	689	98	**131**	164	246	**328**	426	inch/z	.004	.009	.004	.010
	4	328	**426**	492	394	**492**	558	82	**131**	148	164	**262**	344	inch/z	.004	.009	.004	.010
	5	262	**328**	394	328	**426**	492	33	**66**	98	98	**131**	180	inch/z	.003	.008	.003	.009
	6	262	**328**	394	328	**426**	492	33	**66**	98	98	**131**	180	inch/z	.003	.008	.003	.009
M	1	–	**–**	–	–	**–**	–	26	**33**	49	49	**66**	92	inch/z	.003	.007	.003	.008
	2	–	**–**	–	–	**–**	–	26	**33**	49	49	**66**	92	inch/z	.003	.007	.003	.008
	3	–	**–**	–	–	**–**	–	26	**33**	49	49	**66**	92	inch/z	.003	.007	.003	.008
K	1	492	**590**	656	590	**689**	787	98	**164**	197	262	**361**	426	inch/z	.004	.009	.004	.010
	2	426	**525**	590	492	**590**	689	82	**131**	148	213	**295**	361	inch/z	.004	.009	.004	.010
	3	328	**426**	525	394	**492**	558	66	**98**	131	164	**230**	295	inch/z	.004	.008	.004	.009
N	1	–	**–**	–	–	**–**	–	361	**492**	640	–	**–**	–	inch/z	.004	.012	.004	.012
	2	–	**–**	–	–	**–**	–	361	**492**	640	–	**–**	–	inch/z	.004	.012	.004	.012
	3	–	**–**	–	–	**–**	–	361	**492**	640	–	**–**	–	inch/z	.004	.012	.004	.012
	4	–	**–**	–	–	**–**	–	361	**492**	640	–	**–**	–	inch/z	.004	.012	.004	.012
	5	–	**–**	–	–	**–**	–	344	**459**	590	–	**–**	–	inch/z	.004	.012	.004	.012
S	1	–	**–**	–	–	**–**	–	26	**33**	49	49	**66**	92	inch/z	.004	.007	.004	.008
	2	–	**–**	–	–	**–**	–	26	**33**	49	49	**66**	92	inch/z	.004	.007	.004	.008
	3	–	**–**	–	–	**–**	–	49	**66**	98	66	**98**	131	inch/z	.004	.008	.004	.008
	4	–	**–**	–	–	**–**	–	49	**66**	98	66	**98**	131	inch/z	.004	.008	.004	.008

Reaming Allowances for Multi-Blade Reaming

		reaming allowances in diameter					
		mm			in		
mm	in	min	middle	max	min	middle	max
1,40–4,80	.055–.189	0,08	0,12	0,20	.003	.005	.008
4,81–9,59	.189–.378	0,10	0,15	0,25	.004	.006	.010
9,60–15,00	.378–.591	0,15	0,20	0,30	.006	.008	.012
15,00–20,00	.591–.787	0,15	0,25	0,35	.006	.010	.014
20,00–50,00	.787–1.969	0,20	0,30	0,40	.008	.012	.016

Troubleshooting

Problem		Cause	Possible Remedy
Hole diameter too large.		• Reaming tool running out-of-center. • Concentricity of pilot hole and ream machining unsatisfactory. • Built-up edge. • Unsuitable cooling lubricant. • Reaming tool diameter too large.	• Use equalizing adapter. • 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 equalizing adapter. • 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-center and/or showing chatter marks.		• Reaming tool running out-of-center. • Slanted cutting surface/asymmetrical cutting. • Workpiece twisted.	• Use equalizing adapter. • 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-center. • Incorrect technology data (cutting parameters). • Inadequate chip evacuation.	• Use equalizing adapter. • 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.

Customization

- All diameters between 14–42,5mm (.5512–1.6732").
- Variation of leads and cylindrical margin for application-specific optimization.

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 module 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.

Customization

- 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.

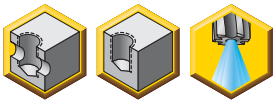
Increased Tool Life

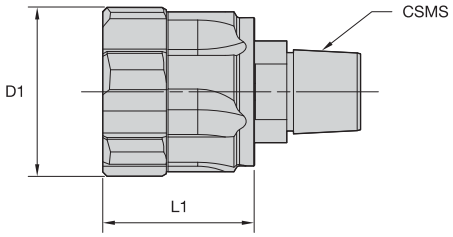
- Longer tool life at smaller tolerances.

Customization

- Diameters up to 42mm (1.65") available with helical and straight flutes in 0,001mm (.00004") increments.

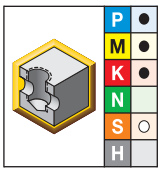
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Please order lock screw and retention knob separately.







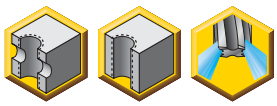
RHR • Disc Style Reamer Head • Straight Fluted for Blind Holes with Internal Coolant

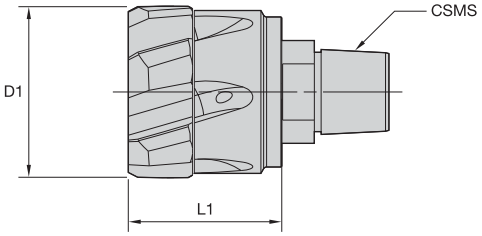


● first choice
○ alternate choice

KCU05	CSMS system size	D1 mm	D1 in	L1 mm	L1 in	Z
RHR14000KST115H7SF	KST115	14,00	.551	17,90	.705	6
RHR15000KST115H7SF	KST115	15,00	.591	17,90	.705	6
RHR16000KST135H7SF	KST135	16,00	.630	17,90	.705	6
RHR17000KST135H7SF	KST135	17,00	.669	17,90	.705	6
RHR18000KST155H7SF	KST155	18,00	.709	17,90	.705	6
RHR19000KST155H7SF	KST155	19,00	.748	17,90	.705	6
RHR20000KST175H7SF	KST175	20,00	.787	17,90	.705	6
RHR21000KST175H7SF	KST175	21,00	.827	17,90	.705	6
RHR22000KST175H7SF	KST175	22,00	.866	17,90	.705	6
RHR23000KST200H7SF	KST200	23,00	.906	18,90	.744	6
RHR24000KST200H7SF	KST200	24,00	.945	18,90	.744	6
RHR25000KST200H7SF	KST200	25,00	.984	18,90	.744	8
RHR26000KST200H7SF	KST200	26,00	1.024	18,90	.744	8
RHR27000KST200H7SF	KST200	27,00	1.063	18,90	.744	8
RHR28000KST250H7SF	KST250	28,00	1.102	18,90	.744	8
RHR29000KST250H7SF	KST250	29,00	1.142	18,90	.744	8
RHR30000KST250H7SF	KST250	30,00	1.181	18,90	.744	8
RHR31000KST250H7SF	KST250	31,00	1.221	18,90	.744	8
RHR32000KST250H7SF	KST250	32,00	1.260	18,90	.744	8
RHR33000KST300H7SF	KST300	33,00	1.299	20,40	.803	8
RHR34000KST300H7SF	KST300	34,00	1.339	20,40	.803	8
RHR35000KST300H7SF	KST300	35,00	1.378	20,40	.803	8
RHR36000KST300H7SF	KST300	36,00	1.417	20,40	.803	8
RHR37000KST300H7SF	KST300	37,00	1.457	20,40	.803	8
RHR38000KST350H7SF	KST350	38,00	1.496	20,40	.803	8
RHR39000KST350H7SF	KST350	39,00	1.535	20,40	.803	8
RHR40000KST350H7SF	KST350	40,00	1.575	20,40	.803	8
RHR41000KST350H7SF	KST350	41,00	1.614	20,40	.803	8
RHR42000KST350H7SF	KST350	42,00	1.654	20,40	.803	8

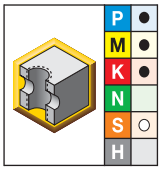
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Please order lock screw and retention knob separately.







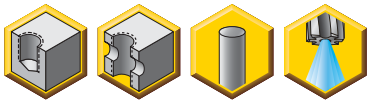
RHR • Disc Style Reamer Head • Helical Fluted for Through Holes with Internal Coolant

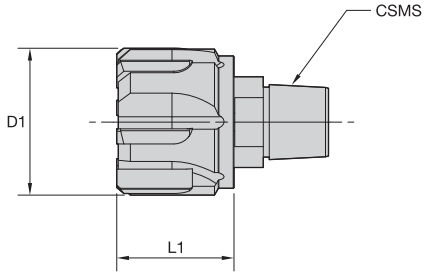


● first choice
○ alternate choice

KCU05	CSMS system size	D1 mm	D1 in	L1 mm	L1 in	Z
RHR14000KST115H7HF	KST115	14,00	.551	17,90	.705	6
RHR15000KST115H7HF	KST115	15,00	.591	17,90	.705	6
RHR16000KST135H7HF	KST135	16,00	.630	17,90	.705	6
RHR17000KST135H7HF	KST135	17,00	.669	17,90	.705	6
RHR18000KST155H7HF	KST155	18,00	.709	17,90	.705	6
RHR19000KST155H7HF	KST155	19,00	.748	17,90	.705	6
RHR20000KST175H7HF	KST175	20,00	.787	17,90	.705	6
RHR21000KST175H7HF	KST175	21,00	.827	17,90	.705	6
RHR22000KST175H7HF	KST175	22,00	.866	17,90	.705	6
RHR23000KST200H7HF	KST200	23,00	.906	18,90	.744	6
RHR24000KST200H7HF	KST200	24,00	.945	18,90	.744	6
RHR25000KST200H7HF	KST200	25,00	.984	18,90	.744	8
RHR26000KST200H7HF	KST200	26,00	1.024	18,90	.744	8
RHR27000KST200H7HF	KST200	27,00	1.063	18,90	.744	8
RHR28000KST250H7HF	KST250	28,00	1.102	18,90	.744	8
RHR29000KST250H7HF	KST250	29,00	1.142	18,90	.744	8
RHR30000KST250H7HF	KST250	30,00	1.181	18,90	.744	8
RHR31000KST250H7HF	KST250	31,00	1.221	18,90	.744	8
RHR32000KST250H7HF	KST250	32,00	1.260	18,90	.744	8
RHR33000KST300H7HF	KST300	33,00	1.299	20,40	.803	8
RHR34000KST300H7HF	KST300	34,00	1.339	20,40	.803	8
RHR35000KST300H7HF	KST300	35,00	1.378	20,40	.803	8
RHR36000KST300H7HF	KST300	36,00	1.417	20,40	.803	8
RHR37000KST300H7HF	KST300	37,00	1.457	20,40	.803	8
RHR38000KST350H7HF	KST350	38,00	1.496	20,40	.803	8
RHR39000KST350H7HF	KST350	39,00	1.535	20,40	.803	8
RHR40000KST350H7HF	KST350	40,00	1.575	20,40	.803	8
RHR41000KST350H7HF	KST350	41,00	1.614	20,40	.803	8
RHR42000KST350H7HF	KST350	42,00	1.654	20,40	.803	8

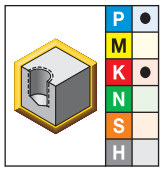
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Please order lock screw for axial use or retention knob separately.

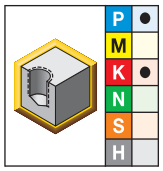






RHM • Blind Hole Cermet Tipped Reamer



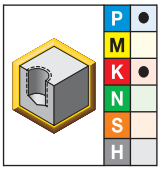


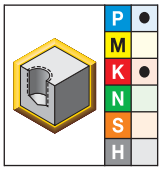
● first choice
○ alternate choice

KT325	KT6215	CSMS system size	D1 mm	D1 in	L1 mm	L1 in	Z
RHM14000KST115H7SF *	RHM14000KST115H7SF	KST115	14,00	.551	13,50	.531	6
RHM14288KST115H7SF *	RHM14288KST115H7SF	KST115	14,29	.563	13,50	.531	6
RHM15000KST115H7SF *	–	KST115	15,00	.591	13,50	.531	6
RHM15875KST115H7SF *	RHM15875KST115H7SF	KST115	15,88	.625	13,50	.531	6
RHM16000KST135H7SF *	RHM16000KST135H7SF	KST135	16,00	.630	13,50	.531	6
RHM17000KST135H7SF *	RHM17000KST135H7SF *	KST135	17,00	.669	15,50	.610	6
RHM17463KST135H7SF *	–	KST135	17,46	.688	15,50	.610	6
RHM18000KST155H7SF	RHM18000KST155H7SF	KST155	18,00	.709	15,50	.610	6
RHM19000KST155H7SF *	–	KST155	19,00	.748	15,50	.610	6
–	RHM19050KST155H7SF *	KST155	19,05	.750	15,50	.610	6
RHM20000KST175H7SF	RHM20000KST175H7SF	KST175	20,00	.787	15,50	.610	6
RHM20640KST175H7SF *	RHM20640KST175H7SF *	KST175	20,64	.813	15,50	.610	6
RHM21000KST175H7SF *	RHM21000KST175H7SF	KST175	21,00	.827	15,50	.610	6
–	RHM22000KST175H7SF *	KST175	22,00	.866	15,50	.610	6
RHM22230KST175H7SF *	RHM22230KST175H7SF *	KST175	22,23	.875	15,50	.610	6
RHM22500KST200H7SF *	RHM22500KST200H7SF *	KST200	22,50	.886	16,50	.650	6
RHM23000KST200H7SF *	RHM23000KST200H7SF *	KST200	23,00	.906	16,50	.650	6
RHM23810KST200H7SF *	RHM23810KST200H7SF *	KST200	23,81	.937	16,50	.650	6
RHM24000KST200H7SF *	RHM24000KST200H7SF *	KST200	24,00	.945	16,50	.650	6
RHM25000KST200H7SF *	RHM25000KST200H7SF	KST200	25,00	.984	16,50	.650	6
RHM25400KST200H7SF *	RHM25400KST200H7SF *	KST200	25,40	1.000	16,50	.650	6
RHM26000KST200H7SF *	–	KST200	26,00	1.024	16,50	.650	8
RHM26990KST200H7SF *	RHM26990KST200H7SF *	KST200	26,99	1.063	16,50	.650	8
RHM27000KST200H7SF	RHM27000KST200H7SF *	KST200	27,00	1.063	16,50	.650	8

(continued)

(RHM • Blind Hole Cermet Tipped Reamer — continued)



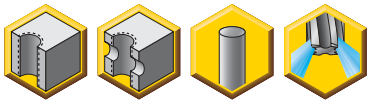


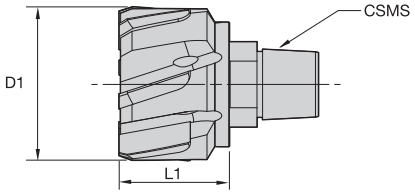
● first choice
○ alternate choice

KT325	KT6215	CSMS system size	D1 mm	D1 in	L1 mm	L1 in	Z
RHM27500KST250H7SF *	**RHM27500KST250H7SF** *	KST250	27,50	1.083	16,50	.650	8
RHM28000KST250H7SF *	**RHM28000KST250H7SF**	KST250	28,00	1.102	16,50	.650	8
RHM28580KST250H7SF *	**RHM28580KST250H7SF** *	KST250	28,58	1.125	16,50	.650	8
RHM29000KST250H7SF	**RHM29000KST250H7SF** *	KST250	29,00	1.142	16,50	.650	8
RHM30000KST250H7SF	**RHM30000KST250H7SF** *	KST250	30,00	1.181	16,50	.650	8
RHM30160KST250H7SF *	–	KST250	30,16	1.187	16,50	.650	8
RHM31000KST250H7SF *	**RHM31000KST250H7SF** *	KST250	31,00	1.221	16,50	.650	8
RHM31750KST250H7SF *	**RHM31750KST250H7SF** *	KST250	31,75	1.250	16,50	.650	8
RHM32000KST250H7SF *	–	KST250	32,00	1.260	16,50	.650	8
RHM32500KST300H7SF *	**RHM32500KST300H7SF** *	KST300	32,50	1.280	18,00	.709	8
RHM33000KST300H7SF *	**RHM33000KST300H7SF** *	KST300	33,00	1.299	18,00	.709	8
RHM33340KST300H7SF *	**RHM33340KST300H7SF** *	KST300	33,34	1.313	18,00	.709	8
RHM34000KST300H7SF *	–	KST300	34,00	1.339	18,00	.709	8
RHM34930KST300H7SF *	**RHM34930KST300H7SF** *	KST300	34,93	1.375	18,00	.709	8
RHM35000KST300H7SF *	**RHM35000KST300H7SF** *	KST300	35,00	1.378	18,00	.709	8
RHM36000KST300H7SF *	**RHM36000KST300H7SF** *	KST300	36,00	1.417	18,00	.709	8
RHM36510KST300H7SF *	**RHM36510KST300H7SF** *	KST300	36,51	1.437	18,00	.709	8
RHM37000KST300H7SF *	–	KST300	37,00	1.457	18,00	.709	8
RHM37500KST350H7SF *	**RHM37500KST350H7SF** *	KST350	37,50	1.476	18,00	.709	8
RHM38000KST350H7SF *	**RHM38000KST350H7SF** *	KST350	38,00	1.496	18,00	.709	8
RHM38100KST350H7SF *	**RHM38100KST350H7SF** *	KST350	38,10	1.500	18,00	.709	8
RHM39000KST350H7SF *	**RHM39000KST350H7SF** *	KST350	39,00	1.535	18,00	.709	8
RHM39690KST350H7SF *	**RHM39690KST350H7SF** *	KST350	39,69	1.563	18,00	.709	8
–	**RHM40000KST350H7SF** *	KST350	40,00	1.575	18,00	.709	8
RHM41000KST350H7SF *	**RHM41000KST350H7SF** *	KST350	41,00	1.614	18,00	.709	8
RHM41280KST350H7SF *	**RHM41280KST350H7SF** *	KST350	41,28	1.625	18,00	.709	8
RHM42000KST350H7SF	**RHM42000KST350H7SF** *	KST350	42,00	1.654	18,00	.709	8

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

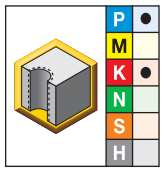
- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Please order lock screw for axial use or retention knob separately.

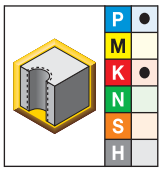






RHM • Through Hole Cermet Tipped Reamer



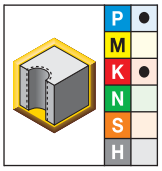


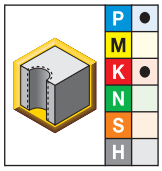
● first choice
○ alternate choice

KT325	KT6215	CSMS system size	D1 mm	D1 in	L1 mm	L1 in	Z
RHM14000KST115H7HF *	RHM14000KST115H7HF	KST115	14,00	.551	13,50	.531	6
RHM14288KST115H7HF *	RHM14288KST115H7HF *	KST115	14,29	.563	13,50	.531	6
RHM15875KST115H7HF *	–	KST115	15,88	.625	13,50	.531	6
RHM16000KST135H7HF	RHM16000KST135H7HF	KST135	16,00	.630	13,50	.531	6
RHM17000KST135H7HF *	RHM17000KST135H7HF	KST135	17,00	.669	15,50	.610	6
RHM17463KST135H7HF *	RHM17463KST135H7HF *	KST135	17,46	.688	15,50	.610	6
RHM18000KST155H7HF *	RHM18000KST155H7HF	KST155	18,00	.709	15,50	.610	6
RHM19000KST155H7HF *	RHM19000KST155H7HF	KST155	19,00	.748	15,50	.610	6
RHM19050KST155H7HF *	RHM19050KST155H7HF	KST155	19,05	.750	15,50	.610	6
RHM20000KST175H7HF	RHM20000KST175H7HF	KST175	20,00	.787	15,50	.610	6
RHM20640KST175H7HF *	RHM20640KST175H7HF	KST175	20,64	.813	15,50	.610	6
RHM21000KST175H7HF	RHM21000KST175H7HF	KST175	21,00	.827	15,50	.610	6
RHM22000KST175H7HF	RHM22000KST175H7HF *	KST175	22,00	.866	15,50	.610	6
RHM22230KST175H7HF *	RHM22230KST175H7HF *	KST175	22,23	.875	15,50	.610	6
RHM22500KST200H7HF *	RHM22500KST200H7HF *	KST200	22,50	.886	16,50	.650	6
RHM23000KST200H7HF *	RHM23000KST200H7HF *	KST200	23,00	.906	16,50	.650	6
RHM23810KST200H7HF *	RHM23810KST200H7HF *	KST200	23,81	.937	16,50	.650	6
RHM24000KST200H7HF	RHM24000KST200H7HF *	KST200	24,00	.945	16,50	.650	6
RHM25000KST200H7HF	RHM25000KST200H7HF	KST200	25,00	.984	16,50	.650	6
RHM25400KST200H7HF *	RHM25400KST200H7HF	KST200	25,40	1.000	16,50	.650	6
RHM26000KST200H7HF *	–	KST200	26,00	1.024	16,50	.650	8
RHM26990KST200H7HF *	RHM26990KST200H7HF *	KST200	26,99	1.063	16,50	.650	8
RHM27000KST200H7HF *	RHM27000KST200H7HF *	KST200	27,00	1.063	16,50	.650	8
RHM27500KST250H7HF *	RHM27500KST250H7HF *	KST250	27,50	1.083	16,50	.650	8

(continued)

(RHM • Through Hole Cermet Tipped Reamer — continued)



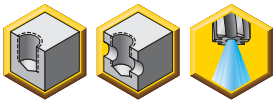


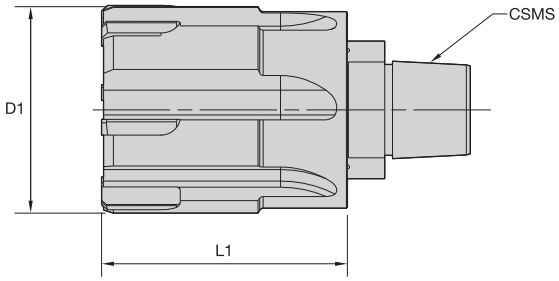
● first choice
○ alternate choice

KT325	KT6215	CSMS system size	D1 mm	D1 in	L1 mm	L1 in	Z
RHM28000KST250H7HF	**RHM28000KST250H7HF**	KST250	28,00	1.102	16,50	.650	8
RHM28580KST250H7HF *	–	KST250	28,58	1.125	16,50	.650	8
RHM29000KST250H7HF *	**RHM29000KST250H7HF** *	KST250	29,00	1.142	16,50	.650	8
RHM30000KST250H7HF	**RHM30000KST250H7HF**	KST250	30,00	1.181	16,50	.650	8
RHM30160KST250H7HF *	**RHM30160KST250H7HF** *	KST250	30,16	1.187	16,50	.650	8
RHM31000KST250H7HF *	**RHM31000KST250H7HF** *	KST250	31,00	1.221	16,50	.650	8
RHM31750KST250H7HF *	**RHM31750KST250H7HF** *	KST250	31,75	1.250	16,50	.650	8
RHM32000KST250H7HF *	**RHM32000KST250H7HF** *	KST250	32,00	1.260	16,50	.650	8
RHM32500KST300H7HF *	**RHM32500KST300H7HF** *	KST300	32,50	1.280	18,00	.709	8
RHM33000KST300H7HF *	**RHM33000KST300H7HF** *	KST300	33,00	1.299	18,00	.709	8
RHM33340KST300H7HF *	**RHM33340KST300H7HF** *	KST300	33,34	1.313	18,00	.709	8
–	**RHM34000KST300H7HF**	KST300	34,00	1.339	18,00	.709	8
RHM34930KST300H7HF *	**RHM34930KST300H7HF** *	KST300	34,93	1.375	18,00	.709	8
RHM35000KST300H7HF	**RHM35000KST300H7HF**	KST300	35,00	1.378	18,00	.709	8
RHM36000KST300H7HF	–	KST300	36,00	1.417	18,00	.709	8
RHM36510KST300H7HF *	**RHM36510KST300H7HF** *	KST300	36,51	1.437	18,00	.709	8
RHM37000KST300H7HF *	**RHM37000KST300H7HF**	KST300	37,00	1.457	18,00	.709	8
RHM37500KST350H7HF *	**RHM37500KST350H7HF** *	KST350	37,50	1.476	18,00	.709	8
RHM38100KST350H7HF *	–	KST350	38,10	1.500	18,00	.709	8
RHM39000KST350H7HF *	**RHM39000KST350H7HF** *	KST350	39,00	1.535	18,00	.709	8
RHM39690KST350H7HF *	**RHM39690KST350H7HF** *	KST350	39,69	1.563	18,00	.709	8
RHM40000KST350H7HF	**RHM40000KST350H7HF**	KST350	40,00	1.575	18,00	.709	8
RHM41000KST350H7HF *	**RHM41000KST350H7HF** *	KST350	41,00	1.614	18,00	.709	8
RHM41280KST350H7HF *	**RHM41280KST350H7HF** *	KST350	41,28	1.625	18,00	.709	8
RHM42000KST350H7HF	**RHM42000KST350H7HF** *	KST350	42,00	1.654	18,00	.709	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.

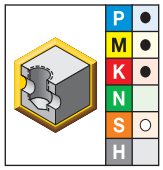
- For hole tolerance H6.
- Intermediate sizes available.
- Lock screw for axial use or retention knob comes with holder.
- Allen expansion screw.

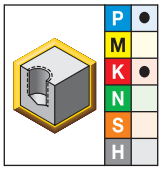






RHM-E • Blind Hole Expansion Reamer





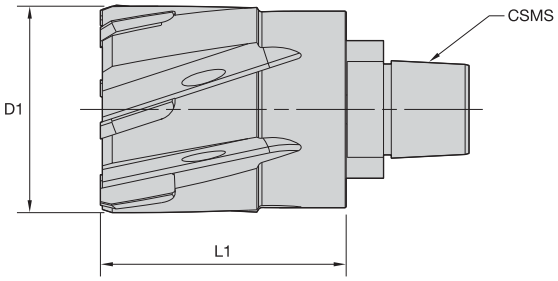
● first choice
○ alternate choice

KC6005	KC6305	CSMS system size	D1 mm	D1 in	L1 mm	L1 in	Z
RHME14000KST115H6SF *	RHME14000KST115H6SF	KST115	14,00	.551	25,00	.984	6
RHME14288KST115H6SF *	RHME14288KST115H6SF *	KST115	14,29	.563	25,00	.984	6
RHME15000KST115H6SF *	RHME15000KST115H6SF	KST115	15,00	.591	25,00	.984	6
RHME16000KST135H6SF	RHME16000KST135H6SF	KST135	16,00	.630	25,00	.984	6
RHME17000KST135H6SF *	RHME17000KST135H6SF	KST135	17,00	.669	25,00	.984	6
RHME17463KST135H6SF *	RHME17463KST135H6SF *	KST135	17,46	.688	25,00	.984	6
RHME18000KST155H6SF *	RHME18000KST155H6SF *	KST155	18,00	.709	25,00	.984	6
RHME19000KST155H6SF *	RHME19000KST155H6SF *	KST155	19,00	.748	25,00	.984	6
RHME19050KST155H6SF *	RHME19050KST155H6SF *	KST155	19,05	.750	25,00	.984	6
RHME20000KST175H6SF *	RHME20000KST175H6SF	KST175	20,00	.787	25,00	.984	6
RHME21000KST175H6SF	RHME21000KST175H6SF *	KST175	21,00	.827	25,00	.984	6
RHME22000KST175H6SF *	RHME22000KST175H6SF *	KST175	22,00	.866	25,00	.984	6
RHME22225KST175H6SF *	RHME22225KST175H6SF	KST175	22,23	.875	25,00	.984	6
RHME23000KST200H6SF *	RHME23000KST200H6SF *	KST200	23,00	.906	25,00	.984	6
RHME23813KST200H6SF *	RHME23813KST200H6SF *	KST200	23,81	.938	25,00	.984	6
RHME24000KST200H6SF	RHME24000KST200H6SF *	KST200	24,00	.945	25,00	.984	6
RHME25000KST200H6SF	RHME25000KST200H6SF	KST200	25,00	.984	30,00	1.181	6
RHME25400KST200H6SF *	RHME25400KST200H6SF *	KST200	25,40	1.000	30,00	1.181	6
RHME26000KST200H6SF *	RHME26000KST200H6SF *	KST200	26,00	1.024	30,00	1.181	8
RHME27000KST200H6SF *	RHME27000KST200H6SF	KST200	27,00	1.063	30,00	1.181	8
RHME28000KST250H6SF	RHME28000KST250H6SF	KST250	28,00	1.102	36,00	1.417	8
RHME30000KST250H6SF	RHME30000KST250H6SF	KST250	30,00	1.181	36,00	1.417	8
RHME31750KST250H6SF *	RHME31750KST250H6SF *	KST250	31,75	1.250	36,00	1.417	8
RHME32000KST250H6SF *	RHME32000KST250H6SF *	KST250	32,00	1.260	36,00	1.417	8
RHME34000KST300H6SF *	RHME34000KST300H6SF *	KST300	34,00	1.339	36,00	1.417	8
RHME36000KST300H6SF *	RHME36000KST300H6SF *	KST300	36,00	1.417	36,00	1.417	8
RHME38000KST350H6SF *	RHME38000KST350H6SF *	KST350	38,00	1.496	36,00	1.417	8
RHME40000KST350H6SF *	RHME40000KST350H6SF *	KST350	40,00	1.575	36,00	1.417	8
RHME42000KST350H6SF	RHME42000KST350H6SF *	KST350	42,00	1.654	36,00	1.417	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.

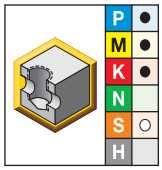
- For hole tolerance H6.
- Intermediate sizes available.
- Lock screw for axial use or retention knob comes with holder.
- Allen expansion screw.

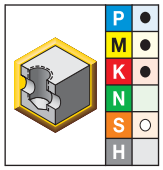






RHM-E • Through Hole Expansion Reamer





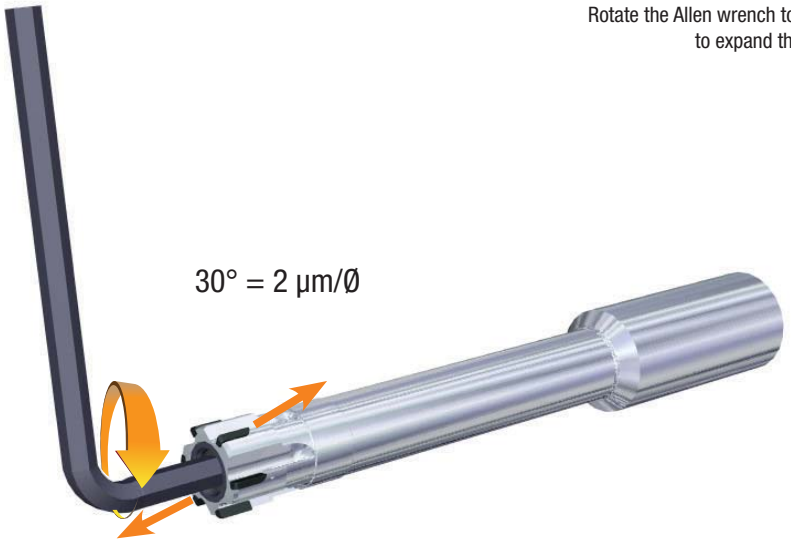
● first choice
○ alternate choice

KC6005	KC6305	CSMS system size	D1 mm	D1 in	L1 mm	L1 in	Z
RHME14000KST115H6HF *	RHME14000KST115H6HF *	KST115	14,00	.551	25,00	.984	6
RHME14288KST115H6HF *	RHME14288KST115H6HF *	KST115	14,29	.563	25,00	.984	6
RHME15000KST115H6HF *	RHME15000KST115H6HF *	KST115	15,00	.591	25,00	.984	6
RHME16000KST135H6HF	RHME16000KST135H6HF	KST135	16,00	.630	25,00	.984	6
RHME17000KST135H6HF	RHME17000KST135H6HF *	KST135	17,00	.669	25,00	.984	6
RHME17463KST135H6HF	RHME17463KST135H6HF *	KST135	17,46	.688	25,00	.984	6
RHME18000KST155H6HF *	RHME18000KST155H6HF	KST155	18,00	.709	25,00	.984	6
RHME19000KST155H6HF *	RHME19000KST155H6HF *	KST155	19,00	.748	25,00	.984	6
RHME19050KST155H6HF *	RHME19050KST155H6HF	KST155	19,05	.750	25,00	.984	6
RHME20000KST175H6HF	RHME20000KST175H6HF	KST175	20,00	.787	25,00	.984	6
RHME21000KST175H6HF *	RHME21000KST175H6HF *	KST175	21,00	.827	25,00	.984	6
RHME22000KST175H6HF	RHME22000KST175H6HF	KST175	22,00	.866	25,00	.984	6
RHME22225KST175H6HF *	RHME22225KST175H6HF	KST175	22,23	.875	25,00	.984	6
RHME23000KST200H6HF *	RHME23000KST200H6HF *	KST200	23,00	.906	25,00	.984	6
RHME23813KST200H6HF *	RHME23813KST200H6HF *	KST200	23,81	.938	25,00	.984	6
RHME24000KST200H6HF *	RHME24000KST200H6HF *	KST200	24,00	.945	25,00	.984	6
RHME25000KST200H6HF *	RHME25000KST200H6HF	KST200	25,00	.984	30,00	1.181	6
RHME25400KST200H6HF	RHME25400KST200H6HF	KST200	25,40	1.000	30,00	1.181	6
RHME26000KST200H6HF *	RHME26000KST200H6HF	KST200	26,00	1.024	30,00	1.181	8
RHME27000KST200H6HF *	RHME27000KST200H6HF *	KST200	27,00	1.063	30,00	1.181	8
RHME28000KST250H6HF	RHME28000KST250H6HF	KST250	28,00	1.102	36,00	1.417	8
RHME30000KST250H6HF	RHME30000KST250H6HF	KST250	30,00	1.181	36,00	1.417	8
RHME31750KST250H6HF *	RHME31750KST250H6HF	KST250	31,75	1.250	36,00	1.417	8
RHME32000KST250H6HF *	RHME32000KST250H6HF *	KST250	32,00	1.260	36,00	1.417	8
RHME34000KST300H6HF *	RHME34000KST300H6HF *	KST300	34,00	1.339	36,00	1.417	8
RHME36000KST300H6HF *	RHME36000KST300H6HF *	KST300	36,00	1.417	36,00	1.417	8
RHME38000KST350H6HF *	RHME38000KST350H6HF *	KST350	38,00	1.496	36,00	1.417	8
RHME40000KST350H6HF *	–	KST350	39,99	1.574	36,00	1.417	8
–	RHME40000KST350H6HF *	KST350	40,00	1.575	36,00	1.417	8
RHME42000KST350H6HF *	RHME42000KST350H6HF *	KST350	42,00	1.654	36,00	1.417	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.

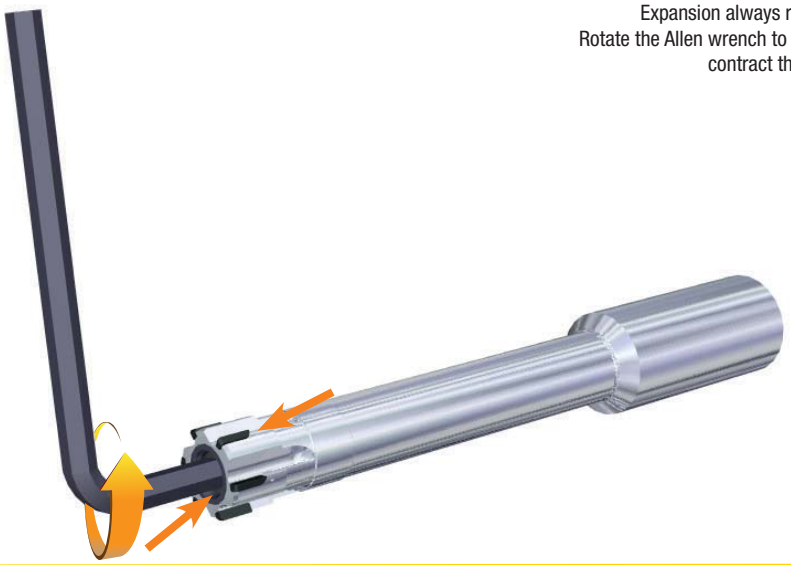
To Expand

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; = 48 µm maximum expansion.
- Hard stop after 720° expansion. You cannot over expand!
- The expansion occurs in the elastic material behavior.
- You cannot reduce the diameter below D1.

RHR • Metric

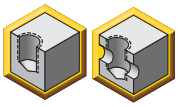
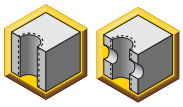
Material Group		KCU05 Cutting Speed — vc Range — m/min			Metric Recommended Feed Rate per Tooth						
					Tool Diameter (mm)	14,00–19,99mm		20,00–32,00mm		32,50–42,00mm	
		min	Starting Value	max	Feed/Tooth	min	max	min	max	min	max
P	1	90	**120**	155	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	2	90	**120**	155	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

Hole Finishing

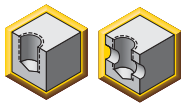
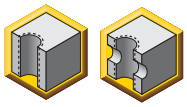
RHR • Inch

Material Group		KCU05 Cutting Speed — vc Range — SFM			Inch Recommended Feed Rate per Tooth						
					Tool Diameter (inch)	.551–.787"		.787–1.260"		1.260–1.654"	
		min	Starting Value	max	Feed/Tooth	min	max	min	max	min	max
P	1	295	**394**	509	inch/z	.004	.008	.004	.009	.004	.010
	2	295	**394**	509	inch/z	.004	.008	.004	.009	.004	.010
	3	246	**328**	427	inch/z	.004	.008	.004	.009	.004	.010
	4	164	**262**	344	inch/z	.004	.008	.004	.009	.004	.010
	5	98	**131**	197	inch/z	.003	.007	.004	.008	.004	.009
	6	98	**131**	197	inch/z	.003	.007	.003	.008	.003	.009
M	1	49	**66**	131	inch/z	.003	.006	.003	.007	.003	.008
	2	49	**66**	98	inch/z	.003	.006	.003	.007	.003	.008
	3	49	**66**	98	inch/z	.003	.006	.003	.007	.003	.008
K	1	262	**361**	427	inch/z	.004	.008	.004	.009	.004	.010
	2	213	**295**	361	inch/z	.004	.008	.004	.009	.004	.010
	3	164	**230**	295	inch/z	.004	.007	.004	.008	.004	.009
S	1	49	**66**	98	inch/z	.002	.006	.004	.007	.004	.008
	2	49	**66**	98	inch/z	.002	.006	.004	.007	.004	.008
	3	66	**98**	131	inch/z	.003	.007	.004	.008	.004	.008
	4	66	**98**	131	inch/z	.003	.007	.004	.008	.004	.008

RHM™ and RHM-E™ • Metric

Material Group		Cermet Tipped						Carbide Tipped						Metric						
																				
		straight flute			helical flute			straight flute			helical flute									
		KT325			KT6215			K605			KC6305									
		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

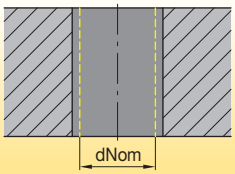
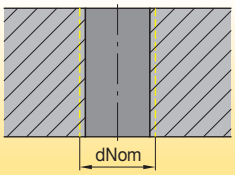
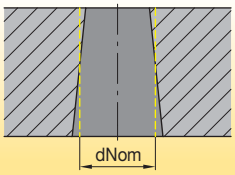
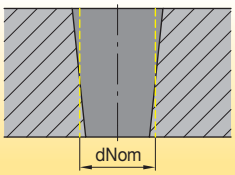
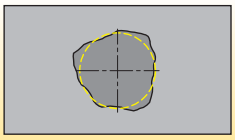
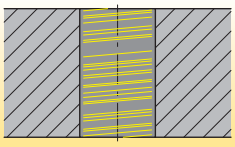
RHM™ and RHM-E™ • Inch

Material Group		Cermet Tipped						Carbide Tipped						Inch						
																				
		straight flute			helical flute			straight flute			helical flute									
		KT325			KT6215			K605			KC6305									
		Cutting Speed — vc												Recommended Feed Rate per Tooth						
		Range — SFM												Tool Diameter (inch)	.551–.787"		.787–1.260"		1.280–1.654"	
		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	492	**590**	689	590	**689**	787	131	**197**	230	295	**394**	508	inch/z	.004	.008	.004	.009	.004	.010
	2	492	**590**	689	590	**689**	787	131	**197**	230	295	**394**	508	inch/z	.004	.008	.004	.009	.004	.010
	3	426	**525**	590	492	**590**	689	98	**131**	164	246	**328**	426	inch/z	.004	.008	.004	.009	.004	.010
	4	328	**426**	492	394	**492**	558	82	**131**	148	164	**262**	344	inch/z	.004	.008	.004	.009	.004	.010
	5	262	**328**	394	328	**426**	492	33	**66**	98	98	**131**	180	inch/z	.003	.007	.003	.008	.003	.009
	6	262	**328**	394	328	**426**	492	33	**66**	98	98	**131**	180	inch/z	.003	.007	.003	.008	.003	.009
M	1	–	**–**	–	–	**–**	–	26	**33**	49	49	**66**	92	inch/z	.003	.006	.003	.007	.003	.008
	2	–	**–**	–	–	**–**	–	26	**33**	49	49	**66**	92	inch/z	.003	.006	.003	.007	.003	.008
	3	–	**–**	–	–	**–**	–	26	**33**	49	49	**66**	92	inch/z	.003	.006	.003	.007	.003	.008
K	1	492	**590**	656	590	**689**	787	98	**164**	197	262	**361**	426	inch/z	.004	.008	.004	.009	.004	.010
	2	426	**525**	590	492	**590**	689	82	**131**	148	213	**295**	361	inch/z	.004	.008	.004	.009	.004	.010
	3	328	**426**	525	394	**492**	558	66	**98**	131	164	**230**	295	inch/z	.004	.007	.004	.008	.004	.009
N	1	–	**–**	–	–	**–**	–	361	**492**	640	–	**–**	–	inch/z	.004	.012	.004	.012	.004	.012
	2	–	**–**	–	–	**–**	–	361	**492**	640	–	**–**	–	inch/z	.004	.012	.004	.012	.004	.012
	3	–	**–**	–	–	**–**	–	361	**492**	640	–	**–**	–	inch/z	.004	.012	.004	.012	.004	.012
	4	–	**–**	–	–	**–**	–	361	**492**	640	–	**–**	–	inch/z	.004	.012	.004	.012	.004	.012
	5	–	**–**	–	–	**–**	–	344	**459**	590	–	**–**	–	inch/z	.004	.012	.004	.012	.004	.012
S	1	–	**–**	–	–	**–**	–	26	**33**	49	49	**66**	92	inch/z	.002	.006	.004	.007	.004	.008
	2	–	**–**	–	–	**–**	–	26	**33**	49	49	**66**	92	inch/z	.002	.006	.004	.007	.004	.008
	3	–	**–**	–	–	**–**	–	49	**66**	98	66	**98**	131	inch/z	.003	.007	.004	.008	.004	.008
	4	–	**–**	–	–	**–**	–	49	**66**	98	66	**98**	131	inch/z	.003	.007	.004	.008	.004	.008

Reaming Allowances for Multi-Blade Reaming

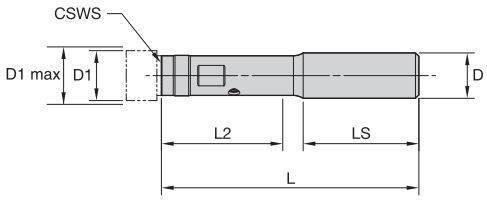
		reaming allowances in diameter					
		mm			in		
mm	in	min	middle	max	min	middle	max
1,40–4,80	.055–.189	0,08	0,12	0,20	.003	.005	.008
4,81–9,59	.189–.378	0,10	0,15	0,25	.004	.006	.010
9,60–15,00	.378–.591	0,15	0,20	0,30	.006	.008	.012
15,00–20,00	.591–.787	0,15	0,25	0,35	.006	.010	.014
20,00–50,00	.787–1.969	0,20	0,30	0,40	.008	.012	.016

Troubleshooting

Problem		Cause	Possible Remedy
Hole diameter too large.		• Reaming tool running out-of-center. • Concentricity of pilot hole and ream machining unsatisfactory. • Built-up edge. • Unsuitable cooling lubricant. • Reaming tool diameter too large.	• Use equalizing adapter. • 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 equalizing adapter. • 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-center and/or showing chatter marks.		• Reaming tool running out-of-center. • Slanted cutting surface/asymmetrical cutting. • Workpiece twisted.	• Use equalizing adapter. • 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-center. • Incorrect technology data (cutting parameters). • Inadequate chip evacuation.	• Use equalizing adapter. • 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.





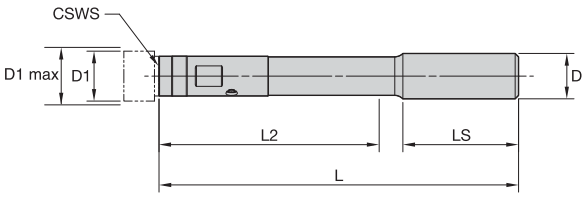


Straight Shank • Axial Clamping • 3 x D

order number	catalog number	CSWS system size	D1 mm	D1 in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L2 mm	L2 in	LS mm	LS in	central lock screw	Torx wrench	Nm	ft. lbs.
4056174	SS16KST115AR3M	KST115	14,00	.551	15,999	.630	16,00	.630	91,00	3.583	36,00	1.420	48,00	1.89	KST115115AS	FT8	3,0	2.2
4056175	SS20KST135AR3M	KST135	16,00	.630	17,999	.709	20,00	.787	99,00	3.898	39,00	1.540	51,00	2.01	KST135155AS	FT10	4,0	3.0
4056176	SS20KST155AR3M	KST155	18,00	.709	19,999	.787	20,00	.787	106,00	4.173	45,00	1.770	51,00	2.01	KST135155AS	FT10	4,0	3.0
3861185	SS20KST175AR3M	KST175	20,00	.787	22,499	.886	20,00	.787	113,50	4.469	51,50	2.028	51,00	2.01	KST175200AS	TT15	5,0	3.7
3861186	SS20KST200AR3M	KST200	22,50	.886	27,499	1.083	20,00	.787	130,50	5.138	65,50	2.579	51,00	2.01	KST175200AS	TT15	5,0	3.7
3861187	SS25KST250AR3M	KST250	27,50	1.083	32,499	1.280	25,00	.984	152,50	6.004	80,50	3.169	56,00	2.20	KST250250AS	TT25	9,0	6.7
3861188	SS32KST300AR3M	KST300	32,50	1.280	37,499	1.476	32,00	1.260	174,00	6.850	94,00	3.701	61,00	2.40	KST300350AS	TT30	13,0	9.7
3861189	SS32KST350AR3M	KST350	37,50	1.476	42,000	1.654	32,00	1.260	190,00	7.480	108,00	4.252	61,00	2.40	KST300350AS	TT30	13,0	9.7

- Tool body shipped with lock screw and wrench.
- Order reamer head separately.





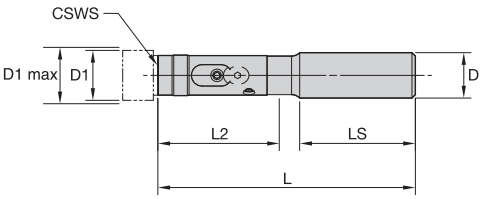


Straight Shank • Axial Clamping • 5 x D

order number	catalog number	CSWS system size	D1 mm	D1 in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L2 mm	L2 in	LS mm	LS in	central lock screw	Torx wrench	Nm	ft. lbs.
4056177	SS16KST115AR5M	KST115	14,00	.551	15,999	.630	16,00	.630	123,00	4.843	68,00	2.680	48,00	1.89	KST115115AS	FT8	3,0	2.2
4056178	SS20KST135AR5M	KST135	16,00	.630	17,999	.709	20,00	.787	135,00	5.315	75,00	2.950	51,00	2.01	KST135155AS	FT10	4,0	3.0
4056179	SS20KST155AR5M	KST155	18,00	.709	19,999	.787	20,00	.787	146,00	5.748	85,00	3.350	51,00	2.01	KST135155AS	FT10	4,0	3.0
3861190	SS20KST175AR5M	KST175	20,00	.787	22,499	.886	20,00	.787	158,50	6.240	96,50	3.799	51,00	2.01	KST175200AS	TT15	5,0	3.7
3861191	SS20KST200AR5M	KST200	22,50	.886	27,499	1.083	20,00	.787	185,50	7.303	120,50	4.744	51,00	2.01	KST175200AS	TT15	5,0	3.7
3861192	SS25KST250AR5M	KST250	27,50	1.083	32,499	1.280	25,00	.984	217,50	8.563	145,50	5.728	56,00	2.20	KST250250AS	TT25	9,0	6.7
3861193	SS32KST300AR5M	KST300	32,50	1.280	37,499	1.476	32,00	1.260	249,00	9.803	169,00	6.654	61,00	2.40	KST300350AS	TT30	13,0	9.7
3861194	SS32KST350AR5M	KST350	37,50	1.476	42,000	1.654	32,00	1.260	274,00	10.787	192,00	7.559	61,00	2.40	KST300350AS	TT30	13,0	9.7

- Tool body shipped with retention knob, clamp set, and wrench.
- Order reamer head separately.





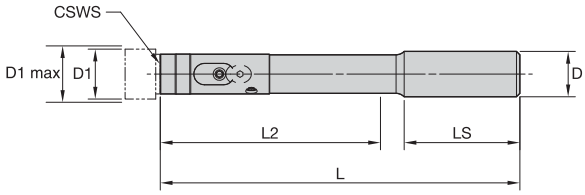


Straight Shank • Radial Clamping • 3 x D

order number	catalog number	CSWS system size	D1 mm	D1 in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L2 mm	L2 in	LS mm	LS in	retention knob	clamp set	Torx wrench	Nm	ft. lbs.
3861195	SS20KST175RR3M	KST175	20,00	.787	22,499	.886	20,00	.787	113,50	4.469	51,50	2.028	51,00	2.01	KST175200RK	KST175CS	TT15	5,0	3.7
3861196	SS20KST200RR3M	KST200	22,50	.886	27,499	1.083	20,00	.787	130,50	5.138	65,50	2.579	51,00	2.01	KST175200RK	KST200CS	TT15	5,0	3.7
3861197	SS25KST250RR3M	KST250	27,50	1.083	32,499	1.280	25,00	.984	152,50	6.004	80,50	3.169	56,00	2.21	KST250250RK	KST250CS	TT25	9,0	6.7
3861198	SS32KST300RR3M	KST300	32,50	1.280	37,499	1.476	32,00	1.259	174,00	6.850	94,00	3.701	61,00	2.40	KST300350RK	KST300CS	TT30	13,0	9.7
3861199	SS32KST350RR3M	KST350	37,50	1.476	42,000	1.654	32,00	1.259	190,00	7.480	108,00	4.252	61,00	2.40	KST300350RK	KST350CS	TT30	13,0	9.7

- Tool body shipped with retention knob, clamp set, and wrench.
- Order reamer head separately.





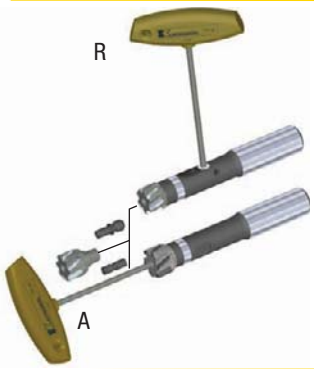


Straight Shank • Radial Clamping • 5 x D

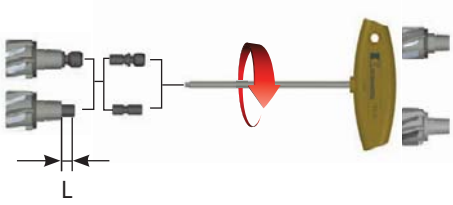
order number	catalog number	CSWS system size	D1 mm	D1 in	D1 max mm	D1 max in	D mm	D in	L mm	L in	L2 mm	L2 in	LS mm	LS in	retention knob	clamp set	Torx wrench	Nm	ft. lbs.
3861200	SS20KST175RR5M	KST175	20,00	.787	22,499	.886	20,00	.787	158,50	6.24	96,50	3.80	51,00	2.01	KST175200RK	KST175CS	TT15	5,0	3.7
3861201	SS20KST200RR5M	KST200	22,50	.886	27,499	1.083	20,00	.787	185,50	7.30	120,50	4.74	51,00	2.01	KST175200RK	KST200CS	TT15	5,0	3.7
3861202	SS25KST250RR5M	KST250	27,50	1.083	32,499	1.280	25,00	.984	217,50	8.56	145,50	5.73	56,00	2.21	KST250250RK	KST250CS	TT25	9,0	6.7
3861203	SS32KST300RR5M	KST300	32,50	1.280	37,499	1.476	32,00	1.259	249,00	9.80	169,00	6.65	61,00	2.40	KST300350RK	KST300CS	TT30	13,0	9.7
3861204	SS32KST350RR5M	KST350	37,50	1.476	42,000	1.654	32,00	1.259	274,00	10.79	192,00	7.56	61,00	2.40	KST300350RK	KST350CS	TT30	13,0	9.7

Assemble

1

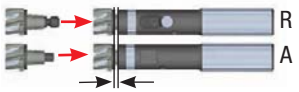


2

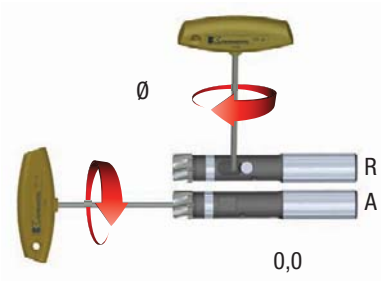


Ø (mm)		Ø (in)		L (mm)
14,000	27,499	0.549	1.078	5–5,5
27,500	42,000	1.078	1.647	5,5–6

3



4

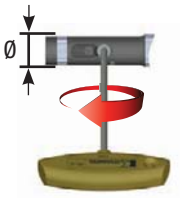


Ø (mm)		Ø (in)			(Nm)	(ft. lbs.)
14,000	15,999	0.549	0.627	DT - 8	2	1.5
16,000	19,999	0.627	0.784	DT - 10	3	2.2
20,000	27,499	0.784	1.078	TT - 15	4	3.7
27,500	32,499	1.078	1.274	TT - 25	5	6.7
32,500	42,000	1.275	1.647	TT- 30	13	9.7

Disassemble 4 → 3 → 2 → 1

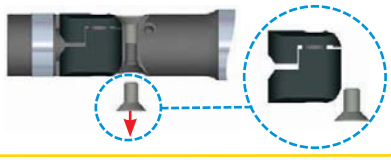
Disassemble

1

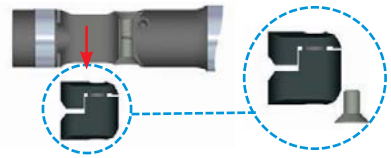


Ø (mm)	Ø (in)			(Nm)	(ft. lbs.)
17,5	0.686	KST175CS	2,5	2,5	1.9
20	0.784	KST200CS	2,5	2,5	1.9
25	0.980	KST250CS	3	5	3.7
30	1.176	KST300CS	4	9	6.7
35	1.373	KST350CS	4	9	9.7

2



3

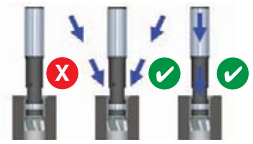


Assemble 3 → 2 → 1

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-optimized 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 adapters 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.

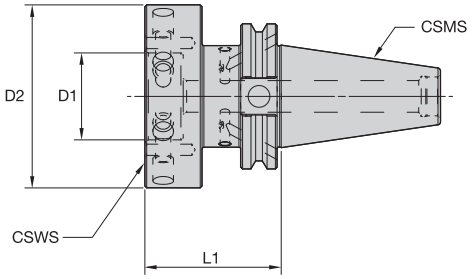


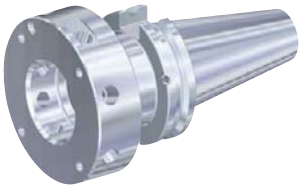
Customization

- Different length versions and coupling size combinations are available.

- Through-the-toolholder coolant capability — form AD or form B.
- Suitable for SIF adapters.







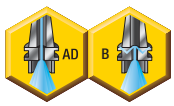
SIF-CV50 Form B/AD

order number	catalog number	CSMS system size	CSWS system size	D2 mm	D2 in	D1 mm	D1 in	L1 mm	L1 in	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738506	**CV50BSIF70236**	CV50	SIF70	70	3	38	1.496	60	2.362	**121.808**	**170.004**	**170.005**	**125.625**	3,49	7.700
3738507	**CV50BSIF100236**	CV50	SIF100	100	4	58	2.283	60	2.362	**121.812**	**170.004**	**170.006**	**–**	4,14	9.140



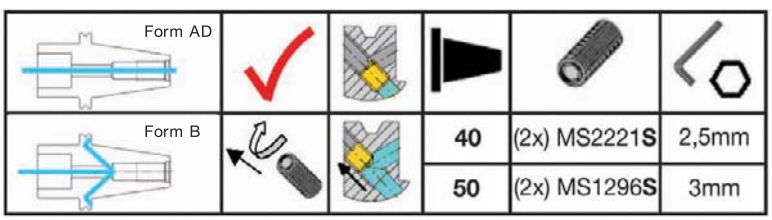
SIF-CV40 Form B/AD

order number	catalog number	CSMS system size	CSWS system size	D2 mm	D2 in	D1 mm	D1 in	L1 mm	L1 in	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738505	**CV40BSIF80248**	CV40	SIF80	80	3	38	1.496	63	2.480	**121.812**	**170.004**	**170.005**	**125.625**	1,77	3.900



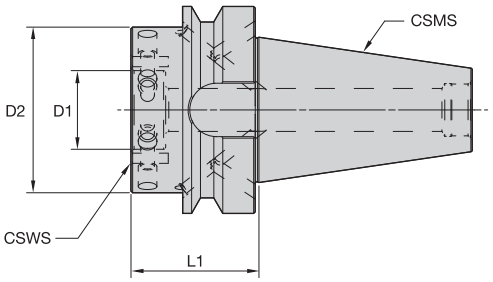
SIF-BT40 Form B/AD

order number	catalog number	CSMS system size	CSWS system size	D2 mm	D2 in	D1 mm	D1 in	L1 mm	L1 in	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738492	**BT40BSIF80063M**	BT40	SIF80	80	3	38	1.496	63	2.480	**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 adapters.







SIF-BT50 Form B/AD

				D2		D1		L1							
order number	catalog number	CSMS system size	CSWS system size	mm	in	mm	in	mm	in	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738503	BT50BSIF70063M	BT50	SIF70	70	3	38	1.496	63	2.480	121.808	170.004	170.005	125.625	4,08	9.000
3738504	BT50BSIF100068M	BT50	SIF100	100	4	58	2.283	68	2.677	121.812	170.004	170.006	–	4,94	10.890



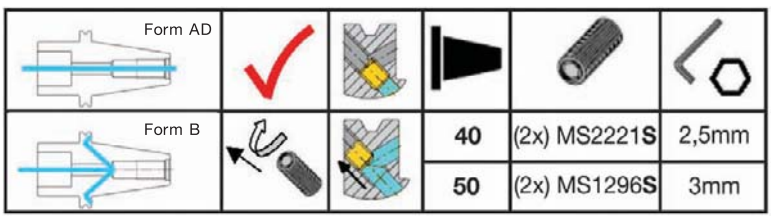
SIF-DV40 Form B/AD

				D2		D1		L1							
order number	catalog number	CSMS system size	CSWS system size	mm	in	mm	in	mm	in	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738488	DV40BSIF80061M	DV40	SIF80	80	3	38	1.496	61	2.402	121.812	170.004	170.005	125.625	1,83	4.020



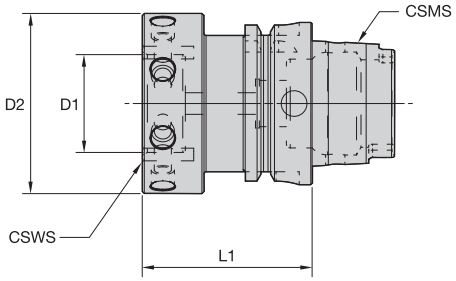
SIF-DV50 Form B/AD

				D2		D1		L1							
order number	catalog number	CSMS system size	CSWS system size	mm	in	mm	in	mm	in	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738490	DV50BSIF70060M	DV50	SIF70	70	3	38	1.496	60	2.362	121.808	170.004	170.005	125.625	3,60	7.930
3738491	DV50BSIF100060M	DV50	SIF100	100	4	58	2.283	60	2.362	121.812	170.004	170.006	–	4,30	9.480



- Through-the-toolholder coolant capability.
- Suitable for SIF adapters.







SIF-HSK63 Form A

order number	catalog number	CSMS system size	CSWS system size	D2 mm	D2 in	D1 mm	D1 in	L1 mm	L1 in	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738508	**HSK63ASIF70066M**	HSK63A	SIF70	70	3	38	1.496	66	2.598	**121.808**	**170.004**	**170.005**	**125.625**	1,44	3.180
3878347	**HSK63ASIF80063M**	HSK63A	SIF80	80	3	38	1.496	63	2.480	**121.812**	**170.004**	**170.005**	**125.625**	1,48	3.250

SIF-HSK80 Form A

order number	catalog number	CSMS system size	CSWS system size	D2 mm	D2 in	D1 mm	D1 in	L1 mm	L1 in	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738510	**HSK80ASIF70066M**	HSK80A	SIF70	70	3	38	1.496	66	2.598	**121.808**	**170.004**	**170.005**	**125.625**	2,05	4.520

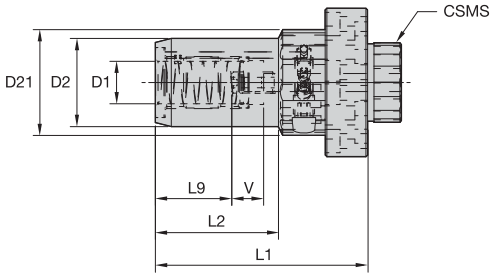
NOTE: HSK coolant unit and wrench are available and must be ordered separately.

SIF-HSK100 Form A

order number	catalog number	CSMS system size	CSWS system size	D2 mm	D2 in	D1 mm	D1 in	L1 mm	L1 in	dog-point set screw	hex wrench	hex wrench	socket-head cap screw	kg	lbs
3738511	**HSK100ASIF70050M**	HSK100A	SIF70	70	3	38	1.496	50	1.969	**121.808**	**170.004**	**170.005**	**125.625**	2,43	5.360
3738512	**HSK100ASIF100070M**	HSK100A	SIF100	100	4	58	2.283	70	2.756	**121.812**	**170.004**	**170.006**	**–**	3,84	8.460

NOTE: HSK coolant unit and wrench are available and must be ordered separately.

- Runout < .0001" (0,003mm).
- External side actuation adjustment stop, giving 3/8" (10mm) axial adjustment.





HC HP Line • SIF70

order number	catalog number	CSMS system size	D1 mm	D1 in	D2 mm	D2 in	D21 mm	D21 in	L1 mm	L1 in	L2 mm	L2 in	L9 mm	L9 in	V mm	V in	hex wrench	T-handle hex wrench	kg	lbs
3667056	**SIF70HC12090M**	SIF70	12	.472	32	1.244	44	1.724	90	3.543	45	1.752	36	1.417	10	.394	**170.002**	**170.135**	1,13	2.49
3667057	**SIF70HC20100M**	SIF70	20	.787	42	1.636	44	1.724	100	3.937	58	2.283	41	1.614	10	.394	**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	catalog number	CSMS system size	D1 mm	D1 in	D2 mm	D2 in	D21 mm	D21 in	L1 mm	L1 in	L2 mm	L2 in	L9 mm	L9 in	V mm	V in	hex wrench	T-handle hex wrench	kg	lbs
3667058	**SIF80HC12090M**	SIF80	12	.472	32	1.244	50	1.963	90	3.543	45	1.752	36	1.417	10	.394	**170.002**	**170.135**	9,00	19.84
3667059	**SIF80HC20100M**	SIF80	20	.787	42	1.638	50	1.963	100	3.937	58	2.283	41	1.614	10	.394	**170.003**	**170.135**	1,60	3.53
3667060	**SIF80HC25100M**	SIF80	25	.984	50	1.959	54	2.118	100	3.937	51	2.008	47	1.850	10	.394	**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	catalog 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.

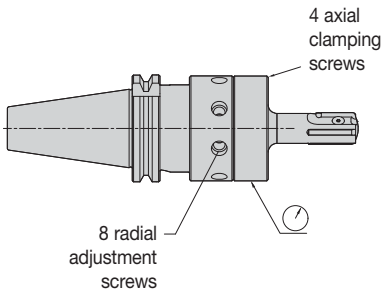
IMPORTANT: Do not overtorque clamp screw. Use supplied wrench and tighten by hand until stop is felt.

SIF Tooling Setup

Step 1: Rough setup of runout at flange

1

- Set gage (TIR) at SIF flange.
- Tight axial clamping screws 4.4–5.9 ft. lbs. (6–8 Nm).
- Use radial adjustment screws to achieve .0002" (5 µm) runout.

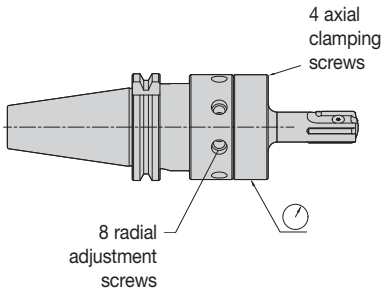




Step 2: Fine setup of runout at the flange

2

- Tight axial clamping screws crosswise:
  SIF70/80 13.3 ft. lbs. (18 Nm).
  SIF100 23.6 ft. lbs. (32 Nm).
- Use radial adjustment screws to achieve .00008" (2 µm) runout.
- All radial adjustment screws to be clamped tight at 3.0 ft. lbs. (4 Nm).

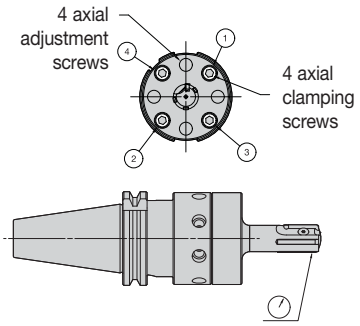




Step 3: Adjustment of runout at front

3

- Set gage (TIR) at control grind, cylindrical land, or guide pads.
- Use axial adjustment screws to achieve a maximum runout error of .00008" (2 µm).
- All axial adjustment screws to be clamped tight at 3.0 ft. lbs. (4 Nm).

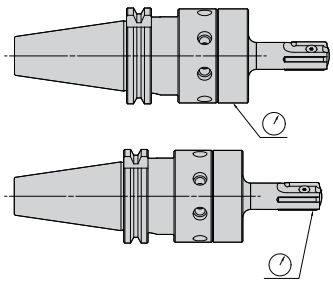




Step 4: Final runout check

4

- Check using gage (TIR) at flange; no deviation by theory.
- If needed, use radial adjustment screws to set runout below .00008" (2 µm).
- Any modification of radial setup demands an axial runout check and adjustment, if necessary.





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

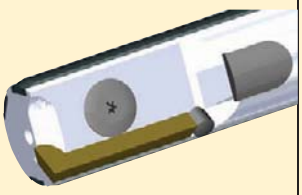
- Longer tool life with Kennametal grades.
- User friendly — RIQ padded reamers reduce setup time.
- Use four full edges even in PCD or PcBN styles of RIQ inserts.

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.

Customization

- 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.

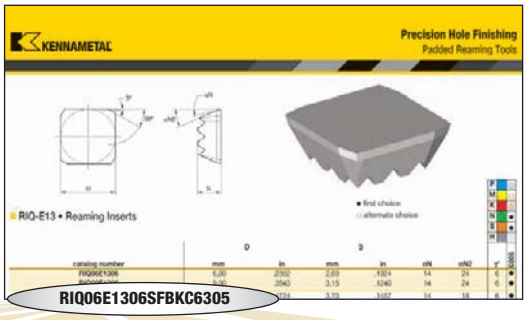

RIR™ Reamer


RIQ™ Reamer


RIQ™ Valve Seat Tool

How Do Catalog Numbers Work?

Each character in our catalog 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

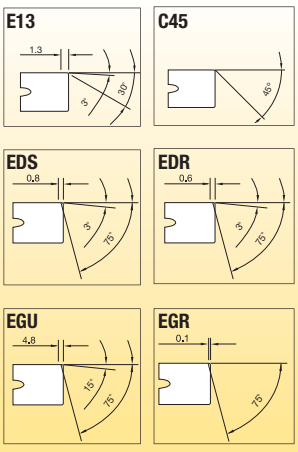
RIQ = Reamer Insert Quattro Cut™

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

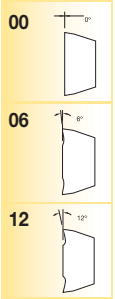
Ø [mm]	RIR	
6,0–7,99	**A0**	10,5 x 2,50mm
8,0–10,99	**01**	15,0 x 2,80mm
11,0–13,99	**02**	18,0 x 4,00mm
14,0–17,99	**03**	20,0 x 4,76mm
18,0–45,99	**04**	27,0 x 5,56mm
>46	**05**	27,0 x 6,75mm
Taper Reamer	**T4**	45,0 x 5,56mm

Cutting Lead



R = Radius Blade
R02
R04
R05

Rake Angle

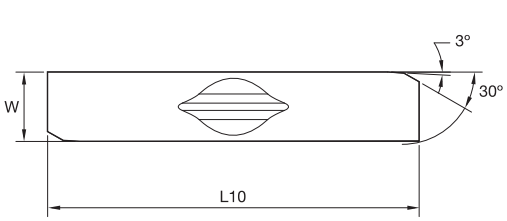


S  Chamfered and Rounded

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	●	●	○
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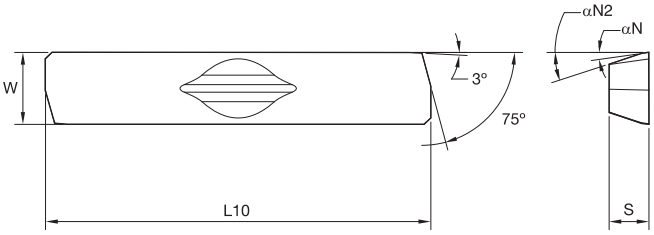
RIR-E13 • Reaming Inserts

ISO catalog number	ANSI catalog number	L10 mm	L10 in	S mm	S in	W mm	W in	αN°	αN2°	γ°	KC6005	KC6105	KC6305
RIR01E1306 *	RIR01E1306 *	15,00	.5906	1,53	.0602	2,80	.1102	8	18	6	–	●	–
RIR01E1312 *	RIR01E1312 *	15,00	.5910	1,53	.0600	2,80	.1100	8	18	12	–	●	–
RIR02E1312 *	RIR02E1312 *	18,00	.7090	1,93	.0760	4,00	.1575	8	18	12	–	●	●
RIR03E1312 *	RIR03E1312 *	20,00	.7870	2,33	.0920	4,76	.1870	8	18	12	–	–	●
RIR04E1312	RIR04E1312	27,00	1.0630	3,13	.1230	5,56	.2190	8	18	12	●	–	–
RIR04E1312 *	RIR04E1312 *	27,00	1.0630	3,13	.1230	5,56	.2190	8	18	12	–	●	–

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





● first choice
○ alternate choice

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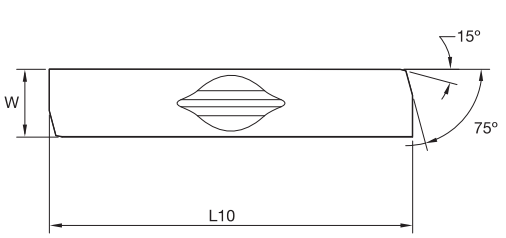
RIR-EDS • Reaming Inserts

ISO catalog number	ANSI catalog number	L10 mm	L10 in	S mm	S in	W mm	W in	αN°	αN2°	γ°	KD1415
RIR04EDS06 *	RIR04EDS06 *	27,00	1.0630	3,15	.1240	5,56	.2190	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

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K	●
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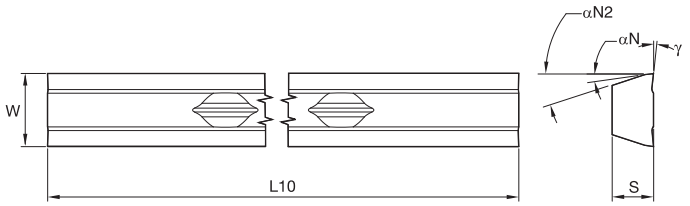
RIR-EGU • Reaming Inserts

ISO catalog number	ANSI catalog number	L10 mm	L10 in	S mm	S in	W mm	W in	αN°	αN2°	KC6105
RIR01EGU00	RIR01EGU00	14,48	.5699	1,55	.0610	2,80	.1100	8	18	
RIR05EGU00 *	RIR05EGU00 *	27,00	1.0630	3,15	.1240	6,75	.2660	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	●
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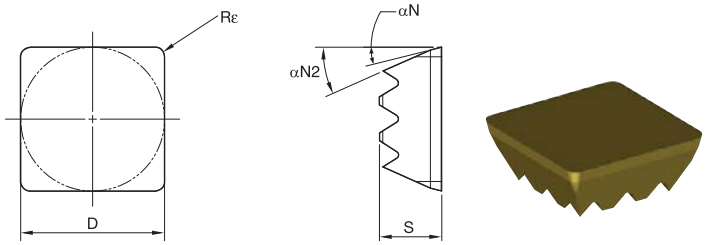
RIR-C45 • Reaming Inserts

ISO catalog number	ANSI catalog number	L10 mm	L10 in	S mm	S in	W mm	W in	αN°	αN2°	γ°	KC6005
RIRT4C4512	**RIRT4C4512**	45,00	1.7720	3,15	.1240	5,56	.2190	8	18	12	●

NOTE: For use with taper reamer bodies.



● first choice
○ alternate choice

P	
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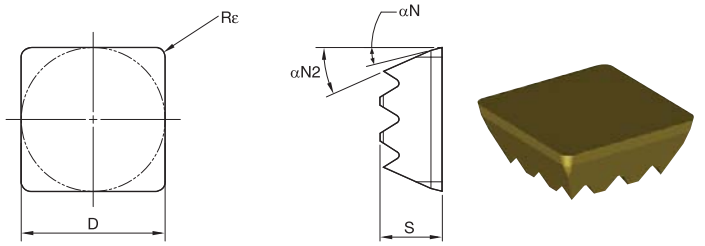
RIQ-R02 • Reaming Inserts

ISO catalog number	ANSI catalog number	D mm	D in	S mm	S in	Rε mm	Rε in	αN°	αN2°	γ°	KD1415
RIQ06R0200 *	**RIQ06R0200 ***	6,00	.2362	2,60	.1024	0,20	.0079	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	
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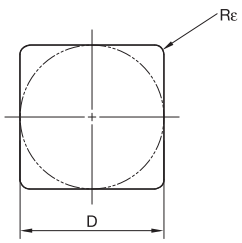
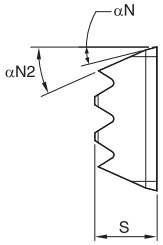
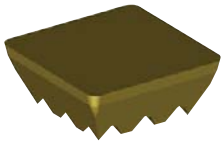
H	●

RIQ-R04 • Reaming Inserts

ISO catalog number	ANSI catalog number	D mm	D in	S mm	S in	Rε mm	Rε in	αN°	αN2°	γ°	KB1610	KT6225
RIQ06R0400S	**RIQ06R0400S**	6,00	.2362	2,60	.1024	0,40	.0160	8	18	0	●	–
RIQ09R0400S	**RIQ09R0400S**	9,00	.3540	3,15	.1240	0,40	.0160	8	18	0	●	–







● first choice
○ alternate choice

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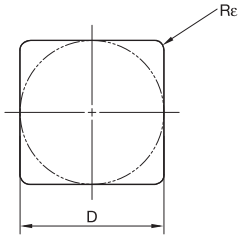
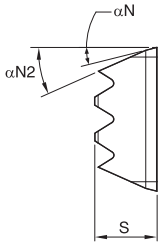
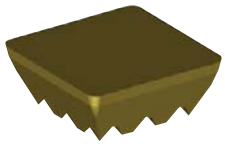
K	○	
N		
S		
H	●	

RIQ-R04-FB • Reaming Inserts • With Chipbreaker • For Blind Holes

ISO catalog number	ANSI catalog number	D mm	D in	S mm	S in	Rε mm	Rε in	αN°	αN2°	γ°	KB1610	KT6225
RIQ06R0400FB	RIQ06R0400FB	6,00	.2362	2,60	.1024	0,40	.0169	3	18	12	–	●
RIQ09R0400FB	RIQ09R0400FB	9,00	.3543	3,15	.1240	0,40	.0156	3	18	12	–	●







● first choice
○ alternate choice

P		●
M		○
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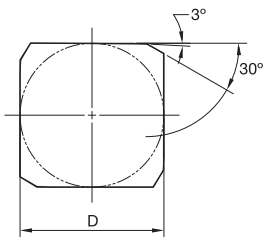
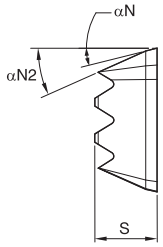
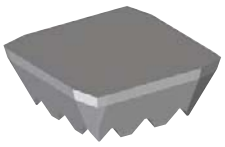
S		
H		

RIQ-R05 • Reaming Inserts • With Chipbreaker • For Through Holes

ISO catalog number	ANSI catalog number	D mm	D in	S mm	S in	Rε mm	Rε in	αN°	αN2°	γ°	KT6315
RIQ06R0500FT	RIQ06R0500FT	6,00	.2362	2,60	.1024	0,50	.0197	8	18	0	●
RIQ09R0506FT	RIQ09R0506FT	9,00	.3543	3,15	.1240	0,50	.0197	14	24	6	●







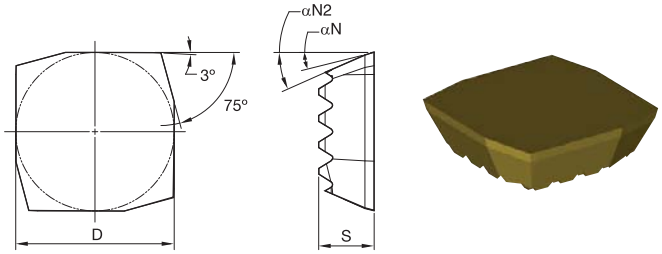
● first choice
○ alternate choice

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

RIQ-E13 • Reaming Inserts

ISO catalog number	ANSI catalog number	D mm	D in	S mm	S in	αN°	αN2°	γ°	KC6005	KC6105	KC6305
RIQ06E1300 *	RIQ06E1300 *	6,00	.2362	2,60	.1024	8	18	0	●	●	●
RIQ06E1306 *	RIQ06E1306 *	6,00	.2362	2,60	.1024	14	24	6	●	●	●
RIQ06E1312 *	RIQ06E1312 *	6,00	.2362	2,60	.1024	20	30	12	●	●	●
RIQ09E1300 *	RIQ09E1300 *	9,00	.3543	3,15	.1240	8	18	0	●	●	●
RIQ09E1306 *	RIQ09E1306 *	9,00	.3543	3,15	.1240	14	24	6	●	●	●
RIQ09E1312 *	RIQ09E1312 *	9,00	.3543	3,15	.1240	20	30	12	●	●	●

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



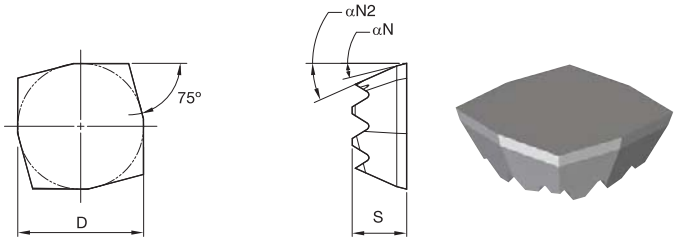
● first choice
○ alternate choice

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

RIQ-EDR • Reaming Inserts

ISO catalog number	ANSI catalog number	D mm	D in	S mm	S in	αN°	αN2°	γ°	KC6005	KC6105	KC6305	KD1415
RIQ06EDR00	RIQ06EDR00	6,00	.2362	2,60	.1024	8	18	0	●	–	●	–
RIQ06EDR00 *	RIQ06EDR00 *	6,00	.2362	2,60	.1024	8	18	0	–	●	–	–
RIQ06EDR06 *	RIQ06EDR06 *	6,00	.2362	2,60	.1024	14	24	6	●	–	–	–
RIQ06EDR06	RIQ06EDR06	6,00	.2362	2,60	.1024	14	24	6	–	●	●	●
RIQ06EDR12 *	RIQ06EDR12 *	6,00	.2362	2,60	.1024	20	30	12	●	●	●	–
RIQ09EDR00 *	RIQ09EDR00 *	9,00	.3543	3,15	.1240	8	18	0	●	●	●	–
RIQ09EDR06 *	RIQ09EDR06 *	9,00	.3543	3,15	.1240	14	24	6	●	●	●	●
RIQ09EDR12 *	RIQ09EDR12 *	9,00	.3543	3,15	.1240	20	30	12	●	●	●	–

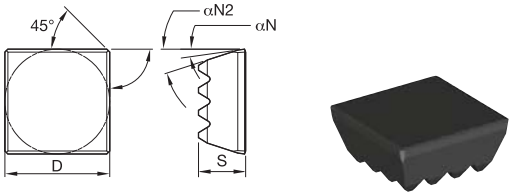
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.



RIQ-EGR • Reaming Inserts

ISO catalog number	ANSI catalog number	D mm	D in	S mm	S in	αN°	αN2°	γ°	KC6005	KC6105	KC6305	KD1415
RIQ06EGR00	RIQ06EGR00	6,00	.2362	2,60	.1020	8	18	0	●	–	–	–
RIQ06EGR00 *	RIQ06EGR00 *	6,00	.2362	2,60	.1020	8	18	0	–	●	●	–
RIQ06EGR06	RIQ06EGR06	6,00	.2362	2,60	.1020	14	24	6	●	–	–	●
RIQ06EGR06 *	RIQ06EGR06 *	6,00	.2362	2,60	.1020	14	24	6	–	●	●	–
RIQ06EGR12 *	RIQ06EGR12 *	6,00	.2362	2,60	.1020	20	30	12	●	●	●	–
RIQ09EGR00	RIQ09EGR00	9,00	.3543	3,15	.1240	8	18	0	●	–	–	–
RIQ09EGR00 *	RIQ09EGR00 *	9,00	.3543	3,15	.1240	8	18	0	–	●	●	–
RIQ09EGR06 *	RIQ09EGR06 *	9,00	.3543	3,15	.1240	14	24	6	●	●	–	–
RIQ09EGR06	RIQ09EGR06	9,00	.3543	3,15	.1240	14	24	6	–	–	●	●
RIQ09EGR12 *	RIQ09EGR12 *	9,00	.3543	3,15	.1240	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 catalog number	ANSI catalog number	D mm	D in	S mm	S in	αN°	αN2°	KBHK10	KBHK15
RIQB6C4500S	RIQB6C4500S	6,00	.2362	2,60	.1024	8	18	●	●
RIQB7C4500S	RIQB7C4500S	6,50	.2559	2,60	.1024	8	18	●	●
RIQ07C4500S	RIQ07C4500S	7,00	.2756	3,15	.1240	8	18	●	●
RIQ08C4500S	RIQ08C4500S	8,00	.3150	3,15	.1240	8	18	●	●
RIQ09C4500S	RIQ09C4500S	9,00	.3540	3,15	.1240	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 16 SFM (5 m/min), starting vc 33 SFM (10 m/min), max. vc 66 SFM (20 m/min).

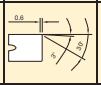
RIR™/RIQ™ • Inch

Material Group		Grade	Cutting Speed — vc Range — SFM min	Starting Value	max	Hole Types	1	2	3	4	5		
						Inch							
						Recommended Feed Rate per Tooth							
							E13	EDS	EDR	EGR	EGU	R0X	C45*
P	1	KC6005	98	**197**	328	IPR	0.004–0.008	–	–	–	–	–	0.008–0.012
	2	KC6005	66	**164**	295	IPR	0.004–0.008	–	–	–	–	–	0.008–0.012
	3	KC6005	66	**131**	262	IPR	0.002–0.008	–	–	–	–	–	0.008–0.012
		KT6225	394	**590**	787	IPR	–	–	–	–	–	0.006–0.008	–
		KT6315	394	**590**	787	IPR	–	–	–	–	–	0.006–0.008	–
	4	KC6005	49	**98**	164	IPR	0.002–0.008	–	–	–	–	–	0.008–0.012
		KC6105	49	**98**	164	IPR	0.002–0.008	–	–	–	–	–	–
		KT6225	394	**590**	787	IPR	–	–	–	–	–	0.006–0.008	–
		KT6315	394	**590**	787	IPR	–	–	–	–	–	0.006–0.008	–
	5	KC6105	33	**82**	131	IPR	0.002–0.008	–	–	–	–	–	–
	6	KC6105	33	**82**	131	IPR	0.002–0.008	–	–	–	–	–	–
M	1	KC6305	33	**82**	131	IPR	0.002–0.008	–	–	–	–	–	–
	2	KC6305	33	**82**	131	IPR	0.002–0.008	–	–	–	–	–	–
	3	KC6305	33	**82**	131	IPR	0.002–0.008	–	–	–	–	–	–
K	1	KC6005	66	**230**	328	IPR	0.004–0.008	0.006–0.008	0.006–0.008	0.007–0.008	–	–	0.008–0.012
		K6105	66	**230**	328	IPR	–	–	–	–	0.008	–	–
	2	KC6005	66	**197**	328	IPR	0.004–0.008	0.006–0.008	0.006–0.008	0.007–0.008	–	–	0.008–0.012
		K6105	66	**197**	328	IPR	–	–	–	–	0.008	–	–
	3	KC6005	66	**197**	328	IPR	0.004–0.008	0.005–0.008	0.005–0.008	0.006–0.008	0.007–0.008	–	0.008–0.012
N	1	KD1415	328	**820**	1968+	IPR	–	0.004–0.008	0.004–0.008	0.004–0.008	–	–	–
	2	KD1415	328	**820**	1968+	IPR	–	0.004–0.008	0.004–0.008	0.004–0.008	–	–	–
	3	KD1415	328	**820**	1968+	IPR	–	0.004–0.008	0.004–0.008	0.004–0.008	–	–	–
	4	KD1415	328	**820**	1968+	IPR	–	0.004–0.008	0.004–0.008	0.004–0.008	–	–	–
S	1	–	–	**–**	–	IPR	Recommendations available on request						
	2	–	–	**–**	–	IPR							
	3	–	–	**–**	–	IPR							
	4	–	–	**–**	–	IPR							
H	1	KB1610	492	**590**	656	IPR	–	–	–	–	–	0.002–0.004	–

*For taper reamers vc min 16 SFM (5 m/min), starting vc 33 SFM (10 m/min), max. vc 66 SFM (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
															R
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.

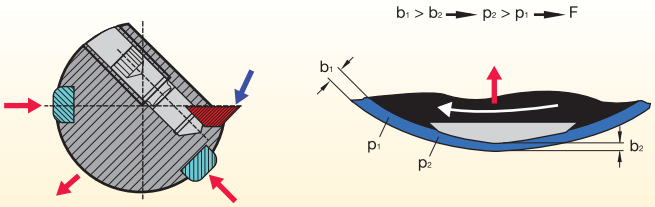
coolant selection		
	recommended	alternative
material type	mineral-oil-based emulsions	semi-synthetic
steel	6%	10%
nickel chrome steel	6%	12%
stainless steel	6%	12%
cast iron	6%	6%
aluminum	6%	12%
zinc alloys	6%	12%
copper	6%	12%
brass	6%	6%

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

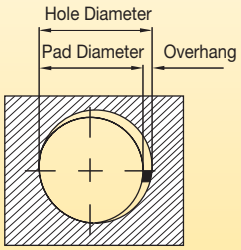
The Kennametal padded reaming tools follow two basic rules. The result, perfectly cylindrical bores with exceptional straightness and superior surface finishes combined with a bore diameter tolerance held to microns:

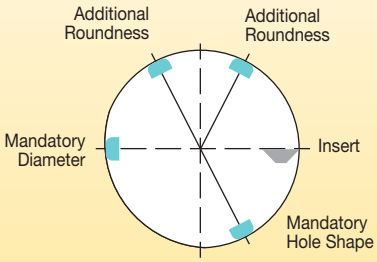
1. A SINGLE-POINT BORING TOOL SUPPORTED BY BEARING PADS, FLOATING ON A COOLANT FILM.
2. A TOOL MUST DEFLECT ONTO THE PADS, ON ENTERING THE HOLE, IN ORDER TO OBTAIN THE CORRECT SIZE.



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.

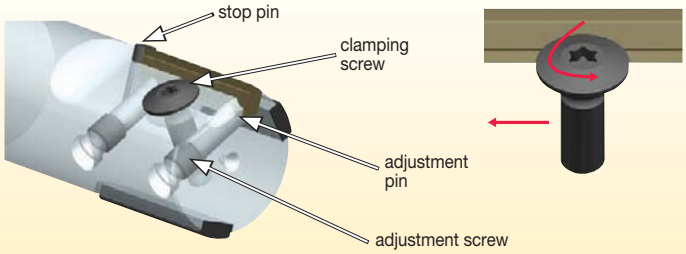
As padded reamers are specifically ground, relative to diameter and tolerance, guide pads are not flexible or adjustable. The pad below the insert ensures hole roundness while the pad opposite the insert defines the bore diameter. Each further pad improves the roundness, straightness, and bridges interruptions 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			○		●		●

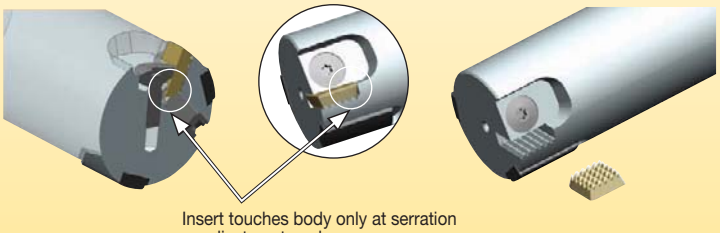
RIR Clamping



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

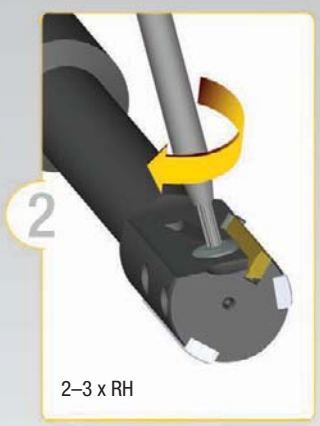
The proprietary adjustment wedge prevents any unpredictable rotation. This avoids errors during setup that cause tool damages.

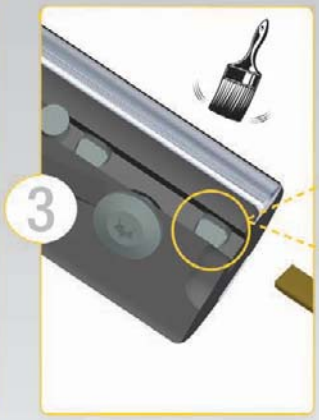
Adjustment Pin and Screw

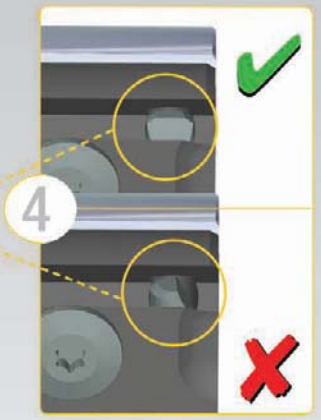


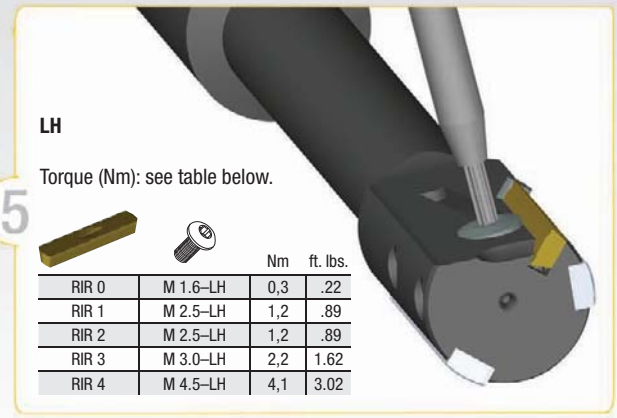
RIR Tooling Setup



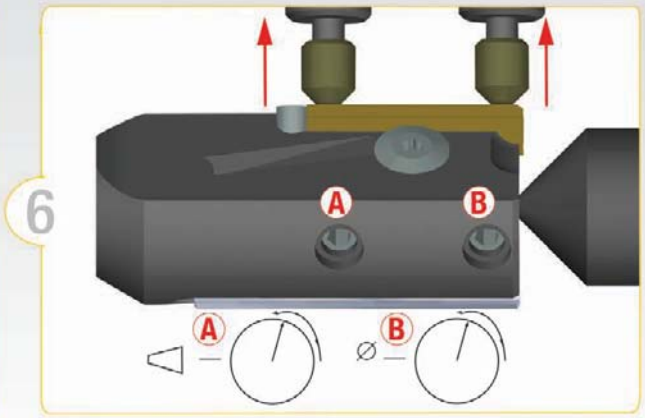






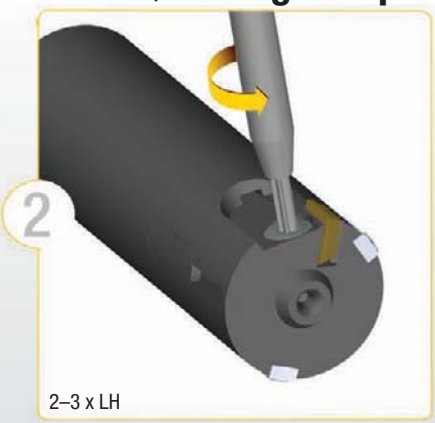


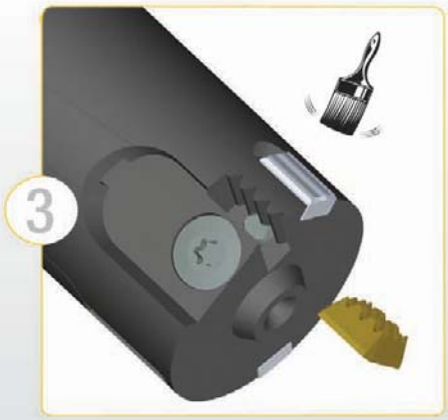
		Nm	ft. lbs.
RIR 0	M 1.6–LH	0,3	.22
RIR 1	M 2.5–LH	1,2	.89
RIR 2	M 2.5–LH	1,2	.89
RIR 3	M 3.0–LH	2,2	1.62
RIR 4	M 4.5–LH	4,1	3.02

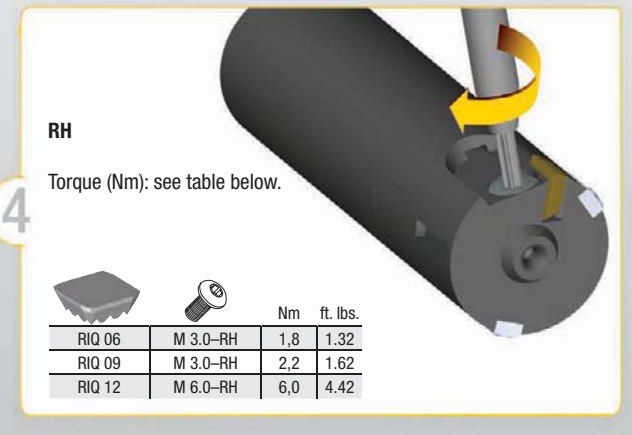


RIQ Tooling Setup

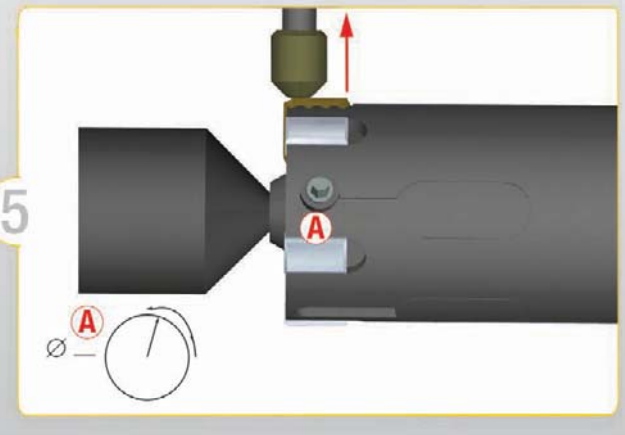






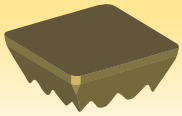


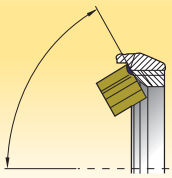
		Nm	ft. lbs.
RIQ 06	M 3.0–RH	1,8	1.32
RIQ 09	M 3.0–RH	2,2	1.62
RIQ 12	M 6.0–RH	6,0	4.42

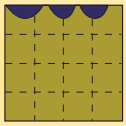


Valve Seat Tools • RIQ™ Quattro Cut™ Based Tooling

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 Center Solutions

RIQ valve seat tooling with integrated hydraulic chuck to clamp multiflute RMS™ or RIR™ guide pad reamer.

Machining Center • 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



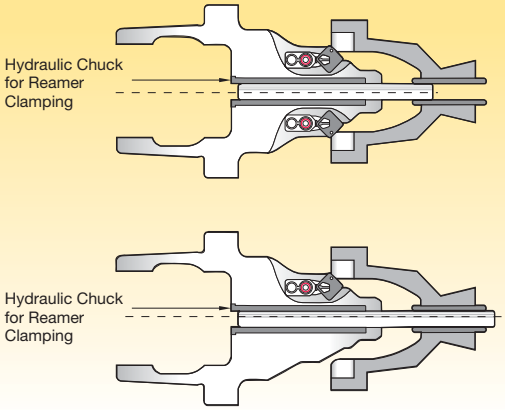
Machining Center Process • All Angles Formed to Finish Specifications in TWO Passes

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

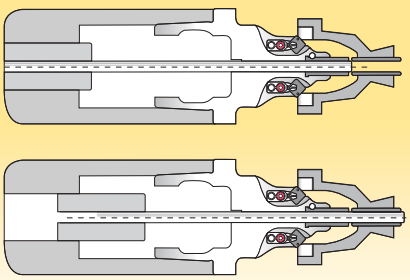


Transfer Line Process • All Angles Formed to Finish Specifications in TWO Passes/ONE Pass

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 center	❒ 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

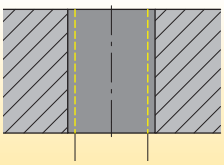
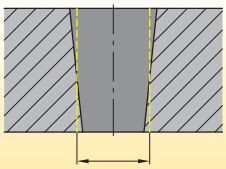
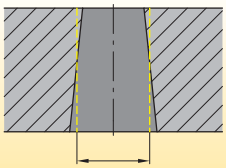
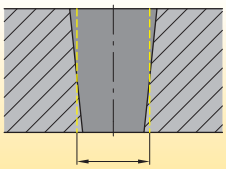
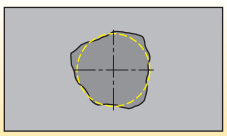
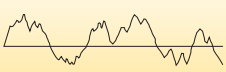
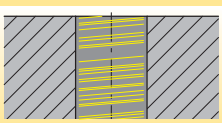
Additional Information: (e.g. interferences, weight or dimensional restrictions, customer reason for change, known issues,...)

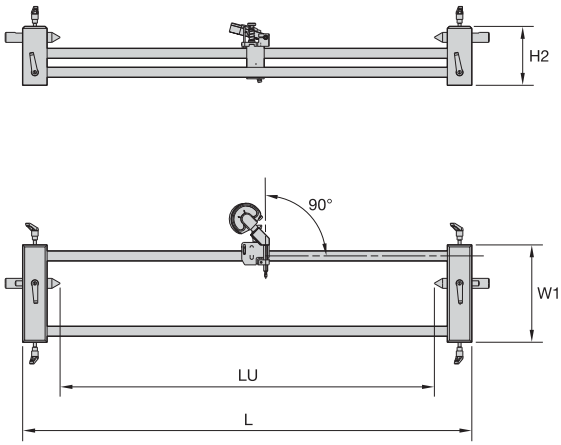
Quotation Processing Only with Workpiece Drawing and Filled Out Form

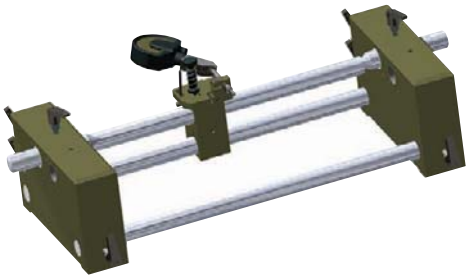
Reaming Allowances for Single Blade Reaming

		reaming allowance in diameter					
		mm			in		
mm	in	min	middle	max	min	middle	max
6,00–9,59	.189–.378	0,10	0,15	0,25	.004	.006	.010
9,60–15,00	.378–.591	0,15	0,20	0,30	.006	.008	.012
15,00–20,00	.591–.787	0,15	0,25	0,35	.006	.010	.014
20,00–50,00	.787–1.969	0,20	0,30	0,40	.008	.012	.016

Causes of and Remedies for Reaming Problems

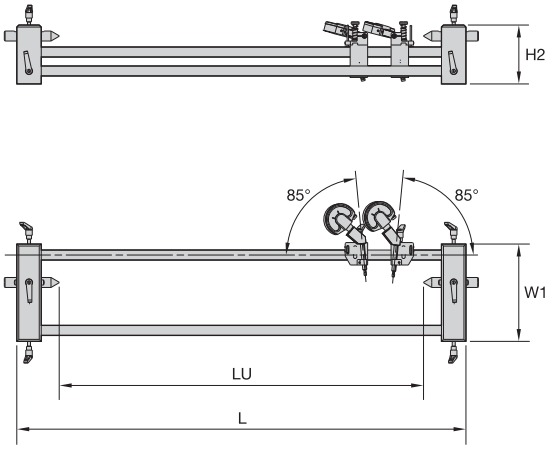
Problem		Cause	Possible Remedy
Drill diameter too large	 d_{Nom}	1. Reaming tool running out-of-center. 2. Concentricity of pilot hole and ream machining unsatisfactory. 3. Built-up edge. 4. Unsuitable cooling lubricant. 5. Reaming tool Ø too large.	• Use SIF™ equalizing adapter. • Re-align, use floating 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 equalizing adapter. • 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-center and/or showing chatter marks		1. Reaming tool running out-of-center. 2. Slanted cutting surface/asymmetrical cutting. 3. Workpiece twisted.	• Use SIF equalizing adapter. • 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-center. 3. Incorrect technology data (cutting parameters). 4. Inadequate chip evacuation.	• Replace and refit tool. • Use SIF equalizing adapter. • Change cutting parameters in machining range. • Optimize coolant supply; increase coolant pressure and volume.
Feed grooves		1. Built-up edge.	• Change cooling lubricant. • Change cutting speed.

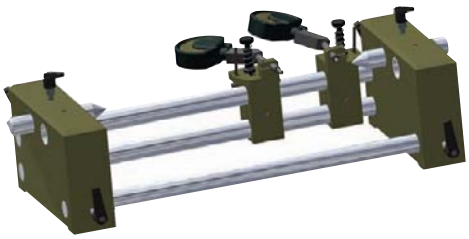




Setting Fixture • One Gage

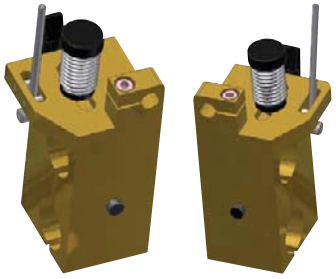
		H2		L		LU		W1	
order number	catalog number	mm	in	mm	in	mm	in	mm	in
5025599	SF300M1RS	118	4.646	450	17.717	300	11.811	195	7.677
5025670	SF750M1RS	118	4.646	900	35.443	750	29.527	195	7.677





Setting Fixture • Two Gage

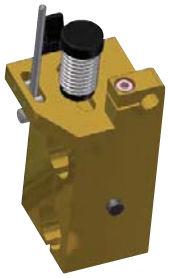
		H2		L		LU		W1	
order number	catalog number	mm	in	mm	in	mm	in	mm	in
5025597	SF300M1LA1RA	118	4.646	450	17.717	300	11.811	195	7.677
5025598	SF750M1LA1RA	118	4.646	900	35.443	750	29.527	195	7.677



Left Hand Right Hand

Axial Slide • 90° with Angle Fine Adjustment

order number	catalog number
5025672	SFSLLS
5025671	SFSLRS



SM Screw Sets for Slides

Axial Slides

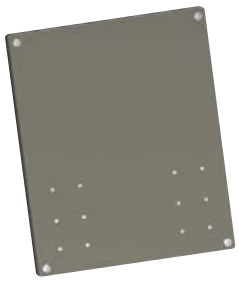
order number	catalog number
5025683	SFSLSS



Left Hand Right Hand

Axial Slide • 85°

order number	catalog number
5025674	SFSLLA
5025673	SFSLRA



Base Plate for Vertical Setup

order number	catalog number
5025680	SFVB



SM Clamp Handle

Clamp Handle for End Blocks and Axial Slides

order number	catalog number
5025682	SFEBCH



SM End Block

End Block Including Screws

order number	catalog number
5025681	SFEBS



Contact Pins Set

order number	catalog number
5025686	SFCPS



Support Bars (450mm and 900mm)

order number	catalog number
5025684	SFSB450
5025685	SFSB900



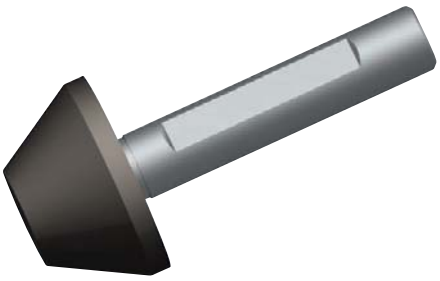
Gage Set

order number	catalog number
5025675	SFMGS



Spring-Loaded Center Ø 20mm

order number	catalog number
5025679	SFCR20S



HSK Center

order number	catalog number
5025677	SFCRHSK3263
5025678	SFCRHSK63100



Standard Center Ø 20mm

order number	catalog 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.

Customization

- Engineered solutions available for multistep or high length-to-diameter tooling.
- Anti-chatter devices and various non-standard machine spindle coupling sizes available.



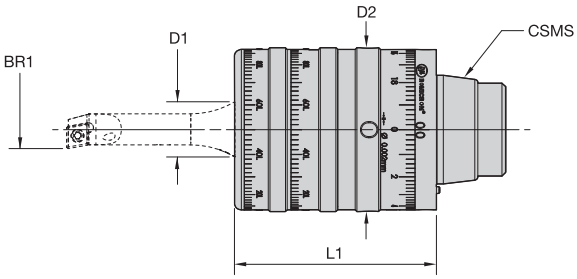
Boring range, coolant capacity, and maximum RPM features for all Romicron boring heads.

	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**	.157" 4mm — .650" 16,5mm
• 10,000 RPM max. • Balanceable. • 1,050 psi coolant capacity. • 1,050 psi/70 bar coolant capacity. • Movable zero reference.	**SVUBB2**	.236" 6mm — 1.00" 25,5mm
• 20,000 RPM. • Prebalanced. • 1740 psi/120 bar coolant capacity.	**AVS00B**	.984" 25mm — 1.26" 32mm
• 20,000 RPM. • Prebalanced. • 1740 psi/120 bar coolant capacity.	**AVS0B**	1.24" 31,5mm — 1.67" 42,5mm
• 20,000 RPM. • Prebalanced. • 1740 psi/120 bar coolant capacity.	**AVS1B**	1.65" 42mm — 2.08" 53mm
• 20,000 RPM. • Prebalanced. • 1740 psi/120 bar coolant capacity.	**AVS2B**	2.04" 52mm — 2.59" 66mm
• 20,000 RPM. • Prebalanced. • 1740 psi/120 bar coolant capacity.	**AVS3B**	2.55" 65mm — 3.11" 79mm
• 4,500 RPM. • Prebalanced. • 300 psi/20 bar coolant capacity.	**SVS4B**	3.07" 78mm — 3.85" 98mm
• 4,500 RPM. • Prebalanced. • 300 psi/20 bar coolant capacity.	**SVS5B**	3.81" 97mm — 4.60" 117mm
• 3,500 RPM. • Prebalanced. • 300 psi/20 bar coolant capacity.	**SVS6B**	4.56" 116mm — 5.47" 139mm
• 6,000 RPM. • Balanceable. • 300 psi/20 bar coolant capacity. • Movable zero reference.	**SVU65**	2.79" 71mm — 4.37" 111mm
• 6,000 RPM. • Balanceable. • 300 psi/20 bar coolant capacity. • Movable zero reference.	**SVU92**	3.97" 101mm — 8.38" 213mm
• 6,000 RPM. • Balanceable. • 300 psi/20 bar coolant capacity. • Movable zero reference.	**SVU120**	5.47" 139mm — 12.83" 326mm

range mm	range in	order number	catalog number	content	
4,00–16,50	.1575–.6496	**4046076**	**SVUBB1KR32KIT**	KR32SVUBB1060M KRBB10FADRS102C KRBB10SCLDRS4060C KRBB10SCFPR06085C KRBB10SCFPR06110C KRBB10SCFPR06135C	
6,00–25,50	.2362–1.0040	**4046077**	**SVUBB2KR32KITD025M**	KR32SVUBB2085M KRBB16SCLDRS4060A KRBB16SCFPR06085A KRBB16SCFPR06110A KRBB16SCFPR06135A KRBB16SCFPR06160A KRBB16SCFPR06190A KRBB16SCFPR06220A	
6,00–25,50	.2362–1.0040	**4046078**	**SVUBB2KR50KITD025M**	KRBB16SCFPR06220A KR50SVUBB2075M KRBB16SCLDRS4060A KRBB16SCFPR06085A KRBB16SCFPR06110A KRBB16SCFPR06135A KRBB16SCFPR06160A KRBB16SCFPR06190A KRBB16SCFPR06220A	
6,00–100,00	.2362–3.9370	**4052608**	**SVUBB2KR32KITD100M**	KR32SVUBB2085M KRBB16SCLDRS4060A KRBB16SCFPR06085A KRBB16SCFPR06110A KRBB16SCFPR06135A KRBB16SCFPR06160A KRBB16SCFPR06190A KRBB16SCFPR06220A KRDEA046AM KRDE025010M KRDE033010M KRDEA051AM KRDE043010M KRDEA012AM KRDE065012M KRCW032A	
6,00–100,00	.2362–3.9370	**4052609**	**SVUBB2KR50KITD100M**	KR50SVUBB2075M KRBB16SCLDRS4060A KRBB16SCFPR06085A KRBB16SCFPR06110A KRBB16SCFPR06135A KRBB16SCFPR06160A KRBB16SCFPR06190A KRBB16SCFPR06220A KRDEA046AM KRDE025010M KRDE033010M KRDEA051AM KRDE043010M KRDEA012AM KRDE065012M KRCW032A	

- For correct balance ring settings, see page K100–K101.
- Order boring bar separately; see page K78.
- Order taper shank seperately; see page K91.





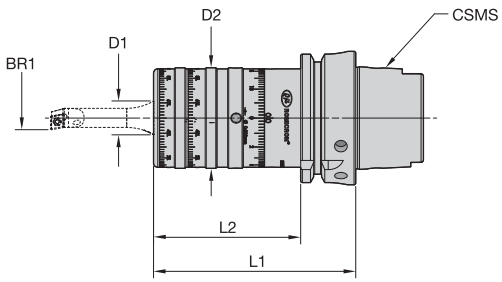


SVU BB1 • KR Back End with CLB Capability

		BR1 bore range			D1		D2		L1					
order number	catalog number	mm	in	CSMS system size	mm	in	mm	in	mm	in	Torx wrench	hex wrench	kg	lbs
4054737	KR32SVUBB1060MCLB	4,000-16,500	0.1575-0.6496	KR32	10,0	.39	46,5	1.83	58,6	2.31	KT8	170.000	0,94	2.07

- For correct balance ring settings, see page K100–K101.
- Order boring bar separately; see page K78.





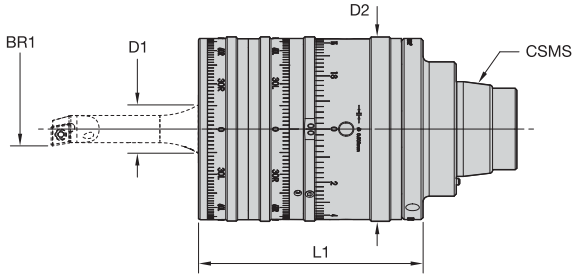


SVU BB1 • HSK Back End with CLB Capability

		BR1 bore range			D1		D2		L1		L2				
order number	catalog number	mm	in	CSMS system size	mm	in	mm	in	mm	in	mm	in	Torx wrench	radial adjusting screw	kg	lbs
4054734	HSK63ASVUBB1095MCLB	4,000-16,500	0.1575-0.6496	HSK63A	10,0	.39	46,5	1.83	95,5	3.76	69,4	2.73	KT15	191.282	1,45	3.20

- For correct balance ring settings, see page K102–K107.
- Order boring bar separately; see page K79.
- Order taper shank separately; see page K91.





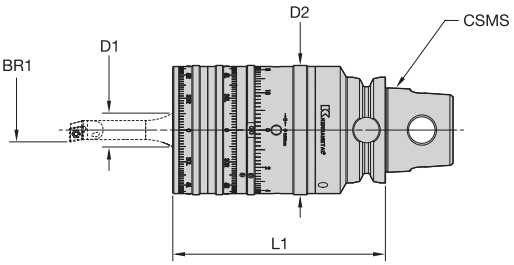


SVU BB2 • KR Back End with CLB Capability

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D1 mm	D1 in	D2 mm	D2 in	L1 mm	L1 in	Torx wrench	kg	lbs
4054738	KR32SVUBB2085MCLB	6,000-25,500	0.2362-1.0039	KR32	16,0	.63	60,0	2.36	85,0	3.35	KT27	1,81	3.99
4054739	KR50SVUBB2075MCLB	6,000-25,500	0.2362-1.0039	KR50	16,0	.63	60,0	2.36	75,0	2.95	KT27	1,61	3.55

- For correct balance ring settings, see page K102–K107.
- Order boring bar separately; see page K79.





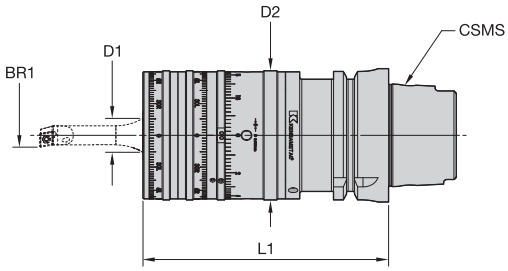


SVU BB2 • KM™ Back End with CLB Capability

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D1 mm	D1 in	D2 mm	D2 in	L1 mm	L1 in	Torx wrench	kg	lbs
4054736	KM50TSSVUBB2100MCLB	6,000-25,500	0.2362-1.0039	KM50TS	16,0	.63	60,0	2.36	100,0	3.94	KT27	1,91	4.21

- For correct balance ring settings, see page K102–K107.
- Order boring bar separately; see page K79.



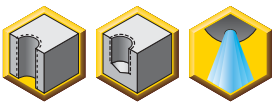


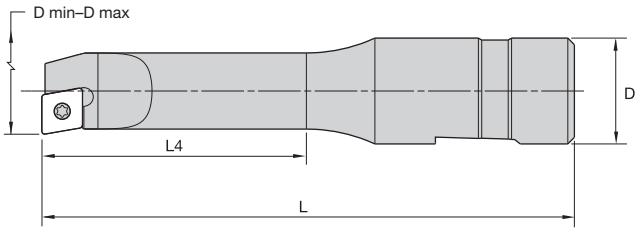


SVU BB2 • HSK Back End with CLB Capability

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D1 mm	D1 in	D2 mm	D2 in	L1 mm	L1 in	Torx wrench	kg	lbs
4054735	**HSK63ASVUBB2116MCLB**	6,000-25,500	0.2362-1.0039	HSK63A	16,0	.63	60,0	2.36	116,0	4.57	**KT27**	2,52	5.56
4054733	**HSK100ASVUBB2124MCLB**	6,000-25,500	0.2362-1.0039	HSK100A	16,0	.63	60,0	2.36	124,4	4.90	**KT27**	4,21	9.28

- Order inserts separately.





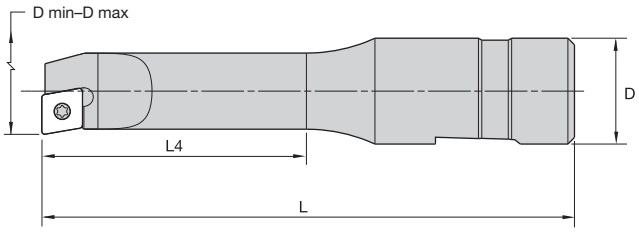


SVU BB1 • Universal Boring Bars

order number	catalog number	D min mm	D min in	D max mm	D max in	D mm	D in	L mm	L in	L4 mm	L4 in	gage insert	insert screw	Torx wrench	kg	lbs
2202438	**KRBB10FABDRS204C**	4,00	.158	7,00	.276	10	.394	57	2.23	14	.56	–	**–**	**–**	0,05	.11
2202439	**KRBB10SCLDR4060C**	6,00	.236	9,00	.354	10	.394	53	2.09	22	.85	CD..S4T004	**MS1454**	**FT5**	0,05	.11
2202440	**KRBB10SCFPR06085C**	8,50	.335	11,50	.453	10	.394	58	2.28	31	1.20	CP..060204	**MS2005**	**FT7**	0,08	.17
2202450	**KRBB10SCFPR06110C**	11,00	.433	14,00	.551	10	.394	60	2.36	33	1.28	CP..060204	**MS2005**	**FT7**	0,08	.18
2202451	**KRBB10SCFPR06135C**	13,50	.532	16,50	.650	10	.394	65	2.56	39	1.52	CP..060204	**MS1153**	**FT7**	0,09	.20

NOTE: Carbide shank and customized boring bars are available upon request to meet your specific requirements.
Please contact Kennametal for a design and quotation.

- Order inserts separately.

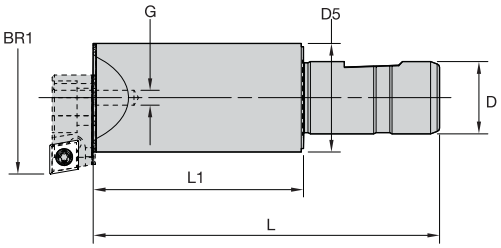




SVU BB2 • Universal Boring Bars

order number	catalog number	D min mm	D min in	D max mm	D max in	D mm	D in	L mm	L in	L4 mm	L4 in	gage insert	insert screw	Torx wrench	kg	lbs
1522063	KRBB16SCFPR06085A	8,50	.335	12,00	.472	16	.630	68	2.70	26	1.04	CP..060204	MS1153	FT7	0,06	.14
1522062	KRBB16SCLDRS406A	6,00	.236	9,50	.374	16	.630	62	2.44	20	.80	CD..S4T004	MS1454	FT6	0,06	.13
1522064	KRBB16SCFPR0611A	11,00	.433	14,50	.571	16	.630	78	3.09	36	1.42	CP..060204	MS1153	FT7	0,08	.17
1522068	KRBB16SCFPR06135A	13,50	.532	17,00	.669	16	.630	80	3.17	40	1.57	CP..060204	MS1153	FT7	0,09	.20
1522069	KRBB16SCFPR0616A	16,00	.630	19,50	.768	16	.630	90	3.54	55	2.17	CP..060204	MS1153	FT7	0,11	.25
1522070	KRBB16SCFPR0619A	19,00	.748	22,50	.886	16	.630	90	3.54	60	2.36	CP..060204	MS1153	FT7	0,12	.27
1522071	KRBB16SCFPR0622A	22,00	.866	25,50	1.004	16	.630	90	3.54	60	2.36	CP..060204	MS1153	FT7	0,15	.32

NOTE: Carbide shank and customized boring bars are available upon request to meet your specific requirements. Please contact Kennametal for a design and quotation.

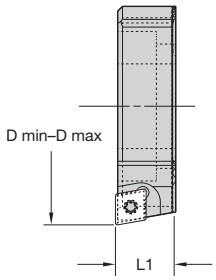


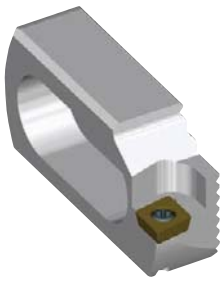


SVU BB2 • Universal Adapters

order number	catalog number	BR1 bore range mm	BR1 bore range in	D mm	D in	D5 mm	D5 in	G	L mm	L in	L1 mm	L1 in	kg	lbs
2541200	KRDEA046AM	25,500-43,500	1.0039-1.7126	16	.63	24,0	.94	M4X0.70	76,4	3.01	46,4	1.83	0,2	.50
2541201	KRDEA051AM	43,000-65,000	1.6929-2.5591	16	.63	25,0	.98	M6X1.00	81,7	3.22	51,7	2.04	0,2	.52
2541202	KRDEA012AM	65,000-100,000	2.5591-3.9371	16	.63	63,5	2.50	M8X1.25	42,5	1.67	12,5	.49	0,2	.42

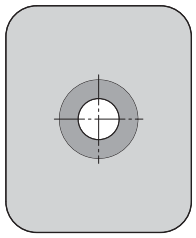
- Order inserts separately.

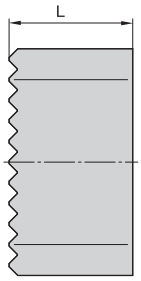


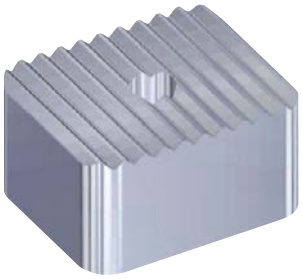


SVU BB2 • Universal Diameter Extenders

		D min		D max		L1						
order number	catalog number	mm	in	mm	in	mm	in	gage insert	insert screw	Torx wrench	kg	lbs
2541213	**KRDE025010M**	25,50	1.004	33,50	1.319	10,0	.39	CP..0602../CP..215...	**MS1153**	**FT7**	0,02	.04
2541214	**KRDE033010M**	33,50	1.319	43,50	1.713	10,0	.39	CP..0602../CP..215...	**MS1153**	**FT7**	0,02	.05
2541215	**KRDE043010M**	43,00	1.693	65,00	2.559	10,0	.39	CP..0602../CP..215...	**MS1153**	**FT7**	0,03	.07
2541216	**KRDE065012M**	65,00	2.559	100,00	3.937	12,0	.47	CP..0602../CP..215...	**MS1153**	**FT7**	0,05	.10







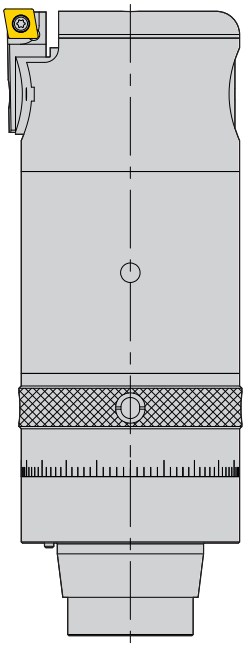
SVU BB2 • Counterweight

		L			
order number	catalog number	mm	in	kg	lbs
2541217	**KRCW032A**	12,0	.47	0,04	.08

NOTE: Counterweight must be used with KRDEA012M adapter and KRDEA065012M extender.

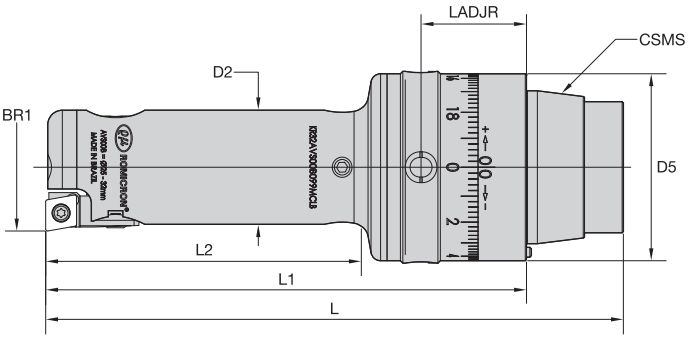
AVS and SVS Systems • Tooling Tree

cartridge range	cartridge size	bore range	head size
.984–1.083" (25–27,5mm)	1Y	.984–1.260" (25–32mm)	AVS00B
1.073–1.171" (27,25–29,75mm)	2Y		
1.161–1.260" (29,5–32mm)	3Y		
1.240–1.398" (31,5–35,5mm)	1X	1.240–1.673" (31,5–42,5mm)	AVS0B
1.378–1.535" (35–39mm)	2X		
1.516–1.673" (38,5–42,5mm)	3X		
1.654–1.811" (42–46mm)	1X	1.654–2.087" (42–53mm)	AVS1B
1.791–1.949" (45,5–49,5mm)	2X		
1.929–2.087" (49–53mm)	3X		
2.047–2.244" (52–57mm)	1W	2.047–2.598" (52–66mm)	AVS2B
2.224–2.421" (56,5–61,5mm)	2W		
2.402–2.598" (61–66mm)	3W		
2.559–2.756" (65–70mm)	1W	2.559–3.110" (65–79mm)	AVS3B
2.736–2.933" (69,5–74,5mm)	2W		
2.913–3.110" (74–79mm)	3W		



- Order cartridges separately.
- Order taper shank separately.





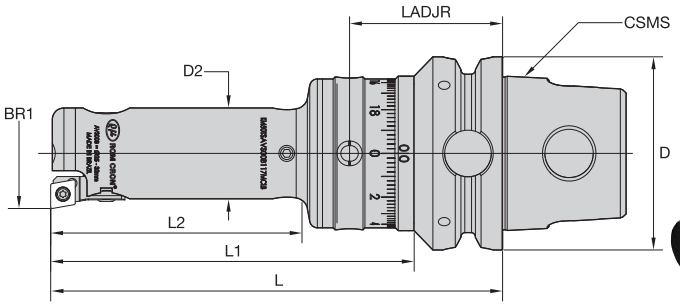


AVS • KR Back End with CLB Capability

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D2 mm	D2 in	D5 mm	D5 in	L mm	L in	L1 mm	L1 in	L2 mm	L2 in	LADJR mm	LADJR in	kg	lbs
5124812	KR32AVS00B099MCLB	25,000-32,000	0.9840-1.2600	KR32	23,5	.93	39,5	1.56	119,0	4.68	99,0	3.90	64,0	2.50	21,7	.86	0,6	1.20
5124814	KR32AVS0B116MCLB	31,500-42,500	1.2400-1.6730	KR32	30,0	1.18	39,5	1.55	136,0	5.36	116,0	4.57	85,0	3.35	21,7	.86	0,8	1.81
5124816	KR32AVS1B100MCLB	42,000-53,000	1.6530-2.0860	KR32	38,5	1.52	39,5	1.55	120,0	4.73	100,0	3.94	100,0	3.94	21,7	.85	1,0	2.13
5124818	KR32AVS2B115MCLB	52,000-66,000	2.0470-2.5980	KR32	47,0	1.85	48,0	1.89	135,0	5.32	115,0	4.53	115,0	4.53	29,2	1.15	1,5	3.27
5124820	KR32AVS3B115MCLB	65,000-79,000	2.5590-3.1100	KR32	47,0	1.85	48,0	1.89	135,0	5.32	115,0	4.53	115,0	4.53	29,2	1.15	1,5	3.36

- Order cartridges separately.





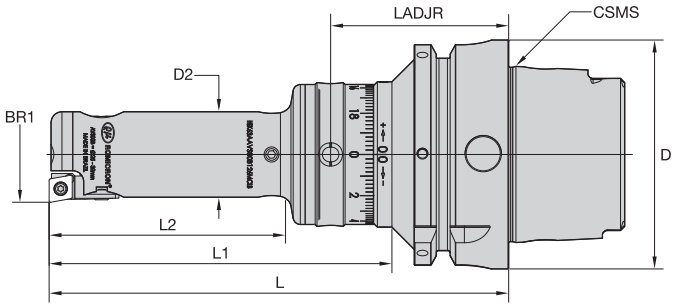


AVS • KM™ Back End with CLB Capability

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D mm	D in	D2 mm	D2 in	L mm	L in	L1 mm	L1 in	L2 mm	L2 in	LADJR mm	LADJR in	kg	lbs
5124801	KM40TSAVS00B111MCLB	25.000-32.000	0.9840-1.2600	KM40TS	40,000	1.5730	23,5	.93	136,0	5.36	111,0	4.38	63,5	2.50	34,0	1.34	0,6	1.36
5124802	KM40TSAVS0B128MCLB	31.500-42.500	1.2400-1.6730	KM40TS	40,000	1.5730	30,0	1.18	153,0	6.04	128,0	5.06	—	—	34,0	1.34	0,8	1.82
5124803	KM40TSAVS1B112MCLB	42.000-53.000	1.6530-2.0860	KM40TS	40,000	1.5730	38,5	1.52	137,0	5.40	112,0	4.42	112,0	4.42	34,0	1.34	1,0	2.18
5124804	KM40TSAVS2B127MCLB	52.000-66.000	2.0470-2.5980	KM40TS	40,000	1.5730	47,0	1.85	152,0	6.00	127,0	5.01	127,0	5.01	41,3	1.63	1,6	3.41
5124805	KM50TSAVS00B117MCLB	25.000-32.000	0.9840-1.2600	KM50TS	50,000	1.9670	23,5	.93	149,0	5.86	117,0	4.60	63,5	2.50	39,7	1.56	0,8	1.79
5124807	KM50TSAVS0B134MCLB	31.500-42.500	1.2400-1.6730	KM50TS	50,000	1.9670	30,0	1.18	166,0	6.53	134,0	5.27	83,0	3.27	39,7	1.56	1,0	2.25
5124808	KM50TSAVS1B118MCLB	42.000-53.000	1.6530-2.0860	KM50TS	50,000	1.9670	38,5	1.52	150,0	5.90	118,0	4.65	—	—	39,6	1.56	1,2	2.57
5124809	KM50TSAVS2B128MCLB	52.000-66.000	2.0470-2.5980	KM50TS	50,000	1.9670	47,0	1.85	160,0	6.31	128,0	5.05	128,0	5.05	42,3	1.67	1,7	3.67
5124810	KM50TSAVS3B128MCLB	65.000-79.000	2.5590-3.1100	KM50TS	50,000	1.9670	47,0	1.85	160,0	6.31	128,0	5.05	128,0	5.05	42,3	1.67	1,7	3.82
5124811	KM63TSAVS3B130MCLB	65.000-79.000	2.5590-3.1100	KM63TS	63,000	2.4780	47,0	1.85	170,0	6.70	130,0	5.13	130,0	5.13	44,3	1.74	2,0	4.46

- Order cartridges separately.



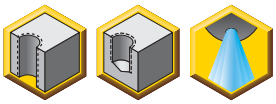


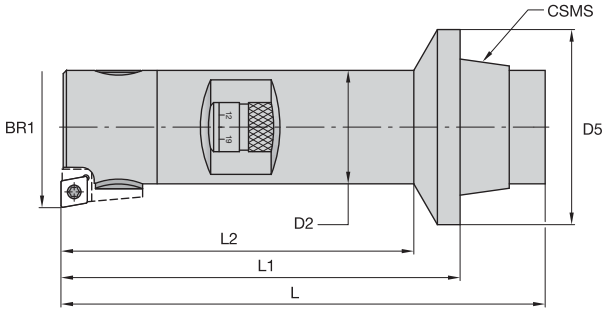


AVS • HSK Back End with CLB Capability

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D mm	D in	D2 mm	D2 in	L mm	L in	L1 mm	L1 in	L2 mm	L2 in	LADJR mm	LADJR in	kg	lbs
5124576	**HSK63AAVS00B126MCLB**	25.000-32.000	0.9840-1.2600	HSK63A	63,000	.2478	23,5	.93	158,0	6.23	126,0	4.97	63,5	2.50	49,0	1.93	1,2	2.71
5124577	**HSK63AAVS0B143MCLB**	31.500-42.500	1.2400-1.6730	HSK63A	63,000	.2478	30,0	1.18	175,0	6.89	143,0	5.64	83,0	3.27	49,0	1.93	1,4	3.17
5124578	**HSK63AAVS1B127MCLB**	42.000-53.000	1.6530-2.0860	HSK63A	63,000	.2478	38,5	1.52	159,0	6.27	127,0	5.02	95,0	3.75	49,0	1.93	1,6	3.53
5124579	**HSK63AAVS2B139MCLB**	52.000-66.000	2.0400-2.5900	HSK63A	63,000	.2478	47,0	1.85	171,0	6.75	139,0	5.47	109,0	4.31	53,5	2.11	2,2	4.73
5124800	**HSK63AAVS3B139MCLB**	65.000-79.000	2.5500-3.1100	HSK63A	63,000	.2478	47,0	1.85	171,0	6.75	139,0	5.47	109,0	4.30	53,5	2.11	2,2	4.85

- Order cartridges separately; see page K86.
- Order taper shank separately; see page K91.





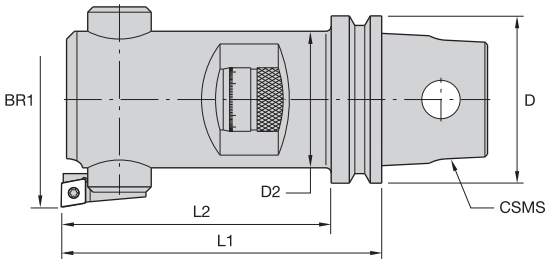


SVS • KR Back End

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D2 mm	D2 in	L mm	L in	L1 mm	L1 in	kg	lbs
1192281	**KR50SVS4B094M**	78,000-98,000	3.0709-3.8583	KR50	65,0	2.56	119,0	4.69	94,0	3.70	2,4	5.21
1279787	**KR50SVS5B094M**	97,000-117,000	3.8189-4.6063	KR50	65,0	2.56	119,0	4.69	94,0	3.70	3,0	6.49
1279793	**KR63SVS6B126M**	116,000-139,000	4.5669-5.4724	KR63	85,0	3.35	162,0	6.38	126,0	4.96	5,7	12.63

- Order cartridges separately; see page K86.



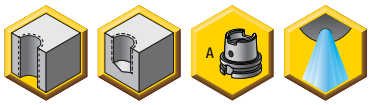


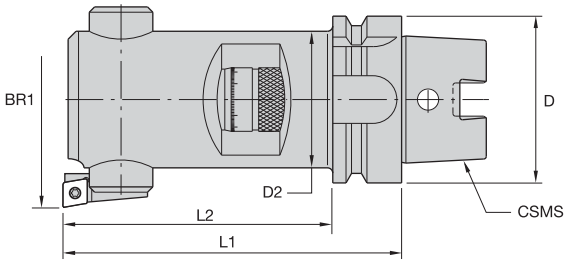


SVS • KM™ Back End

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D mm	D in	D2 mm	D2 in	L1 mm	L1 in	L2 mm	L2 in	kg	lbs
1763375	KM50SVS4B125M	78,000-98,000	3.0710-3.8580	KM50	50,000	1.9685	65,0	2.56	125,0	4.92	110,0	4.33	2,2	4.90
1763378	KM50SVS5B125M	97,000-117,000	3.8190-4.6060	KM50	50,000	1.9685	65,0	2.56	125,0	4.92	110,0	4.33	3,2	7.10
1763376	KM63SVS4B110M	78,000-98,000	3.0710-3.8580	KM63	63,000	2.4803	65,0	2.56	110,0	4.33	92,0	3.62	2,4	5.30
1763379	KM63SVS5B110M	97,000-117,000	3.8190-4.6060	KM63	63,000	2.4803	65,0	2.56	110,0	4.33	92,0	3.62	3,2	7.10
1763382	KM80SVS6B150M	116,000-139,000	4.5670-5.4720	KM80	80,000	3.1496	85,0	3.35	150,0	5.91	128,0	5.04	7,8	17.20

- Order cartridges separately.





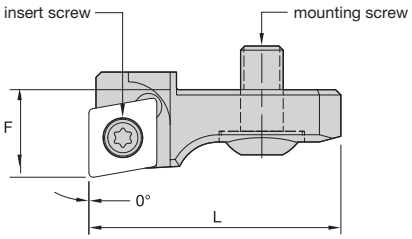


SVS • HSK Back End

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D mm	D in	D2 mm	D2 in	L1 mm	L1 in	L2 mm	L2 in	kg	lbs
1763116	HSK63ASVS4B139M	78,000-98,000	3.0710-3.8580	HSK63A	63,000	2.4803	65,0	2.56	139,0	5.47	113,0	4.45	3,6	8.00
1763118	HSK63ASVS5B139M	97,000-117,000	3.8190-4.6060	HSK63A	63,000	2.4803	65,0	2.56	139,0	5.47	113,0	4.45	5,9	13.00

- Order inserts separately.







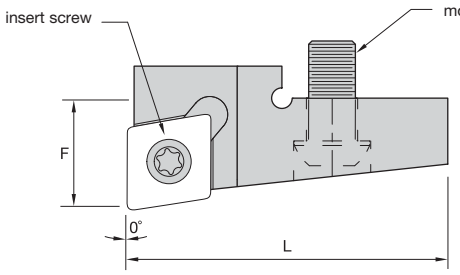
AVS • Cartridges SCF



order number	catalog number	L mm	L in	F mm	F in	gage insert	reference head	cartridge size	mounting screw	Torx wrench	insert screw	Torx wrench	kg	lbs
5124822	**KRCSCFPR061Y**	19,20	.76	4,76	.19	CP..0602../CP..215...	AVS00B	1Y	**MS2006**	**FT8**	**MS2005**	**FT7**	0,00	.010
5124823	**KRCSCFPR062Y**	19,20	.76	5,88	.23	CP..0602../CP..215...	AVS00B	2Y	**MS2006**	**FT8**	**MS2005**	**FT7**	0,00	.010
5124824	**KRCSCFPR063Y**	19,20	.76	7,01	.28	CP..0602../CP..215...	AVS00B	3Y	**MS2006**	**FT8**	**MS2005**	**FT7**	0,00	.010
5124825	**KRCSCFPR061X**	23,75	.94	6,46	.25	CP..0602../CP..215...	AVS1B,AVS0B	1X	**MS-1896**	**FT15**	**MS1153**	**FT7**	0,01	.020
5124826	**KRCSCFPR062X**	23,60	.93	8,21	.32	CP..0602../CP..215...	AVS1B,AVS0B	2X	**MS-1896**	**FT15**	**MS1153**	**FT7**	0,01	.020
5124827	**KRCSCFPR063X**	23,60	.93	9,96	.39	CP..0602../CP..215...	AVS1B,AVS0B	3X	**MS-1896**	**FT15**	**MS1153**	**FT7**	0,01	.020
5124828	**KRCSCFPR061W**	26,60	1.05	6,45	.25	CP..0602../CP..215...	AVS3B1,AVS2B1	1W	**MS-1896**	**FT15**	**MS1153**	**FT7**	0,01	.030
5124829	**KRCSCFPR062W**	26,75	1.05	8,70	.34	CP..0602../CP..215...	AVS2B1,AVS3B1	2W	**MS-1896**	**FT15**	**MS1153**	**FT7**	0,01	.030
5124850	**KRCSCFPR063W**	26,60	1.05	10,95	.43	CP..0602../CP..215...	AVS3B1,AVS2B1	3W	**MS-1896**	**FT15**	**MS1153**	**FT7**	0,01	.020

- Order inserts separately.



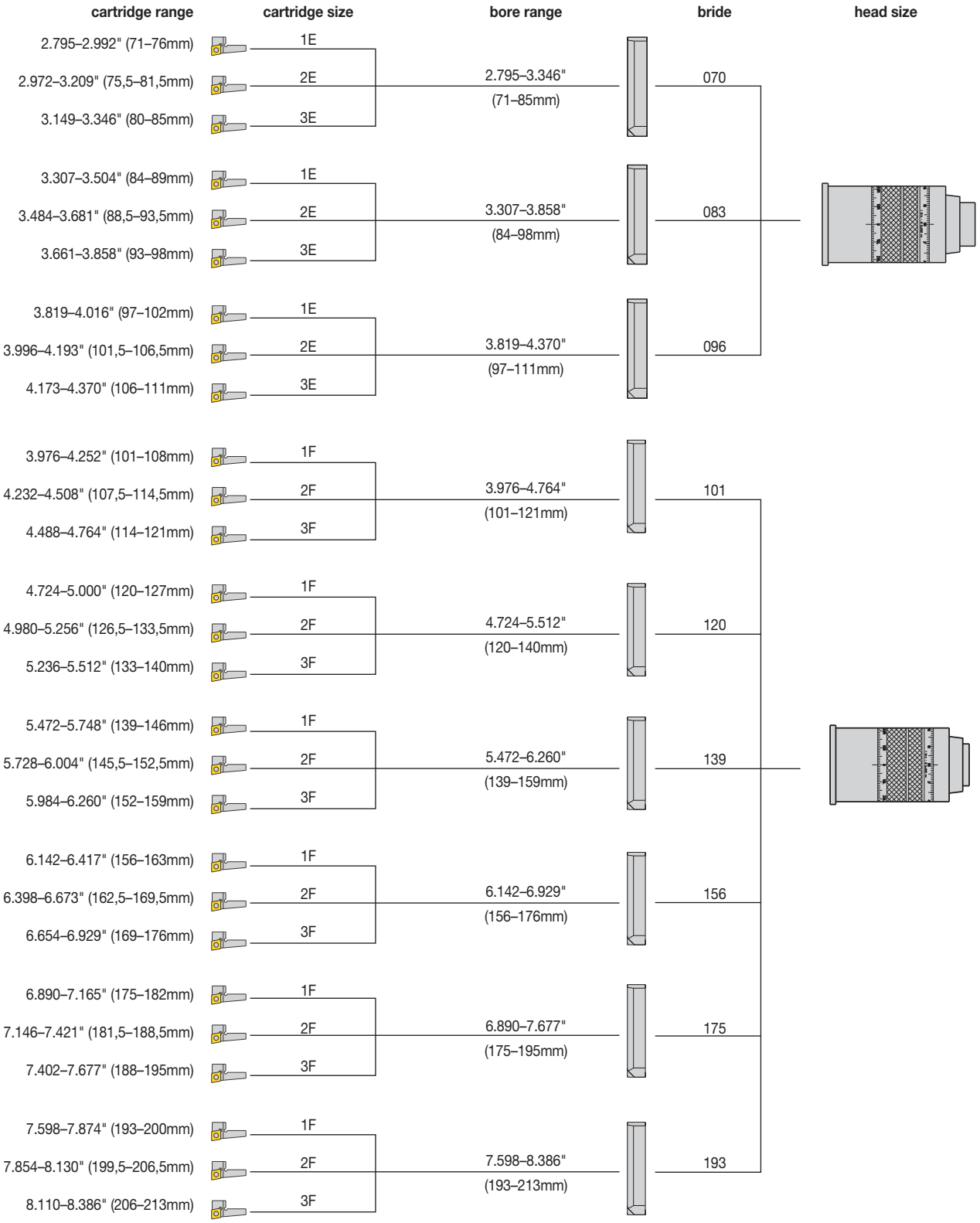




SVS • Cartridges SCF

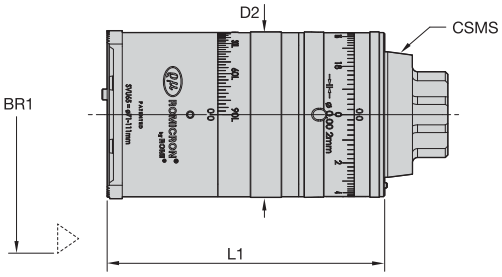
order number	catalog number	L mm	L in	F mm	F in	gage insert	reference head	cartridge size	kg	lbs
1501356	**KRCSCFPR061L**	19,15	.75	4,76	.19	CP..0602../CP..215...	AVS00B	1L.	0,01	.02
1500650	**KRCSCFPR062L**	19,15	.75	5,89	.23	CP..0602../CP..215...	KRMSVS00M50049M,AVS00B	2L.	0,01	.02
1501357	**KRCSCFPR063L**	19,15	.75	7,01	.28	CP..0602../CP..215...	AVS00B	3L.	0,01	.03
1099162	**KRCSCFPR061A**	23,65	.93	6,45	.25	CP..0602../CP..215...	AVS0B,AVS1B,AVS1B	1A.	0,01	.02
1099163	**KRCSCFPR062A**	23,70	.93	8,20	.32	CP..0602../CP..215...	AVS0B,AVS1B,AVS1B	2A.	0,01	.02
1099164	**KRCSCFPR063A**	23,70	.93	9,95	.39	CP..0602../CP..215...	AVS0B,AVS1B,AVS1B	3A.	0,01	.03
1099166	**KRCSCFPR062B**	24,65	.97	8,70	.34	CP..0602../CP..215...	SVS3B,SVS2B	2B.	0,01	.03
1099167	**KRCSCFPR063B**	24,65	.97	10,95	.43	CP..0602../CP..215...	SVS3B,SVS2B	3B.	0,02	.04
1099165	**KRCSCFPR061B**	24,70	.97	6,45	.25	CP..0602../CP..215...	SVS3B,SVS2B	1B.	0,01	.02
1099168	**KRCSCFPR061C**	30,70	1.21	8,45	.33	CP..0602../CP..215..	SVS5B,SVS4B	1C.	0,02	.05
1099169	**KRCSCFPR062C**	30,70	1.21	11,70	.46	CP..0602../CP..215...	SVS5B,SVS4B	2C.	0,03	.06
1099170	**KRCSCFPR063C**	30,70	1.21	14,95	.59	CP..0602../CP..215...	SVS5B,SVS4B	3C.	0,04	.08
1099171	**KRCSCFPR061D**	38,70	1.52	8,45	.33	CP..0602../CP..215...	SVS8B,SVS7B,SVS6B	1D.	0,03	.07
1099172	**KRCSCFPR062D**	38,70	1.52	12,20	.48	CP..0602../CP..215...	SVS8B,SVS7B,SVS6B	2D.	0,05	.10
1099173	**KRCSCFPR063D**	38,70	1.52	15,95	.63	CP..0602../CP..215...	SVS8B,SVS7B,SVS6B	3D.	0,06	.13

SVU System • Tooling Tree



- For correct balance ring settings, see page K108–K109.
- Order diameter extenders, cartridges, and taper shanks separately.





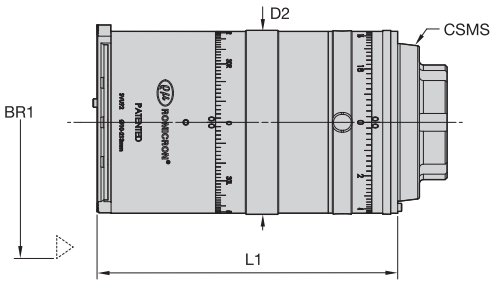


SVU65 • KR Boring Head with CLB Capability

		BR1 bore range			D2		L1				
order number	catalog number	mm	in	CSMS system size	mm	in	mm	in	Torx wrench	kg	lbs
1582600	**KR50SVU65110MCLB**	71,000-111,000	2.7950-4.3700	KR50	65,0	2.56	110,0	4.33	**KT27**	2,8	6.20

- For correct balance ring settings, see page K110–K114.
- Order diameter extenders, cartridges, and taper shanks separately.

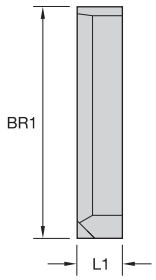






SVU92 • KR Boring Head with CLB Capability

		BR1 bore range			D2		L1				
order number	catalog number	mm	in	CSMS system size	mm	in	mm	in	Torx wrench	kg	lbs
4054740	**KR80SVU92152MCLB**	101,000-213,000	3.9764-8.3858	KR80	92,0	3.62	152,0	5.98	**KT27**	7,5	16.54



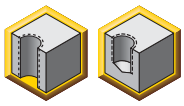


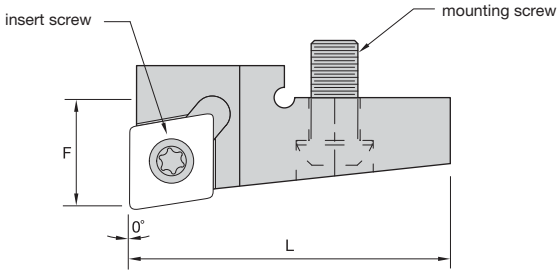


SVU • Diameter Extenders

order number	catalog number	BR1 bore range mm	BR1 bore range in	L1 assy mm	L1 assy in	kg	lbs
1279736	KRDE070019M	70,000-85,000	2.7559-3.3465	19,2	.76	0,2	.48
1279739	KRDE083019M	83,000-98,000	3.2677-3.8583	19,2	.76	0,3	.62
1279740	KRDE096019M	96,000-111,000	3.7795-4.3701	19,2	.76	0,3	.76
1279741	KRDE101023M	101,000-121,000	3.9764-4.7638	23,2	.91	0,6	1.25
1279742	KRDE120023M	120,000-140,000	4.7244-5.5118	23,2	.91	0,7	1.54
1279743	KRDE139026M	139,000-159,000	5.4724-6.2598	26,2	1.03	1,0	2.15
1279745	KRDE156026M	156,000-176,000	6.1417-6.9291	26,2	1.03	1,1	2.51
1279746	KRDE175026M	175,000-195,000	3.8898-7.6772	26,2	1.03	1,3	2.83
1279748	KRDE193026M	193,000-213,000	7.5984-8.3858	26,2	1.03	1,4	3.14

- Order inserts separately.

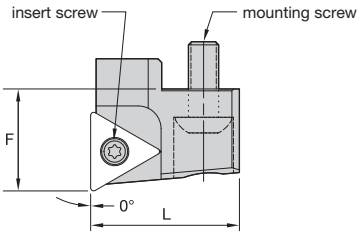






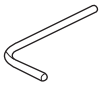
SVU • Cartri1dges SCF

order number	catalog number	reference head	F mm	F in	L mm	L in	gage insert	insert screw	mounting screw	insert Torx wrench	Torx wrench	cartridge size	kg	lbs
1099174	KRCSCFPR061E	SVU65	6,75	.27	19,70	.78	CP..0602../CP..215...	MS1375	MS1153	FT7	KT15	1E.	0,01	.02
1099175	KRCSCFPR062E	SVU65	9,00	.35	19,70	.78	CP..0602../CP..215...	MS1375	MS1153	FT7	KT15	2E.	0,01	.02
1099176	KRCSCFPR063E	SVU65	11,25	.44	19,70	.78	CP..0602../CP..215...	MS1375	MS1153	FT7	KT15	3E.	0,01	.03
1099177	KRCSCFPR061F	SVU92	6,75	.27	19,70	.78	CP..0602../CP..215...	MS1375	MS1153	FT7	KT15	1F.	0,01	.02
1099178	KRCSCFPR062F	SVU92	10,00	.39	19,70	.78	CP..0602../CP..215...	MS1375	MS1153	FT7	KT15	2F.	0,01	.03
1099179	KRCSCFPR063F	SVU92	13,25	.52	19,70	.78	CP..0602../CP..215...	MS1375	MS1153	FT7	KT15	3F.	0,02	.03

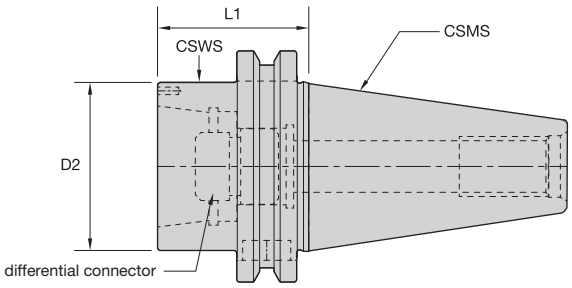


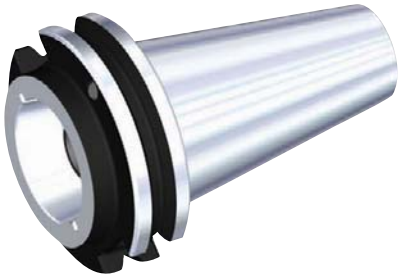


SVU92 • Cartridges STF 0° Lead Angle

order number	catalog number	reference head	F mm	F in	L mm	L in	gage insert	 insert screw	 mounting screw	 insert Torx wrench	 Torx wrench	kg	lbs
1279732	**KRCSTFPR113F**	SVU92	13,25	.52	19,70	.78	TP..1102../TP..215...	**MS1375**	**MS1153**	**FT7**	**KT15**	0,02	.03

- Differential connector included.





CV to KR Adapters AD/B

order number	catalog number	CSMS system size	CSWS system size	D2 mm	D2 in	L1 mm	L1 in	differential connector	kg	lbs	reference head
3554366	CV40BKR32157	CV40	KR32	47	1.85	40	1.58	KRDCKR32M	1,08	2.40	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
3554367	CV40BKR50236	CV40	KR50	65	2.56	60	2.37	KRDCKR50M	1,23	2.70	SVS4B,5B,SVU65,SVUBB2
3554368	CV50BKR32157	CV50	KR32	50	1.97	40	1.57	KRDCKR32M	3,25	7.20	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
3554369	CV50BKR50157	CV50	KR50	65	2.56	40	1.57	KRDCKR50M	3,05	6.70	SVS4B,5B,SVU65,SVUBB2
3554370	CV50BKR63236	CV50	KR63	85	3.35	60	2.36	KRDCKR63M	3,50	7.70	SVS6B,7B,8B
3554371	CV50BKR80275	CV50	KR80	95	3.74	70	2.75	KRDCKR80M	4,28	9.40	SVU92,120

DV to KR DIN 69871 AD/B

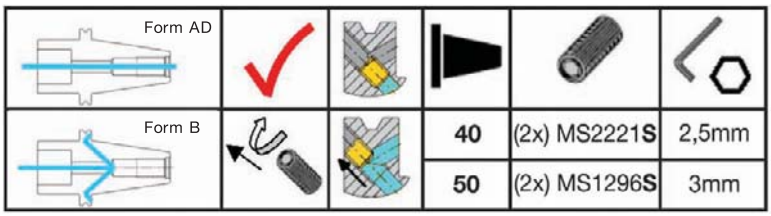


order number	catalog number	CSMS system size	CSWS system size	D2 mm	D2 in	L1 mm	L1 in	differential connector	kg	lbs	reference head
1539005	DV40BKR32041M	DV40	KR32	44	1.75	41	1.61	KRDCKR32M	1,00	2.20	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
1263816	DV40BKR50060M	DV40	KR50	65	2.56	60	2.36	KRDCKR50M	1,40	3.08	SVS4B,5B,SVU65,SVUBB2
1528328	DV50BKR32041M	DV50	KR32	50	1.96	41	1.61	KRDCKR32M	2,80	6.16	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
1191970	DV50BKR32040M	DV50	KR32	50	1.96	40	1.57	KRDCKR32M	2,80	6.16	AVS0B, AVS2B, AVS3B
1191971	DV50BKR50040M	DV50	KR50	65	2.56	40	1.57	KRDCKR50M	2,80	6.16	SVS4B,5B,SVU65,SVUBB2
1264135	DV50BKR63060M	DV50	KR63	85	3.34	60	2.36	KRDCKR63M	3,30	7.26	SVS6B,7B,8B
1264136	DV50BKR80070M	DV50	KR80	95	3.73	70	2.76	KRDCKR80M	4,10	9.02	SVU92,120

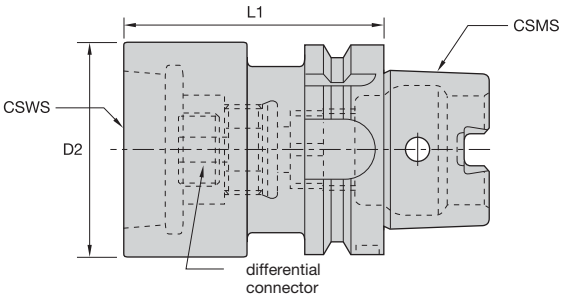
BT to KR JIS B6339 Adapters AD/B



order number	catalog number	CSMS system size	CSWS system size	D2 mm	D2 in	L1 mm	L1 in	differential connector	kg	lbs	reference head
3554372	BT40BKR32030M	BT40	KR32	50	1.97	30	1.18	KRDCKR32M	1,20	2.63	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
3554373	BT40BKR50050M	BT40	KR50	63	2.48	50	1.97	KRDCKR50M	1,26	2.80	SVS4B,5B,SVU65,SVUBB2
3554374	BT50BKR32040M	BT50	KR32	50	1.97	40	1.57	KRDCKR32M	3,90	8.60	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
3554375	BT50BKR50040M	BT50	KR50	65	2.56	40	1.57	KRDCKR50M	3,17	7.00	SVS4B,5B,SVU65,SVUBB2
3554376	BT50BKR63060M	BT50	KR63	85	3.35	60	2.36	KRDCKR63M	4,31	9.50	SVS6B,7B,8B
3554377	BT50BKR80060M	BT50	KR80	95	3.74	60	2.36	KRDCKR80M	4,53	9.98	SVU92,120



- Differential connector included.





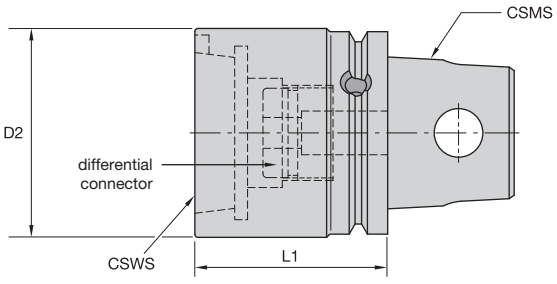
ERICKSON

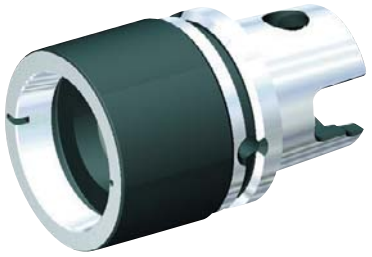
HSK Form A to KR Adapters

order number	catalog number	CSMS system size	CSWS system size	D2 mm	D2 in	L1 mm	L1 in	differential connector	kg	lbs	reference head
1153403	HSK63AKR32075M	HSK63A	KR32	50	1.96	75	2.95	KRDCKR32M	1,20	2.64	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
1153604	HSK63AKR50080M	HSK63A	KR50	65	2.56	80	3.15	KRDCKR50M	1,60	3.52	SVS4B,5B,SVU65,SVUBB2
1153606	HSK100AKR32075M	HSK100A	KR32	50	1.96	75	2.95	KRDCKR32M	2,56	5.64	AVS00B,0B,1B,2B,3B,SVUBB1,BB2
1107188	HSK100AKR50085M	HSK100A	KR50	65	2.56	85	3.35	KRDCKR50M	3,12	6.87	SVS4B,5B,SVU65,SVUBB2
1173988	HSK100AKR63100M	HSK100A	KR63	85	3.34	100	3.94	KRDCKR63M	4,26	9.40	SVS6B,7B,8B
1153612	HSK100AKR80090M	HSK100A	KR80	95	3.73	90	3.54	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.





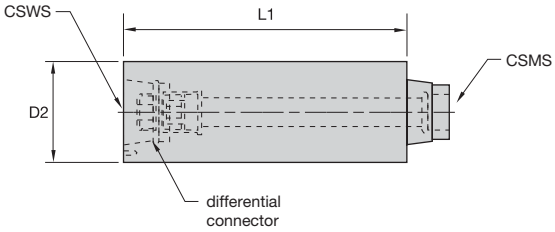
KM QUICK CHANGE

KM63XMZ to KR Adapters

order number	catalog number	CSMS system size	CSWS system size	D2 mm	D2 in	L1 mm	L1 in	differential connector	kg	lbs	reference head
1831590	KM63XMZKR5060Y	KM63XMZ	KR50	65	2.56	60	2.36	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.

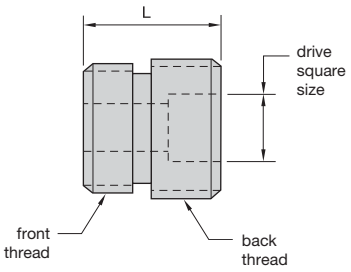
- Differential connector included.





Length Extenders and Spare Differential Connectors

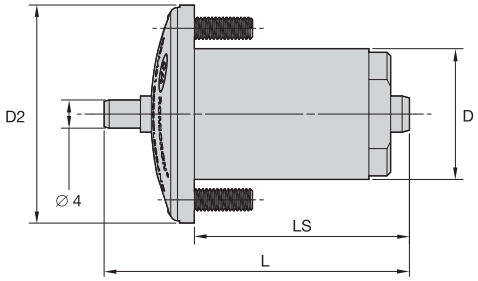
order number	catalog number	CSWS system size	CSMS system size	D2 mm	D2 in	L1 mm	L1 in	differential connector	kg	lbs	reference head
1279772	**KR32KR32038050M**	KR32	KR32	38	1.50	50	1.97	**KRDCKR32M**	0,45	.99	AVS00B,1B
1192275	**KR32KR32038100M**	KR32	KR32	38	1.50	100	3.94	**KRDCKR32M**	0,82	1.81	AVS00B,1B
1279775	**KR32KR32047050M**	KR32	KR32	47	1.85	50	1.97	**KRDCKR32M**	0,69	1.52	AVS0B,2B,3B,SVUBB1
1192276	**KR32KR32047100M**	KR32	KR32	47	1.85	100	3.94	**KRDCKR32M**	1,28	2.82	AVS0B,2B,3B,SVUBB1
1279785	**KR50KR50065050M**	KR50	KR50	65	2.56	50	1.97	**KRDCKR50M**	1,16	2.56	SVS4B,5B,SVU65,SVUBB2
1192280	**KR50KR50065100M**	KR50	KR50	65	2.56	100	3.94	**KRDCKR50M**	2,25	4.96	SVS4B,5B,SVU65,SVUBB2
1279791	**KR63KR63085050M**	KR63	KR63	85	3.35	50	1.97	**KRDCKR63M**	2,00	4.41	SVS6B,7B,8B
1279792	**KR63KR63085100M**	KR63	KR63	85	3.35	100	3.94	**KRDCKR63M**	4,02	8.86	SVS6B,7B,8B
1279797	**KR80KR80095050M**	KR80	KR80	95	3.74	50	1.97	**KRDCKR80M**	2,50	5.51	SVU92,120
1279798	**KR80KR80095100M**	KR80	KR80	95	3.74	100	3.94	**KRDCKR80M**	5,00	11.02	SVU92,120





Spare Differential Connectors

order number	catalog number	L mm	L in	back thread	front thread	drive square size
1192295	**KRDCKR32M**	22	.87	M20 X 2	M18 X 1	3/8 SQ
1192296	**KRDCKR50M**	22	.87	M28 X 2	M26 X 1	3/8 SQ
1279733	**KRDCKR63M**	25	.98	M36 X 2	M32 X 1	1/2 SQ
1279734	**KRDCKR80M**	28	1.10	M42 X 2	M38 X 1	1/2 SQ



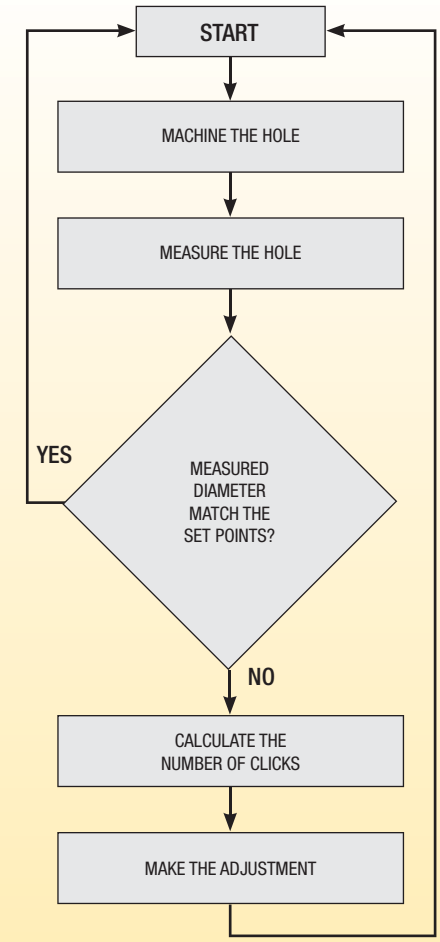


KRM • CLB Pin

		D		D2		LS		L			
order number	catalog number	mm	in	mm	in	mm	in	mm	in	kg	lbs
4052592	KRM018030CLB004NE	18,0	.71	30,0	1.18	29,6	1.17	42,0	1.65	0,1	.15

The Romicron Closed Loop Boring Process

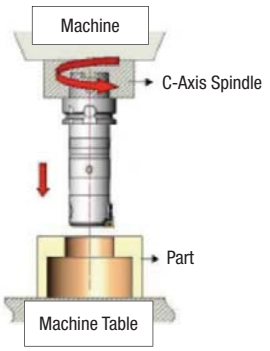
Closed Loop Boring (CLB) provides the unique possibility to automate the insert wear compensation with minimal investment due to the precise 2 µm adjustment in diameter of these tools per increment. Retrofit existing machines to automated wear compensation using the standard CLB pin without any electronic equipment needed besides a measuring device of holes produced.



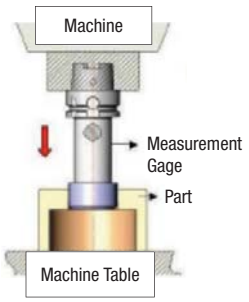
NOTE: This process is only possible with the Romicron system because it does not require tools to make the adjustment.

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

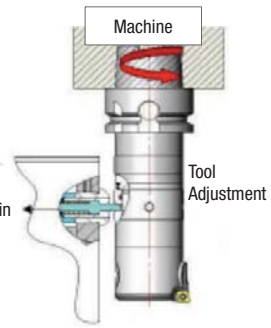


CNC calculates the correction and commands the tool.

Step 3



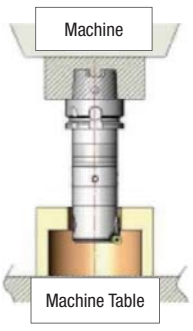
CLB retractable pin to lock the dial ring during diameter adjustment.



Step 4



Four CLB holes positioned at diameter dial ring.



Finishing Hole

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 adapter assembly are identified on Figures 1 and 2. The SVS model is shown. The instructions are also valid to the SVU and SVUBB models.

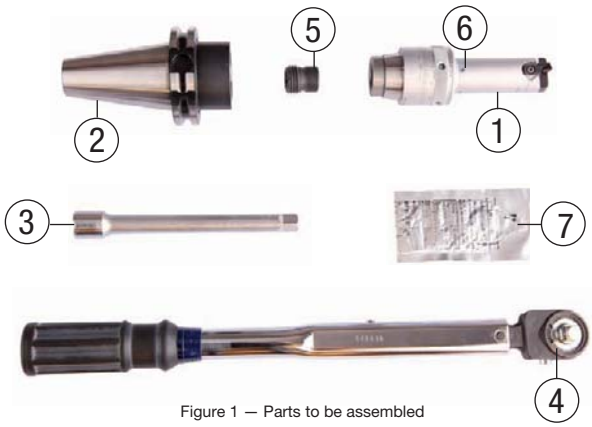


Figure 1 — Parts to be assembled

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



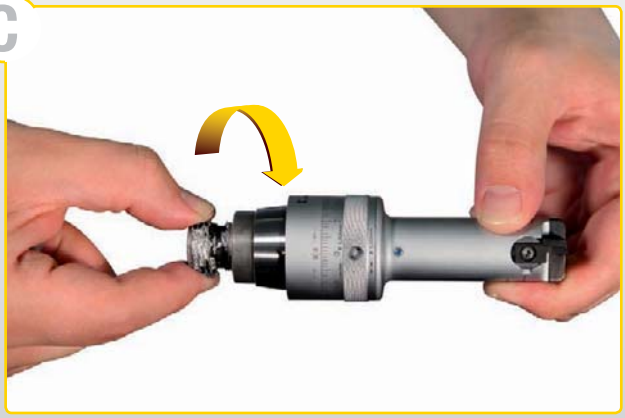
A. Remove the Differential Connector (5) from the Taper Shank (2).

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) counter-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



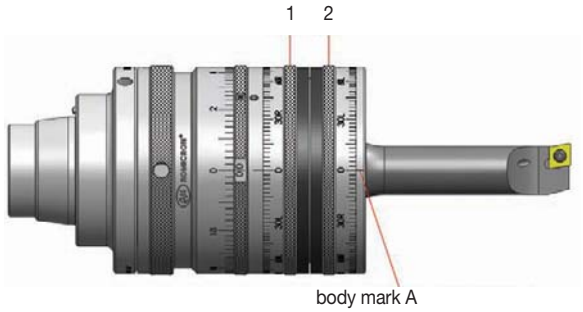
G. Tighten the Differential Connector (5) with the specified required torque, as shown on the table below. Use the Torque Wrench (4) to do this.

Tightening Torque Specifications

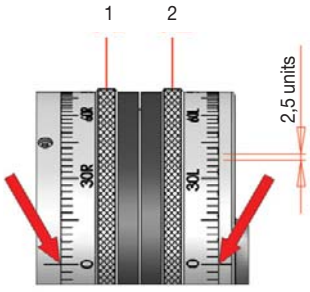
joint size	Torque Nm	drive square
KR32	30	3/8"
KR50	40	3/8"
KR63	55	1/2"
KR80	65	1/2"

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 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.



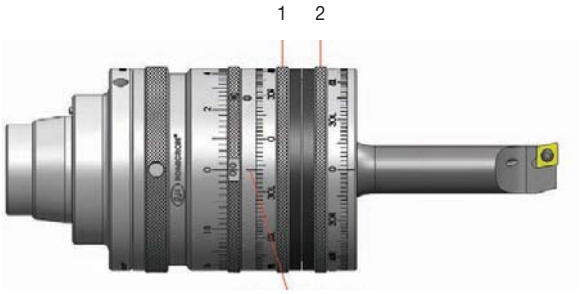
Balancing Table • SVU-BB1 Boring Head

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	in					mm	in					mm	in				
4	0.1575	40	L	58	L	6	0.2362	34	L	66	L	8,5	0.3346	34	L	66	L
4,1	0.1614	42	L	58	L	6,1	0.2402	36	L	66	L	8,6	0.3386	36	L	68	L
4,2	0.1654	42	L	54	L	6,2	0.2441	36	L	64	L	8,7	0.3425	36	L	64	L
4,3	0.1693	44	L	54	L	6,3	0.2480	38	L	62	L	8,8	0.3465	38	L	62	L
4,4	0.1732	44	L	50	L	6,4	0.2520	38	L	62	L	8,9	0.3504	36	L	60	L
4,5	0.1772	46	L	50	L	6,5	0.2559	40	L	60	L	9	0.3543	40	L	60	L
4,6	0.1811	46	L	48	L	6,6	0.2598	40	L	58	L	9,1	0.3583	40	L	58	L
4,7	0.1850	46	L	46	L	6,7	0.2638	40	L	56	L	9,2	0.3622	42	L	56	L
4,8	0.1890	46	L	42	L	6,8	0.2677	40	L	54	L	9,3	0.3661	40	L	54	L
4,9	0.1929	46	L	40	L	6,9	0.2717	42	L	52	L	9,4	0.3701	42	L	52	L
5	0.1969	22	R	20	R	7	0.2756	42	L	54	L	9,5	0.3740	42	L	50	L
5,1	0.2008	32	R	26	R	7,1	0.2795	54	R	60	R	9,6	0.3780	40	L	46	L
5,2	0.2047	40	R	32	R	7,2	0.2835	54	R	60	R	9,7	0.3819	38	L	42	L
5,3	0.2087	44	R	34	R	7,3	0.2874	60	R	60	R	9,8	0.3858	30	L	32	L
5,4	0.2126	48	R	36	R	7,4	0.2913	70	R	72	R	9,9	0.3898	24	R	22	R
5,5	0.2165	50	R	36	R	7,5	0.2953	42	R	40	R	10	0.3937	24	R	22	R
5,6	0.2205	52	R	34	R	7,6	0.2992	48	R	44	R	10,1	0.3976	26	R	22	R
5,7	0.2244	54	R	34	R	7,7	0.3031	50	R	42	R	10,2	0.4016	44	R	38	R
5,8	0.2283	56	R	32	R	7,8	0.3071	50	R	42	R	10,3	0.4055	48	R	38	R
5,9	0.2323	58	R	32	R	7,9	0.3110	52	R	40	R	10,4	0.4094	52	R	38	R
6	0.2362	60	R	30	R	8	0.3150	54	R	40	R	10,5	0.4134	52	R	38	R
6,1	0.2402	62	R	30	R	8,1	0.3189	54	R	38	R	10,6	0.4173	56	R	36	R
6,2	0.2441	64	R	28	R	8,2	0.3228	56	R	38	R	10,7	0.4213	56	R	36	R
6,3	0.2480	66	R	28	R	8,3	0.3268	58	R	36	R	10,8	0.4252	58	R	34	R
6,4	0.2520	68	R	24	R	8,4	0.3307	58	R	34	R	10,9	0.4291	58	R	32	R
–	–	–	–	–	–	8,5	0.3346	60	R	36	R	11	0.4331	62	R	32	R
–	–	–	–	–	–	8,6	0.3386	62	R	34	R	11,1	0.4370	60	R	30	R
–	–	–	–	–	–	8,7	0.3425	62	R	32	R	11,2	0.4409	62	R	28	R
–	–	–	–	–	–	8,8	0.3465	62	R	32	R	11,3	0.4449	62	R	28	R
–	–	–	–	–	–	8,9	0.3504	66	R	28	R	11,4	0.4488	68	R	26	R
–	–	–	–	–	–	9	0.3543	66	R	28	R	11,5	0.4528	68	R	26	R

(continued)

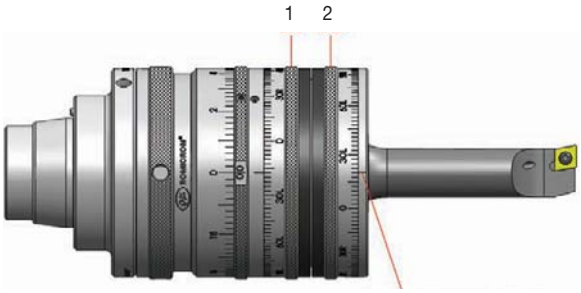
(Balancing Table • SVU-BB1 Boring Head — continued)

3. Set ring 1 first, referencing to body mark B (one dial mark equals 2.5 units).



body mark B

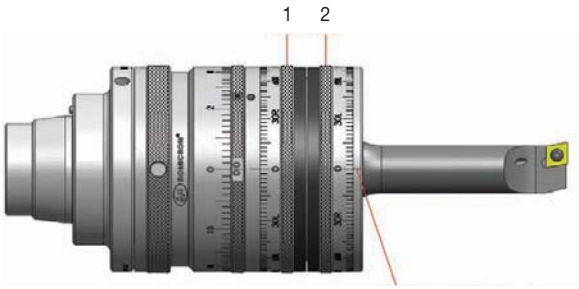
4. Set ring 2, referencing to body mark A (one dial mark equals 2.5 units).



body mark A

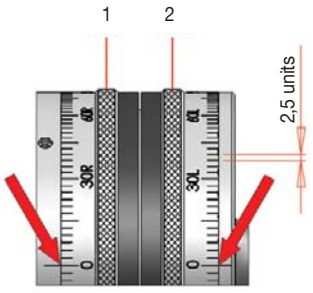
KRBB10SCFPR06110C 11–14mm						KRBB10SCFPR06135C 13,5–16,5mm					
diameter		ring 1		ring 2		diameter		ring 1		ring 2	
mm	in					mm	in				
11	0.4331	32	L	66	L	13,5	0.5315	34	L	62	L
11,1	0.4370	34	L	64	L	13,6	0.5354	36	L	60	L
11,2	0.4409	34	L	62	L	13,7	0.5394	38	L	58	L
11,3	0.4449	36	L	60	L	13,8	0.5433	38	L	56	L
11,4	0.4488	36	L	58	L	13,9	0.5472	40	L	56	L
11,5	0.4528	38	L	58	L	14	0.5512	42	L	44	L
11,6	0.4567	38	L	56	L	14,1	0.5551	42	L	52	L
11,7	0.4606	40	L	54	L	14,2	0.5591	44	L	50	L
11,8	0.4646	40	L	52	L	14,3	0.5630	42	L	46	L
11,9	0.4685	40	L	52	L	14,4	0.5669	34	L	36	L
12	0.4724	38	L	46	L	14,5	0.5709	18	L	20	L
12,1	0.4764	34	L	42	L	14,6	0.5748	10	R	6	R
12,2	0.4803	26	L	30	L	14,7	0.5787	18	R	10	R
12,3	0.4843	24	R	22	R	14,8	0.5827	40	R	30	R
12,4	0.4882	28	L	26	L	14,9	0.5866	44	R	32	R
12,5	0.4921	44	L	38	R	15	0.5906	48	R	34	R
12,6	0.4961	44	R	36	R	15,1	0.5945	48	R	32	R
12,7	0.5000	50	R	40	R	15,2	0.5984	50	R	30	R
12,8	0.5039	50	R	38	R	15,3	0.6024	52	R	30	R
12,9	0.5079	52	R	36	R	15,4	0.6063	56	R	32	R
13	0.5118	52	R	36	R	15,5	0.6102	54	R	28	R
13,1	0.5157	54	R	34	R	15,6	0.6142	58	R	28	R
13,2	0.5197	54	R	32	R	15,7	0.6181	60	R	26	R
13,3	0.5236	56	R	32	R	15,8	0.6220	64	R	26	R
13,4	0.5276	56	R	30	R	15,9	0.6260	64	R	26	R
13,5	0.5315	60	R	28	R	16	0.6299	66	R	24	R
13,6	0.5354	60	R	28	R	16,1	0.6339	66	R	22	R
13,7	0.5394	62	R	26	R	16,2	0.6378	70	R	20	R
13,8	0.5433	64	R	26	R	16,3	0.6417	74	R	18	R
13,9	0.5472	68	R	24	R	16,4	0.6457	76	R	16	R
14	0.5512	68	R	24	R	16,5	0.6496	78	R	14	R

1. There are 2 balancing dials on the SVUBB system. Align ring 2 "zero" with body mark A. Align "zero" mark of ring 1 with the "zero" mark of ring 2.



body mark A

2. Look up your diameter in the table below and read the setting values for ring 1 and ring 2.



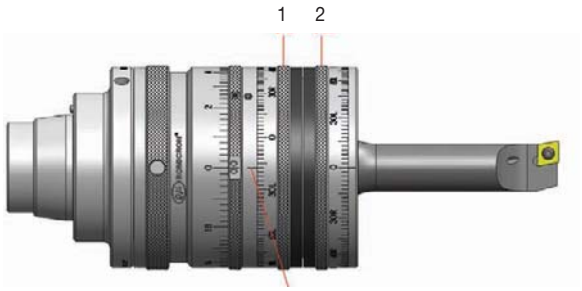
Balancing Table • SVU-BB2 Boring Head

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	in					mm	in					mm	in					mm	in				
6	0.2362	67.5	L	67.5	L	8,5	0.3346	67.5	L	67.5	L	11	0.4331	67.5	L	70	L	13,5	0.5315	65	L	70	L
6,1	0.2402	62.5	L	62.5	L	8,6	0.3386	62.5	L	62.5	L	11,1	0.4370	60	L	62.5	L	13,6	0.5354	60	L	65	L
6,2	0.2441	57.5	L	57.5	L	8,7	0.3425	57.5	L	57.5	L	11,2	0.4409	57.5	L	60	L	13,7	0.5394	55	L	60	L
6,3	0.2480	55	L	55	L	8,8	0.3465	52.5	L	55	L	11,3	0.4449	52.5	L	55	L	13,8	0.5433	50	L	55	L
6,4	0.2520	50	L	50	L	8,9	0.3504	50	L	50	L	11,4	0.4488	47.5	L	50	L	13,9	0.5472	47.5	L	52.5	L
6,5	0.2559	47.5	L	47.5	L	9	0.3543	47.5	L	47.5	L	11,5	0.4528	45	L	47.5	L	14	0.5512	42.5	L	47.5	L
6,6	0.2598	45	L	45	L	9,1	0.3583	42.5	L	45	L	11,6	0.4567	42.5	L	45	L	14,1	0.5551	40	L	45	L
6,7	0.2638	40	L	40	L	9,2	0.3622	40	L	40	L	11,7	0.4606	37.5	L	42.5	L	14,2	0.5591	35	L	42.5	L
6,8	0.2677	37.5	L	37.5	L	9,3	0.3661	37.5	L	37.5	L	11,8	0.4646	35	L	37.5	L	14,3	0.5630	32.5	L	40	L
6,9	0.2717	35	L	35	L	9,4	0.3701	35	L	35	L	11,9	0.4685	32.5	L	35	L	14,4	0.5669	30	L	37.5	L
7	0.2756	32.5	L	32.5	L	9,5	0.3740	30	L	32.5	L	12	0.4724	30	L	32.5	L	14,5	0.5709	25	L	35	L
7,1	0.2795	30	L	30	L	9,6	0.3780	27.5	L	30	L	12,1	0.4764	27.5	L	30	L	14,6	0.5748	22.5	L	32.5	L
7,2	0.2835	27.5	L	27.5	L	9,7	0.3819	25	L	27.5	L	12,2	0.4803	25	L	27.5	L	14,7	0.5787	20	L	30	L
7,3	0.2874	25	L	25	L	9,8	0.3858	22.5	L	25	L	12,3	0.4843	22.5	L	25	L	14,8	0.5827	17.5	L	27.5	L
7,4	0.2913	22.5	L	22.5	L	9,9	0.3898	20	L	22.5	L	12,4	0.4882	17.5	L	25	L	14,9	0.5866	15	L	25	L
7,5	0.2953	20	L	20	L	10	0.3937	17.5	L	20	L	12,5	0.4921	15	L	22.5	L	15	0.5906	10	L	25	L
7,6	0.2992	17.5	L	17.5	L	10,1	0.3976	15	L	17.5	L	12,6	0.4961	12.5	L	20	L	15,1	0.5945	7.5	L	22.5	L
7,7	0.3031	15	L	15	L	10,2	0.4016	12.5	L	15	L	12,7	0.5000	10	L	17.5	L	15,2	0.5984	2.5	L	22.5	L
7,8	0.3071	12.5	L	12.5	L	10,3	0.4055	10	L	15	L	12,8	0.5039	5	L	17.5	L	15,3	0.6024	2.5	R	22.5	L
7,9	0.3110	10	L	12.5	L	10,4	0.4094	7.5	L	12.5	L	12,9	0.5079	2.5	L	15	L	15,4	0.6063	7.5	R	22.5	L
8	0.3150	7.5	L	10	L	10,5	0.4134	5	L	10	L	13	0.5118	2.5	R	15	L	15,5	0.6102	17.5	R	27.5	L
8,1	0.3189	5	L	7.5	L	10,6	0.4173	0	L	10	L	13,1	0.5157	10	R	17.5	L	15,6	0.6142	37.5	R	42.5	L
8,2	0.3228	2.5	L	5	L	10,7	0.4213	5	R	10	L	13,2	0.5197	25	R	30	L	15,7	0.6181	85	L	90	R
8,3	0.3268	2.5	R	5	L	10,8	0.4252	45	R	45	L	13,3	0.5236	62.5	L	65	R	15,8	0.6220	35	L	42.5	R
8,4	0.3307	10	L	12.5	R	10,9	0.4291	10	L	15	R	13,4	0.5276	17.5	L	22.5	R	15,9	0.6260	17.5	L	27.5	R
8,5	0.3346	0	R	5	R	11	0.4331	2.5	L	10	R	13,5	0.5315	5	L	15	R	16	0.6299	7.5	L	22.5	R
8,6	0.3386	2.5	R	7.5	R	11,1	0.4370	2.5	R	10	R	13,6	0.5354	0	R	15	R	16,1	0.6339	2.5	L	22.5	R
8,7	0.3425	7.5	R	7.5	R	11,2	0.4409	5	R	12.5	R	13,7	0.5394	5	R	15	R	16,2	0.6378	2.5	R	22.5	R
8,8	0.3465	10	R	10	R	11,3	0.4449	10	R	12.5	R	13,8	0.5433	7.5	R	17.5	R	16,3	0.6417	7.5	R	22.5	R
8,9	0.3504	12.5	R	12.5	R	11,4	0.4488	12.5	R	15	R	13,9	0.5472	10	R	20	R	16,4	0.6457	10	R	25	R
9	0.3543	12.5	R	15	R	11,5	0.4528	15	R	17.5	R	14	0.5512	15	R	20	R	16,5	0.6496	15	R	25	R
9,1	0.3583	15	R	17.5	R	11,6	0.4567	17.5	R	20	R	14,1	0.5551	17.5	R	22.5	R	16,6	0.6535	17.5	R	27.5	R
9,2	0.3622	17.5	R	20	R	11,7	0.4606	20	R	22.5	R	14,2	0.5591	20	R	25	R	16,7	0.6575	20	R	30	R
9,3	0.3661	20	R	22.5	R	11,8	0.4646	22.5	R	25	R	14,3	0.5630	22.5	R	27.5	R	16,8	0.6614	22.5	R	32.5	R
9,4	0.3701	22.5	R	25	R	11,9	0.4685	25	R	27.5	R	14,4	0.5669	25	R	30	R	16,9	0.6654	27.5	R	35	R
9,5	0.3740	25	R	27.5	R	12	0.4724	27.5	R	30	R	14,5	0.5709	27.5	R	32.5	R	17	0.6693	30	R	37.5	R

(continued)

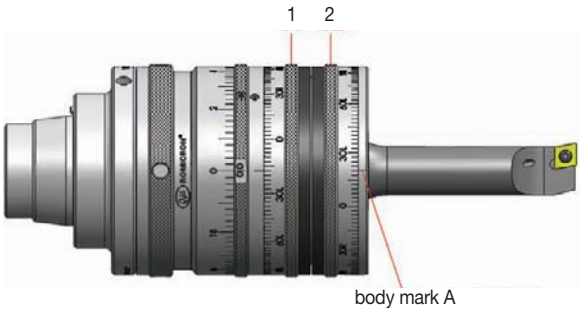
(Balancing Table • SVU-BB2 Boring Head — continued)

3. Set ring 1 first, referencing to body mark B (one dial mark equals 2.5 units).



body mark B

4. Set ring 2, referencing to body mark A (one dial mark equals 2.5 units).



body mark A

KRBB16SCFPR0616A 16–19,5mm diameter						KRBB16SCFPR0619A 19–22,5mm diameter						KRBB16SCFPR0622A 22–25,5mm diameter					
mm	in	ring 1		ring 2		mm	in	ring 1		ring 2		mm	in	ring 1		ring 2	
16	0.6299	65	L	72.5	L	19	0.7480	60	L	75	L	22	0.8661	57.5	L	80	L
16,1	0.6339	57.5	L	65	L	19,1	0.7520	55	L	70	L	22,1	0.8701	50	L	72.5	L
16,2	0.6378	52.5	L	62.5	L	19,2	0.7559	50	L	65	L	22,2	0.8740	45	L	70	L
16,3	0.6417	47.5	L	57.5	L	19,3	0.7598	45	L	60	L	22,3	0.8780	37.5	L	65	L
16,4	0.6457	42.5	L	52.5	L	19,4	0.7638	40	L	57.5	L	22,4	0.8819	32.5	L	62.5	L
16,5	0.6496	40	L	50	L	19,5	0.7677	35	L	52.5	L	22,5	0.8858	27.5	L	60	L
16,6	0.6535	35	L	47.5	L	19,6	0.7717	30	L	50	L	22,6	0.8898	22.5	L	57.5	L
16,7	0.6575	32.5	L	45	L	19,7	0.7756	27.5	L	47.5	L	22,7	0.8937	20	L	55	L
16,8	0.6614	27.5	L	42.5	L	19,8	0.7795	22.5	L	45	L	22,8	0.8976	15	L	52.5	L
16,9	0.6654	25	L	40	L	19,9	0.7835	20	L	42.5	L	22,9	0.9016	10	L	52.5	L
17	0.6693	20	L	37.5	L	20	0.7874	15	L	42.5	L	23	0.9055	5	L	50	L
17,1	0.6732	17.5	L	35	L	20,1	0.7913	10	L	40	L	23,1	0.9094	0	R	50	L
17,2	0.6772	12.5	L	32.5	L	20,2	0.7953	5	L	40	L	23,2	0.9134	7.5	R	52.5	L
17,3	0.6811	10	L	30	L	20,3	0.7992	0	L	40	L	23,3	0.9173	12.5	R	52.5	L
17,4	0.6850	5	L	30	L	20,4	0.8031	5	R	40	L	23,4	0.9213	20	R	55	L
17,5	0.6890	0	L	30	L	20,5	0.8071	10	R	40	L	23,5	0.9252	30	R	60	L
17,6	0.6929	5	R	30	L	20,6	0.8110	17.5	R	42.5	L	23,6	0.9291	40	R	65	L
17,7	0.6969	12.5	R	32.5	L	20,7	0.8150	27.5	R	47.5	L	23,7	0.9331	52.5	R	75	L
17,8	0.7008	22.5	R	37.5	L	20,8	0.8189	40	R	57.5	L	23,8	0.9370	67.5	R	90	L
17,9	0.7047	35	R	47.5	L	20,9	0.8228	57.5	R	72.5	L	23,9	0.9409	77.5	L	97.5	R
18	0.7087	60	R	67.5	L	21	0.8268	80	R	92.5	L	24	0.9449	60	L	82.5	R
18,1	0.7126	75	L	82.5	R	21,1	0.8307	65	L	77.5	R	24,1	0.9488	47.5	L	72.5	R
18,2	0.7165	45	L	55	R	21,2	0.8346	45	L	60	R	24,2	0.9528	35	L	62.5	R
18,3	0.7205	25	L	40	R	21,3	0.8386	30	L	50	R	24,3	0.9567	25	L	57.5	R
18,4	0.7244	15	L	32.5	R	21,4	0.8425	20	L	45	R	24,4	0.9606	17.5	L	55	R
18,5	0.7283	7.5	L	30	R	21,5	0.8465	12.5	L	40	R	24,5	0.9646	10	L	52.5	R
18,6	0.7323	2.5	L	30	R	21,6	0.8504	5	L	40	R	24,6	0.9685	5	L	50	R
18,7	0.7362	2.5	R	30	R	21,7	0.8543	0	L	40	R	24,7	0.9724	2.5	R	50	R
18,8	0.7402	7.5	R	30	R	21,8	0.8583	5	R	40	R	24,8	0.9764	7.5	R	50	R
18,9	0.7441	12.5	R	32.5	R	21,9	0.8622	10	R	40	R	24,9	0.9803	12.5	R	52.5	R
19	0.7480	15	R	35	R	22	0.8661	12.5	R	42.5	R	25	0.9843	17.5	R	52.5	R
19,1	0.7520	20	R	35	R	22,1	0.8701	17.5	R	42.5	R	25,1	0.9882	20	R	55	R
19,2	0.7559	22.5	R	37.5	R	22,2	0.8740	22.5	R	45	R	25,2	0.9921	25	R	57.5	R
19,3	0.7598	27.5	R	40	R	22,3	0.8780	25	R	47.5	R	25,3	0.9961	30	R	60	R
19,4	0.7638	30	R	42.5	R	22,4	0.8819	30	R	50	R	25,4	1.0000	35	R	62.5	R
19,5	0.7677	35	R	45	R	22.5	0.8858	35	R	52.5	R	25,5	1.0039	40	R	67.5	R

(continued)

(Balancing Table • SVU-BB2 Boring Head — continued)

KRDEA046AM • KRDE025010M 25,5–33,5mm

diameter		ring 1		ring 2		diameter		ring 1		ring 2		diameter		ring 1		ring 2	
mm	in					mm	in					mm	in				
25,5	1.0039	62.5	L	65	L	28,5	1.1220	57.5	L	60	L	31,5	1.2402	52.5	L	55	L
25,6	1.0079	57.5	L	60	L	28,6	1.1260	52.5	L	55	L	31,6	1.2441	47.5	L	50	L
25,7	1.0118	50	L	52.5	L	28,7	1.1299	45	L	50	L	31,7	1.2480	42.5	L	45	L
25,8	1.0157	45	L	47.5	L	28,8	1.1339	40	L	45	L	31,8	1.2520	37.5	L	42.5	L
25,9	1.0197	40	L	45	L	28,9	1.1378	37.5	L	40	L	31,9	1.2559	32.5	L	37.5	L
26,0	1.0236	35	L	40	L	29,0	1.1417	32.5	L	37.5	L	32,0	1.2598	27.5	L	35	L
26,1	1.0276	32.5	L	35	L	29,1	1.1457	27.5	L	32.5	L	32,1	1.2638	25	L	30	L
26,2	1.0315	27.5	L	32.5	L	29,2	1.1496	25	L	30	L	32,2	1.2677	20	L	27.5	L
26,3	1.0354	22.5	L	30	L	29,3	1.1535	20	L	27.5	L	32,3	1.2717	17.5	L	22.5	L
26,4	1.0394	20	L	25	L	29,4	1.1575	15	L	25	L	32,4	1.2756	12.5	L	22.5	L
26,5	1.0433	62.5	L	65	L	29,5	1.1614	55	L	57.5	L	32,5	1.2795	50	L	55	L
26,6	1.0472	55	L	57.5	L	29,6	1.1654	50	L	52.5	L	32,6	1.2835	45	L	50	L
26,7	1.0512	50	L	52.5	L	29,7	1.1693	45	L	47.5	L	32,7	1.2874	40	L	45	L
26,8	1.0551	45	L	47.5	L	29,8	1.1732	40	L	45	L	32,8	1.2913	37.5	L	40	L
26,9	1.0591	40	L	42.5	L	29,9	1.1772	35	L	40	L	32,9	1.2953	32.5	L	37.5	L
27,0	1.0630	35	L	40	L	30,0	1.1811	32.5	L	35	L	33,0	1.2992	27.5	L	32.5	L
27,1	1.0669	30	L	35	L	30,1	1.1850	27.5	L	32.5	L	33,1	1.3031	22.5	L	30	L
27,2	1.0709	25	L	32.5	L	30,2	1.1890	22.5	L	30	L	33,2	1.3071	20	L	25	L
27,3	1.0748	22.5	L	27.5	L	30,3	1.1929	20	L	25	L	33,3	1.3110	15	L	22.5	L
27,4	1.0787	17.5	L	25	L	30,4	1.1969	15	L	22.5	L	33,4	1.3150	12.5	L	20	L
27,5	1.0827	60	L	62.5	L	30,5	1.2008	55	L	57.5	L	33,5	1.3189	50	L	52.5	L
27,6	1.0866	52.5	L	55	L	30,6	1.2047	47.5	L	52.5	L	33,6	1.3228	45	L	47.5	L
27,7	1.0906	47.5	L	50	L	30,7	1.2087	42.5	L	47.5	L	33,7	1.3268	40	L	42.5	L
27,8	1.0945	42.5	L	45	L	30,8	1.2126	37.5	L	42.5	L	33,8	1.3307	35	L	40	L
27,9	1.0984	37.5	L	42.5	L	30,9	1.2165	35	L	37.5	L	33,9	1.3346	30	L	35	L
28,0	1.1024	32.5	L	37.5	L	31,0	1.2205	30	L	35	L	34,0	1.3386	27.5	L	32.5	L
28,1	1.1063	30	L	35	L	31,1	1.2244	25	L	32.5	L	34,1	1.3425	22.5	L	27.5	L
28,2	1.1102	25	L	30	L	31,2	1.2283	22.5	L	27.5	L	34,2	1.3465	20	L	25	L
28,3	1.1142	20	L	27.5	L	31,3	1.2323	17.5	L	25	L	34,3	1.3504	15	L	22.5	L
28,4	1.1181	17.5	L	25	L	31,4	1.2362	12.5	L	22.5	L	34,4	1.3543	10	L	20	L

KRDEA046AM • KRDE033010M 33,5–44,4mm

diameter		ring 1		ring 2		diameter		ring 1		ring 2		diameter		ring 1		ring 2		diameter		ring 1		ring 2	
mm	in					mm	in					mm	in					mm	in				
33,5	1.3189	55	L	57.5	L	36,5	1.4370	47.5	L	52.5	L	39,5	1.5551	42.5	L	47.5	L	42,5	1.6732	37.5	L	40	L
33,6	1.3228	50	L	52.5	L	36,6	1.4409	42.5	L	47.5	L	39,6	1.5591	37.5	L	42.5	L	42,6	1.6772	32.5	L	37.5	L
33,7	1.3268	45	L	47.5	L	36,7	1.4449	37.5	L	42.5	L	39,7	1.5630	32.5	L	37.5	L	42,7	1.6811	27.5	L	35	L
33,8	1.3307	40	L	42.5	L	36,8	1.4488	35	L	37.5	L	39,8	1.5669	27.5	L	35	L	42,8	1.6850	25	L	30	L
33,9	1.3346	35	L	40	L	36,9	1.4528	30	L	35	L	39,9	1.5709	25	L	30	L	42,9	1.6890	20	L	27.5	L
34,0	1.3386	30	L	35	L	37,0	1.4567	25	L	32.5	L	40,0	1.5748	20	L	27.5	L	43,0	1.6929	15	L	25	L
34,1	1.3425	25	L	32.5	L	37,1	1.4606	22.5	L	27.5	L	40,1	1.5787	15	L	25	L	43,1	1.6969	10	L	22.5	L
34,2	1.3465	22.5	L	27.5	L	37,2	1.4646	17.5	L	25	L	40,2	1.5827	10	L	22.5	L	43,2	1.7008	5	L	20	L
34,3	1.3504	17.5	L	25	L	37,3	1.4685	12.5	L	22.5	L	40,3	1.5866	7.5	L	20	L	43,3	1.7047	0	L	17.5	L
34,4	1.3543	12.5	L	22.5	L	37,4	1.4724	7.5	L	20	L	40,4	1.5906	2.5	L	17.5	L	43,4	1.7087	7.5	R	20	L
34,5	1.3583	52.5	L	57.5	L	37,5	1.4764	47.5	L	50	L	40,5	1.5945	40	L	45	L	43,5	1.7126	35	L	40	L
34,6	1.3622	47.5	L	50	L	37,6	1.4803	42.5	L	45	L	40,6	1.5984	35	L	40	L	43,6	1.7165	30	L	35	L
34,7	1.3661	42.5	L	47.5	L	37,7	1.4843	37.5	L	40	L	40,7	1.6024	30	L	37.5	L	43,7	1.7205	25	L	32.5	L
34,8	1.3701	37.5	L	42.5	L	37,8	1.4882	32.5	L	37.5	L	40,8	1.6063	27.5	L	32.5	L	43,8	1.7244	22.5	L	27.5	L
34,9	1.3740	32.5	L	37.5	L	37,9	1.4921	27.5	L	35	L	40,9	1.6102	22.5	L	30	L	43,9	1.7283	17.5	L	25	L
35,0	1.3780	27.5	L	35	L	38,0	1.4961	25	L	30	L	41,0	1.6142	17.5	L	27.5	L	44,0	1.7323	15	L	22.5	L
35,1	1.3819	25	L	30	L	38,1	1.5000	20	L	27.5	L	41,1	1.6181	15	L	22.5	L	44,1	1.7362	10	L	20	L
35,2	1.3858	20	L	27.5	L	38,2	1.5039	15	L	25	L	41,2	1.6220	10	L	20	L	44,2	1.7402	5	L	17.5	L
35,3	1.3898	15	L	25	L	38,3	1.5079	10	L	22.5	L	41,3	1.6260	5	L	20	L	44,3	1.7441	2.5	R	17.5	L
35,4	1.3937	10	L	22.5	L	38,4	1.5118	5	L	20	L	41,4	1.6299	0	R	17.5	L	44,4	1.7480	12.5	R	22.5	L
35,5	1.3976	50	L	55	L	38,5	1.5157	45	L	47.5	L	41,5	1.6339	37.5	L	42.5	L	–	–	–	–	–	–
35,6	1.4016	45	L	50	L	38,6	1.5197	40	L	42.5	L	41,6	1.6378	35	L	37.5	L	–	–	–	–	–	–
35,7	1.4055	40	L	45	L	38,7	1.5236	35	L	40	L	41,7	1.6417	30	L	35	L	–	–	–	–	–	–
35,8	1.4094	35	L	40	L	38,8	1.5276	30	L	35	L	41,8	1.6457	25	L	32.5	L	–	–	–	–	–	–
35,9	1.4134	30	L	37.5	L	38,9	1.5315	25	L	32.5	L	41,9	1.6496	22.5	L	27.5	L	–	–	–	–	–	–
36,0	1.4173	27.5	L	32.5	L	39,0	1.5354	22.5	L	27.5	L	42,0	1.6535	17.5	L	25	L	–	–	–	–	–	–
36,1	1.4213	22.5	L	30	L	39,1	1.5394	17.5	L	25	L	42,1	1.6575	12.5	L	22.5	L	–	–	–	–	–	–
36,2	1.4252	17.5	L	27.5	L	39,2	1.5433	15	L	22.5	L	42,2	1.6614	7.5	L	20	L	–	–	–	–	–	–
36,3	1.4291	15	L	22.5	L	39,3	1.5472	10	L	20	L	42,3	1.6654	2.5	L	17.5	L	–	–	–	–	–	–
36,4	1.4331	10	L	20	L	39,4	1.5512	5	L	17.5	L	42,4	1.6693	5	R	20	L	–	–	–	–	–	–

(continued)

(Balancing Table • SVU-BB2 Boring Head — continued)

KRDEA051AM • KRDE043010M 43–65,9mm

diameter						diameter						diameter						diameter					
mm	in	ring 1		ring 2		mm	in	ring 1		ring 2		mm	in	ring 1		ring 2		mm	in	ring 1		ring 2	
43,0	1.6929	55	L	65	L	46,0	1.8110	42.5	L	55	L	49,0	1.9291	32.5	L	47.5	L	52,0	2.0472	25	L	40	L
43,1	1.6969	47.5	L	57.5	L	46,1	1.8150	37.5	L	50	L	49,1	1.9331	27.5	L	42.5	L	52,1	2.0512	20	L	37.5	L
43,2	1.7008	40	L	52.5	L	46,2	1.8189	30	L	45	L	49,2	1.9370	22.5	L	40	L	52,2	2.0551	12.5	L	35	L
43,3	1.7047	35	L	47.5	L	46,3	1.8228	25	L	42.5	L	49,3	1.9409	17.5	L	35	L	52,3	2.0591	7.5	L	32.5	L
43,4	1.7087	30	L	42.5	L	46,4	1.8268	20	L	37.5	L	49,4	1.9449	12.5	L	32.5	L	52,4	2.0630	0	L	32.5	L
43,5	1.7126	22.5	L	40	L	46,5	1.8307	15	L	35	L	49,5	1.9488	5	L	32.5	L	52,5	2.0669	7.5	R	32.5	L
43,6	1.7165	17.5	L	37.5	L	46,6	1.8346	7.5	L	32.5	L	49,6	1.9528	2.5	R	32.5	L	52,6	2.0709	20	R	37.5	L
43,7	1.7205	12.5	L	32.5	L	46,7	1.8386	2.5	L	30	L	49,7	1.9567	12.5	R	35	L	52,7	2.0748	42.5	R	52.5	L
43,8	1.7244	5	L	32.5	L	46,8	1.8425	7.5	R	32.5	L	49,8	1.9606	27.5	R	42.5	L	52,8	2.0787	85	L	92.5	R
43,9	1.7283	2.5	R	32.5	L	46,9	1.8465	17.5	R	35	L	49,9	1.9646	60	R	70	L	52,9	2.0827	40	L	52.5	R
44,0	1.7323	50	L	60	L	47,0	1.8504	40	L	52.5	L	50,0	1.9685	30	L	45	L	53,0	2.0866	22.5	L	37.5	L
44,1	1.7362	42.5	L	55	L	47,1	1.8543	35	L	47.5	L	50,1	1.9724	25	L	40	L	53,1	2.0906	17.5	L	35	L
44,2	1.7402	37.5	L	50	L	47,2	1.8583	27.5	L	42.5	L	50,2	1.9764	20	L	37.5	L	53,2	2.0945	10	L	32.5	L
44,3	1.7441	32.5	L	45	L	47.3	1.8622	22.5	L	40	L	50,3	1.9803	12.5	L	35	L	53,3	2.0984	2.5	L	32.5	L
44,4	1.7480	25	L	42.5	L	47,4	1.8661	17.5	L	35	L	50,4	1.9843	7.5	L	32.5	L	53,4	2.1024	5	R	32.5	L
44,5	1.7520	20	L	37.5	L	47,5	1.8701	12.5	L	32.5	L	50,5	1.9882	0	L	32.5	L	53,5	2.1063	15	R	35	L
44,6	1.7559	15	L	35	L	47,6	1.8740	5	L	32.5	L	50,6	1.9921	7.5	R	32.5	L	53,6	2.1102	30	R	45	L
44,7	1.7598	10	L	32.5	L	47,7	1.8780	2.5	R	32.5	L	50,7	1.9961	20	R	37.5	L	53,7	2.1142	62.5	R	72.5	L
44,8	1.7638	2.5	L	30	L	47,8	1.8819	12.5	R	35	L	50,8	2.0000	40	R	52.5	L	53,8	2.1181	57.5	L	67.5	R
44,9	1.7677	7.5	R	32.5	L	47,9	1.8858	27.5	R	42.5	L	50,9	2.0039	87.5	R	95	L	53,9	2.1220	27.5	L	42.5	R
45,0	1.7717	47.5	L	57.5	L	48,0	1.8898	37.5	L	50	L	51,0	2.0079	27.5	L	42.5	L	54,0	2.1260	20	L	37.5	L
45,1	1.7756	40	L	52.5	L	48,1	1.8937	30	L	45	L	51,1	2.0118	22.5	L	40	L	54,1	2.1299	12.5	L	35	L
45,2	1.7795	35	L	47.5	L	48,2	1.8976	25	L	40	L	51,2	2.0157	17.5	L	35	L	54,2	2.1339	7.5	L	32.5	L
45,3	1.7835	30	L	42.5	L	48,3	1.9016	20	L	37.5	L	51,3	2.0197	10	L	35	L	54,3	2.1378	0	L	32.5	L
45,4	1.7874	22.5	L	40	L	48,4	1.9055	15	L	35	L	51,4	2.0236	5	L	32.5	L	54,4	2.1417	7.5	R	32.5	L
45,5	1.7913	17.5	L	35	L	48,5	1.9094	7.5	L	32.5	L	51,5	2.0276	2.5	R	30	L	54,5	2.1457	20	R	37.5	L
45,6	1.7953	12.5	L	32.5	L	48,6	1.9134	0	L	32.5	L	51,6	2.0315	12.5	R	32.5	L	54,6	2.1496	45	R	55	L
45,7	1.7992	5	L	32.5	L	48,7	1.9173	7.5	R	32.5	L	51,7	2.0354	30	R	45	L	54,7	2.1535	82.5	L	90	R
45,8	1.8031	2.5	R	32.5	L	48,8	1.9213	20	R	37.5	L	51,8	2.0394	60	R	70	L	54,8	2.1575	40	L	52.5	R
45,9	1.8071	12.5	R	35	L	48,9	1.9252	40	R	52.5	L	51,9	2.0433	60	L	70	R	54,9	2.1614	20	L	37.5	R
55,0	2.1654	17.5	L	35	L	58,0	2.2835	7.5	L	32.5	L	61,0	2.4016	5	R	32.5	L	64,0	2.5197	25	R	40	L
55,1	2.1693	10	L	32.5	L	58,1	2.2874	0	R	30	L	61,1	2.4055	15	R	35	L	64,1	2.5236	55	R	65	L
55,2	2.1732	2.5	L	32.5	L	58,2	2.2913	10	R	32.5	L	61,2	2.4094	35	R	47.5	L	64,2	2.5276	67.5	L	77.5	R
55,3	2.1772	5	R	32.5	L	58,3	2.2953	22.5	R	40	L	61,3	2.4134	75	R	82.5	L	64,3	2.5315	32.5	L	45	R
55,4	2.1811	15	R	35	L	58,4	2.2992	47.5	R	57.5	L	61,4	2.4173	50	L	60	R	64,4	2.5354	15	L	35	R
55,5	2.1850	32.5	R	45	L	58,5	2.3031	75	L	82.5	R	61,5	2.4213	25	L	40	R	64,5	2.5394	5	L	32.5	R
55,6	2.1890	65	R	75	L	58,6	2.3071	35	L	47.5	R	61,6	2.4252	10	L	32.5	R	64,6	2.5433	2.5	R	32.5	R
55,7	2.1929	55	L	65	R	58,7	2.3110	17.5	L	37.5	R	61,7	2.4291	0	L	30	R	64,7	2.5472	10	R	32.5	R
55,8	2.1969	27.5	L	42.5	R	58,8	2.3150	5	L	32.5	R	61,8	2.4331	5	R	32.5	R	64,8	2.5512	15	R	35	R
55,9	2.2008	12.5	L	35	R	58,9	2.3189	2.5	R	32.5	R	61,9	2.4370	12.5	R	35	R	64,9	2.5551	22.5	R	37.5	R
56,0	2.2047	12.5	L	35	L	59,0	2.3228	2.5	L	32.5	L	62,0	2.4409	10	R	32.5	L	65,0	2.5591	37.5	R	50	L
56,1	2.2087	7.5	L	32.5	L	59,1	2.3268	5	R	32.5	L	62,1	2.4449	25	R	40	L	65,1	2.5630	80	R	87.5	L
56,2	2.2126	0	R	32.5	L	59,2	2.3307	15	R	35	L	62,2	2.4488	52.5	R	62.5	L	65,2	2.5669	47.5	L	57.5	R
56,3	2.2165	10	R	32.5	L	59,3	2.3346	35	R	47.5	L	62,3	2.4528	70	L	77.5	R	65,3	2.5709	22.5	L	40	R
56,4	2.2205	22.5	R	40	L	59,4	2.3386	72.5	R	80	L	62,4	2.4567	35	L	47.5	R	65,4	2.5748	7.5	L	32.5	R
56,5	2.2244	47.5	R	57.5	L	59,5	2.3425	52.5	L	62.5	R	62,5	2.4606	15	L	35	R	65,5	2.5787	0	L	32.5	R
56,6	2.2283	80	L	87.5	R	59,6	2.3465	25	L	40	R	62,6	2.4646	5	L	32.5	R	65,6	2.5827	7.5	R	32.5	R
56,7	2.2323	37.5	L	50	R	59,7	2.3504	10	L	32.5	R	62,7	2.4685	2.5	R	32.5	R	65,7	2.5866	12.5	R	35	R
56,8	2.2362	17.5	L	35	R	59,8	2.3543	2.5	L	32.5	R	62,8	2.4724	10	R	32.5	R	65,8	2.5906	17.5	R	37.5	R
56,9	2.2402	7.5	L	32.5	R	59,9	2.3583	5	R	32.5	R	62,9	2.4764	15	R	35	R	65,9	2.5945	25	R	40	R
57,0	2.2441	10	L	32.5	L	60,0	2.3622	0	R	30	L	63,0	2.4803	17.5	R	37.5	L	–	–	–	–	–	–
57,1	2.2480	2.5	L	32.5	L	60,1	2.3661	10	R	32.5	L	63,1	2.4843	37.5	R	50	L	–	–	–	–	–	–
57,2	2.2520	5	R	32.5	L	60,2	2.3701	25	R	40	L	63,2	2.4882	77.5	R	85	L	–	–	–	–	–	–
57,3	2.2559	15	R	35	L	60,3	2.3740	50	R	60	L	63,3	2.4921	47.5	L	57.5	R	–	–	–	–	–	–
57,4	2.2598	32.5	R	45	L	60,4	2.3780	72.5	L	80	R	63,4	2.4961	22.5	L	40	R	–	–	–	–	–	–
57,5	2.2638	67.5	R	77.5	L	60,5	2.3819	35	L	47.5	R	63,5	2.5000	10	L	32.5	R	–	–	–	–	–	–
57,6	2.2677	52.5	L	62.5	R	60,6	2.3858	15	L	35	R	63,6	2.5039	0	L	30	R	–	–	–	–	–	–
57,7	2.2717	25	L	40	R	60,7	2.3898	5	L	32.5	R	63,7	2.5079	7.5	R	32.5	R	–	–	–	–	–	–
57,8	2.2756	10	L	32.5	R	60,8	2.3937	2.5	R	32.5	R	63,8	2.5118	12.5	R	35	R	–	–	–	–	–	–
57,9	2.2795	2.5	L	32.5	R	60,9	2.3976	10	R	32.5	R	63,9	2.5157	17.5	R	37.5	R	–	–	–	–	–	–

(continued)

(Balancing Table • SVU-BB2 Boring Head — continued)

KRDEA012AM • KRDE065012M 65–82,9mm

diameter						diameter						diameter					
mm	in	ring 1		ring 2		mm	in	ring 1		ring 2		mm	in	ring 1		ring 2	
65,0	2.5591	5	L	37.5	R	68,0	2.6772	12.5	R	37.5	R	71,0	2.7953	25	R	45	R
65,1	2.5630	2.5	R	37.5	R	68,1	2.6811	17.5	R	40	R	71,1	2.7992	32.5	R	47.5	R
65,2	2.5669	10	R	37.5	R	68,2	2.6850	22.5	R	42.5	R	71,2	2.8031	37.5	R	52.5	R
65,3	2.5709	15	R	40	R	68,3	2.6890	27.5	R	47.5	R	71,3	2.8071	42.5	R	57.5	R
65,4	2.5748	20	R	42.5	R	68,4	2.6929	32.5	R	50	R	71,4	2.8110	47.5	R	62.5	R
65,5	2.5787	25	R	45	R	68,5	2.6969	40	R	55	R	71,5	2.8150	55	R	67.5	R
65,6	2.5827	30	R	47.5	R	68,6	2.7008	45	R	60	R	71,6	2.8189	65	R	77.5	R
65,7	2.5866	35	R	52.5	R	68,7	2.7047	52.5	R	65	R	71,7	2.8228	65	R	77.5	R
65,8	2.5906	42.5	R	57.5	R	68,8	2.7087	60	R	72.5	R	71,8	2.8268	65	R	77.5	R
65,9	2.5945	47.5	R	62.5	R	68,9	2.7126	70	R	82.5	R	71,9	2.8307	65	R	77.5	R
66,0	2.5984	2.5	R	35	R	69,0	2.7165	17.5	R	40	R	72,0	2.8346	30	R	47.5	R
66,1	2.6024	7.5	R	37.5	R	69,1	2.7205	22.5	R	42.5	R	72,1	2.8386	35	R	52.5	R
66,2	2.6063	12.5	R	40	R	69,2	2.7244	27.5	R	45	R	72,2	2.8425	40	R	55	R
66,3	2.6102	20	R	40	R	69,3	2.7283	32.5	R	50	R	72,3	2.8465	47.5	R	60	R
66,4	2.6142	25	R	45	R	69,4	2.7323	37.5	R	52.5	R	72,4	2.8504	55	R	67.5	R
66,5	2.6181	30	R	47.5	R	69,5	2.7362	45	R	57.5	R	72,5	2.8543	62.5	R	75	R
66,6	2.6220	35	R	52.5	R	69,6	2.7402	50	R	62.5	R	72,6	2.8583	80	R	90	R
66,7	2.6260	40	R	55	R	69,7	2.7441	57.5	R	70	R	72,7	2.8622	80	R	90	R
66,8	2.6299	47.5	R	60	R	69,8	2.7480	67.5	R	80	R	72,8	2.8661	80	R	90	R
66,9	2.6339	55	R	67.5	R	69,9	2.7520	67.5	R	80	R	72,9	2.8701	80	R	90	R
67,0	2.6378	7.5	R	37.5	R	70,0	2.7559	22.5	R	42.5	R	73,0	2.8740	40	R	55	R
67,1	2.6417	12.5	R	40	R	70,1	2.7598	27.5	R	45	R	73,1	2.8780	47.5	R	60	R
67,2	2.6457	17.5	R	42.5	R	70,2	2.7638	32.5	R	50	R	73,2	2.8819	52.5	R	65	R
67,3	2.6496	22.5	R	45	R	70,3	2.7677	37.5	R	52.5	R	73,3	2.8858	62.5	R	75	R
67,4	2.6535	30	R	47.5	R	70,4	2.7717	42.5	R	57.5	R	73,4	2.8898	75	R	87.5	R
67,5	2.6575	35	R	50	R	70,5	2.7756	50	R	62.5	R	73,5	2.8937	75	R	87.5	R
67,6	2.6614	40	R	55	R	70,6	2.7795	57.5	R	70	R	73,6	2.8976	75	R	87.5	R
67,7	2.6654	45	R	60	R	70,7	2.7835	65	R	77.5	R	73,7	2.9016	75	R	87.5	R
67,8	2.6693	52.5	R	65	R	70,8	2.7874	65	R	77.5	R	73,8	2.9055	75	R	87.5	R
67,9	2.6732	60	R	72.5	R	70,9	2.7913	65	R	77.5	R	73,9	2.9094	75	R	87.5	R
74,0	2.9134	40	R	55	R	77,0	3.0315	55	R	67.5	R	80,0	3.1496	22.5	L	45	L
74,1	2.9173	45	R	60	R	77,1	3.0354	65	R	77.5	R	80,1	3.1535	17.5	L	42.5	L
74,2	2.9213	52.5	R	65	R	77,2	3.0394	65	R	77.5	R	80,2	3.1575	12.5	L	40	L
74,3	2.9252	60	R	72.5	R	77,3	3.0433	65	R	77.5	R	80,3	3.1614	5	L	40	L
74,4	2.9291	70	R	82.5	R	77,4	3.0472	65	R	77.5	R	80,4	3.1654	2.5	R	40	L
74,5	2.9331	70	R	82.5	R	77,5	3.0512	65	R	77.5	R	80,5	3.1693	10	R	40	L
74,6	2.9370	70	R	82.5	R	77,6	3.0551	65	R	77.5	R	80,6	3.1732	22.5	R	45	L
74,7	2.9409	70	R	82.5	R	77,7	3.0591	65	R	77.5	R	80,7	3.1772	37.5	R	55	L
74,8	2.9449	70	R	82.5	R	77,8	3.0630	65	R	77.5	R	80,8	3.1811	65	R	77.5	L
74,9	2.9488	70	R	82.5	R	77,9	3.0669	65	R	77.5	R	80,9	3.1850	70	L	82.5	R
75,0	2.9528	52.5	R	65	R	78,0	3.0709	62.5	R	75	R	81,0	3.1890	20	L	42.5	L
75,1	2.9567	57.5	R	70	R	78,1	3.0748	82.5	R	92.5	R	81,1	3.1929	12.5	L	40	L
75,2	2.9606	70	R	82.5	R	78,2	3.0787	82.5	R	92.5	R	81,2	3.1969	5	L	40	L
75,3	2.9646	70	R	82.5	R	78,3	3.0827	82.5	R	92.5	R	81,3	3.2008	0	R	37.5	L
75,4	2.9685	70	R	82.5	R	78,4	3.0866	82.5	R	92.5	R	81,4	3.2047	10	R	40	L
75,5	2.9724	70	R	82.5	R	78,5	3.0906	82.5	R	92.5	R	81,5	3.2087	20	R	45	L
75,6	2.9764	70	R	82.5	R	78,6	3.0945	82.5	R	92.5	R	81,6	3.2126	35	R	52.5	L
75,7	2.9803	70	R	82.5	R	78,7	3.0984	82.5	R	92.5	R	81,7	3.2165	57.5	R	72.5	L
75,8	2.9843	70	R	82.5	R	78,8	3.1024	82.5	R	92.5	R	81,8	3.2205	75	L	87.5	R
75,9	2.9882	70	R	82.5	R	78,9	3.1063	82.5	R	92.5	R	81,9	3.2244	45	L	60	R
76,0	2.9921	50	R	62.5	R	79,0	3.1102	75	R	87.5	R	82,0	3.2283	15	L	40	L
76,1	2.9961	57.5	R	70	R	79,1	3.1142	75	R	87.5	R	82,1	3.2323	7.5	L	40	L
76,2	3.0000	67.5	R	80	R	79,2	3.1181	75	R	87.5	R	82,2	3.2362	0	L	40	L
76,3	3.0039	67.5	R	80	R	79,3	3.1220	75	R	87.5	R	82,3	3.2402	7.5	R	40	L
76,4	3.0079	67.5	R	80	R	79,4	3.1260	75	R	87.5	R	82,4	3.2441	17.5	R	42.5	L
76,5	3.0118	67.5	R	80	R	79,5	3.1299	75	R	87.5	R	82,5	3.2480	30	R	50	L
76,6	3.0157	67.5	R	80	R	79,6	3.1339	75	R	87.5	R	82,6	3.2520	52.5	R	67.5	L
76,7	3.0197	67.5	R	80	R	79,7	3.1378	75	R	87.5	R	82,7	3.2559	82.5	L	95	R
76,8	3.0236	67.5	R	80	R	79,8	3.1417	75	R	87.5	R	82,8	3.2598	50	L	65	R
76,9	3.0276	67.5	R	80	R	79,9	3.1457	75	R	87.5	R	82,9	3.2638	30	L	50	R

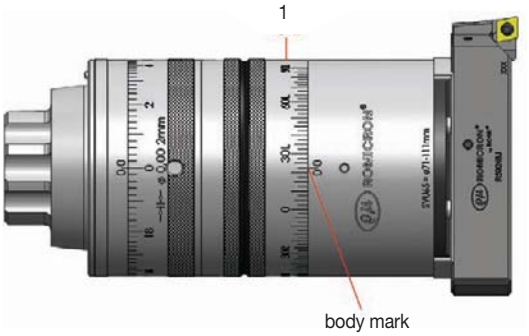
(continued)

(Balancing Table • SVU-BB2 Boring Head — continued)

KRDEA012AM • KRDE065012M 65–100mm

diameter						diameter						diameter					
mm	in	ring 1		ring 2		mm	in	ring 1		ring 2		mm	in	ring 1		ring 2	
83,0	3.2677	10	L	40	L	86,0	3.3858	10	R	40	L	89,0	3.5039	42.5	R	57.5	L
83,1	3.2717	2.5	L	37.5	L	86,1	3.3898	20	R	45	L	89,1	3.5079	72.5	R	85	L
83,2	3.2756	5	R	40	L	86,2	3.3937	35	R	52.5	L	89,2	3.5118	62.5	L	75	R
83,3	3.2795	15	R	42.5	L	86,3	3.3976	57.5	R	72.5	L	89,3	3.5157	37.5	L	55	R
83,4	3.2835	27.5	R	47.5	L	86,4	3.4016	75	L	87.5	R	89,4	3.5197	22.5	L	45	R
83,5	3.2874	47.5	R	62.5	L	86,5	3.4055	45	L	60	R	89,5	3.5236	10	L	40	R
83,6	3.2913	77.5	R	90	L	86,6	3.4094	27.5	L	47.5	R	89,6	3.5276	0	L	37.5	R
83,7	3.2953	55	L	70	R	86,7	3.4134	15	L	42.5	R	89,7	3.5315	5	R	40	R
83,8	3.2992	32.5	L	50	R	86,8	3.4173	5	L	40	R	89,8	3.5354	12.5	R	40	R
83,9	3.3031	17.5	L	42.5	R	86,9	3.4213	2.5	R	40	R	89,9	3.5394	17.5	R	42.5	R
84,0	3.3071	5	L	37.5	L	87,0	3.4252	17.5	R	42.5	L	90,0	3.5433	65	R	77.5	L
84,1	3.3110	2.5	R	37.5	L	87,1	3.4291	30	R	50	L	90,1	3.5472	70	L	82.5	R
84,2	3.3150	12.5	R	40	L	87,2	3.4331	52.5	R	67.5	L	90,2	3.5512	40	L	57.5	R
84,3	3.3189	25	R	47.5	L	87,3	3.4370	82.5	L	95	R	90,3	3.5551	22.5	L	45	R
84,4	3.3228	42.5	R	57.5	L	87,4	3.4409	50	L	65	R	90,4	3.5591	12.5	L	40	R
84,5	3.3268	72.5	R	85	L	87,5	3.4449	30	L	50	R	90,5	3.5630	2.5	L	37.5	R
84,6	3.3307	62.5	L	75	R	87,6	3.4488	17.5	L	42.5	R	90,6	3.5669	5	R	37.5	R
84,7	3.3346	37.5	L	55	R	87,7	3.4528	7.5	L	40	R	90,7	3.5709	10	R	40	R
84,8	3.3386	22.5	L	45	R	87,8	3.4567	2.5	R	37.5	R	90,8	3.5748	17.5	R	42.5	R
84,9	3.3425	10	L	40	R	87,9	3.4606	7.5	R	40	R	90,9	3.5787	22.5	R	45	R
85,0	3.3465	2.5	R	40	L	88,0	3.4646	27.5	R	47.5	L	91,0	3.5827	75	L	87.5	R
85,1	3.3504	10	R	40	L	88,1	3.4685	47.5	R	62.5	L	91,1	3.5866	47.5	L	62.5	R
85,2	3.3543	22.5	R	45	L	88,2	3.4724	77.5	R	90	L	91,2	3.5906	27.5	L	47.5	R
85,3	3.3583	37.5	R	55	L	88,3	3.4764	55	L	70	R	91,3	3.5945	15	L	42.5	R
85,4	3.3622	65	R	77.5	L	88,4	3.4803	35	L	52.5	R	91,4	3.5984	5	L	40	R
85,5	3.3661	70	L	82.5	R	88,5	3.4843	17.5	L	42.5	R	91,5	3.6024	2.5	R	40	R
85,6	3.3701	40	L	57.5	R	88,6	3.4882	7.5	L	40	R	91,6	3.6063	10	R	40	R
85,7	3.3740	22.5	L	45	R	88,7	3.4921	0	R	40	R	91,7	3.6102	15	R	42.5	R
85,8	3.3780	12.5	L	40	R	88,8	3.4961	7.5	R	40	R	91,8	3.6142	22.5	R	45	R
85,9	3.3819	2.5	L	37.5	R	88,9	3.5000	12.5	R	42.5	R	91,9	3.6181	27.5	R	47.5	R
92,0	3.6220	50	L	65	R	95,0	3.7402	12.5	L	40	R	98,0	3.8583	7.5	R	40	R
92,1	3.6260	30	L	50	R	95,1	3.7441	2.5	L	37.5	R	98,1	3.8622	12.5	R	42.5	R
92,2	3.6299	17.5	L	42.5	R	95,2	3.7480	5	R	37.5	R	98,2	3.8661	20	R	42.5	R
92,3	3.6339	7.5	L	40	R	95,3	3.7520	10	R	40	R	98,3	3.8701	25	R	47.5	R
92,4	3.6378	2.5	R	37.5	R	95,4	3.7559	17.5	R	42.5	R	98,4	3.8740	30	R	50	R
92,5	3.6417	7.5	R	40	R	95,5	3.7598	22.5	R	45	R	98,5	3.8780	37.5	R	55	R
92,6	3.6457	15	R	40	R	95,6	3.7638	27.5	R	47.5	R	98,6	3.8819	42.5	R	60	R
92,7	3.6496	20	R	45	R	95,7	3.7677	35	R	52.5	R	98,7	3.8858	50	R	65	R
92,8	3.6535	25	R	47.5	R	95,8	3.7717	40	R	57.5	R	98,8	3.8898	57.5	R	72.5	R
92,9	3.6575	32.5	R	50	R	95,9	3.7756	47.5	R	62.5	R	98,9	3.8937	70	R	82.5	R
93,0	3.6614	35	L	52.5	R	96,0	3.7795	5	L	40	R	99,0	3.8976	12.5	R	40	R
93,1	3.6654	17.5	L	42.5	R	96,1	3.7835	2.5	R	40	R	99,1	3.9016	17.5	R	42.5	R
93,2	3.6693	7.5	L	40	R	96,2	3.7874	10	R	40	R	99,2	3.9055	25	R	45	R
93,3	3.6732	0	R	37.5	R	96,3	3.7913	15	R	42.5	R	99,3	3.9094	30	R	50	R
93,4	3.6772	7.5	R	40	R	96,4	3.7953	22.5	R	45	R	99,4	3.9134	35	R	52.5	R
93,5	3.6811	12.5	R	42.5	R	96,5	3.7992	27.5	R	47.5	R	99,5	3.9173	42.5	R	57.5	R
93,6	3.6850	20	R	42.5	R	96,6	3.8031	32.5	R	52.5	R	99,6	3.9213	47.5	R	62.5	R
93,7	3.6890	25	R	47.5	R	96,7	3.8071	40	R	55	R	99,7	3.9252	55	R	70	R
93,8	3.6929	30	R	50	R	96,8	3.8110	45	R	60	R	99,8	3.9291	67.5	R	80	R
93,9	3.6969	37.5	R	55	R	96,9	3.8150	52.5	R	67.5	R	99,9	3.9331	67.5	R	80	R
94,0	3.7008	22.5	L	45	R	97,0	3.8189	2.5	R	37.5	R	100,0	3.9370	17.5	R	42.5	R
94,1	3.7047	10	L	40	R	97,1	3.8228	7.5	R	40	R	100,1	3.9409	22.5	R	45	R
94,2	3.7087	2.5	L	40	R	97,2	3.8268	15	R	40	R	100,2	3.9449	27.5	R	47.5	R
94,3	3.7126	5	R	40	R	97,3	3.8307	20	R	45	R	100,3	3.9488	35	R	52.5	R
94,4	3.7165	12.5	R	40	R	97,4	3.8346	25	R	47.5	R	100,4	3.9528	40	R	57.5	R
94,5	3.7205	17.5	R	42.5	R	97,5	3.8386	32.5	R	50	R	100,5	3.9567	47.5	R	62.5	R
94,6	3.7244	25	R	45	R	97,6	3.8425	37.5	R	55	R	100,6	3.9606	55	R	70	R
94,7	3.7283	30	R	50	R	97,7	3.8465	45	R	60	R	100,7	3.9646	65	R	77.5	R
94,8	3.7323	35	R	52.5	R	97,8	3.8504	50	R	65	R	100,8	3.9685	65	R	77.5	R
94,9	3.7362	42.5	R	57.5	R	97,9	3.8543	60	R	72.5	R	100,9	3.9724	65	R	77.5	R

Balancing Table • SVU-65 Boring Head





1. There is one 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).

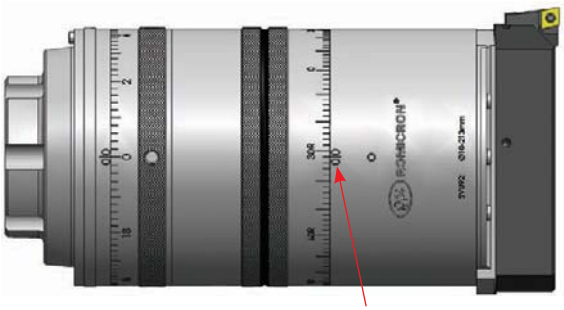
KRDE070019M												KRDE083019M							
KRCSCFPR061E 71–76mm				KRCSCFPR062E 75,5–81,5mm				KRCSCFPR063E 80–85mm				KRCSCFPR061E 84–89mm				KRCSCFPR062E 88,5–93,5mm			
diameter		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting	
mm	in			mm	in			mm	in			mm	in			mm	in		
70,99	2.795	40	L	75,49	2.972	35	L	80,01	3.150	30	L	84,00	3.307	47.5	L	88,49	3.484	40	L
71,12	2.800	37.5	L	75,59	2.976	32.5	L	80,16	3.156	27.5	L	84,12	3.312	45	L	88,65	3.490	37.5	L
71,27	2.806	35	L	75,77	2.983	30	L	80,34	3.163	25	L	84,25	3.317	42.5	L	88,80	3.496	35	L
71,42	2.812	32.5	L	75,95	2.990	27.5	L	80,52	3.170	22.5	L	84,38	3.322	40	L	88,95	3.502	32.5	L
71,60	2.819	30	L	76,10	2.996	25	L	80,70	3.177	20	L	84,51	3.327	37.5	L	89,08	3.507	30	L
71,78	2.826	27.5	L	76,28	3.003	22.5	L	80,87	3.184	17.5	L	84,66	3.333	35	L	89,26	3.514	27.5	L
71,96	2.833	25	L	76,48	3.011	20	L	81,08	3.192	15	L	84,81	3.339	32.5	L	89,41	3.520	25	L
72,14	2.840	22.5	L	76,66	3.018	17.5	L	81,25	3.199	12.5	L	84,96	3.345	30	L	89,56	3.526	22.5	L
72,31	2.847	20	L	76,84	3.025	15	L	81,46	3.207	10	L	85,12	3.351	27.5	L	89,74	3.533	20	L
72,49	2.854	17.5	L	77,04	3.033	12.5	L	81,64	3.214	7.5	L	85,27	3.357	25	L	89,89	3.539	17.5	L
72,69	2.862	15	L	77,22	3.040	10	L	81,84	3.222	5	L	85,42	3.363	22.5	L	90,07	3.546	15	L
72,87	2.869	12.5	L	77,42	3.048	7.5	L	82,02	3.229	2.5	L	85,60	3.370	20	L	90,22	3.552	12.5	L
73,08	2.877	10	L	77,62	3.056	5	L	82,22	3.237	0	–	85,78	3.377	17.5	L	90,40	3.559	10	L
73,25	2.884	7.5	L	77,80	3.063	2.5	L	82,42	3.245	2.5	R	85,93	3.383	15	L	90,58	3.566	7.5	L
73,46	2.892	5	L	78,00	3.071	0	–	82,60	3.252	5	R	86,11	3.390	12.5	L	90,75	3.573	5	L
73,66	2.900	2.5	L	78,21	3.079	2.5	R	82,80	3.260	7.5	R	86,28	3.397	10	L	90,93	3.580	2.5	L
73,86	2.908	0	–	78,38	3.086	5	R	82,98	3.267	10	R	86,46	3.404	7.5	L	91,11	3.587	0	–
74,04	2.915	2.5	R	78,59	3.094	7.5	R	83,19	3.275	12.5	R	86,64	3.411	5	L	91,29	3.594	2.5	R
74,24	2.923	5	R	78,77	3.101	10	R	83,36	3.282	15	R	86,82	3.418	2.5	L	91,47	3.601	5	R
74,45	2.931	7.5	R	78,97	3.109	12.5	R	83,57	3.290	17.5	R	87,00	3.425	0	–	91,64	3.608	7.5	R
74,63	2.938	10	R	79,15	3.116	15	R	83,74	3.297	20	R	87,17	3.432	2.5	R	91,80	3.614	10	R
74,83	2.946	12.5	R	79,35	3.124	17.5	R	83,92	3.304	22.5	R	87,33	3.438	5	R	91,97	3.621	12.5	R
75,01	2.953	15	R	79,53	3.131	20	R	84,10	3.311	25	R	87,50	3.445	7.5	R	92,15	3.628	15	R
75,21	2.961	17.5	R	79,71	3.138	22.5	R	84,28	3.318	27.5	R	87,68	3.452	10	R	92,33	3.635	17.5	R
75,39	2.968	20	R	79,88	3.145	25	R	84,46	3.325	30	R	87,86	3.459	12.5	R	92,48	3.641	20	R
75,57	2.975	22.5	R	80,06	3.152	27.5	R	84,61	3.331	32.5	R	88,04	3.466	15	R	92,66	3.648	22.5	R
75,74	2.982	25	R	80,24	3.159	30	R	84,79	3.338	35	R	88,21	3.473	17.5	R	92,81	3.654	25	R
75,92	2.989	27.5	R	80,42	3.166	32.5	R	84,94	3.344	37.5	R	88,37	3.479	20	R	92,96	3.660	27.5	R
76,00	2.992	30	R	80,49	3.169	35	R	84,99	3.346	40	R	88,54	3.486	22.5	R	93,12	3.666	30	R
–	–	–	–	–	–	–	–	–	–	–	–	88,70	3.492	25	R	93,27	3.672	32.5	R
–	–	–	–	–	–	–	–	–	–	–	–	88,85	3.498	27.5	R	93,42	3.678	35	R
–	–	–	–	–	–	–	–	–	–	–	–	89,00	3.504	30	R	93,50	3.681	37.5	R

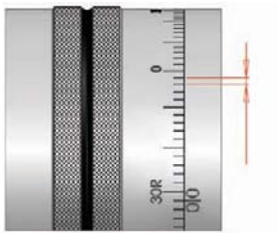
(continued)

(Balancing Table • SVU-65 Boring Head — continued)

KRDE083019M				KRDE096019M											
KRCSCFPR063E 93–98mm				KRCSCFPR061E 97–102mm				KRCSCFPR062E 101,5–106,5mm				KRCSCFPR063E 106–111mm			
diameter		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting	
mm	in			mm	in			mm	in			mm	in		
92,99	3.661	35	L	97,00	3.819	55	L	101,50	3.996	45	L	105,99	4.173	37.5	L
93,14	3.667	32.5	L	97,05	3.821	52.5	L	101,60	4.000	42.5	L	106,17	4.180	35	L
93,29	3.673	30	L	97,16	3.825	50	L	101,73	4.005	40	L	106,32	4.186	32.5	L
93,45	3.679	27.5	L	97,28	3.830	47.5	L	101,85	4.010	37.5	L	106,45	4.191	30	L
93,60	3.685	25	L	97,38	3.834	45	L	101,98	4.015	35	L	106,58	4.196	27.5	L
93,78	3.692	22.5	L	97,51	3.839	42.5	L	102,13	4.021	32.5	L	106,73	4.202	25	L
93,93	3.698	20	L	97,61	3.843	40	L	102,26	4.026	30	L	106,88	4.208	22.5	L
94,11	3.705	17.5	L	97,74	3.848	37.5	L	102,41	4.032	27.5	L	107,04	4.214	20	L
94,26	3.711	15	L	97,87	3.853	35	L	102,54	4.037	25	L	107,19	4.220	17.5	L
94,44	3.718	12.5	L	98,02	3.859	32.5	L	102,69	4.043	22.5	L	107,34	4.226	15	L
94,62	3.725	10	L	98,15	3.864	30	L	102,84	4.049	20	L	107,49	4.232	12.5	L
94,79	3.732	7.5	L	98,30	3.870	27.5	L	103,00	4.055	17.5	L	107,65	4.238	10	L
94,95	3.738	5	L	98,45	3.876	25	L	103,15	4.061	15	L	107,82	4.245	7.5	L
95,12	3.745	2.5	L	98,58	3.881	22.5	L	103,30	4.067	12.5	L	107,98	4.251	5	L
95,30	3.752	0	–	98,73	3.887	20	L	103,48	4.074	10	L	108,13	4.257	2.5	L
95,48	3.759	2.5	R	98,88	3.893	17.5	L	103,63	4.080	7.5	L	108,31	4.264	0	–
95,66	3.766	5	R	99,06	3.900	15	L	103,78	4.086	5	L	108,46	4.270	2.5	R
95,83	3.773	7.5	R	99,21	3.906	12.5	L	103,96	4.093	2.5	L	108,61	4.276	5	R
96,01	3.780	10	R	99,36	3.912	10	L	104,11	4.099	0	–	108,79	4.283	7.5	R
96,19	3.787	12.5	R	99,52	3.918	7.5	L	104,27	4.105	2.5	R	108,94	4.289	10	R
96,34	3.793	15	R	99,70	3.925	5	L	104,44	4.112	5	R	109,09	4.295	12.5	R
96,52	3.800	17.5	R	99,85	3.931	2.5	L	104,60	4.118	7.5	R	109,25	4.301	15	R
96,67	3.806	20	R	100,03	3.938	0	–	104,75	4.124	10	R	109,40	4.307	17.5	R
96,85	3.813	22.5	R	100,18	3.944	2.5	R	104,90	4.130	12.5	R	109,55	4.313	20	R
97,00	3.819	25	R	100,33	3.950	5	R	105,08	4.137	15	R	109,70	4.319	22.5	R
97,16	3.825	27.5	R	100,51	3.957	7.5	R	105,23	4.143	17.5	R	109,86	4.325	25	R
97,31	3.831	30	R	100,66	3.963	10	R	105,38	4.149	20	R	110,01	4.331	27.5	R
97,46	3.837	32.5	R	100,81	3.969	12.5	R	105,54	4.155	22.5	R	110,13	4.336	30	R
97,61	3.843	35	R	100,97	3.975	15	R	105,69	4.161	25	R	110,29	4.342	32.5	R
97,76	3.849	37.5	R	101,14	3.982	17.5	R	105,82	4.166	27.5	R	110,41	4.347	35	R
97,89	3.854	40	R	101,30	3.988	20	R	105,97	4.172	30	R	110,54	4.352	37.5	R
97,99	3.858	42.5	R	101,45	3.994	22.5	R	106,10	4.177	32.5	R	110,67	4.357	40	R
–	–	–	–	101,57	3.999	25	R	106,25	4.183	35	R	110,79	4.362	42.5	R
–	–	–	–	101,73	4.005	27.5	R	106,38	4.188	37.5	R	110,90	4.366	45	R
–	–	–	–	104,39	4.110	30	R	106,43	4.190	40	R	111,00	4.370	47.5	R
–	–	–	–	102,01	4.016	32.5	R	106,53	4.194	42.5	R	–	–	–	–

Balancing Table • SVU-92 Boring Head





1. There is one 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		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting	
mm	in			mm	in			mm	in			mm	in			mm	in		
100,99	3.976	36	L	107,49	4.232	34	L	114,00	4.488	30	L	119,99	4.724	40	L	126,49	4.980	36	L
101,19	3.984	34	L	107,62	4.237	32	L	114,22	4.497	28	L	120,19	4.732	38	L	126,72	4.989	34	L
101,40	3.992	32	L	107,80	4.244	30	L	114,40	4.504	26	L	120,35	4.738	36	L	126,90	4.996	32	L
101,57	3.999	30	L	108,00	4.252	28	L	114,60	4.512	24	L	120,52	4.745	34	L	127,08	5.003	30	L
101,78	4.007	28	L	108,20	4.260	26	L	114,81	4.520	22	L	120,70	4.752	32	L	127,25	5.010	28	L
101,98	4.015	26	L	108,41	4.268	24	L	115,01	4.528	20	L	120,88	4.759	30	L	127,43	5.017	26	L
102,18	4.023	24	L	108,61	4.276	22	L	115,24	4.537	18	L	121,06	4.766	28	L	127,61	5.024	24	L
102,39	4.031	22	L	108,81	4.284	20	L	115,44	4.545	16	L	121,23	4.773	26	L	127,81	5.032	22	L
102,59	4.039	20	L	109,02	4.292	18	L	115,67	4.554	14	L	121,41	4.780	24	L	127,99	5.039	20	L
102,79	4.047	18	L	109,25	4.301	16	L	115,87	4.562	12	L	121,62	4.788	22	L	128,19	5.047	18	L
103,02	4.056	16	L	109,45	4.309	14	L	116,10	4.571	10	L	121,79	4.795	20	L	128,40	5.055	16	L
103,23	4.064	14	L	109,68	4.318	12	L	116,31	4.579	8	L	122,00	4.803	18	L	128,57	5.062	14	L
103,45	4.073	12	L	109,88	4.326	10	L	116,54	4.588	6	L	122,20	4.811	16	L	128,78	5.070	12	L
103,66	4.081	10	L	110,11	4.335	8	L	116,76	4.597	4	L	122,38	4.818	14	L	128,98	5.078	10	L
103,89	4.090	8	L	110,34	4.344	6	L	116,97	4.605	2	L	122,58	4.826	12	L	129,18	5.086	8	L
104,11	4.099	6	L	110,57	4.353	4	L	117,20	4.614	0	–	122,78	4.834	10	L	129,39	5.094	6	L
104,32	4.107	4	L	110,77	4.361	2	L	117,42	4.623	2	R	122,99	4.842	8	L	129,59	5.102	4	L
104,55	4.116	2	L	111,00	4.370	0	–	117,65	4.632	4	R	123,19	4.850	6	L	129,79	5.110	2	L
104,78	4.125	0	–	111,23	4.379	2	R	117,86	4.640	6	R	123,39	4.858	4	L	130,00	5.118	0	–
105,00	4.134	2	R	111,46	4.388	4	R	118,08	4.649	8	R	123,60	4.866	2	L	130,20	5.126	2	R
105,23	4.143	4	R	111,66	4.396	6	R	118,31	4.658	10	R	123,80	4.874	0	–	130,40	5.134	4	R
105,44	4.151	6	R	111,89	4.405	8	R	118,52	4.666	12	R	124,00	4.882	2	R	130,61	5.142	6	R
105,66	4.160	8	R	112,12	4.414	10	R	118,75	4.675	14	R	124,21	4.890	4	R	130,81	5.150	8	R
105,89	4.169	10	R	107,19	4.220	12	R	118,95	4.683	16	R	124,41	4.898	6	R	131,01	5.158	10	R
106,10	4.177	12	R	112,55	4.431	14	R	119,18	4.692	18	R	124,61	4.906	8	R	131,22	5.166	12	R
106,32	4.186	14	R	112,75	4.439	16	R	119,38	4.700	20	R	124,82	4.914	10	R	131,42	5.174	14	R
106,53	4.194	16	R	112,98	4.448	18	R	119,58	4.708	22	R	125,02	4.922	12	R	131,62	5.182	16	R
106,76	4.203	18	R	113,18	4.456	20	R	119,79	4.716	24	R	125,22	4.930	14	R	131,80	5.189	18	R
106,96	4.211	20	R	113,39	4.464	22	R	119,99	4.724	26	R	125,43	4.938	16	R	132,00	5.197	20	R
107,16	4.219	22	R	113,59	4.472	24	R	120,19	4.732	28	R	125,63	4.946	18	R	132,18	5.204	22	R
107,37	4.227	24	R	113,79	4.480	26	R	120,37	4.739	30	R	125,81	4.953	20	R	132,38	5.212	24	R
107,57	4.235	26	R	114,00	4.488	28	R	120,57	4.747	32	R	126,01	4.961	22	R	132,56	5.219	26	R
107,77	4.243	28	R	114,20	4.496	30	R	120,75	4.754	34	R	126,19	4.968	24	R	132,74	5.226	28	R
107,98	4.251	30	R	114,38	4.503	32	R	120,93	4.761	36	R	126,37	4.975	26	R	132,92	5.233	30	R
108,00	4.252	32	R	114,50	4.508	34	R	121,01	4.764	38	R	126,57	4.983	28	R	133,10	5.240	32	R
–	–	–	–	–	–	–	–	–	–	–	–	126,75	4.990	30	R	133,27	5.247	34	R
–	–	–	–	–	–	–	–	–	–	–	–	126,92	4.997	32	R	133,45	5.254	36	R
–	–	–	–	–	–	–	–	–	–	–	–	127,00	5.000	34	R	133,50	5.256	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		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting	
mm	in			mm	in			mm	in			mm	in		
132,99	5.236	34	L	138,99	5.472	50	L	145,49	5.728	44	L	151,99	5.984	40	L
133,10	5.240	32	L	139,09	5.476	48	L	145,67	5.735	42	L	152,12	5.989	38	L
133,27	5.247	30	L	139,22	5.481	46	L	145,80	5.740	40	L	152,27	5.995	36	L
133,45	5.254	28	L	139,34	5.486	44	L	145,95	5.746	38	L	152,40	6.000	34	L
133,63	5.261	26	L	139,47	5.491	42	L	146,08	5.751	36	L	152,55	6.006	32	L
133,81	5.268	24	L	139,60	5.496	40	L	146,23	5.757	34	L	152,70	6.012	30	L
133,99	5.275	22	L	139,73	5.501	38	L	146,35	5.762	32	L	152,86	6.018	28	L
134,19	5.283	20	L	139,88	5.507	36	L	146,51	5.768	30	L	153,01	6.024	26	L
134,37	5.290	18	L	140,00	5.512	34	L	146,66	5.774	28	L	153,16	6.030	24	L
134,57	5.298	16	L	140,16	5.518	32	L	146,81	5.780	26	L	153,31	6.036	22	L
134,77	5.306	14	L	140,31	5.524	30	L	146,99	5.787	24	L	153,49	6.043	20	L
134,98	5.314	12	L	140,46	5.530	28	L	147,14	5.793	22	L	153,64	6.049	18	L
135,18	5.322	10	L	140,61	5.536	26	L	147,29	5.799	20	L	153,82	6.056	16	L
135,36	5.329	8	L	140,77	5.542	24	L	147,47	5.806	18	L	153,97	6.062	14	L
135,56	5.337	6	L	140,92	5.548	22	L	147,62	5.812	16	L	154,15	6.069	12	L
135,76	5.345	4	L	141,10	5.555	20	L	147,80	5.819	14	L	154,33	6.076	10	L
135,97	5.353	2	L	141,25	5.561	18	L	147,96	5.825	12	L	154,48	6.082	8	L
136,17	5.361	0	–	141,43	5.568	16	L	148,13	5.832	10	L	154,66	6.089	6	L
136,37	5.369	2	R	141,58	5.574	14	L	148,31	5.839	8	L	154,84	6.096	4	L
136,58	5.377	4	R	141,76	5.581	12	L	148,49	5.846	6	L	155,02	6.103	2	L
162,18	6.385	6	R	141,94	5.588	10	L	148,64	5.852	4	L	155,19	6.110	0	–
136,98	5.393	8	R	142,11	5.595	8	L	148,82	5.859	2	L	155,35	6.116	2	R
137,19	5.401	10	R	142,27	5.601	6	L	149,00	5.866	0	–	155,52	6.123	4	R
137,39	5.409	12	R	142,44	5.608	4	L	149,17	5.873	2	R	155,70	6.130	6	R
137,59	5.417	14	R	142,62	5.615	2	L	149,35	5.880	4	R	155,88	6.137	8	R
137,80	5.425	16	R	142,80	5.622	0	–	149,53	5.887	6	R	156,03	6.143	10	R
137,97	5.432	18	R	142,98	5.629	2	R	149,68	5.893	8	R	156,21	6.150	12	R
138,18	5.440	20	R	143,15	5.636	4	R	149,86	5.900	10	R	156,39	6.157	14	R
138,38	5.448	22	R	143,31	5.642	6	R	150,04	5.907	12	R	156,54	6.163	16	R
138,56	5.455	24	R	143,48	5.649	8	R	150,19	5.913	14	R	156,72	6.170	18	R
138,73	5.462	26	R	143,66	5.656	10	R	150,37	5.920	16	R	156,87	6.176	20	R
138,91	5.469	28	R	143,84	5.663	12	R	150,55	5.927	18	R	157,05	6.183	22	R
139,09	5.476	30	R	143,99	5.669	14	R	150,70	5.933	20	R	157,20	6.189	24	R
139,27	5.483	32	R	144,17	5.676	16	R	150,85	5.939	22	R	157,35	6.195	26	R
139,45	5.490	34	R	144,32	5.682	18	R	151,03	5.946	24	R	157,51	6.201	28	R
139,60	5.496	36	R	144,50	5.689	20	R	151,18	5.952	26	R	157,66	6.207	30	R
139,78	5.503	38	R	144,65	5.695	22	R	151,33	5.958	28	R	157,81	6.213	32	R
139,93	5.509	40	R	144,83	5.702	24	R	151,49	5.964	30	R	157,96	6.219	34	R
140,00	5.512	42	R	144,98	5.708	26	R	151,64	5.970	32	R	158,09	6.224	36	R
–	–	–	–	145,14	5.714	28	R	151,79	5.976	34	R	158,24	6.23	38	R
–	–	–	–	145,29	5.720	30	R	151,92	5.981	36	R	158,37	6.235	40	R
–	–	–	–	145,44	5.726	32	R	152,07	5.987	38	R	158,50	6.24	42	R
–	–	–	–	145,57	5.731	34	R	152,20	5.992	40	R	158,62	6.245	44	R
–	–	–	–	145,72	5.737	36	R	152,32	5.997	42	R	158,75	6.25	46	R
–	–	–	–	145,87	5.743	38	R	152,45	6.002	44	R	158,88	6.255	48	R
–	–	–	–	145,97	5.747	40	R	152,50	6.004	46	R	158,98	6.259	50	R
–	–	–	–	146,00	5.748	42	R	–	–	–	–	159,00	6.26	52	R

(continued)

(Balancing Table • SVU-92 Boring Head — continued)

KRDE156026M

KRCSCFPR061F 156–163mm				KRCSCFPR062F 162,5–169,5mm				KRCSCFPR063F 169–176mm			
diameter		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting	
mm	in			mm	in			mm	in		
156,01	6.142	56	L	162,51	6.398	50	L	169,01	6.654	44	L
156,11	6.146	54	L	162,61	6.402	48	L	169,11	6.658	42	L
156,21	6.150	52	L	162,71	6.406	46	L	169,24	6.663	40	L
156,31	6.154	50	L	162,81	6.410	44	L	169,37	6.668	38	L
156,41	6.158	48	L	162,94	6.415	42	L	169,49	6.673	36	L
156,51	6.162	46	L	163,07	6.420	40	L	169,62	6.678	34	L
156,62	6.166	44	L	163,20	6.425	38	L	169,75	6.683	32	L
156,74	6.171	42	L	163,32	6.430	36	L	169,90	6.689	30	L
156,87	6.176	40	L	163,45	6.435	34	L	170,03	6.694	28	L
157,00	6.181	38	L	163,58	6.440	32	L	170,18	6.700	26	L
157,12	6.186	36	L	163,70	6.445	30	L	170,33	6.706	24	L
157,25	6.191	34	L	163,86	6.451	28	L	170,46	6.711	22	L
157,38	6.196	32	L	164,01	6.457	26	L	170,61	6.717	20	L
157,53	6.202	30	L	164,13	6.462	24	L	170,76	6.723	18	L
157,66	6.207	28	L	164,29	6.468	22	L	170,92	6.729	16	L
157,81	6.213	26	L	164,44	6.474	20	L	171,07	6.735	14	L
157,94	6.218	24	L	164,59	6.480	18	L	171,22	6.741	12	L
158,09	6.224	22	L	164,74	6.486	16	L	171,37	6.747	10	L
158,24	6.230	20	L	164,90	6.492	14	L	171,55	6.754	8	L
158,39	6.236	18	L	165,05	6.498	12	L	171,70	6.760	6	L
158,55	6.242	16	L	165,20	6.504	10	L	171,86	6.766	4	L
158,70	6.248	14	L	165,35	6.510	8	L	172,01	6.772	2	L
158,85	6.254	12	L	165,53	6.517	6	L	172,19	6.779	0	–
159,00	6.260	10	L	165,68	6.523	4	L	172,34	6.785	2	R
159,18	6.267	8	L	165,84	6.529	2	L	172,49	6.791	4	R
159,33	6.273	6	L	165,99	6.535	0	–	172,64	6.797	6	R
159,49	6.279	4	L	166,17	6.542	2	R	172,82	6.804	8	R
159,64	6.285	2	L	166,32	6.548	4	R	172,97	6.810	10	R
159,82	6.292	0	–	166,47	6.554	6	R	173,13	6.816	12	R
159,97	6.298	2	R	166,62	6.560	8	R	173,28	6.822	14	R
160,12	6.304	4	R	166,80	6.567	10	R	173,43	6.828	16	R
160,27	6.310	6	R	166,95	6.573	12	R	173,58	6.834	18	R
160,45	6.317	8	R	167,11	6.579	14	R	173,74	6.840	20	R
160,60	6.323	10	R	167,26	6.585	16	R	173,89	6.846	22	R
160,76	6.329	12	R	167,41	6.591	18	R	174,04	6.852	24	R
160,91	6.335	14	R	167,56	6.597	20	R	174,17	6.857	26	R
161,06	6.341	16	R	167,72	6.603	22	R	174,32	6.863	28	R
161,21	6.347	18	R	167,87	6.609	24	R	174,45	6.868	30	R
161,37	6.353	20	R	168,00	6.614	26	R	174,60	6.874	32	R
161,52	6.359	22	R	168,15	6.620	28	R	174,73	6.879	34	R
161,67	6.365	24	R	168,28	6.625	30	R	174,85	6.884	36	R
161,82	6.371	26	R	168,43	6.631	32	R	174,98	6.889	38	R
161,95	6.376	28	R	168,55	6.636	34	R	175,11	6.894	40	R
162,10	6.382	30	R	168,68	6.641	36	R	175,23	6.899	42	R
162,23	6.387	32	R	168,81	6.646	38	R	175,34	6.903	44	R
162,36	6.392	34	R	168,94	6.651	40	R	175,46	6.908	46	R
162,51	6.398	36	R	169,06	6.656	42	R	175,56	6.912	48	R
162,64	6.403	38	R	169,16	6.660	44	R	175,67	6.916	50	R
162,74	6.407	40	R	169,29	6.665	46	R	175,77	6.920	52	R
162,86	6.412	42	R	169,39	6.669	48	R	175,87	6.924	54	R
162,99	6.417	44	R	169,49	6.673	50	R	175,95	6.927	56	R
162,99	6.417	46	R	169,49	6.673	52	R	176,00	6.929	58	R

(continued)

(Balancing Table • SVU-92 Boring Head — continued)

KRDE175026M

KRCSCFPR061F 175–182mm				KRCSCFPR062F 181,5–188,5mm				KRCSCFPR063F 188–195mm			
diameter		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting	
mm	in			mm	in			mm	in		
175,01	6.890	64	L	181,51	7.146	56	L	188,0108	7.402	48	L
175,06	6.892	62	L	181,56	7.148	54	L	188,1124	7.406	46	L
175,13	6.895	60	L	181,64	7.151	52	L	188,214	7.410	44	L
175,21	6.898	58	L	181,74	7.155	50	L	188,3156	7.414	42	L
175,29	6.901	56	L	181,84	7.159	48	L	188,4426	7.419	40	L
175,36	6.904	54	L	181,94	7.163	46	L	188,5442	7.423	38	L
175,46	6.908	52	L	182,04	7.167	44	L	188,6712	7.428	36	L
175,56	6.912	50	L	182,14	7.171	42	L	188,7982	7.433	34	L
175,64	6.915	48	L	182,27	7.176	40	L	188,8998	7.437	32	L
175,74	6.919	46	L	182,37	7.180	38	L	189,0268	7.442	30	L
175,87	6.924	44	L	182,50	7.185	36	L	189,1792	7.448	28	L
175,97	6.928	42	L	182,63	7.190	34	L	189,3062	7.453	26	L
176,07	6.932	40	L	182,75	7.195	32	L	189,4332	7.458	24	L
176,20	6.937	38	L	182,88	7.200	30	L	189,5602	7.463	22	L
176,30	6.941	36	L	183,01	7.205	28	L	189,7126	7.469	20	L
176,43	6.946	34	L	183,13	7.210	26	L	189,8396	7.474	18	L
176,56	6.951	32	L	183,26	7.215	24	L	189,992	7.480	16	L
176,68	6.956	30	L	183,41	7.221	22	L	190,1444	7.486	14	L
176,81	6.961	28	L	183,54	7.226	20	L	190,2714	7.491	12	L
176,96	6.967	26	L	183,69	7.232	18	L	190,4238	7.497	10	L
177,09	6.972	24	L	183,82	7.237	16	L	114,3762	4.503	8	L
177,22	6.977	22	L	183,97	7.243	14	L	190,7286	7.509	6	L
177,37	6.983	20	L	184,12	7.249	12	L	190,8556	7.514	4	L
177,50	6.988	18	L	184,25	7.254	10	L	191,008	7.520	2	L
177,65	6.994	16	L	184,40	7.260	8	L	191,1604	7.526	0	–
177,80	7.000	14	L	184,56	7.266	6	L	191,3128	7.532	2	R
177,93	7.005	12	L	184,71	7.272	4	L	191,4652	7.538	4	R
178,08	7.011	10	L	184,86	7.278	2	L	191,6176	7.544	6	R
178,23	7.017	8	L	184,99	7.283	0	–	191,7446	7.549	8	R
178,38	7.023	6	L	185,14	7.289	2	R	191,897	7.555	10	R
178,54	7.029	4	L	185,29	7.295	4	R	192,0494	7.561	12	R
178,66	7.034	2	L	185,45	7.301	6	R	192,2018	7.567	14	R
178,82	7.040	0	–	185,60	7.307	8	R	192,3288	7.572	16	R
178,97	7.046	2	R	185,75	7.313	10	R	192,4812	7.578	18	R
179,12	7.052	4	R	185,88	7.318	12	R	192,6082	7.583	20	R
179,27	7.058	6	R	186,03	7.324	14	R	192,7606	7.589	22	R
179,43	7.064	8	R	186,18	7.330	16	R	192,8876	7.594	24	R
179,55	7.069	10	R	186,31	7.335	18	R	193,04	7.600	26	R
179,71	7.075	12	R	186,46	7.341	20	R	193,167	7.605	28	R
179,86	7.081	14	R	186,59	7.346	22	R	193,294	7.610	30	R
180,01	7.087	16	R	186,74	7.352	24	R	193,421	7.615	32	R
180,14	7.092	18	R	186,87	7.357	26	R	193,548	7.620	34	R
180,29	7.098	20	R	186,99	7.362	28	R	193,675	7.625	36	R
180,42	7.103	22	R	187,12	7.367	30	R	193,7766	7.629	38	R
180,57	7.109	24	R	187,25	7.372	32	R	193,9036	7.634	40	R
180,70	7.114	26	R	187,38	7.377	34	R	194,0052	7.638	42	R
180,82	7.119	28	R	187,50	7.382	36	R	194,1068	7.642	44	R
180,95	7.124	30	R	187,63	7.387	38	R	194,2338	7.647	46	R
181,08	7.129	32	R	187,73	7.391	40	R	194,3354	7.651	48	R
181,20	7.134	34	R	187,86	7.396	42	R	194,4116	7.654	50	R
181,33	7.139	36	R	187,96	7.400	44	R	194,5132	7.658	52	R
181,46	7.144	38	R	188,06	7.404	46	R	194,6148	7.662	54	R
181,56	7.148	40	R	188,16	7.408	48	R	194,691	7.665	56	R
181,69	7.153	42	R	188,26	7.412	50	R	194,7672	7.668	58	R
181,79	7.157	44	R	188,37	7.416	52	R	194,8434	7.671	60	R
181,89	7.161	46	R	188,44	7.419	54	R	194,9196	7.674	62	R
181,99	7.165	48	R	188,49	7.421	56	R	194,9958	7.677	64	R
181,99	7.165	50	R	–	–	–	–	194,9958	7.677	66	R

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(Balancing Table • SVU-92 Boring Head — continued)

KRDE193026M

KRCSCFPR061F 193–200mm				KRCSCFPR062F 199,5–206,5mm				KRCSCFPR063F 206–213mm			
diameter		balancing ring setting		diameter		balancing ring setting		diameter		balancing ring setting	
mm	in			mm	in			mm	in		
192,99	7.598	64	L	199,49	7.854	54	L	205,994	8.11	46	L
193,07	7.601	62	L	199,62	7.859	52	L	206,1464	8.116	44	L
193,14	7.604	60	L	199,72	7.863	50	L	206,248	8.12	42	L
193,22	7.607	58	L	199,80	7.866	48	L	206,375	8.125	40	L
193,29	7.610	56	L	199,90	7.870	46	L	206,4766	8.129	38	L
193,37	7.613	54	L	200,03	7.875	44	L	206,6036	8.134	36	L
193,47	7.617	52	L	200,13	7.879	42	L	206,7306	8.139	34	L
193,57	7.621	50	L	200,23	7.883	40	L	206,8576	8.144	32	L
193,65	7.624	48	L	200,36	7.888	38	L	206,9846	8.149	30	L
193,75	7.628	46	L	200,48	7.893	36	L	207,1116	8.154	28	L
193,88	7.633	44	L	200,61	7.898	34	L	207,2386	8.159	26	L
193,98	7.637	42	L	200,71	7.902	32	L	207,391	8.165	24	L
194,08	7.641	40	L	200,86	7.908	30	L	207,518	8.17	22	L
194,21	7.646	38	L	200,99	7.913	28	L	207,6704	8.176	20	L
194,34	7.651	36	L	201,12	7.918	26	L	207,7974	8.181	18	L
194,46	7.656	34	L	201,24	7.923	24	L	207,9498	8.187	16	L
194,59	7.661	32	L	201,40	7.929	22	L	208,1022	8.193	14	L
194,72	7.666	30	L	201,52	7.934	20	L	208,2292	8.198	12	L
194,84	7.671	28	L	201,68	7.940	18	L	208,3816	8.204	10	L
194,97	7.676	26	L	201,80	7.945	16	L	208,534	8.21	8	L
195,10	7.681	24	L	201,96	7.951	14	L	208,6864	8.216	6	L
195,25	7.687	22	L	202,11	7.957	12	L	208,8388	8.222	4	L
195,38	7.692	20	L	202,26	7.963	10	L	208,9912	8.228	2	L
195,53	7.698	18	L	202,41	7.969	8	L	209,1182	8.233	0	–
195,68	7.704	16	L	202,54	7.974	6	L	209,2706	8.239	2	R
195,81	7.709	14	L	202,69	7.980	4	L	209,423	8.245	4	R
195,96	7.715	12	L	202,84	7.986	2	L	209,5754	8.251	6	R
196,11	7.721	10	L	203,00	7.992	0	–	209,7278	8.257	8	R
196,27	7.727	8	L	203,15	7.998	2	R	209,8802	8.263	10	R
196,42	7.733	6	L	203,30	8.004	4	R	210,0326	8.269	12	R
196,57	7.739	4	L	203,45	8.010	6	R	210,1596	8.274	14	R
196,70	7.744	2	L	203,61	8.016	8	R	210,312	8.28	16	R
196,85	7.750	0	–	203,76	8.022	10	R	210,4644	8.286	18	R
197,00	7.756	2	R	203,89	8.027	12	R	210,5914	8.291	20	R
197,15	7.762	4	R	204,04	8.033	14	R	210,7438	8.297	22	R
197,31	7.768	6	R	204,19	8.039	16	R	210,8708	8.302	24	R
197,46	7.774	8	R	204,32	8.044	18	R	210,9978	8.307	26	R
197,61	7.780	10	R	204,47	8.050	20	R	211,1502	8.313	28	R
197,76	7.786	12	R	204,60	8.055	22	R	211,2772	8.318	30	R
197,89	7.791	14	R	204,75	8.061	24	R	211,4042	8.323	32	R
198,04	7.797	16	R	204,88	8.066	26	R	211,5312	8.328	34	R
198,20	7.803	18	R	205,03	8.072	28	R	211,6582	8.333	36	R
198,32	7.808	20	R	205,16	8.077	30	R	211,7598	8.337	38	R
198,48	7.814	22	R	205,28	8.082	32	R	84,8868	3.342	40	R
198,60	7.819	24	R	205,41	8.087	34	R	211,9884	8.346	42	R
198,76	7.825	26	R	205,54	8.092	36	R	212,1154	8.351	44	R
198,88	7.830	28	R	205,64	8.096	38	R	212,217	8.355	46	R
199,01	7.835	30	R	205,77	8.101	40	R	212,3186	8.359	48	R
199,14	7.840	32	R	205,87	8.105	42	R	212,4202	8.363	50	R
199,26	7.845	34	R	205,99	8.110	44	R	212,4964	8.366	52	R
199,39	7.850	36	R	206,10	8.114	46	R	212,598	8.37	54	R
199,52	7.855	38	R	206,20	8.118	48	R	212,6742	8.373	56	R
199,62	7.859	40	R	206,30	8.122	50	R	212,7758	8.377	58	R
199,75	7.864	42	R	206,38	8.125	52	R	212,852	8.38	60	R
199,85	7.868	44	R	206,48	8.129	54	R	212,9028	8.382	62	R
199,95	7.872	46	R	206,50	8.130	56	R	212,979	8.385	64	R
200,00	7.874	48	R	–	–	–	–	213,0044	8.386	66	R

Ready for **Takeoff**

Machining carbon-fiber 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 minimizing 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-fiber 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 Authorized Kennametal Distributor or at **kennametal.com**.

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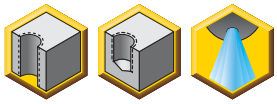
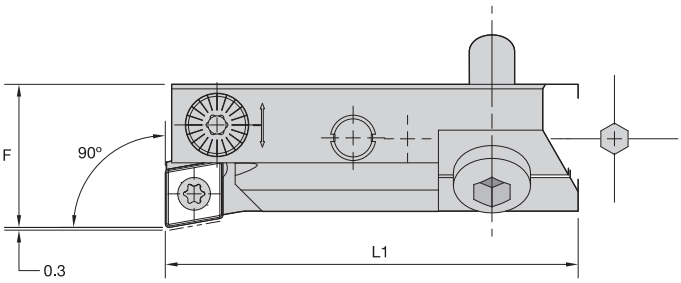
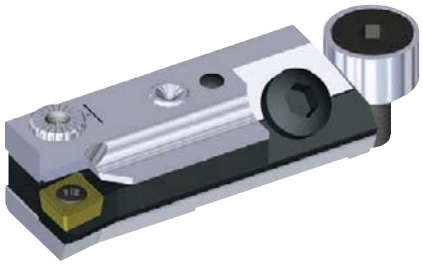


- All cartridges have internal coolant supply directed to the cutting edge.
- .0004" (0,01mm) diameter adjustment respective 0.00008" (2 µm) with vernier scale within a range of .0118" (0,3mm).
- Radial adjustment without influence on axial position.
- Axial adjustment range of .039" (1mm).
- Smallest diameters can be machined starting from 1.102" (28,0mm).

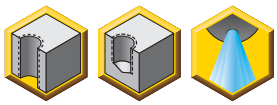




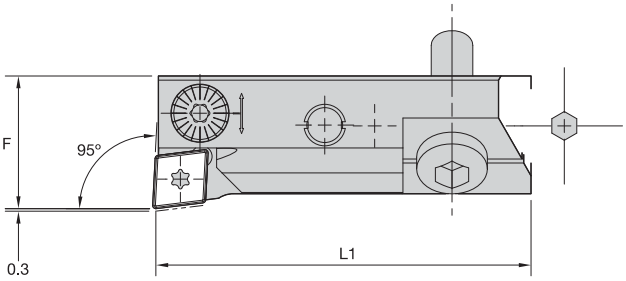
90° Lead • Micro-Adjustable Cartridge • C-Style

order number	catalog number	F mm	F in	L1 mm	L1 in	gage insert	insert screw	set screw
right hand 3784474	FBSCFCR09CA06F	16,15	.636	45,50	1.791	CCMT060204	12148068700	12147629800
left hand 3784475	FBSCFCL09CA06F	16,15	.636	45,50	1.791	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.
- .0004" (0,01mm) diameter adjustment respective 0.00008" (2 µm) with vernier scale within a range of .0118" (0,3mm).
- Radial adjustment without influence on axial position.
- Axial adjustment range of .039" (1mm).
- Smallest diameters can be machined starting from 1.102" (28,0mm).



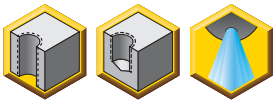


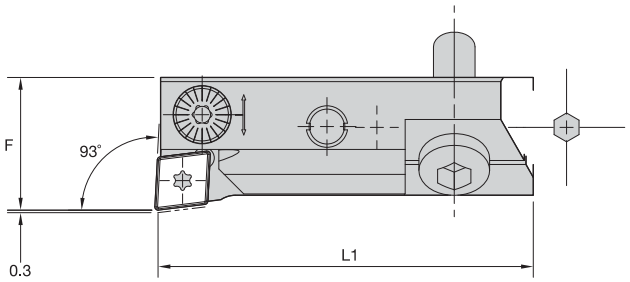
95° Lead • Micro-Adjustable Cartridge • C-Style

order number	catalog number	F mm	F in	L1 mm	L1 in	gage insert	insert screw	set screw
right hand 3784476	FBSCLCR09CA06F	16,15	.636	45,50	1.791	CCMT060204	12148068700	12147629800
left hand 3784477	FBSCLCL09CA06F	16,15	.636	45,50	1.791	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.
- .0004" (0,01mm) diameter adjustment respective 0.00008" (2 µm) with vernier scale within a range of .0118" (0,3mm).
- Radial adjustment without influence on axial position.
- Axial adjustment range of .039" (1mm).
- Smallest diameters can be machined starting from 1.102" (28,0mm).





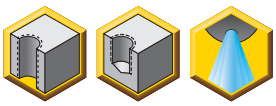


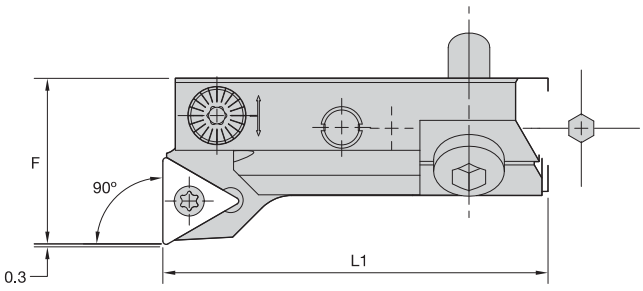
93° Lead • Micro-Adjustable Cartridge • C-Style

order number	catalog number	F mm	F in	L1 mm	L1 in	gage insert	insert screw	set screw
right hand								
2907289	**FBSCUCR09CA06F**	16,15	.636	45,50	1.791	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.
- .0004" (0,01mm) diameter adjustment respective 0.00008" (2 µm) with vernier scale within a range of .0118" (0,3mm).
- Radial adjustment without influence on axial position.
- Axial adjustment range of .039" (1mm).
- Smallest diameters can be machined starting from 1.102" (28,0mm).







90° Lead • Micro-Adjustable Cartridge • T-Style

order number	catalog number	F mm	F in	L1 mm	L1 in	gage insert	insert screw	set screw
right hand								
2907291	**FBSTFCR09CA11F**	20,15	.793	45,50	1.791	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 adapters.
- HSK shanks for use without adapters.
- Inch shanks are most economical to use with compatible adapters.



Customization

- 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 adapters. 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.
- Aluminum diameter extender with insert cartridges and counterweight used for diameters starting at 3.38" (86mm) 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



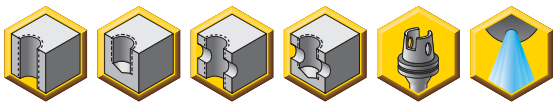
- Diameters 23,5–153mm (.925–6.024").
- KM, HSK, and inch straight shank back end styles available.
- Precision-ground micrometric screw enables fine adjustment of 2 µm (.00008") via easy-to-read vernier scale.
- Large selection of insert holders:
  — 95° — for use with wiper turning inserts.
  — 90° 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.

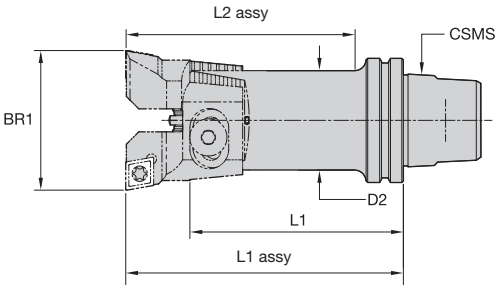
BT • Bridge Tools for Rough and Finish Boring



- 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 adapters 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 aluminum-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 page K124–K126.





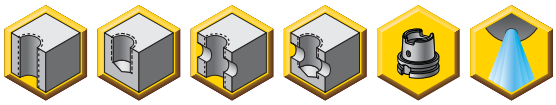


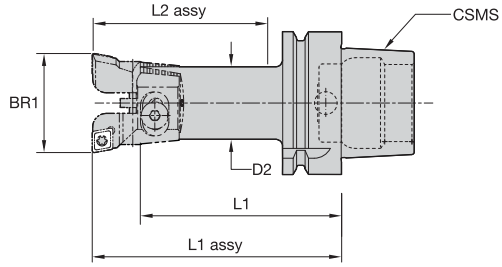
KM QUICK CHANGE

RBHT • KM™ Rough-Boring Twin Cutters

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D2 mm	D2 in	L1 mm	L1 in	L1 assy mm	L1 assy in	L2 assy mm	L2 assy in	blade screw	washer	pin
3586519	KM32RBHT24	23.500-30.500	0.9252-1.2008	KM32	20,0	.79	75,4	2.97	90,0	3.54	76,0	2.99	840.142.200	841.142.200	841.342.200
3586520	KM32RBHT30	29.500-40.000	1.1614-1.5748	KM32	25,0	.98	83,8	3.30	100,0	3.94	86,0	3.39	840.142.250	841.142.250	841.342.200
3586521	KM40RBHT40	39.500-50.500	1.5551-1.9882	KM40	32,0	1.26	68,8	2.71	90,0	3.54	74,0	2.91	840.142.320	841.142.320	841.342.200
3586522	KM50RBHT50	49.500-66.500	1.9488-2.6181	KM50	42,0	1.65	62,2	2.45	90,0	3.54	70,0	2.76	840.142.420	841.142.200	841.342.420
3586543	KM50RBHT66	65.500-87.500	2.5787-3.4449	KM50	55,0	2.17	63,0	2.48	100,0	3.94	100,0	3.94	840.142.550	841.142.550	841.342.420
3586544	KM50RBHT87	86.500-115.500	3.4055-4.5472	KM50	72,0	2.83	70,5	2.78	120,0	4.72	120,0	4.72	840.142.720	841.142.720	841.342.420
3586545	KM63UTRBHT87	86.500-115.500	3.4055-4.5472	KM63UT	72,0	2.83	70,5	2.78	120,0	4.72	120,0	4.72	840.142.720	841.142.720	841.342.420
3586546	KM63UTRBHT115	114.500-153.000	4.5079-6.0236	KM63UT	94,0	3.70	83,2	3.28	150,0	5.91	150,0	5.91	840.142.940	841.142.940	841.342.420

- Order blade sets separately; see page K124–K126.



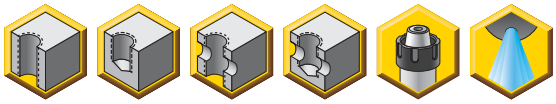


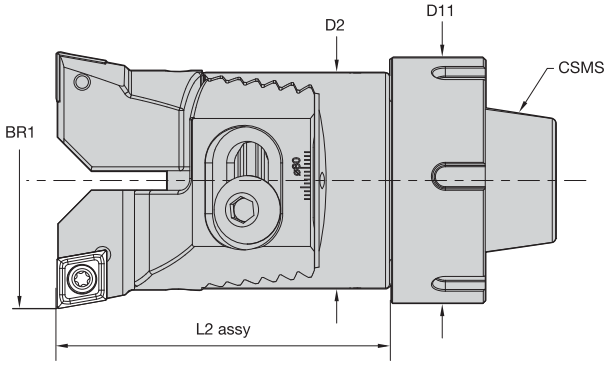


RBHT • HSK Rough-Boring Twin Cutters

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D2 mm	D2 in	L1 mm	L1 in	L1 assy mm	L1 assy in	L2 assy mm	L2 assy in	blade screw	washer	pin
3586547	HSK63RBHT24	23.500-30.500	0.9252-1.2008	HSK63A	20,0	.79	75,4	2.97	90,0	3.54	64,1	2.52	840.142.200	841.142.200	841.342.200
3586548	HSK63RBHT30	29.500-40.000	1.1614-1.5748	HSK63A	25,0	.98	88,8	3.50	105,0	4.13	79,1	3.11	840.142.250	841.142.250	841.342.200
3586549	HSK63RBHT40	39.500-50.500	1.5551-1.9882	HSK63A	32,0	1.26	92,2	3.63	110,0	4.33	84,1	3.31	840.142.320	841.142.320	841.342.200
3586550	HSK63RBHT50	49.500-66.500	1.9488-2.6181	HSK63A	42,0	1.65	92,2	3.63	120,0	4.72	94,1	3.70	840.142.420	841.142.420	841.342.200
3586551	HSK63RBHT66	65.500-87.500	2.5787-3.4449	HSK63A	55,0	2.17	95,5	3.76	125,0	4.92	125,0	4.92	840.142.550	841.142.720	841.342.420
3586563	HSK63RBHT87	86.500-115.500	3.4055-4.5472	HSK63A	72,0	2.83	95,5	3.76	145,0	5.71	145,0	5.71	840.142.720	841.142.720	841.342.420

• Order blade sets separately; see page K124–K126.



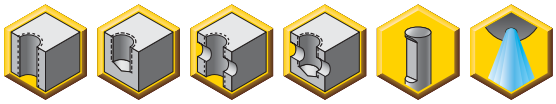


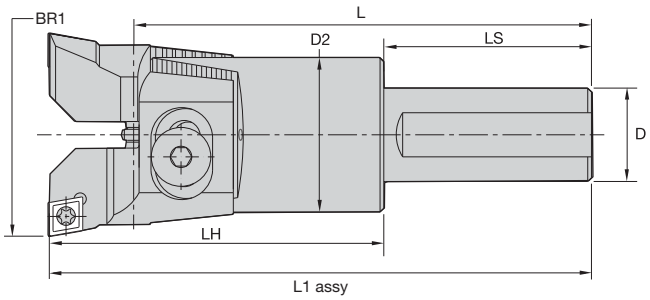


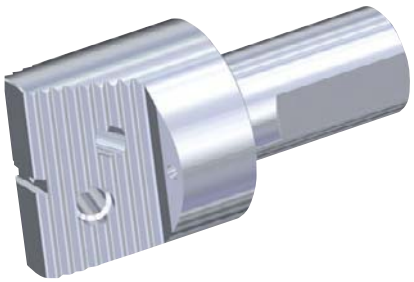
RBHT • ER Rough-Boring Twin Cutters

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D11 mm	D11 in	D2 mm	D2 in	L2 assy mm	L2 assy in	blade screw	washer	pin
5544148	ER25RBHT40	39,500-50,500	1.5550-1.9880	ER25	39,0	1.5	32,0	1.26	65,5	2.58	840.142.320	841.142.320	841.342.200
5544190	ER32RBHT50	49,500-66,500	1.9480-2.6180	ER32	49,5	1.9	42,0	1.65	75,5	2.97	840.142.420	841.142.200	841.342.420
5544192	ER40RBHT66	65,500-87,500	2.5780-3.4440	ER40	62,7	2.5	55,0	2.17	85,5	3.37	840.142.550	841.142.550	841.342.420

• Order blade sets separately; see page K124–K126.



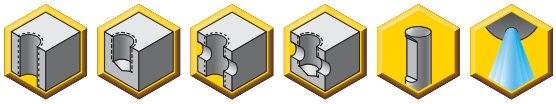


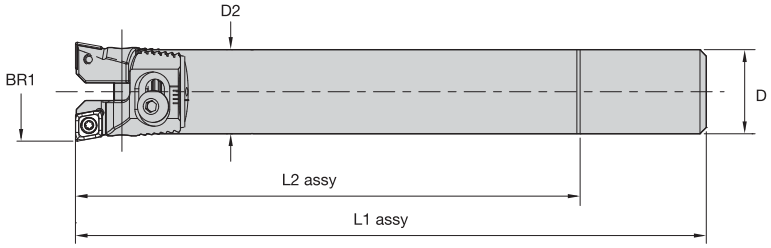


RBHT • Steel Straight Shank Rough Boring Twin Cutters

order number	catalog number	BR1 bore range mm	BR1 bore range in	D mm	D in	D2 mm	D2 in	L mm	L in	LH mm	LH in	L1 assy mm	L1 assy in	LS mm	LS in	blade screw	washer	pin
3586564	SF075RBHT24	23,500-30,500	0.9252-1.2008	19,1	.75	20,0	.79	135,4	5.33	27,8	1.09	150,0	5.91	107,6	4.24	840.142.200	841.142.200	841.342.200
3586565	SF100RBHT30	29,500-40,000	1.1614-1.5748	25,4	1.00	25,0	.98	153,8	6.06	30,6	1.20	170,0	6.69	123,2	1.85	840.142.250	841.142.250	841.342.200
3586566	SF125RBHT40	39,500-50,500	1.5551-1.9882	31,8	1.25	32,0	1.26	168,8	6.65	31,3	1.23	190,0	7.48	137,5	5.41	840.142.320	841.142.320	841.342.200
3586567	SF100RBHT50	49,500-66,500	1.9488-2.6181	25,4	1.00	42,0	1.65	118,1	4.65	62,2	2.45	145,9	5.74	55,9	2.20	840.142.420	841.142.420	841.342.420
3586569	SF125RBHT66	65,500-87,500	2.5787-3.4449	31,8	1.25	55,0	2.17	123,7	4.87	63,0	2.48	160,7	6.33	60,7	2.39	840.142.550	841.142.720	841.342.420
3586570	SF150RBHT87	86,500-115,500	3.4055-4.5472	38,1	1.50	72,0	2.83	142,1	5.59	70,5	2.78	191,6	7.54	71,6	2.82	840.142.720	841.142.720	841.342.420
3586571	SF200RBHT115	114,500-153,000	4.5079-6.0236	50,8	2.00	94,0	3.70	169,1	6.66	82,6	3.25	235,9	9.29	86,5	3.41	840.142.940	841.142.940	841.342.420

- Order blade sets separately; see page K124–K126.

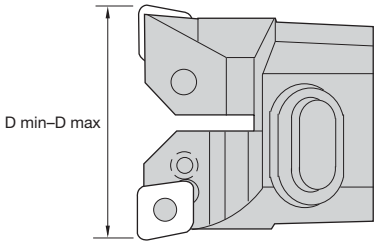


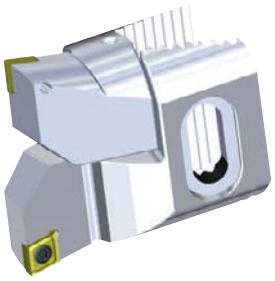




RBHT • Straight Shank Rough-Boring Twin Cutters • Metric

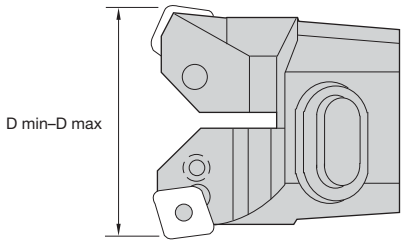
order number	catalog number	BR1 bore range mm	BR1 bore range in	D mm	D in	D2 mm	D2 in	L1 assy mm	L1 assy in	L2 assy mm	L2 assy in	blade screw	washer	pin
5544143	SS20RBHT24	23,500-30,500	0.9250-1.2000	20,0	.79	20,0	.79	150,0	5.10	120,0	4.72	840.142.200	841.142.200	841.342.200
5544145	SS25RBHT30	29,500-40,000	1.1610-1.5740	25,0	.98	25,0	.98	170,0	6.69	140,0	5.51	840.142.250	841.142.250	841.342.200

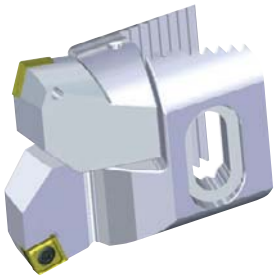




90° Lead Blade Sets

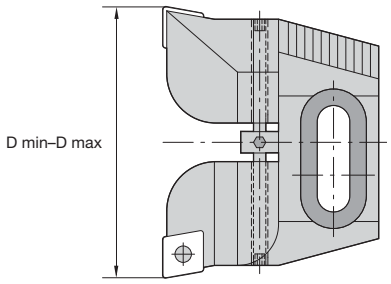
order number	catalog number	D min mm	D min in	D max mm	D max in	gage insert	adjusting screw	insert screw	shim	shim pin	toggle lever	Torx wrench	Torx size
3556346	MB24RBHT06F	23,50	.925	30,50	1.201	CC..0602../CC..215..	848.200.407	843.006.000	–	–	–	FT7	T7
3556347	MB30RBHT06F	29,50	1.161	40,10	1.579	CC..0602../CC..215..	848.250.409	843.006.000	–	–	–	FT7	T7
3556348	MB40RBHT09F	39,50	1.555	50,50	1.988	CC..09T3../CC..325..	848.320.413	843.009.000	–	–	–	FT15	T15
3556349	MB50RBHT09F	49,50	1.949	66,50	2.618	CC..09T3../CC..325..	848.420.614	843.009.000	–	–	–	FT15	T15
3556350	MB66RBHT12F	65,50	2.579	87,50	3.445	CC..1204../CC..43..	848.550.620	843.012.000	–	–	–	FT20	T20
3556352	MB66RBHT12LF	65,50	2.579	87,50	3.445	CN..1204../CN..43..	847.012.000	–	845.012.000	844.012.000	846.012.000	–	–
3556393	MB87RBHT12F	86,50	3.406	115,50	4.547	CC..1204../CC..43..	848.720.000	843.012.000	–	–	–	FT20	T20
3556394	MB87RBHT16LF	86,50	3.406	115,50	4.547	CN..1606../CN..54..	847.016.000	–	845.016.000	844.016.000	846.016.000	–	–
3556395	MB115RBHT12F	114,50	4.508	153,00	6.024	CC..1204../CC..43..	848.940.640	843.012.000	–	–	–	FT20	T20
3556396	MB115RBHT16LF	114,50	4.508	153,00	6.024	CN..1606../CN..54..	847.016.000	–	845.016.000	844.016.000	846.016.000	–	–

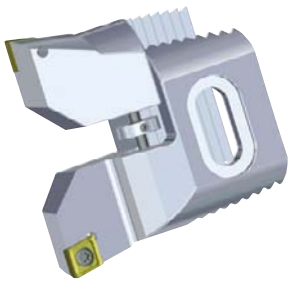




70° Lead Blade Sets

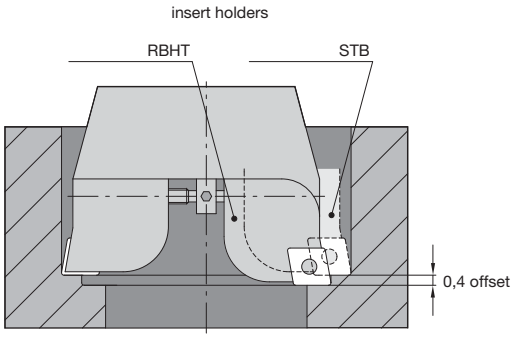
order number	catalog number	D min mm	D min in	D max mm	D max in	gage insert	adjusting screw	insert screw	shim	shim pin	toggle lever	Torx wrench	Torx size	hex size
3556397	MB24RBHT06K	23,50	.925	30,50	1.201	CC..0602../CC..215..	848.200.407	843.006.000	–	–	–	FT7	T7	–
3556398	MB30RBHT06K	29,50	1.161	40,10	1.579	CC..0602../CC..215..	848.250.409	843.006.000	–	–	–	FT7	T7	–
3556399	MB40RBHT09K	39,50	1.555	50,50	1.988	CC..09T3../CC..325..	848.320.413	843.009.000	–	–	–	FT15	T15	–
3556400	MB50RBHT09K	49,50	1.949	66,50	2.618	CC..09T3../CC..325..	848.420.614	843.009.000	–	–	–	FT15	T15	–
3556401	MB66RBHT12K	65,50	2.579	87,50	3.445	CC..1204../CC..43..	848.550.620	843.012.000	–	–	–	FT20	T20	–
3556402	MB66RBHT12LK	65,50	2.579	87,50	3.445	CN..1204../CN..43..	847.012.000	–	845.012.000	844.012.000	846.012.000	–	–	3 mm
3556403	MB87RBHT12K	86,50	3.406	115,50	4.547	CC..1204../CC..43..	848.720.000	843.012.000	–	–	–	FT20	T20	–
3556404	MB87RBHT16LK	86,50	3.406	115,50	4.547	CN..1606../CN..54..	847.016.000	–	845.016.000	844.016.000	846.016.000	–	–	3 mm
3556405	MB115RBHT16LK	114,50	4.508	153,00	6.024	CN..1606../CN..54..	847.016.000	–	845.016.000	844.016.000	846.016.000	–	–	3 mm

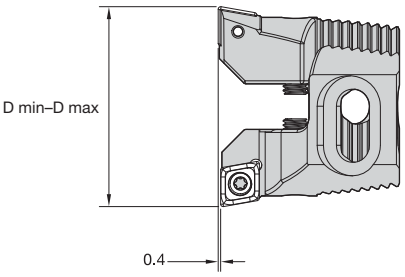




90° Lead Simultaneous Adjusting Blade Sets

order number	catalog number	D min mm	D min in	D max mm	D max in	gage insert	adjusting screw	insert screw	simultaneous adj spindle	shim	shim pin	toggle lever
2652965	SYB24RBHT06F	23,50	.925	30,50	1.201	CC..0602../CC..215..	848.200.407	843.006.000	848.200.005	–	–	–
2652967	SYB30RBHT06F	29,50	1.161	40,10	1.579	CC..0602../CC..215..	848.250.409	843.006.000	848.250.005	–	–	–
2652968	SYB40RBHT09F	39,50	1.555	50,50	1.988	CC..09T3../	848.320.413	843.009.000	848.320.005	–	–	–
2652969	SYB50RBHT09F	49,50	1.949	66,50	2.618	CC..09T3../	848.420.614	843.009.000	848.420.005	–	–	–
2652970	SYB66RBHT12F	65,50	2.579	87,50	3.445	CC..1204../CC..43..	–	843.012.000	848.550.005	–	–	–
2652971	SYB66RBHT12LF	65,50	2.579	87,50	3.445	CN..1204../CN..43..	–	848.550.620	848.550.005	845.012.000	844.012.000	846.012.000
2652972	SYB87RBHT12F	86,50	3.406	115,50	4.547	CC..1204../CC..43..	–	843.012.000	848.720.005	–	–	–
2652983	SYB87RBHT16LF	86,50	3.406	115,50	4.547	CNMG543	847.016.000	–	848.720.005	845.016.000	844.016.000	846.016.000
2652984	SYB115RBHT16LF	114,50	4.508	153,00	6.024	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	catalog number	D min mm	D min in	D max mm	D max in	gage insert	adjusting screw	insert screw	shim	shim pin	toggle lever
4063996	SDB24RBHT06F	23,50	.925	30,50	1.201	CC..0602../CC..215..	848.200.407	843.006.000	–	–	–
4063997	SDB30RBHT06F	29,50	1.161	40,10	1.579	CC..0602../CC..215..	848.250.409	843.006.000	–	–	–
4063998	SDB40RBHT09F	39,50	1.555	50,50	1.988	CC..09T3../CC..325..	848.320.413	843.009.000	–	–	–
4063999	SDB50RBHT09F	49,50	1.949	66,50	2.618	CC..09T3../CC..325..	848.420.614	843.009.000	–	–	–
4064000	SDB66RBHT12F	65,50	2.579	87,50	3.445	CC..1204../CC..43..	848.550.620	843.012.000	–	–	–
4064001	SDB66RBHT12LF	65,50	2.579	87,50	3.445	CN..1204../CN..43..	847.012.000	–	845.012.000	844.012.000	846.012.000
4064002	SDB87RBHT12F	86,50	3.406	115,50	4.547	CC..1204../CC..43..	848.720.000	843.012.000	–	–	–
4064203	SDB87RBHT16LF	86,50	3.406	115,50	4.547	CN..1606../CN..54..	847.016.000	–	845.016.000	844.016.000	846.016.000
4064204	SDB115RBHT16LF	114,50	4.508	153,00	6.024	CN..1606../CN..54..	847.016.000	–	845.016.000	844.016.000	846.016.000
4064205	SDB115RBHT12F	114,50	4.508	153,00	6.024	CC..1204../CC..43..	848.940.640	843.012.000	–	–	–

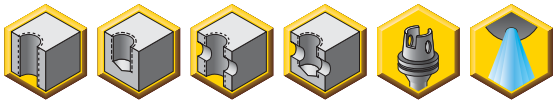
FBHM • Fine-Boring Kits

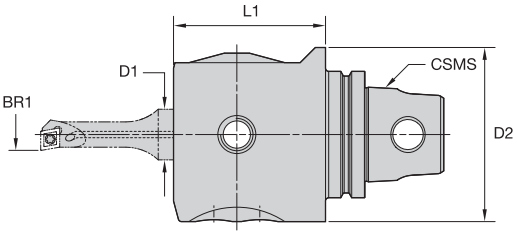
order number	catalog number	range mm	range in	contents	
4057101	KM50TSFBHMKIT164M	9,75-164,0	.383-6.456	KM50TSFBHM1677 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4057098	HSK63FBHMKIT164M	9,75-164,0	.383-6.456	HSK63FBHM1696 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4057099	DV40FBHMKIT164M	9,75-164,0	.383-6.456	DV40FBHM1691 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4057100	BT40FBHMKIT164M	9,75-164,0	.383-6.456	BT40FBHM1691 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4167882	CV40FBHMKIT645	9,75-164,0	.383-6.456	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 page K134–K135.
- .0004" (0,01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.





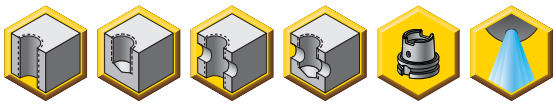


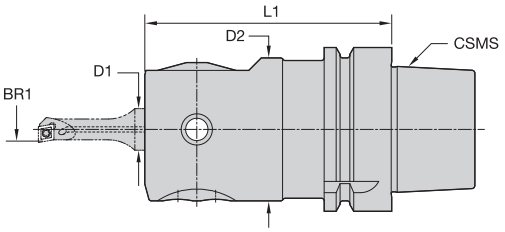
KM QUICK CHANGE

FBHO • KM™ Offset Boring Head

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D1 mm	D1 in	D2 mm	D2 in	L1 mm	L1 in	ModBORE FBHO parts package
1131111	**KM40FBHO1660**	9.750-53.100	0.3840-2.0910	KM40	16	.63	55,0	2.17	60,0	2.36	**PKG7001**
1132036	**KM50FBHO1670**	9.750-53.100	0.3840-2.0910	KM50	16	.63	55,0	2.17	70,0	2.76	**PKG7001**

- Order boring bars separately for required diameter; see page K134–K135.
- .0004" (0,01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.



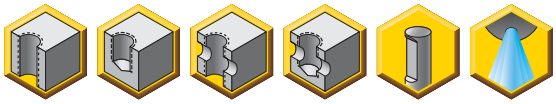


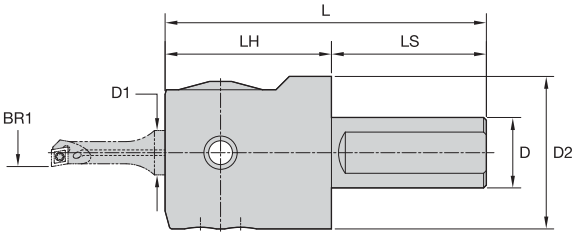


FBHO • HSK Boring Head

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D1 mm	D1 in	D2 mm	D2 in	L1 mm	L1 in	ModBORE FBHO parts package
2651037	**HSK63FBHO1695**	9.750-53.100	0.3840-2.0910	HSK63A	16	.63	55,0	2.17	95,0	3.74	**PKG7001**

- Order boring bars separately for required diameter; see page K134–K135.

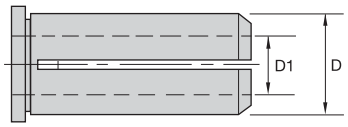






FBHO • Straight Shank Boring Head

		BR1 bore range		D		D1		D2		L		LH		LS	
order number	catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in
3077141	SF100FBHO1660	3.000-88.100	0.1810-3.4685	25	1.000	16	.63	55,0	2.17	115,9	4.56	60,0	2.36	55,9	2.20
3077140	SF150FBHO1660	3.000-88.100	0.1811-3.4685	38	1.500	16	.63	55,0	2.17	131,6	5.18	60,0	2.36	71,6	2.82

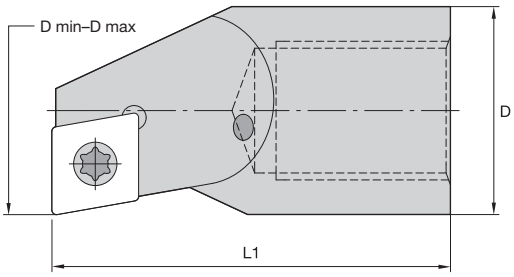




RS Series Sleeves • Metric I.D.

order number	catalog 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.

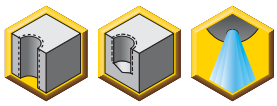


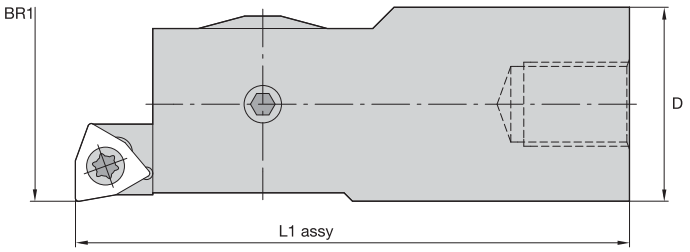


Fixed Pocket Boring Head

		D min		D max		D		L1				
order number	catalog number	mm	in	mm	in	mm	in	mm	in	gage insert	insert screw	Torx size
2651168	**HFB1023SCFPR06**	10,75	.423	16,10	.634	10	.39	23	0.91	CC..0602../CC..215..	**PKG0011**	**T7**
2651169	**HFB1223SCFPR06**	12,75	.502	18,10	.713	12	.47	23	0.91	CC..0602../CC..215..	**PKG0011**	**T7**
2651170	**HFB1627SCFPR06**	16,75	.659	22,10	.870	16	.63	27	1.06	CC..0602../CC..215..	**PKG0011**	**T7**
2651171	**HFB2127SCFPR06**	21,75	.856	27,10	1.067	16	.63	27	1.06	CC..0602../CC..215..	**PKG0011**	**T7**
2651172	**HFB2427SCFPR06**	24,75	.974	30,10	1.185	16	.63	27	1.06	CC..0602../CC..215..	**PKG0011**	**T7**
2651173	**HFB2727SCFPR06**	27,75	1.093	33,10	1.303	16	.63	27	1.06	CC..0602../CC..215..	**PKG0011**	**T7**
2651174	**HFB3127SCFPR06**	31,75	1.250	37,10	1.461	16	.63	27	1.06	CC..0602../CC..215..	**PKG0011**	**T7**
2651175	**HFB3427SCFPR06**	34,75	1.368	40,10	1.579	16	.63	27	1.06	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

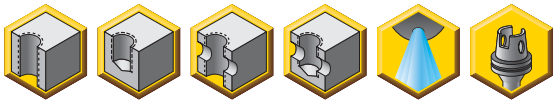
		BR1 bore range		L1 assy		D		
order number	catalog number	mm	in	mm	in	mm	in	cartridge mounting screw
2651176	**HFB14FBHS1440**	14.700-17.100	0.5787-0.6732	40,0	1.57	14	0.55	**PKG1402**
2651177	**HFB16FBHS1640**	16.700-20.100	0.6575-0.7913	40,0	1.57	16	0.63	**PKG1602**
2651178	**HFB19FBHS1840**	19.700-24.100	0.7756-0.9488	40,0	1.57	18	0.71	**PKG1802**

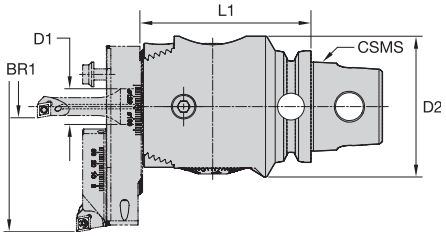
FBHM Fine-Boring Kits

order number	catalog number	range mm	range in	contents	
4057101	KM50TSFBHMKIT164M	9,75-164,0	.383-6.456	KM50TSFBHM1677 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4057098	HSK63FBHMKIT164M	9,75-164,0	.383-6.456	HSK63FBHM1696 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4057099	DV40FBHMKIT164M	9,75-164,0	.383-6.456	DV40FBHM1691 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4057100	BT40FBHMKIT164M	9,75-164,0	.383-6.456	BT40FBHM1691 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09
4167882	CV40FBHMKIT645	9,75-164,0	.383-6.456	CV40FBHM1691 AFB09075SCFCR06 AFB13085SCFCR06 AFB17100SCFCR06 AFB21110SCFCR09 AFB24115SCFCR09	AFM29115 AFM47115 EBM8015086 AFM29SCFPR06 AFM47SCFPR09



- Order boring bars, diameter extension bridge, and cartridges separately.
- .0004" (0,01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.



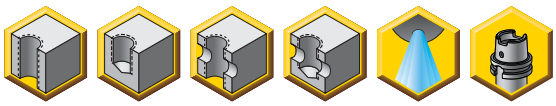


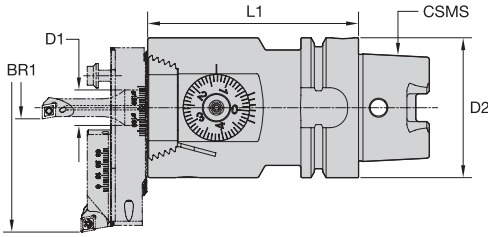


FBHM • KM™ Boring Head

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D1 mm	D1 in	D2 mm	D2 in	L1 mm	L1 in	ModBORE FBHS parts package	kg	lbs
4057060	**KM50TSFBHM1677**	9,750-164,000	.3838-6.4566	KM50TS	16,0	.63	63,0	2.48	76,6	3.02	**PKG-8001**	1,5	3.31

- Order boring bars, diameter extension bridge, and cartridges separately.
- .0004" (0,01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.



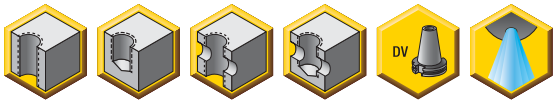


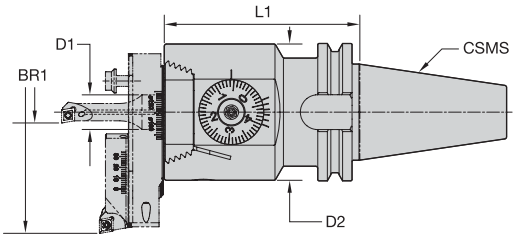


FBHM • HSK Boring Head

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D1 mm	D1 in	D2 mm	D2 in	L1 mm	L1 in	ModBORE FBHS parts package	kg	lbs
4057057	**HSK63FBHM1696**	9,750-164,000	.3838-6.4566	HSK63A	16,0	.63	63,0	2.48	95,0	3.74	**PKG-8001**	2,0	4.30

- Order boring bars, diameter extension bridge, and cartridges separately.
- .0004" (0,01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.



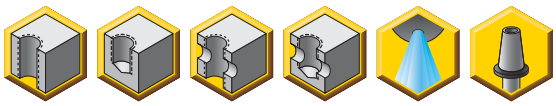


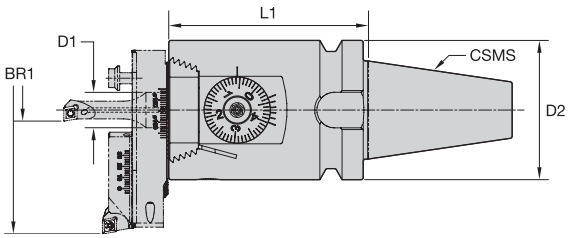


FBHM • DV40 Boring Head

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D1 mm	D1 in	D2 mm	D2 in	L1 mm	L1 in	ModBORE FBHS parts package	kg	lbs
4057058	**DV40FBHM1691**	9,750-154,000	.3838-6.0630	DV40	16,0	63.00	63,0	2.48	90,0	3.54	**PKG-8001**	2,1	4.64

- Order boring bars, diameter extension bridge, and cartridges separately.
- .0004" (0,01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.



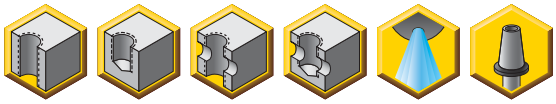


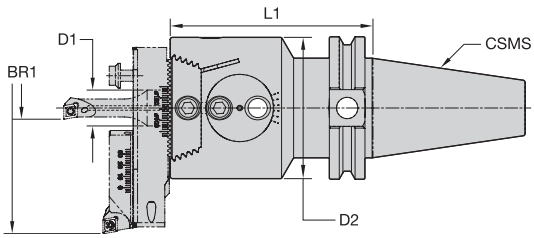


FBHM • BT40 Boring Head

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D1 mm	D1 in	D2 mm	D2 in	L1 mm	L1 in	ModBORE FBHS parts package	kg	lbs
4057059	**BT40FBHM1691**	9,750-164,000	.3838-6.4566	BT40	16,0	.63	63,0	2.48	90,0	3.54	**PKG-8001**	2,2	4.94

- Order boring bars, diameter extension bridge, and cartridges separately.
- .0004" (0,01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.



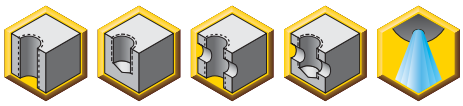


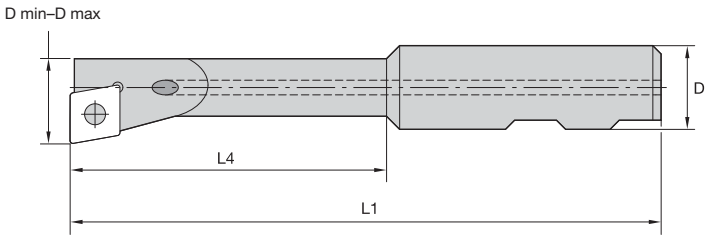


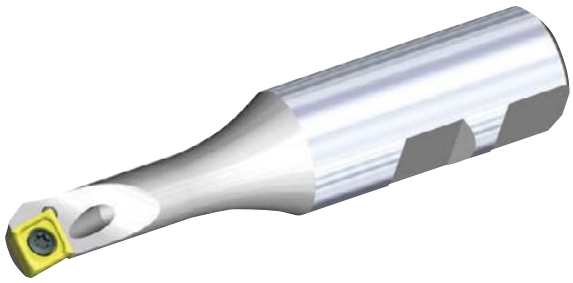
FBHM • CV40 Boring Head

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D1 mm	D1 in	D2 mm	D2 in	L1 mm	L1 in	ModBORE FBHS parts package	kg	lbs
4167881	**CV40FBHM1691**	9,750-164,000	.3838-6.4566	CV40	16,0	.63	63,0	2.48	91,2	3.59	**PKG-8001**	2,1	4.52

- Order inserts separately.



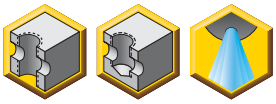


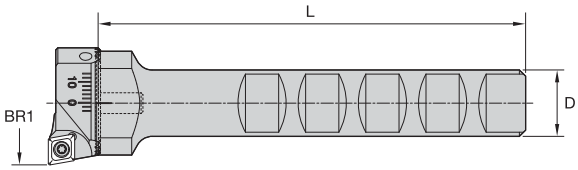


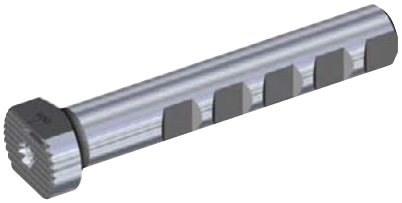
FBHO/FBHM • Universal Boring Bars

order number	catalog number	D min mm	D min in	D max mm	D max in	D mm	D in	L1 mm	L1 in	L4 mm	L4 in	gage insert	insert screw	Torx size
1125110	**AFB09075SCFCR06**	9,75	.384	14,75	.581	16	.63	75,0	2.95	30,0	1.18	CC..0602../CC..215..	**PKG2025**	T7
1133883	**AFB13085SCFCR06**	13,75	.541	18,75	.738	16	.63	85,0	3.35	40,0	1.57	CC..0602../CC..215..	**PKG2025**	T7
1133894	**AFB17100SCFCR06**	17,75	.699	22,75	.896	16	.63	100,0	3.94	55,0	2.17	CC..0602../CC..215..	**PKG2025**	T7
1137835	**AFB21110SCFCR09**	21,75	.856	26,75	1.053	16	.63	110,0	4.33	60,0	2.36	CC..09T3../CC..325..	**PKG3242**	T15
1128324	**AFB24115SCFCR09**	24,75	.974	29,75	1.171	16	.63	115,0	4.53	65,0	2.56	CC..09T3../CC..325..	**PKG3242**	T15
1126838	**AFB27115SCFCR09**	27,75	1.093	32,75	1.289	16	.63	115,0	4.53	70,0	2.76	CC..09T3../CC..325..	**PKG3242**	T15
1120731	**AFB31115SCFCR09**	31,75	1.250	36,75	1.447	16	.63	115,0	4.53	70,0	2.76	CC..09T3../CC..325..	**PKG3242**	T15
1127271	**AFB34115SCFCR09**	34,75	1.368	39,75	1.565	16	.63	115,0	4.53	70,0	2.76	CC..09T3../CC..325..	**PKG3242**	T15
2651038	**AFB38115SCFPR09**	38,75	1.526	44,10	1.736	16	.63	115,0	4.53	85,0	3.35	CC..09T3../CC..325..	**PKG3242**	T15
2651039	**AFB42115SCFPR09**	42,75	1.683	48,10	1.894	16	.63	115,0	4.53	85,0	3.35	CC..09T3../CC..325..	**PKG3242**	T15
2651040	**AFB47115SCFPR09**	47,75	1.880	53,10	2.091	16	.63	115,0	4.53	85,0	3.35	CC..09T3../CC..325..	**PKG3242**	T15

- Order AFM insert cartridge separately.



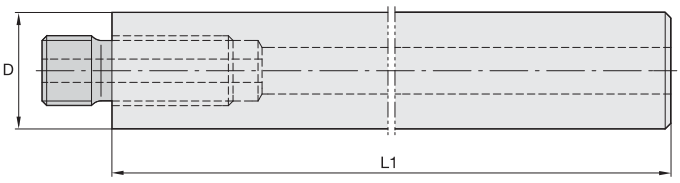




FBHO/FBHM • AFM Boring Bars

		BR1 bore range		D		D2		L	
order number	catalog number	mm	in	mm	in	mm	in	mm	in
4057061	AFM29115	29.750-48.100	1.1712-1.8940	16,0	.63	25,0	.98	103,000	4.06
4057062	AFM47115	47.750-88.100	1.8800-3.4680	16,0	.63	44,0	1.73	101,580	4.00



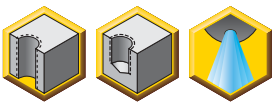


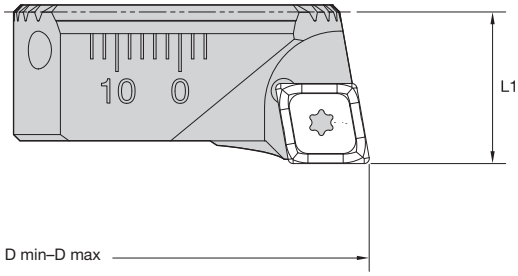


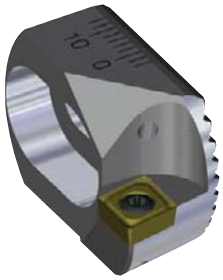
Carbide Shanks for Screw-On Boring Heads

		D		L1	
order number	catalog number	mm	in	mm	in
2651163	CFB10082	10	.39	82	3.23
2651164	CFB12096	12	.47	96	3.78
2651165	CFB14110	14	.55	110	4.33
2651166	CFB16120	16	.63	120	4.72
2651167	CFB18140	18	.71	140	5.51

- For use with AFM boring bars.
- Order inserts separately.



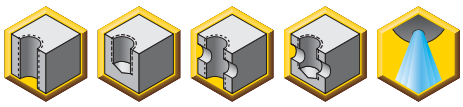


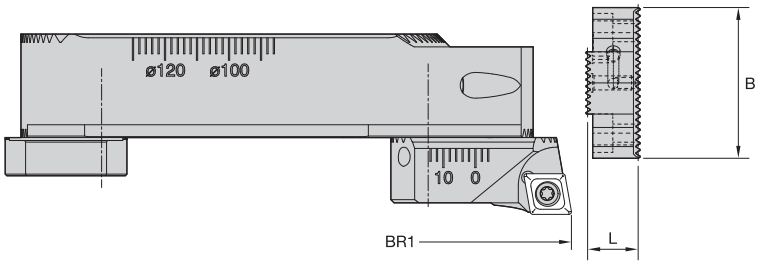


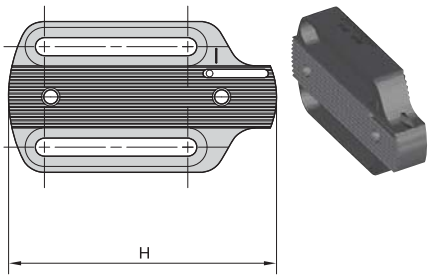
AFM • Insert Cartridges

order number	catalog number	D min mm	D min in	D max mm	D max in	L1 mm	L1 in	gage insert	ModBORE parts package	insert screw ID drive size
4057093	**AFM29SCFPR06**	29,75	1.171	48,10	1.894	12,0	.472	CC..0602../CC..2151..	**PKG2025**	T7
4057094	**AFM47SCFPR09**	47,75	1.880	88,10	3.469	14,0	.551	CC..09T3../CC..3252..	**PKG3242**	T15

- For use with FBHM insert holders and FBHM counterweight.
- Order AFM47SCFPR09 insert cartridge separately to achieve diameter range.



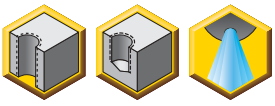


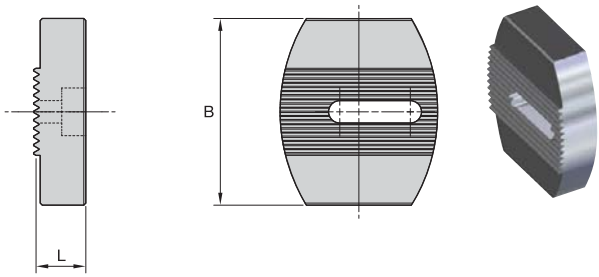


FBHM • Extension Bridge

order number	catalog number	BR1 bore range mm	BR1 bore range in	B mm	B in	H mm	H in	L mm	L in
4057095	**EBM8015086**	86.000-164.000	3.3900-6.4600	45,0	1.77	80,0	3.15	15,0	.59
4168063	**EBM1580160162**	162.000-320.000	6.3778-12.5984	45,0	1.77	158,0	6.22	16,2	.64

- For use with FBHM extension bridge.

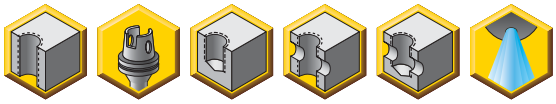


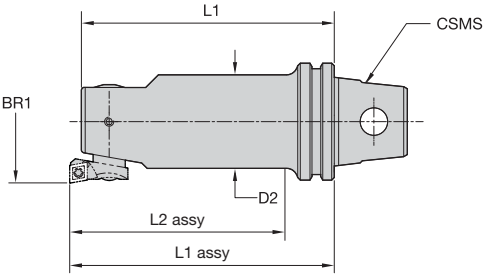


FBHM • Counterweight

order number	catalog number	B mm	B in	L mm	L in
4057096	**886038045**	45	1.77	12	.47

- .0004" (0,01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.
- Internal coolant directed to indexable insert.
- Order insert cartridges separately for required bore range; see page K140.







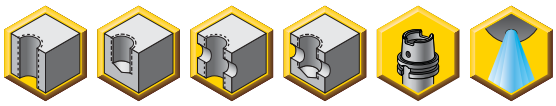
FBHS • KM™ Fine-Boring Single Cutters

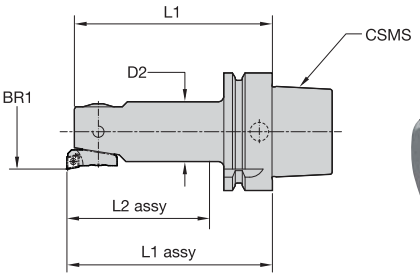




order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D2 mm	D2 in	L1 mm	L1 in	L1 assy mm	L1 assy in	L2 assy mm	L2 assy in	cartridge mounting screw	lock screw
3586572	KM32FBHS24	23,900-37,100	0.9409-1.4606	KM32	20,0	.79	86,0	3.39	90,0	3.54	76,1	2.99	880.252.200	881.252.200
3586573	KM32FBHS31	30,900-47,100	1.2165-1.8543	KM32	25,0	.98	96,0	3.78	100,0	3.94	86,1	3.39	880.252.250	881.252.250
3586574	KM40FBHS40	39,900-59,100	1.5709-2.3268	KM40	32,0	1.26	86,0	3.39	90,0	3.54	74,0	2.92	880.252.320	881.252.320
3586575	KM50FBHS51	50,900-81,100	2.0039-3.1929	KM50	42,0	1.65	86,0	3.39	90,0	3.54	70,0	2.76	880.252.420	881.252.420
3586576	KM50FBHS67	66,900-105,100	2.6339-4.1378	KM50	55,0	2.17	96,0	3.78	100,0	3.94	100,0	3.94	880.252.550	881.252.550
3586577	KM50FBHS87	86,900-134,100	3.4213-5.2795	KM50	72,0	2.84	116,0	4.57	120,0	4.72	120,0	4.72	880.252.550	881.252.720
3586578	KM63UTFBHS87	86,900-134,100	3.4213-5.2795	KM63UT	72,0	2.84	116,0	4.57	120,0	4.72	120,0	4.72	880.252.550	881.252.720
3586579	KM63UTFBHS116	115,900-191,100	4.5630-7.5236	KM63UT	94,0	3.70	146,0	5.75	150,0	5.91	150,0	5.91	880.252.550	881.252.940

- .0004" (0,01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.
- Internal coolant directed to indexable insert.
- Order insert cartridges separately for required bore range; see page K140.







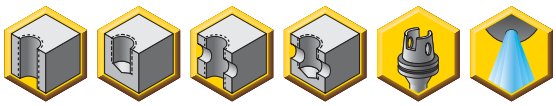
FBHS • HSK Fine-Boring Single Cutters

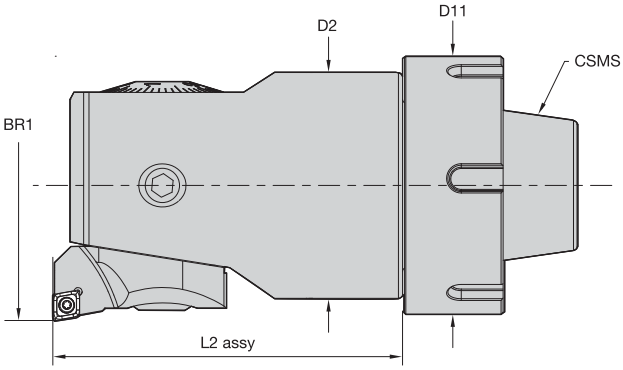




order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D2 mm	D2 in	L1 mm	L1 in	L1 assy mm	L1 assy in	L2 assy mm	L2 assy in	cartridge mounting screw	lock screw
3586580	HSK63FBHS24	23,900-37,100	0.9409-1.4606	HSK63A	20,0	.79	86,0	3.39	90,0	3.54	61,1	2.40	880.252.200	881.252.200
3586581	HSK63FBHS31	30,900-47,100	1.2165-1.8543	HSK63A	25,0	.98	101,0	3.98	105,0	4.13	76,1	2.99	880.252.250	881.252.250
3586582	HSK63FBHS40	39,900-59,100	1.5709-2.3268	HSK63A	32,0	1.26	106,0	4.17	110,0	4.33	81,1	3.19	880.252.320	881.252.320
3586583	HSK63FBHS51	50,900-81,100	2.0039-3.1929	HSK63A	42,0	1.65	116,0	4.57	120,0	4.72	91,1	3.58	880.252.420	881.252.420
3586584	HSK63FBHS67	66,900-105,100	2.6339-4.1378	HSK63A	55,0	2.17	121,0	4.76	125,0	4.92	99,1	3.90	880.252.550	881.252.550
3586585	HSK63FBHS87	86,900-134,100	3.4213-5.2795	HSK63A	72,0	2.84	141,0	5.55	145,0	5.71	145,0	5.71	880.252.550	881.252.720

- .0004" (0,01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.
- Internal coolant directed to indexable insert.
- Order insert cartridges separately for required bore range; see page K140.



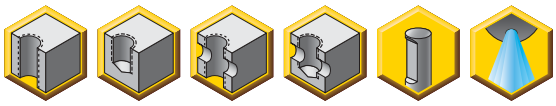


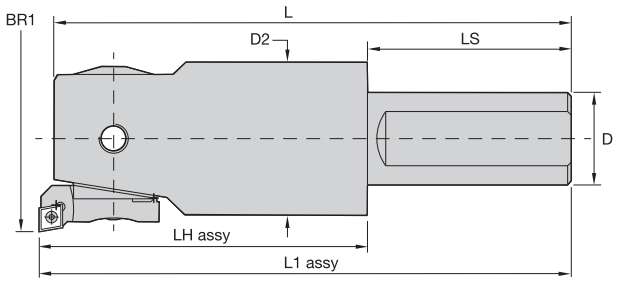


FBHS • ER Fine-Boring Single Cutters

order number	catalog number	BR1 bore range mm	BR1 bore range in	CSMS system size	D11 mm	D11 in	D2 mm	D2 in	L2 assy mm	L2 assy in	cartridge mounting screw	lock screw
5544149	ER25FBHS40	39,900-59,100	1.5700-2.3260	ER25	39,0	1.54	32,0	1.26	65,5	2.58	880.252.320	881.252.320
5544191	ER32FBHS51	50,900-81,100	2.0030-3.1920	ER32	49,5	1.95	42,0	1.65	75,5	2.97	880.252.420	881.252.420
5544193	ER40FBHS67	66,900-105,100	2.6330-4.1370	ER40	62,7	2.47	55,0	2.17	85,5	3.37	880.252.550	881.252.550

- .0004" (0.01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.
- Internal coolant directed to indexable insert.
- Order insert cartridges separately for required bore range; see page K140.



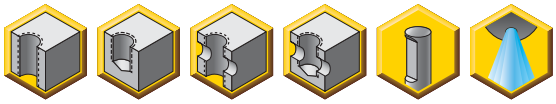


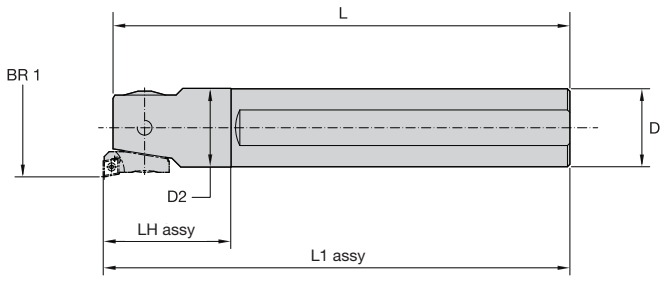


FBHS • Straight Shank Fine-Boring Single Cutters

order number	catalog number	BR1 bore range mm	BR1 bore range in	D	D2	L	LH assy	L1 assy	LS	cartridge mounting screw	lock screw
3586586	SF075FBHS24	23,900-37,100	0.9409-1.4606	.75	.79	5.75	1.65	5.91	4.2370	880.252.200	881.252.200
3586587	SF100FBHS31	30,900-47,100	1.2165-1.8543	1.00	.98	6.54	1.85	6.69	.8940	880.252.250	881.252.250
3586588	SF125FBHS40	39,900-59,100	1.5709-2.3268	1.25	1.26	7.32	2.05	7.48	5.4130	880.252.320	881.252.320
3586589	SF100FBHS51	50,900-81,100	2.0039-3.1929	1.00	1.65	5.59	3.54	5.74	2.2008	880.252.420	881.252.420
3586590	SF125FBHS67	66,900-105,100	2.6339-4.1378	1.25	2.17	6.17	3.94	6.33	2.3898	880.252.550	881.252.550
3586591	SF150FBHS87	86,900-134,100	3.4213-5.2795	1.50	2.84	7.39	4.72	7.54	2.8189	880.252.550	881.252.720
3586592	SF200FBHS116	115,900-191,100	4.5630-7.5236	2.00	3.70	9.13	5.91	9.29	3.3819	880.252.550	881.252.940

- 0.0004" (0,01mm) diameter adjustment respective 0.00008" (2 µm) with vernier scale.
- Order insert cartridges separately for required bore range, see page K140.



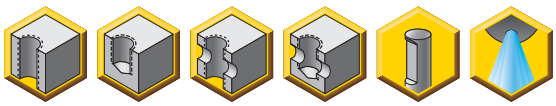


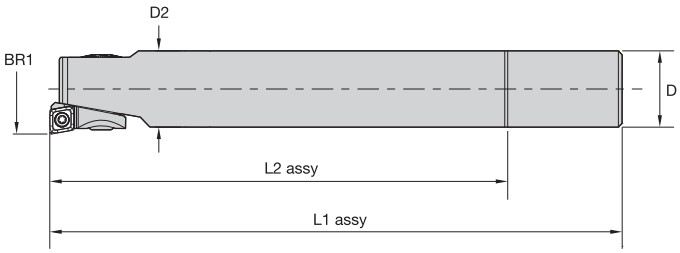


FBHS • Fine Boring Single Cutters • Carbide Straight Shank Series

order number	catalog number	BR1 bore range mm	BR1 bore range in	D	D2	L	LH assy	L1 assy	cartridge mounting screw	lock screw
3586593	SSE075FBHS24	23,900-37,100	0.9409-1.4606	.75	.79	9.69	3.15	9.84	880.252.200	881.252.200
3586594	SSE100FBHS31	30,900-47,100	1.2165-1.8543	1.00	.98	11.89	3.94	12.05	880.252.250	881.252.250
3586595	SSE125FBHS40	39,900-59,100	1.5709-2.3268	1.25	1.26	14.80	5.04	14.96	880.252.320	881.252.320

- .0004" (0,01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.
- Internal coolant directed to indexable insert.
- Order insert cartridges separately for required bore range; see page K140.



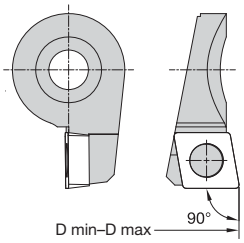


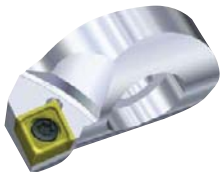


FBHS • Straight Shank Fine-Boring Single Cutters • Metric

order number	catalog number	BR1 bore range mm	BR1 bore range in	D mm	D in	D2 mm	D2 in	L1 assy mm	L1 assy in	L2 assy mm	L2 assy in	cartridge mounting screw	lock screw
5544144	SS20FBHS24	23,900-37,100	0.9400-1.4600	20,0	.79	20,0	.79	150,0	5.10	120,0	4.72	880.252.200	881.252.200
5544146	SS25FBHS31	30,900-47,100	1.2160-1.8540	25,0	.98	25,0	.98	170,0	6.69	140,0	5.51	880.252.250	881.252.250

- Order inserts separately.

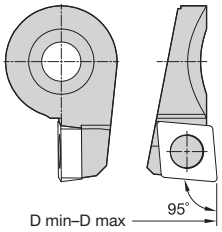




90° Lead • Insert Holders for FBHS Fine-Boring Heads

order number	catalog 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

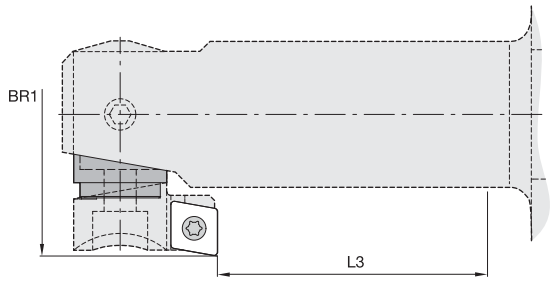
- Order inserts separately.





95° Lead • Insert Holders for FBHS

order number	catalog 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 Adapters

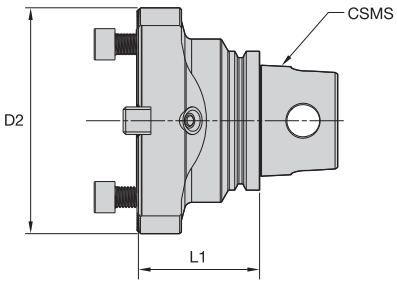
reversal adapter	use with cartridges				L3	
catalog number	90° lead	90° lead	95° lead	fine boring head series	mm	inch
R37FBHSRB	**R24FBHS06**	**–**	**R24FBHS06LF**	**..FBHS24**	13,0	0.512
R40FBHSRB	**R30FBHS06**	**–**	**–**	**..FBHS24**	13,0	0.512
R44FBHSRB	**R31FBHS06**	**–**	**R31FBHS06LF**	**..FBHS31**	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 adapter.

ModBORE™ Bridge Boring Systems

- Extension bridge required.
- Order extension bridge separately; see pages K143–K144.
- Match adapter and extension bridge series.





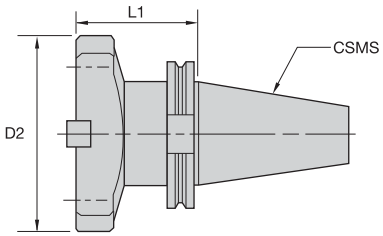


KM™ Bridge Tool Adapters

				D2		L1			
order number	catalog number	CSMS system size	extension bridge series	mm	in	mm	in	spare parts package	socket-head cap screw
1135802	**KM63BT13065**	KM63	A	130,0	5.12	65,0	2.56	**PKG1565**	**MS1085PKG**
1197315	**KM80BT13070**	KM80	B,A	130,0	5.12	70,0	2.76	**PKG1565**	**MS1085PKG**

- Extension bridge required.
- Order extension bridge separately; see pages K143–K144.
- Order coolant cartridge set separately.
- Match adapter and extension bridge series.







CV Bridge Tool Adapters

order number	catalog number	CSMS system size	extension bridge series	D2 mm	D2 in	L1 mm	L1 in	spare parts package	socket-head cap screw
1122185	**CV50BT13069**	CV50	A,B,C	130,0	5.12	69,1	2.72	**PKG1565**	**MS1085PKG**



BT Bridge Tool Adapters

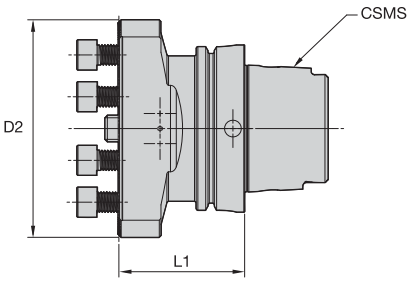
order number	catalog number	CSMS system size	extension bridge series	D2 mm	D2 in	L1 mm	L1 in	spare parts package	socket-head cap screw
1121711	**BT50BT13088**	BT50	A,B,C	130,0	5.12	88,0	3.46	**PKG1565**	**MS1085PKG**

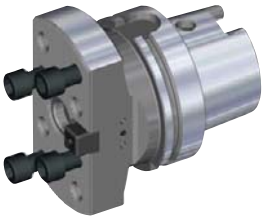


DV Bridge Tool Adapters

order number	catalog number	CSMS system size	extension bridge series	D2 mm	D2 in	L1 mm	L1 in	spare parts package	socket-head cap screw
1263825	**DV40BT13069**	DV40	A	130,0	5.12	69,1	2.72	**PKG1565**	**MS1085PKG**
1133581	**DV50BT13069**	DV50	A,B,C	130,0	5.12	69,1	2.72	**PKG1565**	**MS1085PKG**

- Extension bridge required.
- Order extension bridge separately; see pages K143–K144.
- Match adapter and extension bridge series.



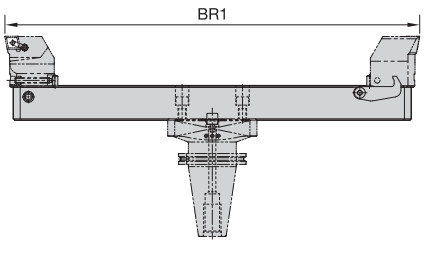


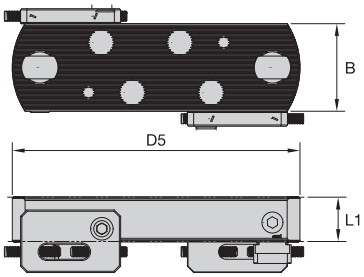
HSK Bridge Tool Adapters

order number	catalog number	CSMS system size	extension bridge series	D2 mm	D2 in	L1 mm	L1 in	spare parts package	socket-head cap screw
4062112	**HSK100BT13075**	HSK100A	A,B,C	130,0	5.12	75,0	2.95	**PKG1565**	**MS1085PKG**

NOTE: Tool adapters combined with small-scale extension bridges cover boring range 5.91–25.79" (150–655mm).
Tool adapters combined with large-scale extension bridge and bridge slides cover boring range from 25.59–86.81" (650–2205mm).

- Match extension bridge series to adapter.





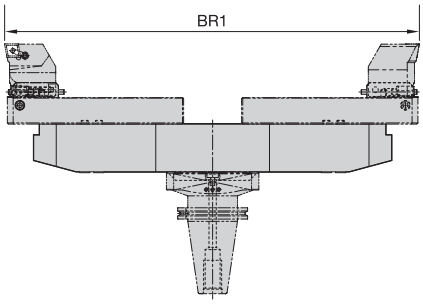


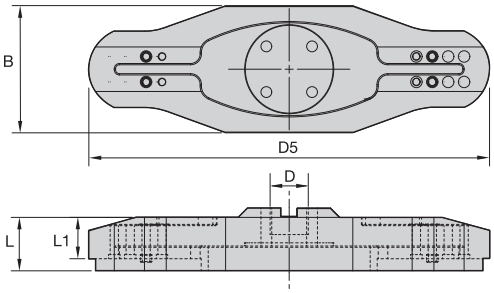
Small-Scale Extension Bridges

order number	catalog number	BR1 bore range mm	BR1 bore range in	max RPM	extension bridge series	B mm	B in	D5 mm	D5 in	L1 mm	L1 in	spare parts package	hex size	kg	lbs
1133280	**EB13030150**	150.000-205.000	5.9055-8.0709	1250	A	70,0	2.76	130,0	5.12	30,0	1.18	**PKG156502**	8 mm	1,95	4.30
1125085	**EB18030200**	200.000-255.000	7.8740-10.0394	1000	A	70,0	2.76	180,0	7.09	30,0	1.18	**PKG156502**	8 mm	2,77	6.10
1132857	**EB23035250**	250.000-305.000	9.8425-12.0079	850	B	70,0	2.76	230,0	9.06	35,0	1.38	**PKG156502**	8 mm	4,00	8.80
1126830	**EB28035300**	300.000-355.000	11.8110-13.9764	700	B	70,0	2.76	280,0	11.02	35,0	1.38	**PKG156502**	8 mm	5,14	11.30
1121703	**EB33040350**	350.000-405.000	13.7795-15.9449	600	B	70,0	2.76	330,0	12.99	40,0	1.57	**PKG156502**	8 mm	6,86	15.10
1140602	**EB38040400**	400.000-455.000	15.7480-17.9134	530	C	70,0	2.76	380,0	14.96	40,0	1.57	**PKG156502**	8 mm	7,95	17.50
1121036	**EB43040450**	450.000-505.000	17.7165-19.8819	480	C	70,0	2.76	430,0	16.93	40,0	1.57	**PKG156502**	8 mm	9,23	20.30
1270619	**EB48040500**	500.000-550.000	19.6850-21.8504	440	C	70,0	2.76	480,0	18.90	40,0	1.57	**PKG156502**	8 mm	10,23	22.50
1270620	**EB53050550**	550.000-605.000	21.6535-23.8189	400	C	70,0	2.76	530,0	20.87	50,0	1.97	**PKG156502**	8 mm	13,91	30.60
1270621	**EB58050600**	600.000-655.000	23.6220-25.7874	370	C	70,0	2.76	580,0	22.84	50,0	1.97	**PKG156502**	8 mm	15,32	33.70

- For use with shell mill adapters or direct connection to the machine spindle.
- Order bridge slides separately.









Large Scale Extension Bridge

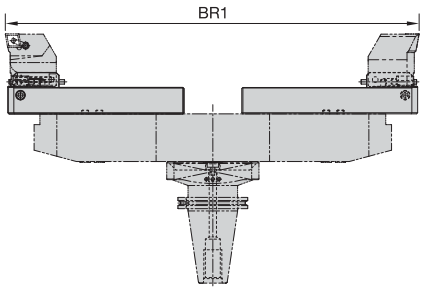
		BR1 bore range		D		D5		B		L		L1			
order number	catalog number	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	kg	lbs
4057204	EB630128650	650.000-1105.000	25.5900-43.5000	60,0	2.36	630,0	24.80	200,0	7.87	99,0	3.90	84,0	3.31	17,20	37.84
4057205	EB10801281100	1100.000-1655.000	43.3100-65.1600	60,0	2.36	1080,0	42.52	200,0	7.87	99,0	3.90	84,0	3.31	28,10	61.82
4057206	EB16301281650	1650.000-2205.000	64.9600-86.8100	60,0	2.36	1630,0	64.17	200,0	7.87	99,0	3.90	84,0	3.31	43,00	94.60

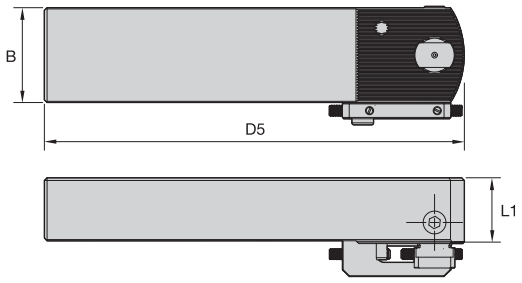
max RPM		
BR1 bore range (mm)	BR1 bore range inch	maximum RPM
650–705	25.59–27.76	300
700–755	27.56–29.72	285
750–805	29.53–31.69	270
800–855	31.50–33.66	255
850–905	33.46–35.63	240
900–955	35.43–37.60	225
950–1005	37.40–39.57	210
1000–1055	39.37–41.54	195
1050–1105	41.34–43.50	180

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.



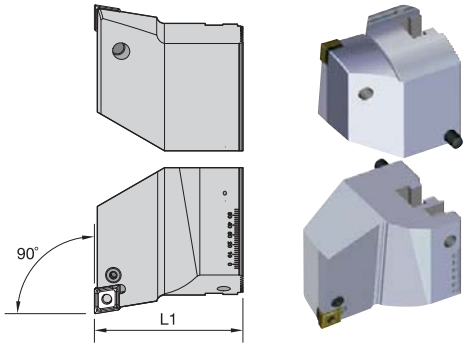




Bridge Slides

		BR1 bore range		B		D5		L1				
order number	catalog number	mm	in	mm	in	mm	in	mm	in	spare parts package	kg	lbs
4057207	EBSLD1105	650.000-1105.000	25.5900-43.5000	70,0	2.76	310,0	12.20	48,0	1.89	PKG156502	7,00	15.40
4057208	EBSLD2205	1100.000-2205.000	43.3100-86.8100	70,0	2.76	360,0	14.17	48,0	1.89	PKG156502	7,90	17.38

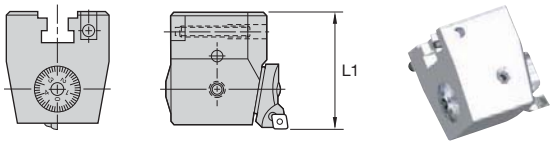
- Packaged as a matched set of two to enable twin cutting operations.



90° Lead • Bridge Tool Rough-Boring Head

order number	catalog number	L1 mm	L1 in	gage insert	spare parts package	insert screw ID drive size	kg	lbs
1624878	**EBURF1975PKG**	75,0	2.95	CN..1906../CN..64..	**PKG7994**	4 mm	1,64	3.60

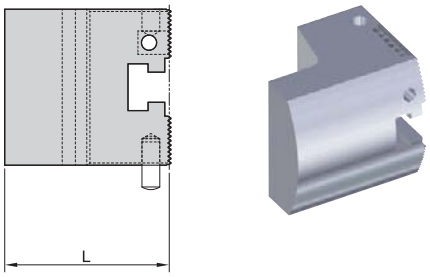
- Insert holder included.
- .0004" (0,01mm) diameter adjustment respective .00008" (2 µm) with vernier scale.
- Use with counterweight for balance.



90° Lead • Bridge Tool Fine-Boring Head

order number	catalog number	L1 mm	L1 in	cartridge	spare parts package	wrench size-adjusting screw	kg	lbs
1135375	**EBUFF0975**	75,0	2.95	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	catalog number	L mm	L in	kg	lbs
4062443	**EBUCW0074**	74,0	2.91	2,10	4.63

ModBORE™ • Roughing • Inch

Material Group		Condition	Geometry -MP	Geometry -MN	Geometry -MF	Cutting Speed SFM min	Cutting Speed SFM Starting Value	Cutting Speed SFM max	Feed Rate IPR -MP	Feed Rate IPR -MN	Feed Rate IPR -MF
P	1		–	KCP05	–	590	**1430**	1620	–	.006–.025	–
			KCP10			590	**1300**	1180	.004–.016	.006–.025	.004–.016
			–	KC9110		590	**1300**	1180	–	.006–.025	.004–.016
			KCP25			410	**900**	1180	.004–.008	.006–.012	.004–.008
			–	KC9125		510	**920**	1180	–	.006–.012	.004–.008
	2		–	KCP05	–	590	**870**	1310	–	.006–.025	–
			KCP10			590	**790**	1540	.004–.016	.006–.025	.004–.016
			–	KC9110		590	**820**	1120	–	.006–.025	.004–.016
			KCP25			410	**640**	920	.004–.008	.006–.012	.004–.008
			–	KC9125		460	**660**	970	–	.006–.012	.004–.008
	3		–	KCP05	–	590	**670**	900	–	.006–.025	–
			KCP10			520	**620**	1150	.004–.016	.006–.025	.004–.016
			–	KC9110		510	**620**	770	–	.006–.025	.004–.016
			KCP25			440	**510**	740	.004–.008	.006–.012	.004–.008
			–	KC9125		440	**510**	740	–	.006–.012	.004–.008
	4		–	KCP05	–	300	**520**	720	–	.006–.025	–
			KCP10			300	**480**	770	.004–.016	.006–.025	.004–.016
			–	KC9110		300	**480**	640	–	.006–.025	.004–.016
			KCP25			250	**340**	590	.004–.008	.006–.012	.004–.008
			–	KC9125		250	**360**	570	–	.006–.012	.004–.008
	5		–	KCP05	–	490	**790**	1030	–	.006–.025	–
			KCP10			490	**710**	980	.004–.016	.006–.025	.004–.016
			–	KC9110		490	**710**	980	–	.006–.025	.004–.016
			KCP25			390	**640**	850	.004–.008	.006–012	.004–.008
			–	KC9125		390	**640**	850	–	.006–.012	.004–.008
	6		–	KCP05	–	460	**660**	980	–	.006–.025	–
			KCP10			360	**590**	890	.004–.016	.006–.025	.004–.016
			–	KC9110		390	**590**	740	–	.006–.025	.004–.016
			KCP25			340	**490**	740	.004–.008	.006–.012	.004–.008
			–	KC9125		340	**490**	740	–	.006–.012	.004–.008

ModBORE™ • Roughing • Inch

Material Group		Condition	Geometry -MP	Geometry -MF	Cutting Speed SFM min	Cutting Speed SFM Starting Value	Cutting Speed SFM max	Feed Rate IPR -MP	Feed Rate IPR -MF
M	1		KCM15		330	**590**	790	.004–.016	.003–.012
			KC5010	–	430	**710**	820	.004–.016	–
			KC9225		570	**610**	820	.004–.016	.003–.012
			KCM25		300	**490**	660	.004–.008	.003–.006
			KC9240		300	**390**	440	.004–.008	.003–.006
	2		KCM15		360	**540**	820	.004–.016	.003–.012
			KC5010	–	410	**660**	820	.004–.016	–
			KC9225		360	**560**	750	.004–.016	.003–.012
			KCM25		300	**490**	740	.004–.008	.003–.006
			KC9240		260	**340**	440	.004–.008	.003–.006
	3		KCM15		360	**490**	820	.004–.016	.003–.012
			KC5010	–	360	**490**	750	.004–.016	–
			KC9225		360	**490**	750	.004–.016	.003–.012
			KCM25		300	**390**	660	.004– .008	.003–.006
			KC9240		260	**300**	440	.004–.008	.003–.006

ModBORE™ • Roughing • Inch

Material Group		Condition	Geometry -MP	Geometry -MW	Cutting Speed SFM min	Cutting Speed SFM Starting Value	Cutting Speed SFM max	Feed Rate IPR -MP	Feed Rate IPR -MW
K	1		KCK20		720	**980**	1770	.004–.016	.006–.039
			–	KT315	520	**900**	1610	–	.006–.039
			KCK20		720	**900**	1150	.004–.016	.006–.039
			–	KC9315	490	**900**	1150	–	.006–.039
			KCK20		460	**690**	1120	.004–.008	.006–.018
			–	KC9325	230	**690**	1120	–	.006–.018
	2		KCK20		720	**900**	1150	.004–.016	.006–.039
			–	KT315	590	**900**	1180	–	.006–.039
			KCK20		720	**900**	1150	.004–.016	.006–.039
			–	KC9315	430	**850**	1120	–	.006–.039
			KCK20		720	**900**	1150	.004–.008	.006–.018
	3		KCK20		360	**490**	750	.004–.016	.006–.039
			–	KT315	560	**750**	1180	–	.006–.039
			KCK20		360	**490**	750	.004–.016	.006–.039
			–	KC9315	430	**710**	1150	–	.006–.039
			KCK20		360	**490**	750	.004–.008	.006–.018

ModBORE™ • Roughing • Inch

Material Group		Condition	Geometry -HP	Geometry –	Cutting Speed SFM min	Cutting Speed SFM Starting Value	Cutting Speed SFM max	Feed Rate IPR -HP	Feed Rate IPR –
N	1		KC5410	–	660	**1800**	3280	.006–.025	–
			–	KD1400	1480	**2510**	8200	–	.010–.025
			KC5410	–	660	**1800**	3280	.006–.012	–
	2		–	KD1425	980	**1710**	2950	–	.010–.025
			–	KD1425	980	**1710**	2950	–	.010–.016
	3		KC5410	–	330	**900**	1640	.006–.025	–
			K313	–	390	**850**	1610	.006–.025	–
			KC5410	–	330	**900**	1640	.006–.012	–
	5		KC5410	–	330	**660**	1150	.006–.025	–
			KC5410	–	330	**660**	1150	.006–.012	–

ModBORE™ • Roughing • Inch

Material Group		Condition	Geometry -MP	Geometry -FP	Geometry -UP	Cutting Speed SFM min	Cutting Speed SFM Starting Value	Cutting Speed SFM max	Feed Rate IPR -MP	Feed Rate IPR -FP	Feed Rate IPR -UP
S	1		KCU10		–	100	**180**	380	.004–.016	.002–.010	–
			KC5010			100	**180**	380	.004–.016	.002–.010	.006–.020
			KCU25		–	30	**130**	180	.004–.008	.002–.005	–
			KC9240	–	KC9240	30	**130**	200	.004–.008	–	.006–.011
	2		KCU10		–	100	**200**	390	.004–.016	.002–.010	–
			KC5010			100	**200**	380	.004–.016	.002–.010	.006–.020
			KCU25		–	30	**100**	180	.004–.008	.002–.005	–
			KC9240	–	KC9240	30	**100**	180	.004–.008	–	.006–.011
	3		KCU10		–	100	**230**	380	.004–.016	.002–.010	–
			KC5010			100	**230**	380	.004–.016	.002–.010	.006–.020
			KCU25		–	70	**130**	180	.004–.008	.002–.005	–
			KC9240	–	KC9240	70	**130**	200	.004–.008	–	.006–.011
	4		KCU10		–	150	**230**	460	.004–.016	.002–.010	–
			KC5010			150	**230**	560	.004–.016	.002–.010	.006–.020
			KCU25		–	70	**180**	300	.004–.008	.002–.005	–
			KC9240	–	KC9240	50	**180**	300	.004–.008	–	.006–.011

ModBORE™ • Roughing • Metric

Material Group		Condition	Geometry -MP	Geometry -MN	Geometry -MF	Cutting Speed — vc m/min min	Cutting Speed — vc m/min Starting Value	Cutting Speed — vc m/min max	Feed Rate mm/r -MP	Feed Rate mm/r -MN	Feed Rate mm/r -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 -MP	Geometry -MF	Geometry —	Cutting Speed — vc m/min min	Cutting Speed — vc m/min Starting Value	Cutting Speed — vc m/min max	Feed Rate mm/r -MP	Feed Rate mm/r -MF	Feed Rate mm/r —
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	–

ModBORE™ • Roughing • Metric

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	–

ModBORE™ • Roughing • Metric

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

ModBORE™ • Finishing • Inch

Material Group		Condition	Geometry				Cutting Speed — vc SFM			Feed Rate IPR			
			-LF	-UF	-FP	-FW	min	Starting Value	max	-LF	-UF	-FP	-FW
P	1		KCP05			–	590	**1430**	1620	.002–.010	.002–.006	.002–.010	–
			–	–	KTP10	–	590	**1430**	1620	–	–	.002–.010	–
			KT315	–	–	–	590	**1310**	1620	.002–.010	–	–	.003–.012
			KCP10			–	590	**1300**	1530	.002–.010	.002–.006	.002–.010	–
			KC9110		–	–	590	**1300**	1620	.002–.010	.002–.006	–	–
			KCP25				460	**920**	1180	.002–.004	.002–.003	.002–.005	.003–.006
			KC9125		–	–	460	**920**	1180	.002–.004	.002–.003	–	–
	2		KCP05			–	590	**870**	1310	.002–.010	.002–.006	.002–.010	–
			–	–	KTP10	–	590	**870**	1310	–	–	.002–.010	–
			KT315	–	–	KT315	620	**890**	1280	.002–.010	–	–	.003–.012
			KCP10			–	590	**790**	1080	.002–.010	.002–.006	.002–.010	–
			KC9110		–	–	590	**790**	1080	.002–.010	.002–.006	–	–
			KCP25				480	**640**	1050	.002–.004	.002–.003	.002–.005	.003–.006
			KC9125		–	–	480	**640**	1050	.002–.004	.002–.003	–	–
	3		KCP05			–	590	**670**	900	.002–.010	.002–.006	.002–.010	–
			–	–	KTP10	–	590	**670**	900	–	–	.002–.010	–
			KT315	–	–	KT315	590	**690**	900	.002–.010	–	–	.003–.012
			KCP10			–	520	**620**	820	.002–.010	.002–.006	.002–.010	–
			KC9110		–	–	510	**620**	790	.002–.010	.002–.006	–	–
			KCP25				440	**510**	740	.002–.004	.002–.003	.002–.005	.003–.006
			KC9125		–	–	440	**510**	740	.002–.004	.002–.003	–	–
	4		KCP05			–	300	**520**	720	.002–.010	.002–.006	.002–.010	–
			–	–	KTP10	–	300	**520**	720	–	–	.002–.010	–
			KT315	–	–	KT315	300	**590**	720	.002–.010	–	–	.003–.012
			KCP10			–	300	**480**	640	.002–.010	.002–.006	.002–.010	–
			KC9110		–	–	300	**480**	640	.002–.010	.002–.006	–	–
			KCP25				250	**340**	590	.002–.004	.002–.003	.002–.005	.003–.006
			KC9125		–	–	250	**340**	590	.002–.004	.002–.003	–	–
	5		KCP05			–	490	**790**	1030	.002–.010	.002–.006	.002–.010	–
			–	–	KTP10	–	490	**790**	1030	–	–	.002–.010	–
			KT315	–	–	KT315	490	**820**	1030	.002–.010	–	–	.003–.012
			KCP10			–	490	**710**	980	.002–.010	.002–.006	.002–.010	–
			KC9110		–	–	490	**710**	980	.002–.010	.002–.006	–	–
			KCP25				390	**640**	840	.002–.004	.002–.003	.002–.005	.003–.006
			KC9125		–	–	390	**640**	840	.002–.004	.002–.003	–	–
	6		KCP05			–	460	**660**	980	.002–.010	.002–.006	.002–.010	–
			–	–	KTP10	–	460	**660**	980	–	–	.002–.010	–
			KT315	–	–	KT315	460	**660**	980	.002–.010	–	–	.003–.012
			KCP10			–	390	**590**	900	.002–.010	.002–.006	.002–.010	–
			KC9110		–	–	390	**590**	740	.002–.010	.002–.006	–	–
			KCP25				340	**490**	740	.002–.004	.002–.003	.002–.005	.003–.006
			KC9125		–	–	340	**490**	740	.002–.004	.002–.003	–	–

ModBORE™ • Finishing • Inch

Material Group		Condition	Geometry				Cutting Speed — vc SFM			Feed Rate IPR			
			-LF	-UF	-FP	-FW	min	Starting Value	max	-LF	-UF	-FP	-FW
M	1		–	–	KTP10	–	460	**750**	1030	–	–	.002–.010	–
			KT315	–	–	KT315	460	**750**	1030	.002–.010	–	–	.003–.012
			KC5010	–	–	KC5010	430	**710**	800	.002–.010	–	–	.003–.012
			KCM15	–	KCM15	–	340	**590**	790	.002–.005	–	.002–.005	–
			KC9225	–	–	KC9225	340	**590**	790	.002–.005	–	–	.003–.006
	2		–	–	KTP10	–	460	**710**	970	–	–	.002–.010	–
			KT315	–	–	KT315	460	**710**	970	.002–.010	–	–	.003–.012
			KC5010	–	–	KC5010	430	**660**	800	.002–.010	–	–	.003–.012
			KCM15	–	KCM15	–	340	**540**	820	.002–.005	–	.002–.005	–
			KC9225	–	–	KC9225	330	**520**	750	.002–.005	–	–	.003–.006
	3		–	–	KTP10	–	460	**660**	980	–	–	.002–.010	–
			KT315	–	–	KT315	460	**660**	980	.002–.010	–	–	.003–.012
			KC5010	–	–	KC5010	430	**610**	750	.002–.010	–	–	.003–.012
			KCM15	–	KCM15	–	380	**490**	840	.002–.005	–	.002–.005	–
			KC9225	–	–	KC9225	360	**490**	750	.002–.005	–	–	.003–.006

ModBORE™ • Finishing • Inch

Material Group		Condition	Geometry				Cutting Speed — vc SFM			Feed Rate IPR			
			-LF	-UF	-FP	-FW	min	Starting Value	max	-LF	-UF	-FP	-FW
K	1		KCK20	–	KCK20		660	980	1770	.002–.010	–	.002–.010	.003–.012
			KT315	–	–	KT315	540	900	1610	.002–.010	–	–	.003–.012
			KC9315	–	–	–	360	900	1480	.002–.010	–	–	–
			KC9320	–	–	–	330	790	1310	.002–.005	–	–	–
	2		KCK20	–	KCK20		490	790	1380	.002–.010	–	.002–.010	.003–.012
			KT315	–	–	KT315	590	900	1180	.002–.010	–	–	.003–.012
			KC5010		–	KC5010	330	660	870	.002–.010	.002–.006	–	.003–.012
			KC9315	–	–	–	480	850	1180	.002–.010	–	–	–
			KC9320	–	–	–	460	790	1080	.002–.005	–	–	–
	3		KCK20	–	KCK20		460	690	1150	.002–.010	–	.002–.010	.003–.012
			KT315	–	–	KT315	590	750	1050	.002–.010	–	–	.003–.012
			KC5010		–	KC5010	390	490	740	.002–.010	.002–.006	–	.003–.012
			KC9315	–	–	–	480	710	900	.002–.010	–	–	–
			KC9320	–	–	–	460	690	850	.002–.005	–	–	–

ModBORE™ • Finishing • Inch

Material Group		Condition	Geometry				Cutting Speed — vc SFM			Feed Rate IPR			
			-LF	–	–	–	min	Starting Value	max	-LF	–	–	–
N	1		KC5410	–	–	–	660	1800	3280	.004–.016	–	–	–
			KC5410	–	–	–	660	1800	3280	.004–.008	–	–	–
			–	KD1400	–	–	1480	2510	9840	–	.002–.006	–	–
	2		–	KD1425	–	–	1230	1900	3770	–	.002–.010	–	–
			–	KD1400	–	–	1310	2130	4100	–	.002–.006	–	–
	3		KC5410	–	–	–	410	900	1720	.004–.016	–	–	–
			–	KD1425	–	–	820	1640	2870	–	.002–.010	–	–
			KC5410	–	–	–	410	900	1720	.004–.008	–	–	–
			–	KD1400	–	–	1230	1710	3280	–	.002–.005	–	–
	5		KC5410	–	–	–	410	660	1230	.004–.016	–	–	–
			KC5410	–	–	–	410	660	1230	.004–.008	–	–	–

ModBORE™ • Finishing • Inch

Material Group		Condition	Geometry				Cutting Speed — vc SFM			Feed Rate IPR			
			-LF	-UF	-FP	-FW	min	Starting Value	max	-LF	-UF	-FP	-FW
S	1		–	–	KCU10	–	100	180	410	–	–	.002–.010	–
			K313	–	–	–	30	100	200	.002–.010	–	–	–
			KC5010		–	KC5010	100	180	390	.002–.010	.002–.006	–	.003–.012
			–	–	KCU10	–	100	180	410	–	–	.002–.010	–
			KC5010		–	KC5010	100	180	390	.002–.010	.002–.006	–	.003–.012
			–	–	KCU25	–	30	130	160	–	–	.002–.005	–
			KC5025	–	–	–	30	130	160	.002–.004	–	–	–
	2		–	–	KCU10	–	100	110	410	–	–	.002–.010	–
			K313	–	–	–	30	110	200	.002–.010	–	–	–
			KC5010		–	KC5010	100	200	390	.002–.010	.002–.006	–	.003–.012
			–	–	KCU10	–	100	110	410	–	–	.002–.010	–
			KC5010		–	KC5010	100	200	390	.002–.010	.002–.006	–	.003–.012
			–	–	KCU25	–	30	100	160	–	–	.002–.005	–
			KC5025	–	–	–	30	100	160	.002–.004	–	–	–
	3		–	–	KCU10	–	100	230	410	–	–	.002–.010	–
			K313	–	–	–	30	130	200	.002–.010	–	–	–
			KC5010		–	KC5010	100	230	390	.002–.010	.002–.006	–	.003–.012
			–	–	KCU10	–	100	110	410	–	–	.002–.010	–
			KC5010		–	KC5010	100	230	390	.002–.010	.002–.006	–	.003–.012
			–	–	KCU25	–	80	130	200	–	–	.002–.005	–
			KC5025	–	–	–	80	130	200	.002–.004	–	–	–
	4		–	–	KCU10	–	150	230	460	–	–	.002–.010	–
			K313	–	–	–	50	150	210	.002–.010	–	–	–
			KC5010		–	KC5010	150	230	460	.002–.010	.002–.006	–	.003–.012
			–	–	KCU10	–	150	230	460	–	–	.002–.010	–
			KC5010		–	KC5010	150	230	460	.002–.010	.002–.006	–	.003–.012
			–	–	KCU25	–	80	180	300	–	–	.002–.005	–
			KC5025	–	–	–	50	180	300	.002–.004	–	–	–

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Material Group		Condition	Geometry -LF	Geometry -UF	Geometry -FP	Geometry -FW	Cutting Speed — vc m/min min	Cutting Speed — vc m/min Starting Value	Cutting Speed — vc m/min max	Feed Rate mm/r -LF	Feed Rate mm/r -UF	Feed Rate mm/r -FP	Feed Rate mm/r -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 -LF	Geometry -UF	Geometry -FP	Geometry -FW	Cutting Speed — vc m/min min	Cutting Speed — vc m/min Starting Value	Cutting Speed — vc m/min max	Feed Rate mm/r -LF	Feed Rate mm/r -UF	Feed Rate mm/r -FP	Feed Rate mm/r -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 Customized 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 aluminum and aluminum 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.

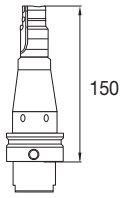


Product Platform Versatility

- 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 optimized 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 optimizes runout and enables highest accuracy and tool life.
- All PCD tooling prebalanced by design. Further precision balancing available on request.

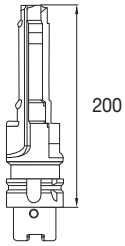
PCD Tooling Basic Design Overview

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.

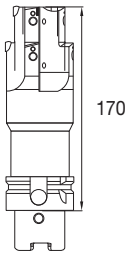


PCD ..ST —
Steel body

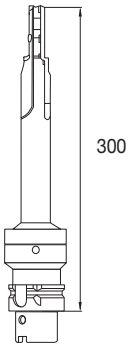
PCD ..SC —
Solid carbide body



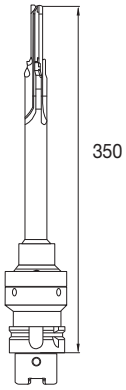
PCD ..STM —
Steel body monoblock



PCD ..STMJ —
Steel body monoblock
Ø adjustable



PCD ..STA —
Steel body with steerable SIF™ backend



PCD ..SCA —
Solid carbide shank and steerable SIF backend

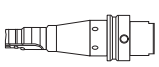
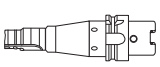
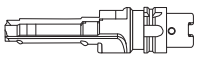
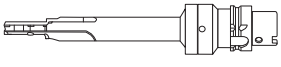
PCDRSC02CCE

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** = Center 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**

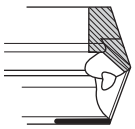
PCD Drill-Point Design Overview

CT
- PCD corner tipped.
- Carbide-based body design.
- Diameter >.166" (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 >.166" (4,2mm).



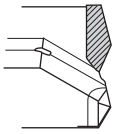
Use at precasted holes at moderate cutting speeds up to 12 x D drilling depth.

SW
- Full-face sandwich PCD.
- Carbide-based body design.
- Diameter >.97" (5mm).



Use at high cutting speeds and abrasive materials up to 5 x D drilling depth.

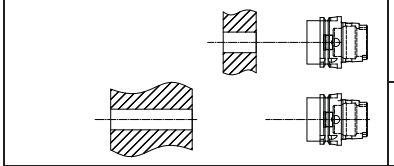
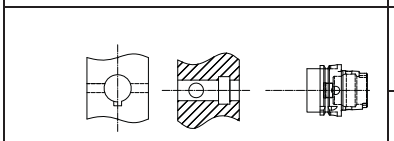
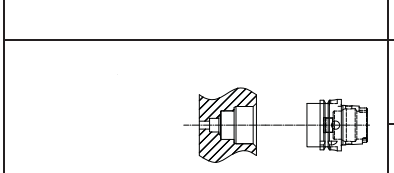
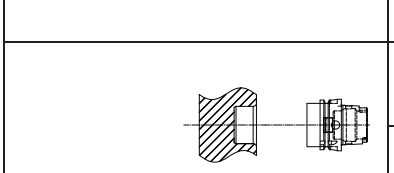
MT
- PCD corner tipped.
- Steel- and carbide-based body design.
- Diameter >.4736" (12mm).



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

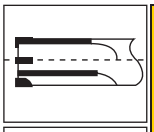
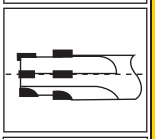
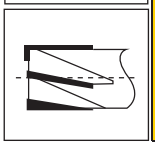
Cutting Grade, Tooling Design

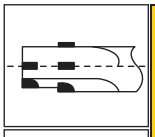
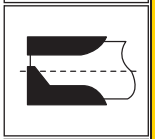
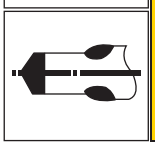
Select cutting data and tooling design based on stability and surface quality demands.

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-center 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	.236–1.26"	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
	center cutting		drilling tool, corner tipped	2	max 20 x D	.197–1.26"	3	axial and radial	max 50%
			countersinker, center cut	2–4	max 10 x D				
			drilling tool, center cut	2	max 12 x D	.197–.472"			

NOTE: 310mm max overall
[1]Depending on the diameter [2]Based on the max diameter

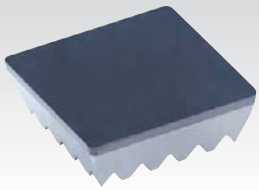
Valve Seat and **Guide Experts**





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.



OPTIMIZED HYDRO CHUCK

- Maximum flexural strength.
- Lowest runout error between seat and guide.



Experience the advantages at your Authorized 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 center 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.
- Aluminum.
- Machining center 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 center 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

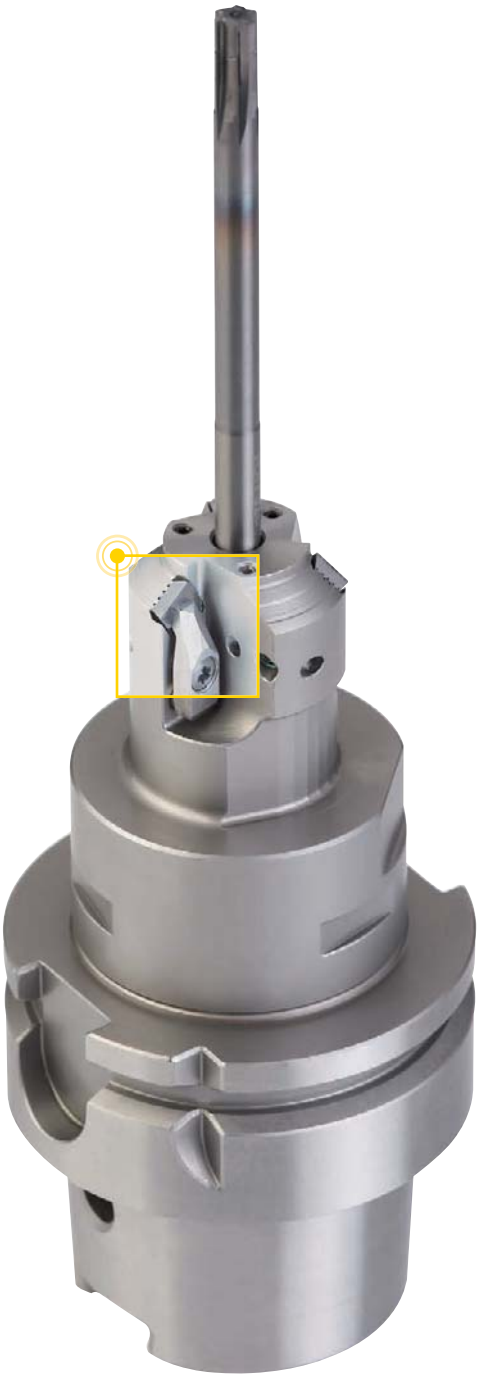
• vc 80 m/min	f 0,10 mm/rev	valve seat.
• vc 80 m/min	f 0,32 mm/rev	valve guide.

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 .472" (12mm).
- Tolerance range 18 µm G7.
- Aluminum AlSi7Mg.
- Machining center 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 1.312 SFM (400 m/min).
- f .004 IPR (0,10 mm/rev).

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 .305–.768" (7,75–19,5mm).
- Tolerance range 5 µm.
- Aluminum G-AlSi7Mg.
- Machining center 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 722 SFM (220 m/min).
- f .014 IPR (0,35 mm/rev).

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 2.220" (56,4mm).
- Tolerance range 30 µm H7.
- Aluminum.
- 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 1.070 SFM (326 m/min).
- f .004 IPR (0,32 mm/rev).

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

- Cambore finishing Ø .984" (25mm).
- Tolerance range 21 µm H7.
- Aluminum.
- Deflection less than 20 µm over total length.
- Machining center 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 1.096 SFM (334 m/min).
- f .006 IPR (0,16 mm/rev).

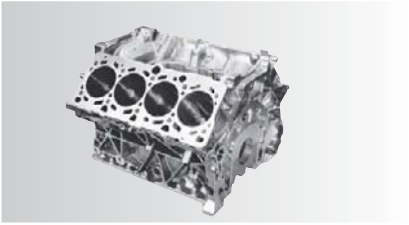
RESULT

- **Tool life of 160,000 cylinder heads.**
- **Surface finish Ra 0.3 µm.**

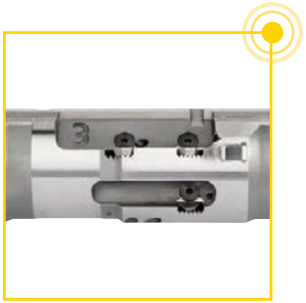
BENEFIT

- **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

- Crank Bore finishing.
- Material: AlSi7/Sinter or AlSi7/GGG60.
- Machine: Hor. M/C.
- Roundness 0.01mm.
- Concentricity 0.025mm.

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

- Speed: 100m/min
- Feed/tooth: SF = 0.2/rev. ; F = 0.16/rev.

RESULT

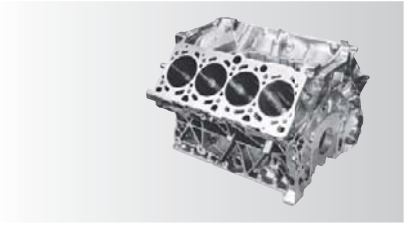
- **Roundness measured: 0.005mm.**
- **Concentricity measured: 0.005mm.**

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 2.953" (75mm).
- Cast iron GG25.
- Semi-finish and finish operation combined in one tool with coolant pressure activated finish stage.
- Machining center 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.

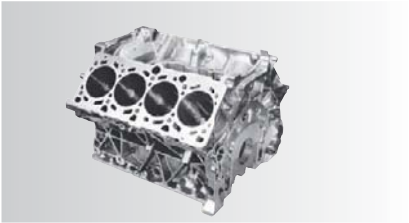
RESULT

- **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 3.108" (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

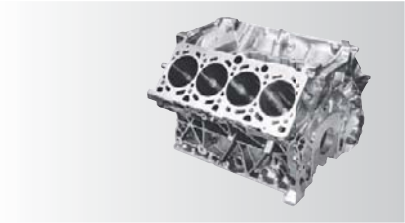
- **Tool life of 100 components per setup.**
- **Cylindricity 13 µm.**
- **Surface finish Ra 1.5 µm.**

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 1.457" (37mm).
- Tolerance range 5 µm.
- Cast iron.
- Maintain tolerance for minimum of 50 bores.
- Machining center 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.

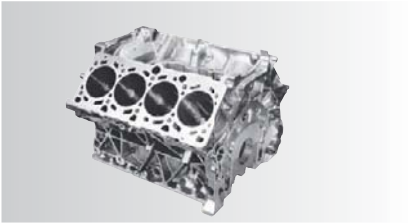
RESULT

- **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 328 SFM (100 m/min).
- f .006 IPR (0,14 mm/rev).

RESULT

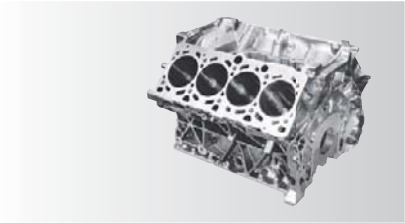
- **Tool life of 8,000 bores per insert.**
- **Surface finish Rz 10 µm.**

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 .787" (20mm).
- Tolerance range 21 µm N7.
- Cast iron GG26Cr.
- Replace padded double-edged reamer.
- Machining center with internal coolant.

SOLUTION

- Special RHM head with six cutting edges.
- Engineered solution KC6105 TiN coated carbide grade.

CUTTING DATA

- vc 207 SFM (63 m/min).
- f .033 IPR (0,84 mm/rev).

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 2.285" (58,033mm).
- Brass.
- Combine finishing of crank and pin bore into one tool to increase productivity.
- Machining center with internal coolant.

SOLUTION

- Romicron engineered-solution tool with two Romicron mechanisms in one tool body.
- KC5010™.

CUTTING DATA

- vc 1.476 SFM (450 m/min).
- f .004 IPR (0,10 mm/rev).

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 3.692" (93,777mm).
- Steel C70.
- Combine finishing of crank and pin bore into one tool to increase productivity.
- Machining center with internal coolant.

SOLUTION

- Romicron engineered solution tool with two Romicron mechanisms in one tool body.
- KT315™.

CUTTING DATA

- vc 1.312 SFM (400 m/min).
- f .004 IPR (0,10 mm/rev).

RESULT

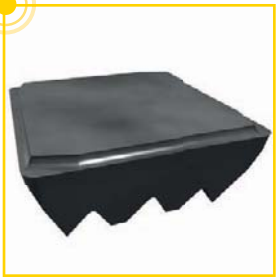
- **Tool life of 260 crank bores per insert.**
- **Surface finish better than Ra 1.0 µm.**
- **Cylindricity 5 µm.**

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 .748" (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 328 SFM (200 m/min).
- f .006 IPR (0,20 mm/rev).

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 .660" (16,77mm).
- Crank bore Ø .818" (20,77mm).
- Steel C70.
- Combines roughing, semi-finishing, and finishing operations 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 fi nish Ra 0.5 µm.**
- **Cylindricity 3 µm.**

BENEFIT

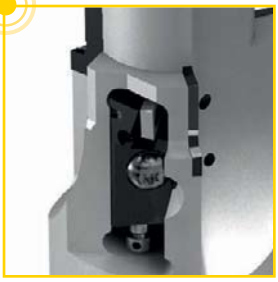
- **Productivity increase due to combination tool.**
- **Bore tolerance range of 20 µm easily and consistently achieved due to 1 µm per click in radius adjustment.**



Steering Column







Adjustable cartridge
with PCD insert

PCD COUNTERSINKING

CHALLENGE

- Bore Ø 26,2; 37,6; and 44mm.
- Tolerance range 21 µm N7.
- Aluminum G-AlSi9Cu3.
- Varying depth of cut ca. 1,5mm.
- Machining center 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

- 1,640 SFM (vc 500 m/min).
- .012 IPR (f 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.
- Aluminum G-AlSi10Mg.
- Varying depth of cut ca. 2,5mm.
- Machining center 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 1,969 SFM (600 m/min).
- f .012 IPR (0,30 mm/rev).

RESULT

- **Tool life of 2,000 meters.**

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.
- Aluminum G-AlSi10Mg.
- Varying depth of cut ca. 0,5mm.
- Machining center with internal coolant.

SOLUTION

- PCD-tipped, carbide-based tool with SIF™ steerable interface with internal coolant.
- Four effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 755 SFM (230 m/min).
- f .010 IPR (0,25 mm/rev).

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.
- Aluminum AlSi9Cu3.
- Machine three different diameters with one tool.
- Machining center 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 .013 IPR (0,32 mm/rev).

RESULT

- **Tool life of 500 workpieces.**

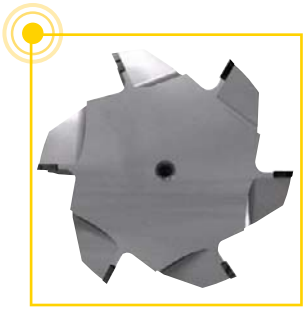
BENEFIT

- **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.
- Aluminum AlSi8Cu3.
- Varying depth of cut ca. 0,5–5mm.
- Machining center 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 1,148 SFM (350 m/min).
- f .024 IPR (0,60 mm/rev).

RESULT

- **Tool life increase versus previous solution.**
- **Surface finish Ra 0.2 µm.**

BENEFIT

- **Secure process.**

Gear Housing



PCD REAMING

CHALLENGE

- Bearing bore Ø .984" (35mm).
- Tolerance range 21 µm H7.
- Aluminum G-AlSi10Mg.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining center 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 771 SFM (235 m/min).
- f .012 IPR (0,30 mm/rev).

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 .435" (11,5mm).
- Tolerance range 18 µm H7.
- Aluminum G-AlSi10Mg.
- Varying depth of cut ca. 3mm.
- Machining center HSK63A with internal coolant.

SOLUTION

- PCD-tipped, carbide based tool with shrink in HSK63A adapter with internal coolant.
- Two effective cutting and chamfering teeth.
- KD1415™.

CUTTING DATA

- vc 3,297 SFM (1,005 m/min).
- f .024 IPR (0,16 mm/rev).

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 3.150" (80mm).
- Tolerance range 30 µm H7.
- Aluminum G-AlSi10Mg.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining center 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 1,312 SFM (400 m/min).
- f .013 IPR (0,32 mm/rev).

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.
- Aluminum G-AlSi10Mg.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining center 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 400 m/min (1,312 SFM).
- f 0,32 mm/rev (.013 IPR).

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.
- Aluminum G-AlSi7Mg.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining center HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with HSK63A interface and internal coolant.
- Four effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 2,625 SFM (800 m/min).
- f .013 IPR (0,32 mm/rev).

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.
- Aluminum G-AlSi7Mg.
- Pre drilled hole with 0,5mm depth of cut.
- Machining center 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 1,312 SFM (400 m/min).
- f .012 IPR (0,30 mm/rev).

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 Ø 17,984 and 66,037mm.
- Tolerance range 8 and 20 µm.
- Aluminum GD-AlSi7.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining center 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.
- Aluminum G-AlSi10Mg.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining center HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with HSK63A interface and internal coolant.
- Four effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 4,921 SFM (1,500 m/min).
- f .002 IPR (0,06 mm/rev).

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.
- Aluminum G-AlSi10Mg.
- Pre-drilled hole with 0,5mm depth of cut.
- Machining center HSK63A with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with HSK63A interface and internal coolant.
- Four effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 4,921 SFM (1,500 m/min).
- f .002 IPR (0,06 mm/rev).

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 1.575 and 2.165" (40 and 55mm).
- Tolerance range 30 µm R7.
- Aluminum GD-AlSi10Mg.
- Fine boring two diameters with one tool.
- Machining center 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 .024 IPR (0,60 mm/rev).

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 .827 and .945" (21 and 24mm).
- Tolerance range 13 and 33 µm.
- Aluminum AlSi9Cu3.
- Pre drilled hole with 0,5mm depth of cut.
- Machining center 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 .311" (7,9mm).
- Tolerance range 22 µm H8.
- Aluminum AlSi9Cu3.
- Combine drilling, back chamfering, and facing.
- Machining center 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 1,148 SFM (350 m/min).
- f .008 IPR (0,20 mm/rev).

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.
- Aluminum GD-AlSi9Cu3.
- Pre-casted hole with 0,3mm depth of cut.
- Machining center 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

- n = 2800 RPM vc 89–162 m/min.
- f .015 IPR (0,4 mm/rev).

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.
- Aluminum AlSi10Mg.
- Casted face with 2,5mm depth of cut.
- Machining center 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 3,294 SFM (1,005 m/min).
- f .002 IPR (0,06 mm/rev).

RESULT

- **Tool life of 3,000 min.**
- **Surface finish Ra 0.3 µm.**

BENEFIT

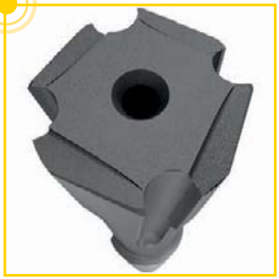
- **Very low bur formation.**



Planetary Gear Carrier







Chip control geometry

RMS™ MULTI-FLUTE REAMING

CHALLENGE

- Bearing bores Ø .346" (8,8mm).
- Tolerance range 9 µm M6.
- Steel 42CrMo4 and 31CrMoV9.
- Increase tool life with long chipping material.
- Machining center 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 230 SFM (70 m/min).
- f .012 IPR (0,30 mm/rev).

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 center with internal coolant.

SOLUTION

- Romicron™ standard AVS heads.
- CCMT06020411 KT315™ cermet insert.

CUTTING DATA

- vc 230 SFM (290 m/min).
- f .012 IPR (0,10 mm/rev).

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 1.772" (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 344 SFM (105 m/min).
- f .002 IPR (0,06 mm/rev).

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 center
- 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 .472" (12mm).
- Tolerance range 30 µm.
- Cast iron.
- Machining center HSK63A with internal coolant.

SOLUTION

- UpSharp engineered-solution solid carbide reamer with six cutting edges.
- TICN coated carbide.

CUTTING DATA

- vc 246 SFM (75 m/min).
- f .031 IPR (0,8 mm/rev).

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 2.127" (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 262 SFM (80 m/min).
- f .016 IPR (0,40 mm/rev).

RESULT

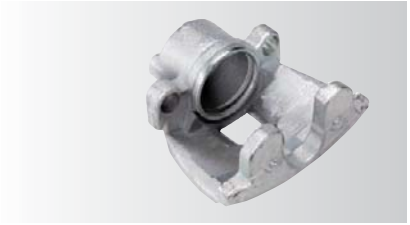
- **Tool life of 16,000 bores per insert.**
- **Surface finish better than Ra 1.6 µm.**

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 1.654" (42mm).
- Tolerance range 8 µm.
- Aluminum.
- Varying depth of cut between 1–2mm.
- Machining center with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with HSK63A interface and internal coolant.
- Four effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 1,640 SFM (500 m/min).
- f .039 IPR (1 mm/rev).

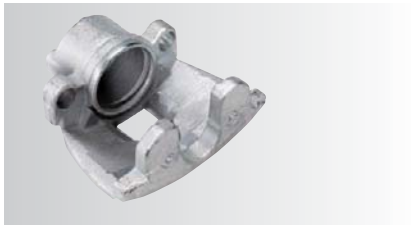
RESULT

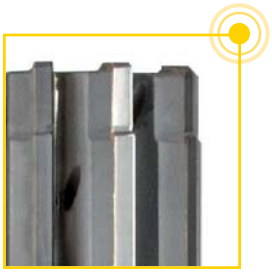
- **Tool life of 400,000–600,000 bores.**
- **Surface finish better than Ra 1.6 µm.**

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 center with internal coolant.



SOLUTION

- RMB engineered-solution carbide tipped reamer with 10 teeth and internal coolant supply.
- KC6305™ TiAlN coated carbide.

CUTTING DATA

- vc 230 SFM (70 m/min).
- f .130 IPR (3,30 mm/rev).

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 1.001" (25,431mm).
- Tolerance range 10 µm.
- Ductile cast iron.
- Replace honing process with reaming.
- Machining center 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 394 SFM (120 m/min).
- f .008 IPR (0,20 mm/rev).

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 3.228" (82mm).
- Replace setup of padded reamer and cover various diameters with one tool.
- Machining center with internal coolant.

SOLUTION

- Romicron™ engineered solution. HSK80ASVSB156M SVS4B head.
- CPMT 060204 FW KCK20™.

CUTTING DATA

- vc 1,312 SFM (400 m/min).
- f .008 IPR (0,20 mm/rev).

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 .728–.906" (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 105 SFM (32 m/min).
- f .005 IPR (0,133 mm/rev).

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 .787" (20mm).
- Tolerance range 21 µm H7.
- Aluminum AlSi9Cu3.
- 220mm overhang due to workpiece fixture.
- Machining center with internal coolant.

SOLUTION

- PCD-tipped, steel-based tool with HSK63A interface and internal coolant.
- Four effective cutting teeth.
- KD1415™.

CUTTING DATA

- vc 410 SFM (125 m/min).
- f .003 IPR (0,70 mm/rev).

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 .472" (12mm).
- Tolerance range 18 µm H7.
- Ductile cast iron.
- Machining center with internal coolant

SOLUTION

- RMS standard reamer with six effective cutting edges and internal coolant.
- KC6305™ TiAlN coated carbide.

CUTTING DATA

- vc 20 m/min (66 SFM).
- f 0,30 mm/rev (.012 IPR).

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 .925" (23,5mm).
- Tolerance range 18 µm.
- Aluminum 12% Si.
- Machining center BT40 with external coolant.

SOLUTION

- Standard SVUBB2 head with KR coupling.
- Standard steel boring bar.
- CPGW060204FST KD1400™.

CUTTING DATA

- vc 1,204 SFM (367 m/min).
- f .003 IPR (0,07 mm/rev).

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 .472–1.220" (12–31mm).
- Tolerance range 50 µm.
- Aluminum G-AlSi12.
- Machining center 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 1,444 SFM (440 m/min).
- f .008 IPR (0,20 mm/rev).

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 1.220" (23,5mm).
- Tolerance range 10 µm.
- Cast iron GGG60.
- Machining center HSK63 with internal coolant.

SOLUTION

- RHM modular reamer with six cutting edges.
- KT325™ uncoated cermet.
- Standard lead geometry.
- SIF™ steerable tooling.

CUTTING DATA

- vc 410 SFM (125 m/min).
- f .030 IPR (0,75 mm/rev).

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 .728" (18,5mm).
- Tolerance range 10 µm.
- Cast iron.
- Up to 4mm varying depth of cut.
- Machining center 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 230 SFM (70 m/min).
- f .005 IPR (0,125 mm/rev).

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 .375" (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 492 SFM (150 m/min).
- f .028 IPR (0,72 mm/rev).

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 .945" (24mm).
- Tolerance range 21 µm F7.
- Aluminum AlSi9Cu3.
- Pre-drilled hole.
- Machining center 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 .008 IPR (0,20 mm/rev).

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.
- Aluminum AlSi1.
- Pre-casted hole with 0,15mm depth of cut.
- Machining center 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 984 SFM (300 m/min).
- f .014 IPR (0,35 mm/rev).

RESULT

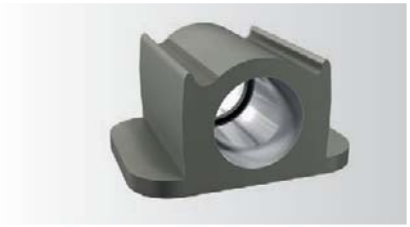
- **Surface finish Ra 0.4–0.6 µm.**

BENEFIT

- **Very stable process control and predictable performance.**
- **Very favorable chip creation.**



Bearing Seat





KST pre-loaded taper face contact interface



RHM™ MODULAR REAMING

CHALLENGE

- Reaming Ø 1.378" (35mm).
- Tolerance range 20 µm.
- Carbon steel, annealed, long-chipping.
- Blind hole limiting chip evacuation.
- Machining center 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 394 SFM	(120 m/min).
• f .046 IPR	(1,18 mm/rev).

RESULT

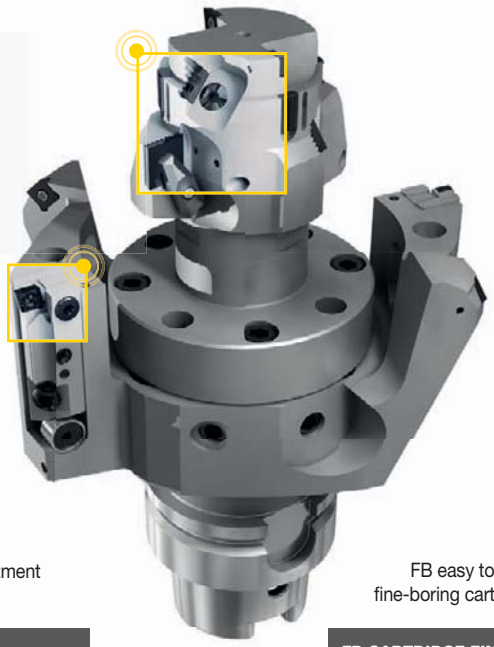
- **Tool life of 145,000 holes.**
- **Surface finish better than Rz 6.3 µm.**

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 1.850" (47mm).
- Tolerance range 19 µm N6.
- Aluminum 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 774 SFM (236 m/min).
- f .003 IPR (R0,08 mm/rev).

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 5.669" (144mm).
- Tolerance range 40 µm H7.
- Aluminum AlSi9Cu3.
- Machine two different diameters.

SOLUTION

- Standard FB fine-boring cartridges with almost backlash-free fine adjustment.
- CCGW060204 KD1415™.

CUTTING DATA

- vc 2,372 SFM (723 m/min).
- f .003 IPR (0,08 mm/rev).

RESULT

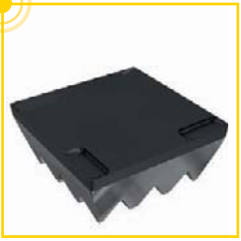
- **Surface finish better than Rz 16 µm.**

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 .728" (18,5mm).
- Tolerance range 21 µm H7.
- Aluminum.
- Heavy interrupted cut and surface finish Rz 6.3.
- Machining center 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 755 SFM (230 m/min).
- f .006 IPR (0,15 mm/rev).

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 6.7–18.9" (170–480mm).
- Tolerance range 75 µm.
- Cast iron GG25.
- Automated wear compensation at interrupted cut.
- Machining center 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 2,625 SFM (800 m/min).
- f .005 IPR (0,12 mm/rev).

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 49.6–55.1" (1260–1400mm).
- Tolerance range 125 µm H7.
- Cast iron GGG40.
- One base bridge for multiple diameters.
- Machining center without coolant.

SOLUTION

- Romicron standard modular MF40 element with engineered-solution aluminum bridge.
- CPGT060204/08HP KC5410™.

CUTTING DATA

- vc 650 SFM (200 m/min).
- f .005 IPR (0,12 mm/rev).

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 .512" (13mm).
- Tolerance range 6 µm.
- Steel 42CrMo4 (4140).
- Machining center with internal coolant.

SOLUTION

- Romicron standard HSK63ASVUBB1095MCLB head with engineered solution pin boring bar.
- TCMT110202FP KTP10™.

CUTTING DATA

- vc 525 SFM (160 m/min).
- f .004 IPR (0,1 mm/rev).

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 Authorized Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

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Tapping

Taps Introduction L2–L19

Spiral-Point/Left-Hand Spiral-Flute Taps M2–M41

Spiral-Flute Taps M42–M104

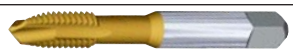
Straight-Flute Taps M106–M134

Forming Taps M136–M148

Pipe Taps M150–M158

Solid Carbide Thread Mills M160–M177

Technical Information M178–M216

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	ANSI 302A	●	●	○	○		
	**T620**	KP6525	DIN 371, 376	●	○	○			
	T620	KP6525	DIN 371, 376	●	○	○			
	**T621**	KP6525	DIN 371, 376	●	○	○			
	**T620**	KP6525, KM6515	ANSI 302A	●	●	○	○		
	**T620**	KP6525, KM6515	DIN 371, 374, 376	●	●	○	○		
	**T621**	KP6525, KM6515	DIN 371, 374, 376	●	●	○	○		
	**T620**	KP6525	DIN 376	●		●			
	**T620**	KP6525	XL	●		●			
	**T690**	KSP27, KSS29	ANSI 302A					●	
	**T690**	KSP27, KSS29	ANSI 302A					●	
	**T660**	KSSM24, KSS20	ANSI 302A					●	
	**T660**	KSSM24, KSS20	ANSI 302A					●	
	**T672**	KSMN34	DIN/ANSI				●		
	T672	KSMN34	DIN/ANSI				●		
	**T600**	KSP21	DIN 371, 374, 376	●				○	
	**T820**	KSP32, KSMN24, KSP39	ANSI 302A	●	●	●	●		
	**T820**	KSP39	DIN 371, 376	○	○	○			
	**T822**	KSP32, KSMN24, KSP39	ANSI 302A	●	●	●	●		
	T820	KSP32, KSMN24, KSP39	ANSI 302A	●	●	●	●		
	T822	KSP32, KSMN24, KSP39	ANSI 302A	●	●	●	●		
	**T820**	KSP32, KSP39	DIN 371, 374, 376	●	○	●	○		
	**T820**	KSU31, KSU30	JIS	●	○	○	○		
	**T820**	KSP39	Extend 4"	○	○	○			
	T820	KSP39	Extend 6"	○	○	○			
	**KHSST Spiral Point**	TiCN, TiN, oxide, uncoated	ANSI 302	●	●	●	●	●	
	**KHSST Spiral Point Oversized PD**	uncoated	ANSI 302	●	○	○	○		
	**KHSST Spiral Point Extended Length**	uncoated	Extend 6"	●	○	○	○		
	**KHSST Spiral Point Heavy Duty**	oxide/nitride	ANSI 302	●	○	○	○		
	**KHSST Spiral Point Bottoming**	uncoated	ANSI 302	●	○	○	○		
	**KHSST Spiral Point**	TiN, uncoated	ANSI 302	●	○	○	●		

	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	M178
	M6–M16	●		plug	D	L15°	●		M4	M178
	M10–M16	●		plug	D	L15°		●	M5	M178
	#2–3/4"	●		plug	D	L15°	●		M6–M7	M179–M180
	#6–1/2"	●		plug	D	L15°	●		M8	M179–M180
	#6–1/2"	●		plug	D	L15°	●		M8	M179–M180
	1/4–1/2"	●		plug	D	L15°		●	M9	M179–M180
	M3–M12	●		plug	D	L15°	●		M10	M179–M180
	M3–M20	●		plug	D	L15°	●		M11	M179–M180
	M5–M18	●		plug	D	L15°		●	M12	M179–M180
	M24–M42	●		plug	D	L15°	●		M13	M179–M180
	M24–M42	●		plug	D	L15°		●	M14	M179–M180
	#2–3/4"	●		plug	D	L15°	●		M15–16	M179–M180
	M2,5–M12	●		plug	D	L15°	●		M17	M179–M180
	#2–1"	●		plug	D	L15°	●		M18	M179–M180
	M2,5–M12	●		plug	D	L15°	●		M19	M179–M180
	#2–1/2"	●		plug	D	L15°	●		M20	M179–M180
	M3–M12	●		plug	D	L15°	●		M21	M179–M180
	M3–M20	●		plug	B	0°	●		M22	M179–M180
	#2–1 1/4"	●		plug	B	0°	●		M23–M25	M181–M182
	#4–1"	●		plug	B	0°	●		M26–M27	M181–M182
	#5–#12	●		plug	B	0°	●		M28	M181–M182
	M3–M16	●		plug	B	0°	●		M29	M181–M182
	M3–M5	●		plug	B	0°	●		M30	M181–M182
	M2–M36	●		plug	B	0°	●		M31–M32	M181–M182
	M3–M20	●		plug	B	0°	●		M33	M181–M182
	#4–1/4"	●		plug	B	0°	●		M34	M181–M182
	#4–5/8"	●		plug	B	0°	●		M35	M181–M182
	#0–3/4"	●		plug	–	0°	●		M36	M183
	1/4–1/2"	●		plug	–	0°	●		M37	M183
	#6–3/8"	●		plug	–	0°	●		M38	M183
	#6–3/4"	●		plug	–	0°	●		M39	M183
	#0–5/16"		●	bottoming	–	0°	●		M40	M183
	M1,6–M20	●		plug	–	0°	●		M41	M183

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	ANSI 302A	●	●	○	○		
	T630	KP6525	DIN 371, 376	●	○	○			
	T630	KP6525	DIN 371, 376	●	○	○			
	T631	KP6525	DIN 371, 376	●	○	○			
	T630	KP6525, KM6515	ANSI 302A	●	●	○	○		
	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	●		●			
	T692	KSP27, KSS29	ANSI 302A					●	
	T692	KSP27, KSS29	ANSI 302A					●	
	T694	KSP27, KSS29	ANSI 302A					●	
	T662	KSSM24, KSS20	ANSI 302A					●	
	T662	KSSM24, KSS20	ANSI 302A					●	
	T682	KSMN34	DIN/ANSI				●		
	T682	KSMN34	DIN/ANSI				●		
	T686	KSMN34	DIN/ANSI				●		
	T686	KSMN34	DIN/ANSI				●		
	T604	KSH26	DIN 371, 374, 376	●				○	

	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°		●	M44	M178
	M6–M16		●	semi-bottoming	C	45°		●	M45	M178
	#2–1”		●	semi-bottoming	C	45°	●		M46	M179–M180
	#6–1/2”		●	semi-bottoming	C	45°	●		M47	M179–M180
	#6–1/2”		●	semi-bottoming	C	45°	●		M47	M179–M180
	1/4–1/2”		●	semi-bottoming	C	45°		●	M48	M179–M180
	M3–M16		●	semi-bottoming	C	45°	●		M49	M179–M180
	M3–M20		●	semi-bottoming	C	45°	●		M50	M179–M180
	M5–M18		●	semi-bottoming	C	45°		●	M51	M179–M180
	M5–M16		●	bottoming	E	45°	●		M52	M179–M180
	M5–M16		●	bottoming	E	45°		●	M53	M179–M180
	M24–M42		●	semi-bottoming	C	45°	●		M54	M179–M180
	M24–M42		●	semi-bottoming	C	45°		●	M55	M179–M180
	M24–M42		●	semi-bottoming	C	45°	●		M56	M179–M180
	M24–M42		●	semi-bottoming	C	45°		●	M57	M179–M180
	M24–M42		●	semi-bottoming	C	15°	●		M58	M179–M180
	M24–M42		●	semi-bottoming	C	15°		●	M59	M179–M180
	M24–M42		●	semi-bottoming	C	15°	●		M60	M179–M180
	M24–M42		●	semi-bottoming	C	15°		●	M61	M179–M180
	#2–3/4”		●	3-4 pitches	–	10°	●		M62–M63	M179–M180
	M2,5–M12		●	3-4 pitches	–	10°	●		M64	M179–M180
	#4–5/8”		●	bottoming	E	10°	●		M65	M179–M180
	#2–1”		●	semi-bottoming	C	10°	●		M66–M67	M179–M180
	M2,5–M12		●	semi-bottoming	C	10°	●		M68	M179–M180
	#2–1/2”		●	semi-bottoming	C	45°	●		M69	M179–M180
	M3–M12		●	semi-bottoming	C	45°	●		M70	M179–M180
	#2–1/2”		●	semi-bottoming	C	25°	●		M71	M179–M180
	M3–M12		●	semi-bottoming	C	25°	●		M72	M179–M180
	M3–M20		●	semi-bottoming	C	42°	●		M73	M179–M180

(continued)

(Spiral-Flute Taps Selection Guide — continued)

Spiral-Flute Taps	series	grade/coating	shank/dimension	● first choice ○ alternate choice P	M	K	N	S	H
	**T830**	KSP32, KSMN24, KSP39	ANSI 302A	●	●	●	●		
	**T832**	KSP39	ANSI 302A	○	○	○			
	**T838**	KSP32, KSP39	ANSI 302A	●	○	●	○		
	**T839**	KSP39	ANSI 302A	○	○	○			
	**T830**	KSP39	DIN 371, 376	○	○	○			
	**T838**	KSU31, KSP39	DIN 371, 374, 376	●	○	○	○		
	**T830**	KSP32, KSMN24, KSP39	ANSI 302A	●	●	●	●		
	**T832**	KSP39	ANSI 302A	○	○	○			
	**T838**	KSP32, KSP39	ANSI 302A	●	○	●	○		
	**T839**	KSP39	ANSI 302A	○	○	○			
	**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**	KSU31, KSU30	JIS	●	○	○	○		
	**T830**	KSP39	Extend 4"	○	○	○			
	T830	KSP39	Extend 6"	○	○	○			
	T832	KSP39	Extend 6"	○	○	○			
	**KHSST Spiral Flute**	TiN, uncoated	ANSI 302A	●	○	○	●		
	KHSST Spiral Flute	TiCN, TiN, uncoated	ANSI 302A	●	○	○	●		
	**KHSST Spiral Flute Heavy Duty**	Oxide	ANSI 302A	●	○	○			

	size range min-max	hole		chamfer		helix angle	coolant		page(s)	recommended cutting parameters
		through	blind	type	form		flood	through		
	#2–1 1/8"		●	semi-bottoming	C	45°	●		M74–M76	M181–M182
	#4–3/4"		●	bottoming	E	45°	●		M77–M78	M181–M182
	#2–1 1/8"		●	semi-bottoming	C	45°	●		M79–M81	M181–M182
	#4–3/4"		●	bottoming	E	45°	●		M82–M83	M181–M182
	#4–1"		●	semi-bottoming	C	45°	●		M84, M87	M181–M182
	#6–2"		●	semi-bottoming	C	45°	●		M85–M86	M181–M182
	M3–M18		●	semi-bottoming	C	45°	●		M88	M181–M182
	M3–M18		●	bottoming	E	45°	●		M89	M181–M182
	M3–M18		●	semi-bottoming	C	45°	●		M90	M181–M182
	M3–M18		●	bottoming	E	45°	●		M91	M181–M182
	M2–M36		●	semi-bottoming	C	45°	●		M92–M93	M181–M182
	M3–M20		●	bottoming	E	45°	●		M94	M181–M182
	M2–M52		●	semi-bottoming	C	45°	●		M95–M96	M181–M182
	M3–M20		●	bottoming	E	45°	●		M97	M181–M182
	M3–M20		●	semi-bottoming	C	45°	●		M98	M181–M182
	#4–1/4"		●	semi-bottoming	C	45°	●		M99	M181–M182
	#4–5/8"		●	semi-bottoming	C	45°	●		M100	M181–M182
	#4–7/16"		●	bottoming	E	45°	●		M101	M181–M182
	#4–3/4"		●	bottoming	–	45°	●		M102	M183
	M3–M10		●	bottoming	–	45°	●		M103	M183
	#6–3/4"		●	plug	–	45°	●		M104	M183

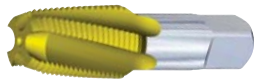
Straight-Flute Taps	series	grade/coating	shank/dimension	● first choice ○ alternate choice P	M	K	N	S	H
	**T340**	KCK17	6535 HA	○		●			
	T340	KCK17	6535 HA	○		●			
	**T351**	KCK17	6535 HA	○		●			
	T351	KCK17	6535 HA	○		●			
	**T351**	KCK17	DIN 371, 374, 376	○		●			
	**T353**	KCK17	DIN 371, 376	○		●			
	**T471**	KCN14	6535 HA				●		
	**T471**	KCN14	DIN 371				●		
	**T410**	KCU36	DIN 371, 374, 376						●
	**T640**	KP6525	ANSI 302A			●	●		
	**T640**	KP6525	DIN 371, 376			●	●		
	T640	KP6525	DIN 371, 376			●	●		
	**T641**	KP6525	DIN 371, 376			●	●		
	**T640**	KP6525	DIN 371, 376			●	●		
	**T641**	KP6525	DIN 371, 376			●	●		
	**T642**	KP6525	DIN 371, 374, 376			●	●		
	**T643**	KP6525	DIN 371, 374, 376			●	●		
	**KHSST Hand Plug**	TiCN, TiN, oxide, uncoated	ANSI 302	●	●	●	●	●	
	**KHSST Hand Bottoming**	TiCN, TiN, oxide, uncoated	ANSI 302	●	●	●	●	●	
	**KHSST Hand Plug**	TiN, uncoated	ANSI 302	●	○	○	●		
	**KHSST Hand Bottoming**	uncoated	ANSI 302	●	○	○	●		
	**KHSST Hand Left Hand Plug**	uncoated	ANSI 302	●	○	○	○		
	KHSST Hand Ext. Length Plug	uncoated	Extend 6"	●	○	○	○		
	KHSST Hand Ext. Length Bottoming	uncoated	Extend 6"	●	○	○	○		

* 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°	●		M108	M178
	M4–M20	●		plug	D	0°	●		M109	M178
	#6*–3/4"		●	bottoming	E	0°		●	M110	M178
	M4*–M16		●	bottoming	E	0°		●	M111	M178
	M6–M14		●	bottoming	E	0°		●	M112	M178
	M4*–M14		●	semi-bottoming	C	0°		●	M113	M178
	M6–M14		●	bottoming	E	0°		●	M114	M178
	M6–M10		●	bottoming	E	0°		●	M115	M178
	M3–M16		●	semi-bottoming	C	0°	●		M116	M178
	#10–3/4"	●	●	semi-bottoming	C	0°	●		M117	M179–M180
	#6–1/2"	●	●	semi-bottoming	C	0°	●		M118	M179–M180
	#6–1/2"	●	●	semi-bottoming	C	0°	●		M118	M179–M180
	1/4–1/2"		●	semi-bottoming	C	0°		●	M119	M179–M180
	M4–M22	●	●	semi-bottoming	C	0°	●		M120	M179–M180
	M5–M20		●	semi-bottoming	C	0°		●	M121	M179–M180
	M5–M16	●	●	bottoming	E	0°	●		M122	M179–M180
	M5–M16		●	bottoming	E	0°		●	M123	M179–M180
	#0–1 1/2"	●		plug	–	0°	●		M124–M126	M183
	#0–1 1/2"		●	bottoming	–	0°	●		M127–M129	M183
	M1,6–M36	●		plug	–	0°	●		M130	M183
	M2–M24		●	bottoming	–	0°	●		M131	M183
	1/4–3/4"	●		plug	–	0°	●		M132	M183
	#6–3/8"	●		plug	–	0°	●		M133	M183
	#10–3/8"		●	bottoming	–	0°	●		M134	M183

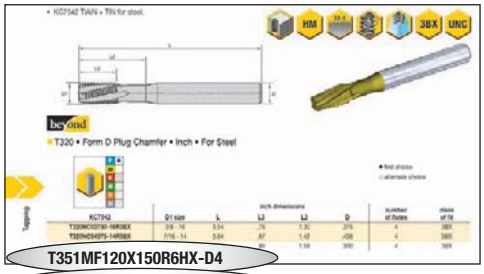
Forming Taps	series	grade/coating	shank/dimension	● first choice ○ alternate choice						
				P	M	K	N	S	H	
	**T491**	KCN14	6535 HA				●			
	**T491**	KCN14	DIN 2174				●			
	**T622**	KSP21, KSN28	DIN 2174	●			●			
	**T623**	KSP21, KSN28	DIN 2174	●			●			
	**T624**	KSP27	DIN/ANSI	●	○					
	**T625**	KSP27	DIN/ANSI	●	○					
	**T626**	KSP27	DIN/ANSI	●	○					
	**T627**	KSP27	DIN/ANSI	●	○					
	**T624**	KSP27	DIN/ANSI	●	○					
	**T625**	KSP27	DIN/ANSI	●	○					
	**T626**	KSP27	DIN/ANSI	●	○					
	**T627**	KSP27	DIN/ANSI	●	○					

	size range min-max	hole		chamfer		helix angle	coolant		page(s)	recommended cutting parameters
		through	blind	type	form		flood	through		
	M5–M12		●	bottoming	E	–		●	M138	M178
	M6–M10		●	bottoming	E	–		●	M138	M178
	M3–M16	●	●	semi-bottoming	C	–	●		M139	M179–M180
	M5–M16		●	semi-bottoming	C	–		●	M140	M179–M180
	#6–3/4"	●	●	semi-bottoming	C	–	●		M141	M179–M180
	1/4–3/4"		●	semi-bottoming	C	–		●	M142	M179–M180
	#2–3/4"		●	bottoming	E	–	●		M143	M179–M180
	1/4–3/4"		●	bottoming	E	–		●	M144	M179–M180
	M3–M16	●	●	semi-bottoming	C	–	●		M145	M179–M180
	M6–M16		●	semi-bottoming	C	–		●	M146	M179–M180
	M3–M16		●	bottoming	E	–	●		M147	M179–M180
	M6–M16		●	bottoming	E	–		●	M148	M179–M180

Pipe Taps	series	grade/coating	shank/dimension	● first choice ○ alternate choice P	M	K	N	S	H	
	**T854**	KSU31, KSP39	ANSI	●	○	○	○			
	**T846**	KSU30	ANSI	○		○				
	**T877**	KSU31, KSP39	DIN 5156	●	○	○	○			
	**T857**	KSU31, KSP39	DIN 5156	●	○	○	○			
	**T848**	KSU30	DIN 5156	○		○				
	**KHSST Taper Pipe**	TiN, uncoated	ANSI	●	○	○	●			
	**KHSST Straight Pipe**	uncoated	ANSI	●	○	○	○			

	size range min-max	hole		chamfer		helix angle	coolant		page(s)	recommended cutting parameters
		through	blind	type	form		flood	through		
	1/16–1"	●	●	standard	–	15°	●		M152	M181–M182
	1/8–3/4"	●	●	standard	–	0°	●		M153	M181–M182
	1/8–1"	●		plug	B	0°	●		M154	M181–M182
	1/8–1"		●	semi-bottoming	C	42°	●		M155	M181–M182
	1/16–1"	●	●	semi-bottoming	C	0°	●		M156	M181–M182
	1/16–2"	●	●	standard	–	0°	●		M157	M183
	1/8–1"	●	●	standard	–	0°	●		M158	M183

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)			

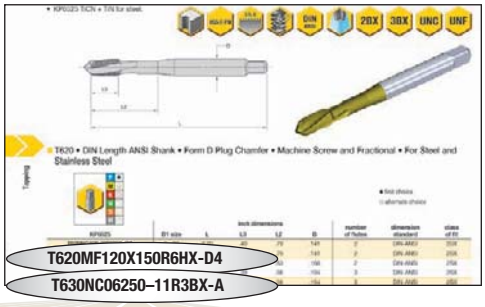
M = Metric coarse-pitch thread (ISO form)
MF = Metric fine-pitch thread (ISO form)
NC = Unified coarse series thread
NF = Unified fine series thread

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 aluminum, through holes, straight flute, solid
T351 = Cast iron and cast aluminum, blind holes, straight flute, through coolant
T353 = Cast iron and cast aluminum, blind holes, straight flute, through coolant
T410 = Hard steel 55–63 HRC, through and blind holes, straight flute, solid
T471 = Aluminum, blind holes, straight flute, through coolant
T491 = Aluminum, blind holes, forming tap, through coolant

HSS-E-PM Tap Identification System



Metric	**T620**	**MF**	**120**	**X**	**150**	**R**	**6HX**	**-D4**
Inch	**T630**	**NC**	**06250**	**–**	**11**	**R**	**3BX**	**-A**
	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)			

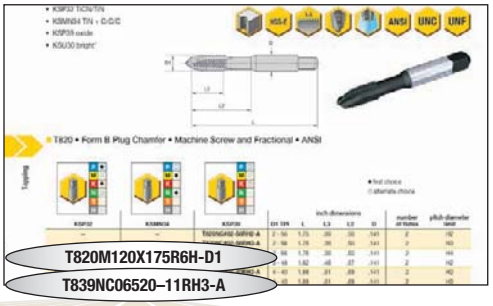
M = Metric coarse-pitch thread (ISO form)
MF = Metric fine-pitch thread (ISO form)
NC = Unified coarse series thread
NF = Unified fine series thread

A = ANSI
DA = DIN length and ANSI shank
D1 = DIN 371
D4 = DIN 374
D6 = DIN 376
D74 = DIN 2174
XL = DIN extra length

Tap design

T620 = Steel and stainless steel, through holes, LH spiral flute, solid
T621 = Steel and stainless steel, through holes, LH spiral flute, through coolant
T624 = Steel and stainless steel, blind and through holes, forming tap, solid
T625 = Steel and stainless steel, blind holes, forming tap, through coolant
T626 = Steel and stainless steel, blind holes, forming tap, solid
T627 = Steel and stainless steel, 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 aluminum, through and blind holes, straight flute, solid
T641 = Cast iron and cast aluminum, blind holes, straight flute, through coolant
T642 = Cast iron and cast aluminum, blind holes, straight flute, solid
T643 = Cast iron and cast aluminum, 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
T660 = Titanium and titanium alloys, through holes, LH spiral flute, solid
T662 = Titanium and titanium alloys, blind holes, RH spiral flute, solid
T672 = Wrought and cast aluminum, through holes, LH spiral flutes, solid
T682 = Wrought aluminum, blind holes, RH 45° spiral flutes, solid
T686 = Cast aluminum, blind holes, RH 25° spiral flutes, solid
T690 = Nickel and cobalt based alloys, through holes, LH spiral flute, solid
T692 = Nickel and cobalt based alloys, blind holes, RH spiral flute, 3–4 pitches chamfer, solid
T694 = Nickel and cobalt based alloys, blind holes, RH spiral flute, bottoming, solid

GOtap HSS-E Tap Identification System



Metric

T820	M	120	X	175	R	6H	-D1

Inch

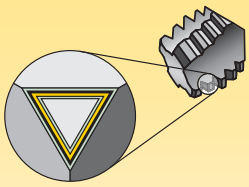
T839	NC	06520	–	11	R	H3	-A
Tap Design	Type of Thread	Nominal Diameter of Thread		Pitch	Cutting Direction	Tolerance Class	Taps Dimension
		mm or inch (depending on type)		mm or TPI (depending on type)			

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

A = ANSI
AS = ANSI Small Shank
D1 = DIN 371
D4 = DIN 374
D6 = DIN 376
D56 = DIN 5156
J = JIS

Tap design

T820 = Steel, stainless steel, ductile iron, and cast aluminum, through holes, spiral point, solid
T822 = Steel, stainless steel, ductile iron, and cast aluminum, through holes, spiral point, 3 flute small tap, solid
T830 = Steel, stainless steel, ductile iron, and cast aluminum, blind holes, spiral flute, semi-bottoming, solid
T832 = Steel, stainless steel, ductile iron, and cast aluminum, blind holes, spiral flute, bottoming, solid
T838 = Steel, stainless steel, ductile iron, and cast aluminum, blind holes, spiral flute, TC, semi-bottoming, solid
T839 = Steel, stainless steel, ductile iron, and cast aluminum, blind holes, spiral flute, TC, bottoming, solid
T846 = Mold steels, NPT, straight flute, solid
T848 = Steel, stainless steel, ductile iron, and cast aluminum, straight flute, NPT, NPTF, solid
T854 = Steel, stainless steel, ductile iron, and cast aluminum, spiral flute, NPT, NPTF, solid
T857 = Steel, stainless steel, ductile iron, and cast aluminum, spiral flute, G, solid
T877 = Steel, stainless steel, ductile iron, and cast aluminum, spiral point, G, solid



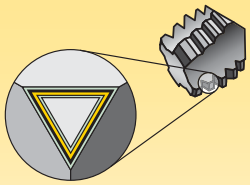
Coatings are designed for optimized tapping performance in specific materials.

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
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 aluminum 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						■	■	■	

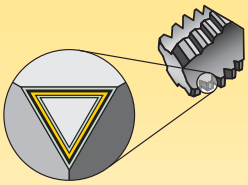


Coatings are designed for optimized tapping performance in specific materials.

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

Grade

Coating	Grade Description	wear resistance ← → toughness	05	10	15	20	25	30	35	40	45
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 aluminum 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					■	■	■		
KSS20	Surface treated HSS-E-PM: powder metal HSS-E-PM substrate with nitride surface treatment that provides wear resistance in non-ferrous materials including titanium. Use for tapping titanium and titanium alloys.	S								■	■
KSSM24	Coated HSS-E-PM, PVD: heat- and wear-resistant high- vanadium, high-cobalt powder metal HSS-E-PM substrate. Coating consists of low friction CrC/C over wear-resistant TiN base layer. Use for tapping titanium and titanium alloys.	S					■	■	■		
KSP27	Coated HSS-E-PM, PVD high vanadium cobalt powder metal HSS substrate coated with heat and wear-resistant multilayer AlCrTiN. Use in cobalt- or nickel-based heat-resistant alloys and steel.	P				■	■	■			
		S				■	■	■			
KSS29	Surface treated HSS-E-PM powder metal HSS-E substrate with oxide/nitride surface treatment that provides wear resistance in nickel alloys.	S							■	■	■



Coatings are designed for optimized tapping performance in specific materials.

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

Grade

Coating	Grade Description	wear resistance ← → toughness	05	10	15	20	25	30	35	40	45
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 aluminum. KSP32 is abrasion resistant.	P							■	■	■
		M							■	■	■
		K							■	■	■
		N							■	■	■
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 aluminum.	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–M41

Beyond High-Performance Solid Carbide Taps M4–M5

High-Performance HSS-E-PM Taps M6–M22

Multipurpose GOtap M23–M35

General-Purpose Taps M36–M41

Spiral-Flute Taps M42–M104

Beyond High-Performance Solid Carbide Taps M44–M45

High-Performance HSS-E-PM Taps M46–M73

Multipurpose GOtap M74–M101

General-Purpose Taps M102–M104

Straight-Flute Taps M106–M134

Beyond High-Performance Solid Carbide Taps M108–M116

High-Performance HSS-E-PM Taps M117–M123

General-Purpose Taps M124–M134

Forming Taps M136–M148

Beyond High-Performance Solid Carbide Taps M138

High-Performance HSS-E-PM Taps M139–M148

Pipe Taps M150–M158

Multipurpose GOtap M152–M156

General-Purpose Taps M157–M158

Solid Carbide Thread Mills M160–M177

Taps and Thread Milling Application and Technical Information M178–M216

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.
- Aluminum.
- 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

- Optimized 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.

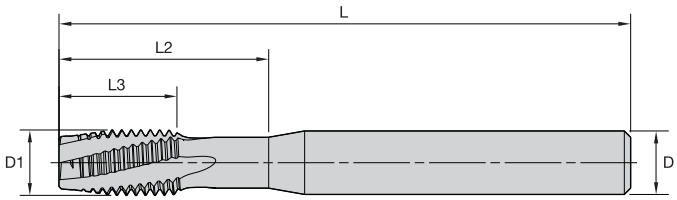


General-Purpose Taps

- High-quality spiral-point HSS taps for reliable, consistent performance.
- Wide range of sizes and pitch limits offered with PVD coatings and surface treatments.

• KC7542 TiAlN + TiN for steel.

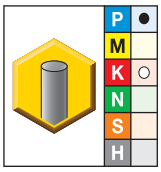






beyond

T320 • Form D Plug Chamfer • Inch • Solid Carbide • For Steel



● first choice
○ alternate choice

KC7542	inch dimensions 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

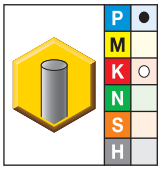
Shank Tolerance

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	metric dimensions 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

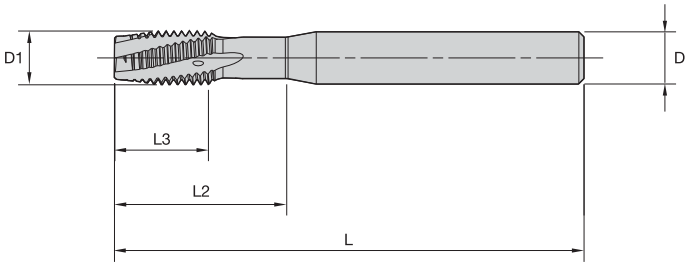
NOTE: Proprietary technology.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

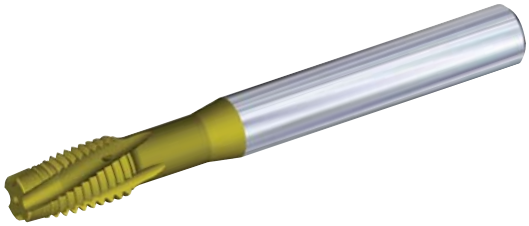
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

• KC7542 TiAlN + TiN for steel.

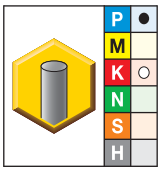






beyond

T321 • Form D Plug Chamfer • Through Coolant • Metric • Solid Carbide • For Steel



● first choice
○ alternate choice

KC7542	metric dimensions 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

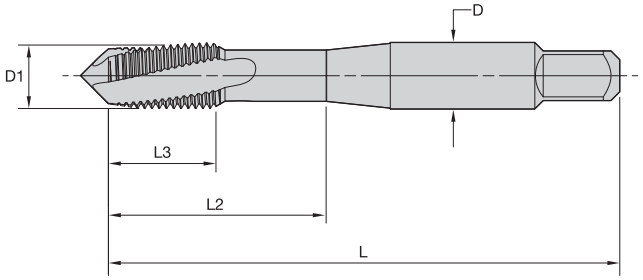
NOTE: Proprietary technology.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

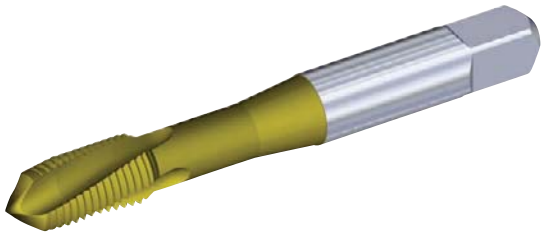
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

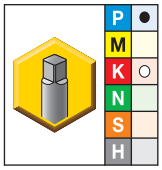
- KM6515 TiN + CrC/C for tapping stainless steel.
- KP6525 TiCN + TiN for tapping steel.

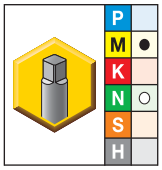






T620 • Machine Screw and Fractional • Form D Plug Chamfer • ANSI • For Steel and Stainless Steel



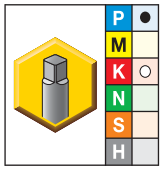


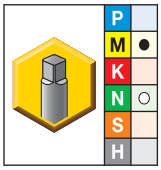
● first choice
○ alternate choice

KP6525	KM6515	inch dimensions D1 size	L	L3	L2	D	number of flutes	class of fit
T620NC#02-56R3BX-A *	T620NC#02-56R3BX-A	2 - 56	1.75	.44	.49	.141	2	3BX
T620NC#02-56R2BX-A *	T620NC#02-56R2BX-A *	2 - 56	1.75	.44	.49	.141	2	2BX
T620NC#04-40R3BX-A	T620NC#04-40R3BX-A *	4 - 40	1.88	.56	.68	.141	2	3BX
T620NC#04-40R2BX-A *	T620NC#04-40R2BX-A	4 - 40	1.88	.56	.68	.141	2	2BX
T620NC#05-40R3BX-A *	T620NC#05-40R3BX-A	5 - 40	1.94	.63	.75	.141	2	3BX
T620NC#06-32R3BX-A	T620NC#06-32R3BX-A	6 - 32	2.00	.36	.71	.141	2	3BX
T620NC#06-32R2BX-A	T620NC#06-32R2BX-A	6 - 32	2.00	.36	.71	.141	2	2BX
T620NC#08-32R3BX-A	T620NC#08-32R3BX-A *	8 - 32	2.13	.31	.76	.168	2	3BX
T620NC#08-32R2BX-A	T620NC#08-32R2BX-A	8 - 32	2.13	.31	.76	.168	2	2BX
T620NF#08-36R3BX-A	T620NF#08-36R3BX-A	8 - 36	2.13	.31	.76	.168	2	3BX
T620NC#10-24R3BX-A	T620NC#10-24R3BX-A	10 - 24	2.38	.47	.91	.194	3	3BX
T620NF#10-32R3BX-A	T620NF#10-32R3BX-A	10 - 32	2.36	.47	.91	.194	3	3BX
T620NF#10-32R2BX-A	T620NF#10-32R2BX-A	10 - 32	2.36	.47	.91	.194	3	2BX
T620NC#12-24R3BX-A *	T620NC#12-24R3BX-A *	12 - 24	2.37	.42	.96	.220	3	3BX
T620NC02500-20R3BX-A	T620NC02500-20R3BX-A	1/4 - 20	1.88	.44	1.01	.255	3	3BX
T620NC02500-20R2BX-A	T620NC02500-20R2BX-A	1/4 - 20	1.75	.44	1.01	.255	3	2BX
T620NF02500-28R3BX-A	T620NF02500-28R3BX-A	1/4 - 28	2.50	.44	1.00	.255	3	3BX
T620NF02500-28R2BX-A	T620NF02500-28R2BX-A	1/4 - 28	2.50	.44	1.00	.255	3	2BX
T620NC03125-18R3BX-A	T620NC03125-18R3BX-A	5/16 - 18	2.12	.49	1.13	.318	3	3BX
T620NC03125-18R2BX-A	T620NC03125-18R2BX-A	5/16 - 18	2.12	.49	1.01	.318	3	2BX
T620NF03125-24R3BX-A	T620NF03125-24R3BX-A	5/16 - 24	2.72	.49	1.13	.318	3	3BX
T620NC03750-16R3BX-A	T620NC03750-16R3BX-A	3/8 - 16	2.94	.60	1.27	.381	3	3BX
T620NC03750-16R2BX-A	T620NC03750-16R2BX-A	3/8 - 16	2.94	.60	1.27	.381	3	2BX
T620NF03750-24R3BX-A	T620NF03750-24R3BX-A *	3/8 - 24	2.94	.60	1.27	.381	3	3BX

(continued)

(T620 • Machine Screw and Fractional • Form D Plug Chamfer • ANSI • For Steel and Stainless Steel — continued)





● first choice
○ alternate choice

KP6525	KM6515	inch dimensions D1 size	L	L3	L2	D	number of flutes	class of fit
T620NC04375-14R3BX-A *	T620NC04375-14R3BX-A	7/16 - 14	3.16	.71	1.49	.323	3	3BX
T620NF04375-20R3BX-A	T620NF04375-20R3BX-A	7/16 - 20	3.16	.71	1.49	.323	3	3BX
T620NC05000-13R3BX-A	T620NC05000-13R3BX-A	1/2 - 13	3.38	.77	1.74	.367	3	3BX
T620NF05000-20R3BX-A	T620NF05000-20R3BX-A	1/2 - 20	3.38	.77	1.74	.367	3	3BX
T620NC06250-11R3BX-A	T620NC06250-11R3BX-A	5/8 - 11	3.81	.91	1.89	.480	4	3BX
T620NC07500-10R3BX-A	T620NC07500-10R3BX-A	3/4 - 10	4.25	1.00	2.08	.590	4	3BX

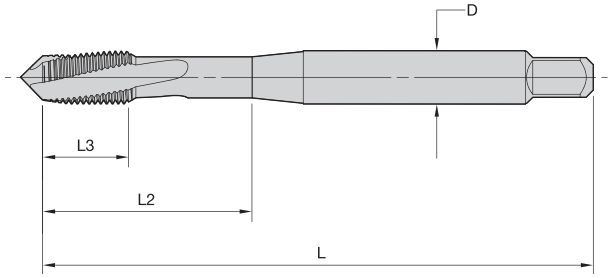
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

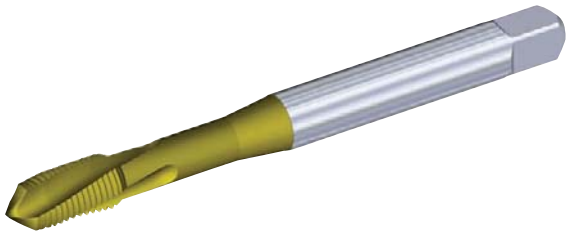
Shank Tolerance

D fractional	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

- KP6525 TiCN + TiN for steel.







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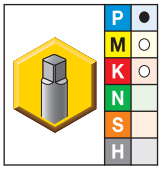


● first choice
○ alternate choice

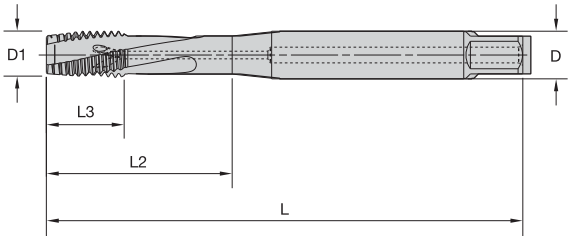
KP6525	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T620NC#06-32R2BX-D1	6 - 32	56	9	20	4,0	2	DIN 371	2BX
T620NF#06-40R2BX-D1	6 - 40	56	9	20	4,0	2	DIN 371	2BX
T620NC#08-32R2BX-D1	8 - 32	63	10	21	4,5	2	DIN 371	2BX
T620NC#10-24R2BX-D1	10 - 24	70	10	25	6,0	3	DIN 371	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

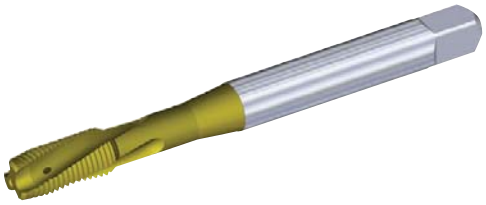
Shank Tolerance

D fractional	tolerance h6
>3–6	+0, -0,008
>6–10	+0, -0,009
<10–18	+0, -0,011

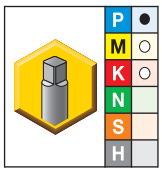
- KP6525 TiCN + TiN for steel.







T621 • DIN 371 and 376 • Form D Plug Chamfer • Through Coolant • Fractional • For Steel and Stainless Steel



● first choice
○ alternate choice

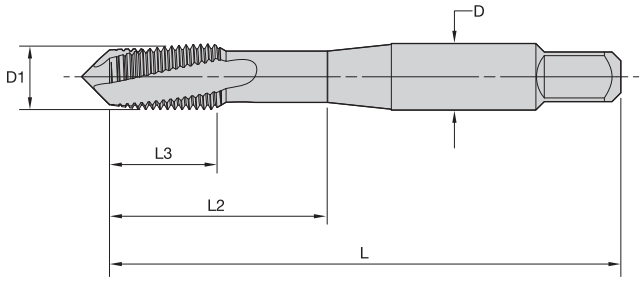
KP6525	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T621NC02500-20R3BX-D1	1/4 - 20	80	13	30	7,0	3	DIN 371	3BX
T621NF02500-28R3BX-D1	1/4 - 28	80	13	30	7,0	3	DIN 371	3BX
T621NC03125-18R3BX-D1	5/16 - 18	90	13	35	8,0	3	DIN 371	3BX
T621NF03125-24R3BX-D1	5/16 - 24	90	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

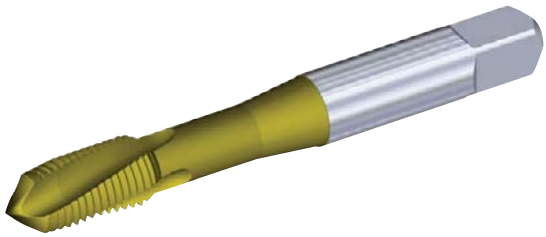
Shank Tolerance

D fractional	tolerance h6
>3–6	+0, -0,008
>6–10	+0, -0,009
<10–18	+0, -0,011

- KM6515 TiN + CrC/C for tapping stainless steel.
- KP6525 TiCN + TiN for tapping steel.







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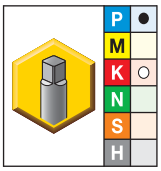
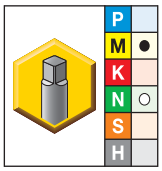




● first choice
○ alternate choice

KP6525	KM6515	D1 size	inch dimensions L	L3	L2	D	number of flutes	class of fit
T620M030X050R6HX-A *	**T620M030X050R6HX-A**	M3 X 0,5	1.94	.63	.75	.141	2	6HX
T620M040X070R6HX-A	**T620M040X070R6HX-A**	M4 X 0,7	2.12	.32	.76	.168	2	6HX
T620M050X080R6HX-A	**T620M050X080R6HX-A**	M5 X 0,8	2.37	.47	.91	.194	2	6HX
T620M060X100R6HX-A	**T620M060X100R6HX-A**	M6 X 1	2.50	.46	1.01	.255	3	6HX
T620M080X100R6HX-A *	**T620MF080X100R6HX-A** *	M8 X 1	2.72	.48	1.12	.318	3	6HX
T620M080X125R6HX-A	**T620M080X125R6HX-A**	M8 X 1,25	2.71	.48	1.13	.318	3	6HX
T620M100X150R6HX-A	**T620M100X150R6HX-A**	M10 X 1,5	2.92	.53	1.26	.381	3	6HX
T620M120X175R6HX-A	**T620M120X175R6HX-A**	M12 X 1,75	3.38	.77	1.74	.367	3	6HX

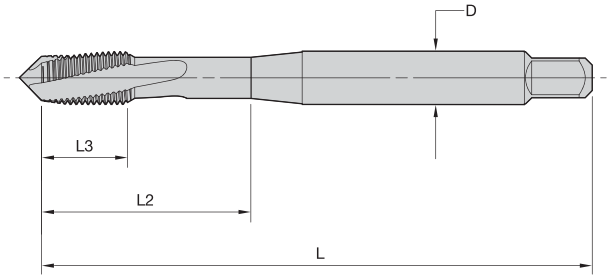
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

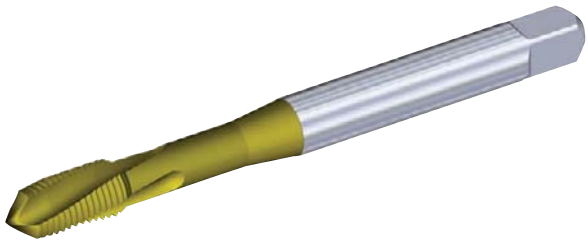
Shank Tolerance

D fractional	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

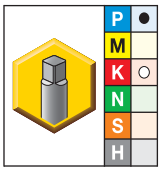
- KM6515 TiN + CrC/C for tapping stainless steel.
- KP6525 TiCN + TiN for tapping steel.

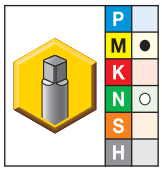






T620 • DIN 371, 374, and 376 • Form D Plug Chamfer • Metric • for Steel and Stainless Steel





● first choice
○ alternate choice

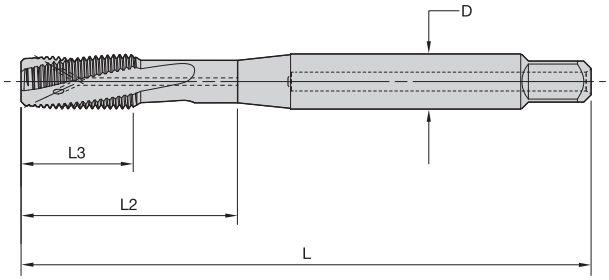
KP6525	KM6515	D1 size	metric dimensions L	L3	L2	D	number of flutes	dimension standard	class of fit
T620M030X050R6HX-D1	T620M030X050R6HX-D1	M3 X 0,5	56	8	18	3,5	2	DIN 371	6HX
T620M040X070R6HX-D1	T620M040X070R6HX-D1	M4 X 0,7	63	10	21	4,5	2	DIN 371	6HX
T620M050X080R6HX-D1	T620M050X080R6HX-D1	M5 X 0,8	70	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

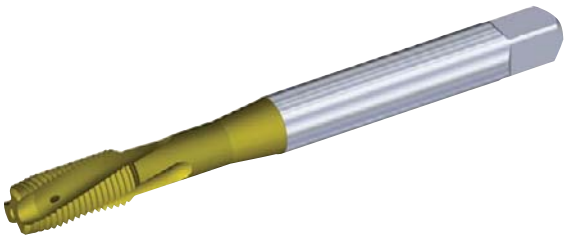
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

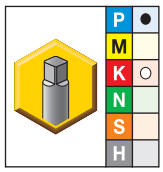
- KM6515 TiN + CrC/C for stainless steel.
- KP6525 TiCN + TiN for steel.

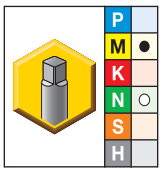






T621 • DIN 371, 374, and 376 • Form D Plug Chamfer • Through Coolant • Metric • For Steel and Stainless Steel





● first choice
○ alternate choice

KP6525	KM6515	metric dimensions 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

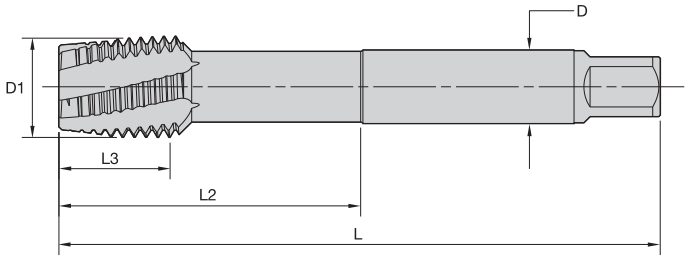
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

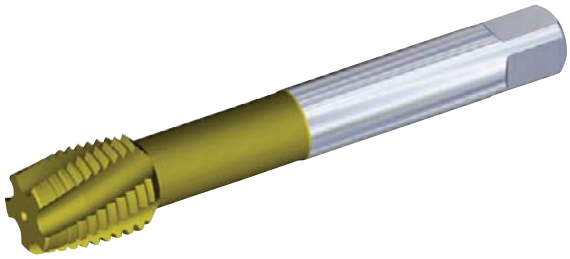
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

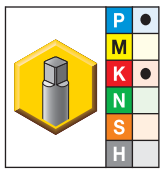
- KP6525 TiCN + TiN for tapping steel and cast iron.







T620 • DIN 376 • Form D Plug Chamfer • Large Sizes • Metric • For Steel and Cast Iron



● first choice
○ alternate choice

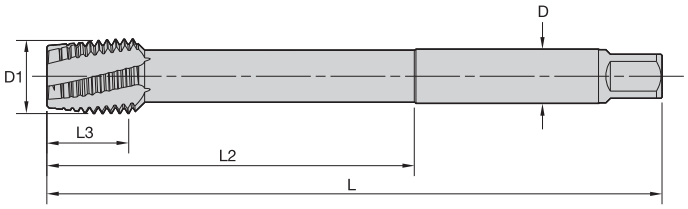
KP6525	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T620M240X300R6HX-D6	M24 X 3	160	30	77	18,0	5	DIN 376	6HX
T620M300X350R6HX-D6	M30 X 3,5	180	35	91	22,0	5	DIN 376	6HX
T620M330X350R6HX-D6	M33 X 3,5	180	35	100	25,0	5	DIN 376	6HX
T620M360X400R6HX-D6	M36 X 4	200	40	110	28,0	6	DIN 376	6HX
T620M420X450R6HX-D6	M42 X 4,5	200	45	120	32,0	6	DIN 376	6HX

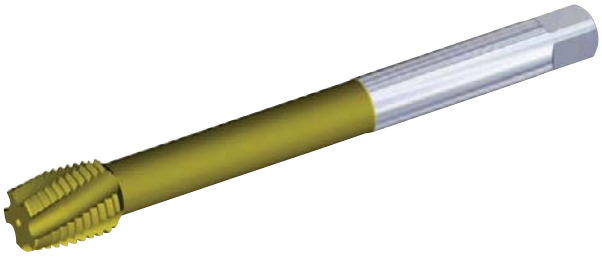
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

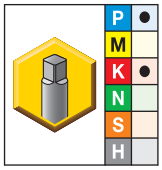
- KP6525 TiCN + TiN for tapping steel and cast iron.







T620 • Extra Long • Form D Plug Chamfer • Larger Sizes • Metric • For Steel and Cast Iron



● first choice
○ alternate choice

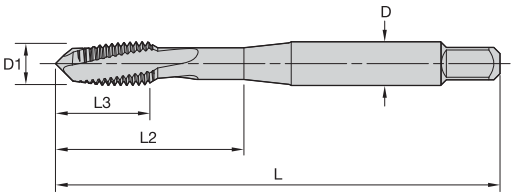
KP6525	D1 size	metric dimensions L	L3	L2	D	number of flutes	class of fit
T620M240X300R6H-XL	M24 X 3	200	30	120	18,0	5	6HX
T620M300X350R6H-XL	M30 X 3,5	250	35	150	22,0	5	6HX
T620M330X350R6H-XL	M33 X 3,5	250	35	150	25,0	5	6HX
T620M360X400R6H-XL	M36 X 4	250	40	150	28,0	6	6HX
T620M420X450R6H-XL	M42 X 4,5	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

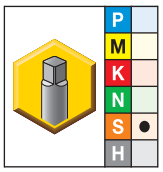
- KSS29 oxide/nitride for nickel- and cobalt-based alloys.
- KSP27 AlCrTiN for nickel- and cobalt-based alloys.

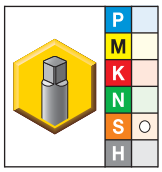






T690 • Machine Screw and Fractional • Form D Plug Chamfer • For Nickel- and Cobalt-Based Alloys



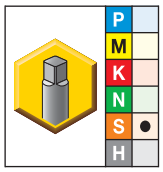


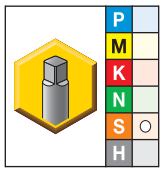
● first choice
○ alternate choice

KSP27	KSS29	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T690NC#02-56RH2-A *	T690NC#02-56RH2-A	2 - 56	1.75	.44	.50	.141	2	H2
T690NC#04-40RH2-A	T690NC#04-40RH2-A	4 - 40	1.88	.56	.69	.141	2	H2
T690NC#04-40RH3-A	T690NC#04-40RH3-A	4 - 40	1.88	.56	.69	.141	2	H3
—	T690NC#04-40RH4-A	4 - 40	1.88	.56	.69	.141	2	H4
T690NF#04-48RH2-A	T690NF#04-48RH2-A	4 - 48	1.88	.56	.69	.141	2	H2
T690NC#05-40RH2-A	T690NC#05-40RH2-A	5 - 40	1.94	.63	.75	.141	3	H2
—	T690NF#06-40RH2-A	6 - 40	2.00	.36	.72	.141	3	H2
T690NC#06-32RH3-A	T690NC#06-32RH3-A	6 - 32	2.00	.36	.72	.141	3	H3
T690NC#06-32RH5-A	T690NC#06-32RH5-A *	6 - 32	2.00	.36	.72	.141	3	H5
T690NC#08-32RH3-A	T690NC#08-32RH3-A	8 - 32	2.13	.31	.77	.168	3	H3
T690NC#08-32RH4-A	T690NC#08-32RH4-A	8 - 32	2.13	.31	.77	.168	3	H4
—	T690NC#08-32RH5-A	8 - 32	2.13	.31	.77	.168	3	H5
—	T690NC#08-32RH6-A	8 - 32	2.13	.31	.77	.168	3	H6
T690NC#10-24RH3-A	T690NC#10-24RH3-A	10 - 24	2.38	.47	.92	.194	3	H3
—	T690NC#10-24RH5-A	10 - 24	2.38	.47	.92	.194	3	H5
T690NF#10-32RH2-A *	T690NF#10-32RH2-A	10 - 32	2.38	.47	.92	.194	3	H2
T690NF#10-32RH3-A	T690NF#10-32RH3-A	10 - 32	2.38	.47	.92	.194	3	H3
T690NF#10-32RH4-A *	T690NF#10-32RH4-A	10 - 32	2.38	.47	.92	.194	3	H4
T690NF#10-32RH5-A *	T690NF#10-32RH5-A	10 - 32	2.38	.47	.92	.194	3	H5
T690NF#10-32RH6-A *	T690NF#10-32RH6-A *	10 - 32	2.38	.47	.92	.194	3	H6
T690NC02500-20RH3-A	T690NC02500-20RH3-A	1/4 - 20	2.51	.44	1.02	.255	3	H3
T690NC02500-20RH5-A *	T690NC02500-20RH5-A	1/4 - 20	2.51	.44	1.02	.255	3	H5
T690NF02500-28RH3-A	T690NF02500-28RH3-A	1/4 - 28	2.51	.44	1.02	.255	3	H3
T690NF02500-28RH4-A	T690NF02500-28RH4-A	1/4 - 28	2.51	.44	1.02	.255	3	H4
T690NF02500-28RH5-A	T690NF02500-28RH5-A	1/4 - 28	2.49	.44	1.02	.255	3	H5
T690NF02500-28RH6-A	T690NF02500-28RH6-A	1/4 - 28	2.51	.44	1.02	.255	3	H6
—	T690NF02500-28RH7-A	1/4 - 28	2.51	.44	1.02	.255	3	H7
T690NC03125-18RH3-A	T690NC03125-18RH3-A	5/16 - 18	2.73	.49	1.15	.318	3	H3
T690NC03125-18RH5-A *	T690NC03125-18RH5-A	5/16 - 18	2.73	.49	1.15	.318	3	H5
—	T690NC03125-18RH7-A	5/16 - 18	2.73	.49	1.15	.318	3	H7
T690NF03125-24RH3-A	T690NF03125-24RH3-A	5/16 - 24	2.73	.49	1.15	.318	3	H3
—	T690NF03125-24RH4-A	5/16- 24	2.73	.49	1.15	.318	3	H4

(continued)

(T690 • Machine Screw and Fractional • Form D Plug Chamfer • For Nickel- and Cobalt-Based Alloys — continued)





● first choice
○ alternate choice

KSP27	KSS29	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
—	T690NF03125-24RH5-A	5/16- 24	2.73	.49	1.15	.318	3	H5
—	T690NF03125-24RH6-A	5/16- 24	2.73	.49	1.15	.318	3	H6
—	T690NF03125-24RH7-A *	5/16- 24	2.73	.49	1.15	.318	3	H7
T690NC03750-16RH3-A	T690NC03750-16RH3-A	3/8 - 16	2.95	.60	1.28	.381	3	H3
T690NC03750-16RH5-A	T690NC03750-16RH5-A	3/8 - 16	2.95	.60	1.28	.381	3	H5
—	T690NC03750-16RH7-A	3/8 - 16	2.95	.60	1.28	.381	3	H7
T690NF03750-24RH3-A	T690NF03750-24RH3-A	3/8 - 24	2.95	.60	1.28	.381	3	H3
—	T690NF03750-24RH4-A	3/8 - 24	2.95	.60	1.28	.381	3	H4
—	T690NF03750-24RH5-A	3/8 - 24	2.95	.60	1.28	.381	3	H5
—	T690NF03750-24RH6-A	3/8 - 24	2.95	.60	1.28	.381	3	H6
—	T690NF03750-24RH7-A *	3/8 - 24	2.95	.60	1.28	.381	3	H7
T690NC04375-14RH3-A	T690NC04375-14RH3-A	7/16 - 14	3.16	.71	1.49	.323	3	H3
T690NF04375-20RH3-A	T690NF04375-20RH3-A	7/16 - 20	3.16	.71	1.49	.323	3	H3
T690NF04375-20RH5-A	T690NF04375-20RH5-A	7/16 - 20	3.16	.71	1.49	.323	3	H5
T690NC05000-13RH3-A	T690NC05000-13RH3-A	1/2 - 13	3.38	.77	1.74	.367	3	H3
—	T690NC05000-13RH5-A	1/2 - 13	3.38	.77	1.74	.367	3	H5
—	T690NC05000-13RH7-A	1/2 - 13	3.38	.77	1.74	.367	3	H7
T690NF05000-20RH3-A	T690NF05000-20RH3-A	1/2 - 20	3.38	.77	1.74	.367	3	H3
—	T690NF05000-20RH5-A	1/2 - 20	3.38	.77	1.74	.367	3	H5
—	T690NF05000-20RH7-A	1/2 - 20	3.38	.77	1.74	.367	3	H7
T690NC06250-11RH3-A	T690NC06250-11RH3-A	5/8 - 11	3.81	.91	1.89	.480	3	H3
T690NF06250-18RH3-A	T690NF06250-18RH3-A *	5/8 - 18	3.81	.91	1.89	.480	3	H3
—	T690NC07500-10RH3-A	3/4 - 10	4.25	1.00	2.08	.590	3	H3
—	T690NF07500-16RH3-A	3/4 - 16	4.25	1.00	2.08	.590	3	H3

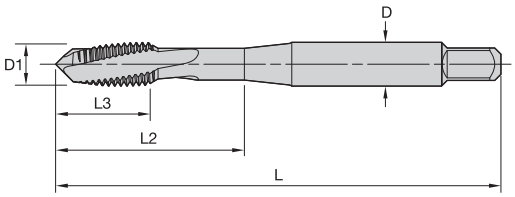
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

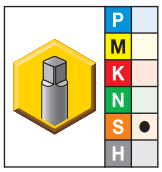
- KSS29 oxide/nitride for nickel- and cobalt-based alloys.
- KSP27 AlCrTiN for nickel- and cobalt-based alloys.

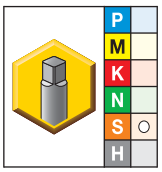






T690 • Form D Plug Chamfer • Metric ANSI • For Nickel- and Cobalt-Based Alloys





● first choice
○ alternate choice

KSP27	KSS29	D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T690M025X045RD3-A	**T690M025X045RD3-A**	M2,5 X 0,45	1.81	.50	.56	.141	2	D3
T690M030X050RD3-A	**T690M030X050RD3-A**	M3 X 0,5	1.94	.63	.75	.141	2	D3
T690M035X060RD4-A	**T690M035X060RD4-A**	M3,5 X 0,6	1.99	.36	.72	.141	3	D4
T690M040X070RD4-A	**T690M040X070RD4-A**	M4 X 0,7	2.12	.32	.77	.168	3	D4
T690M050X080RD4-A	**T690M050X080RD4-A**	M5 X 0,8	2.38	.47	.92	.194	3	D4
T690M060X100RD5-A	**T690M060X100RD5-A**	M6 X 1	2.51	.46	1.01	.255	3	D5
T690MF080X100RD5-A *	**T690MF080X100RD5-A ***	M8 X 1	2.72	.48	1.14	.318	3	D5
T690M080X125RD5-A	**T690M080X125RD5-A**	M8 X 1,25	2.72	.48	1.14	.318	3	D5
T690M100X150RD6-A *	**T690M100X150RD6-A**	M10 X 1,5	2.94	.53	1.27	.381	3	D6
T690M120X175RD6-A	**T690M120X175RD6-A**	M12 X 1,75	3.38	.77	1.74	.367	3	D6

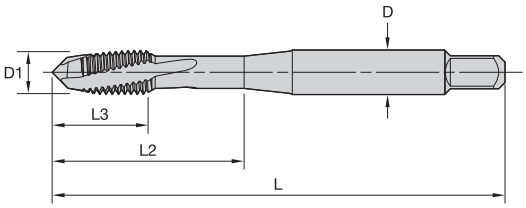
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

- KSS20 nitride for titanium and titanium alloys.
- KSSM24 TiN + CrC/C for titanium and titanium alloys.







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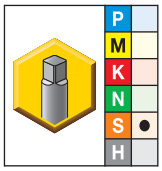
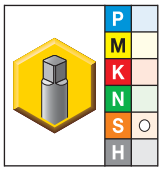




● first choice
○ alternate choice

KSSM24	KSS20	D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T660NC#02-56RH2-A	T660NC#02-56RH2-A	2 - 56	1.75	.44	.50	.141	2	H2
T660NC#04-40RH2-A	T660NC#04-40RH2-A	4 - 40	1.88	.56	.69	.141	2	H2
T660NC#06-32RH2-A	T660NC#06-32RH2-A	6 - 32	1.99	.36	.71	.141	3	H2
T660NC#06-32RH3-A	T660NC#06-32RH3-A	6 - 32	1.99	.36	.71	.141	3	H3
T660NF#06-40RH2-A	T660NF#06-40RH2-A	6 - 40	1.99	.36	.71	.141	3	H2
T660NC#08-32RH2-A	T660NC#08-32RH2-A	8 - 32	2.12	.31	.76	.168	3	H2
T660NC#08-32RH3-A	T660NC#08-32RH3-A	8 - 32	2.12	.31	.76	.168	3	H3
T660NF#08-36RH2-A	T660NF#08-36RH2-A	8 - 36	2.12	.31	.76	.168	3	H2
T660NC#10-24RH3-A *	T660NC#10-24RH3-A	10 - 24	2.37	.47	.91	.194	3	H3
T660NF#10-32RH2-A	T660NF#10-32RH2-A	10 - 32	2.37	.47	.91	.194	3	H2
T660NF#10-32RH3-A *	T660NF#10-32RH3-A	10 - 32	2.37	.47	.91	.194	3	H3
T660NC02500-20RH3-A	T660NC02500-20RH3-A	1/4 - 20	2.50	.44	1.00	.255	3	H3
T660NC02500-20RH5-A	T660NC02500-20RH5-A *	1/4 - 20	2.50	.44	1.00	.255	3	H5
T660NF02500-28RH3-A *	T660NF02500-28RH3-A	1/4 - 28	2.50	.44	1.00	.255	3	H3
T660NF02500-28RH4-A	T660NF02500-28RH4-A	1/4 - 28	2.50	.44	1.00	.255	3	H4
T660NC03125-18RH3-A	T660NC03125-18RH3-A	5/16 - 18	2.72	.49	1.13	.318	3	H3
T660NC03125-18RH5-A	T660NC03125-18RH5-A	5/16 - 18	2.72	.49	1.13	.318	3	H5
T660NF03125-24RH3-A	T660NF03125-24RH3-A *	5/16 - 24	2.72	.49	1.13	.318	3	H3
T660NF03125-24RH4-A	T660NF03125-24RH4-A	5/16 - 24	2.72	.49	1.13	.318	3	H4
T660NC03750-16RH3-A	T660NC03750-16RH3-A	3/8 - 16	2.93	.59	1.26	.381	3	H3
T660NC03750-16RH5-A *	T660NC03750-16RH5-A	3/8 - 16	2.93	.59	1.26	.381	3	H5
T660NF03750-24RH3-A	T660NF03750-24RH3-A	3/8 - 24	2.93	.59	1.26	.381	3	H3
T660NF03750-24RH4-A	T660NF03750-24RH4-A	3/8 - 24	2.93	.59	1.26	.381	3	H4
T660NC04375-14RH3-A	T660NC04375-14RH3-A *	7/16 - 14	3.16	.71	1.49	.323	3	H3
T660NF04375-20RH3-A	T660NF04375-20RH3-A	7/16 - 20	3.16	.71	1.49	.323	3	H3
T660NC05000-13RH3-A	T660NC05000-13RH3-A	1/2 - 13	3.38	.77	1.74	.367	3	H3
T660NF05000-20RH3-A	T660NF05000-20RH3-A	1/2 - 20	3.38	.77	1.74	.367	3	H3
T660NF05625-18RH3-A	—	9/16 - 18	3.59	.83	1.74	.429	4	H3
T660NF05625-18RH5-A	—	9/16 - 18	3.59	.83	1.74	.429	4	H5
T660NC06250-11RH3-A	—	5/8 - 11	3.81	.91	1.89	.480	4	H3
T660NF06250-18RH3-A *	—	5/8 - 18	3.81	.91	1.89	.480	4	H3
T660NF06250-18RH5-A	—	5/8 - 18	3.81	.91	1.89	.480	4	H5
T660NC07500-10RH5-A	—	3/4 - 10	4.25	1.00	2.08	.590	4	H5
T660NF07500-16RH3-A	—	3/4 - 16	4.25	1.00	2.08	.590	4	H3
T660NF07500-16RH5-A	—	3/4 - 16	4.25	1.00	2.08	.590	4	H5
T660NC10000-08RH5-A *	—	1 - 8	5.13	1.25	2.58	.800	5	H5

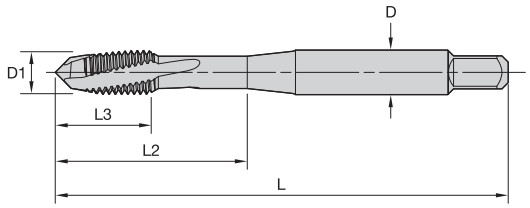
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

- KSS20 nitride for titanium and titanium alloys.
- KSSM24 TiN + CrC/C for titanium and titanium alloys.







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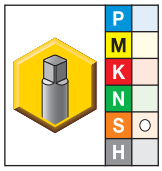
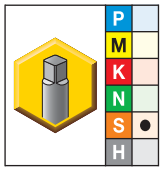




● first choice
○ alternate choice

KSSM24	KSS20	D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T660M025X045RD3-A *	**T660M025X045RD3-A** *	M2,5 X 0,45	1.81	.49	.56	.141	3	D3
T660M030X050RD3-A *	**T660M030X050RD3-A**	M3 X 0,5	1.94	.63	.75	.141	3	D3
T660M040X070RD4-A *	**T660M040X070RD4-A** *	M4 X 0,7	2.12	.32	.76	.168	3	D4
T660M050X080RD4-A	**T660M050X080RD4-A** *	M5 X 0,8	2.37	.47	.91	.194	3	D4
T660M060X100RD5-A	**T660M060X100RD5-A** *	M6 X 1	2.50	.16	1.00	.255	3	D5
T660M070X100RD5-A	**T660M070X100RD5-A**	M7 X 1	2.73	.52	1.15	.318	3	D5
T660M080X125RD5-A	**T660M080X125RD5-A**	M8 X 1,25	2.71	.48	1.12	.318	3	D5
T660MF100X125RD5-A *	**T660MF100X125RD5-A**	M10 X 1,25	2.92	.53	1.26	.381	3	D5
T660M100X150RD6-A	**T660M100X150RD6-A** *	M10 X 1,5	2.92	.53	1.26	.381	3	D6
T660M120X175RD6-A	**T660M120X175RD6-A**	M12 X 1,75	3.38	.77	1.74	.367	3	D6

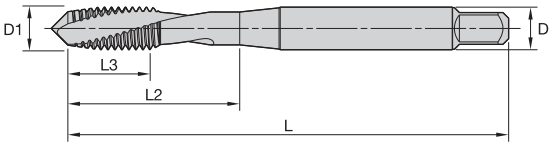
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

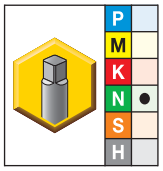
• KSMN34 TiN + CrC/C for aluminum.







T672 • Machine Screw and Fractional • Form D Plug Chamfer • DIN Length ANSI Shank • For Aluminum



● first choice
○ alternate choice

KSMN34	D1 size	L	L3	L2	D	number of flutes	class of fit
T672NC#02-56R2B-DA	2 - 56	1.77	.31	.71	.141	2	2B
T672NC#04-40R3B-DA	4 - 40	2.20	.31	.71	.141	2	3B
T672NC#05-40R3B-DA	5 - 40	2.20	.31	.71	.141	2	3B
T672NC#06-32R2B-DA	6 - 32	2.20	.35	.79	.141	2	2B
T672NC#08-32R2B-DA	8 - 32	2.48	.43	.83	.168	2	2B
T672NC#10-24R2B-DA	10 - 24	2.76	.47	.98	.194	2	2B
T672NF#10-32R2B-DA	10 - 32	2.76	.47	.98	.194	2	2B
T672NC02500-20R2B-DA	1/4 - 20	3.15	.59	1.18	.255	2	2B
T672NC02500-20R3B-DA	1/4 - 20	3.15	.59	1.18	.255	2	3B
T672NF02500-28R2B-DA	1/4 - 28	3.15	.59	1.18	.255	2	2B
T672NF02500-28R3B-DA	1/4 - 28	3.15	.59	1.18	.255	2	3B
T672NC03125-18R2B-DA *	5/16 - 18	3.54	.59	1.38	.318	2	2B
T672NC03125-18R3B-DA	5/16 - 18	3.54	.59	1.38	.318	2	3B
T672NF03125-24R2B-DA *	5/16 - 24	3.54	.59	1.38	.318	2	2B
T672NF03125-24R3B-DA	5/16 - 24	3.54	.59	1.38	.318	2	3B
T672NC03750-16R2B-DA *	3/8 - 16	3.94	.75	1.54	.381	2	2B
T672NC03750-16R3B-DA *	3/8 - 16	3.94	.75	1.54	.381	2	3B
T672NF03750-24R2B-DA	3/8 - 24	3.94	.75	1.54	.381	2	2B
T672NF03750-24R3B-DA	3/8 - 24	3.94	.75	1.54	.381	2	3B
T672NC04375-14R2B-DA	7/16 - 14	3.94	.71	1.61	.323	3	2B
T672NC04375-14R3B-DA	7/16 - 14	3.94	.71	1.61	.323	3	3B
T672NF04375-20R2B-DA	7/16 - 20	3.94	.71	1.61	.323	3	2B
T672NF04375-20R3B-DA	7/16 - 20	3.94	.71	1.61	.323	3	3B
T672NC05000-13R2B-DA	1/2 - 13	4.33	.91	1.85	.367	3	2B
T672NC05000-13R3B-DA	1/2 - 13	4.33	.91	1.85	.367	3	3B
T672NF05000-20R2B-DA	1/2 - 20	4.33	.91	1.85	.367	3	2B
T672NF05000-20R3B-DA	1/2 - 20	4.33	.91	1.85	.367	3	3B

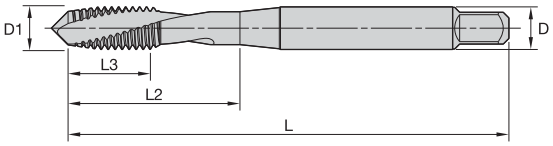
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D inch	tolerance h9
.141–.635	+0, -.0015
<.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

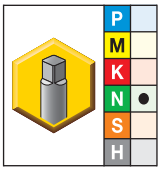
• KSMN34 TiN + CrC/C for aluminum.







T672 • Form D Plug Chamfer • Metric • DIN Length ANSI Shank • For Aluminum



● first choice
○ alternate choice

KSMN34	D1 size	L	L3	L2	D	number of flutes	class of fit
T672M030X050R6H-DA	M3 X 0,5	2.20	.31	.71	.141	2	6H
T672M035X060R6H-DA	M3,5 X 0,6	2.20	.35	.79	.141	2	6H
T672M040X070R6H-DA	M4 X 0,7	2.48	.43	.83	.168	2	6H
T672M050X080R6H-DA	M5 X 0,8	2.76	.47	.98	.194	2	6H
T672M060X100R6H-DA	M6 X 1	3.15	.47	1.18	.255	2	6H
T672M070X100R6H-DA	M7 X 1	3.54	.59	1.38	.318	2	6H
T672MF080X100R6H-DA *	M8 X 1	3.54	.59	1.38	.318	2	6H
T672M080X125R6H-DA	M8 X 1,25	3.54	.59	1.38	.318	2	6H
T672MF100X125R6H-DA	M10 X 1,25	3.94	.71	1.54	.381	2	6H
T672M100X150R6H-DA	M10 X 1,5	3.94	.71	1.54	.381	2	6H
T672MF120X125R6H-DA	M12 X 1,25	4.33	.83	1.73	.367	3	6H
T672MF120X150R6H-DA	M12 X 1,5	4.33	.83	1.73	.367	3	6H
T672M120X175R6H-DA	M12 X 1,75	4.33	.83	1.73	.367	3	6H

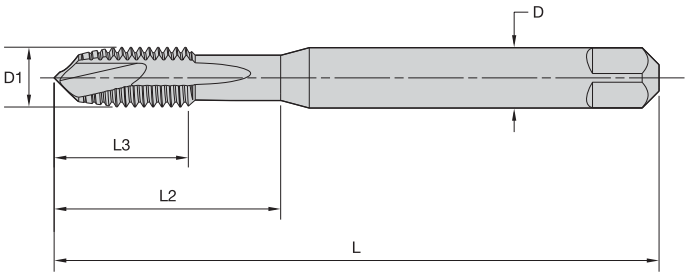
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

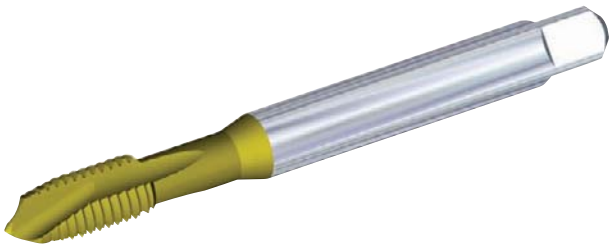
Shank Tolerance

D inch	tolerance h9
.141–.635	+0, -.0015
<.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

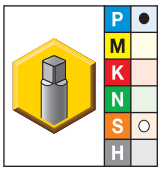
- KSP21 TiN for tapping steel 32–44 HRC.







T600 • DIN 371, 374, and 376 • Form B Plug Chamfer • Metric • For Hard Steel



● first choice
○ alternate choice

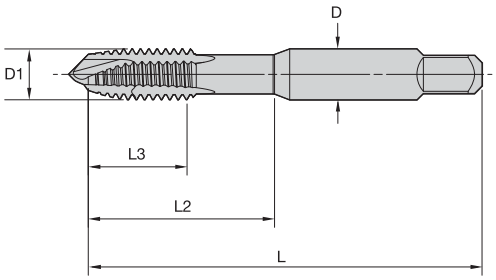
KSP21	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T600M030X050R6HX-D1	M3 X 0,5	56	11	18	3,5	2	DIN 371	6HX
T600M040X070R6HX-D1	M4 X 0,7	63	13	21	4,5	2	DIN 371	6HX
T600M050X080R6HX-D1	M5 X 0,8	70	15	25	6,0	2	DIN 371	6HX
T600M060X100R6HX-D1	M6 X 1	80	17	30	6,0	3	DIN 371	6HX
T600MF080X100R6HX-D4	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

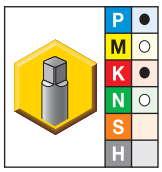
- KSP32 TiCN/TiN
- KSMN34 TiN + CrC/C
- KSP39 oxide
- KSU30 bright**

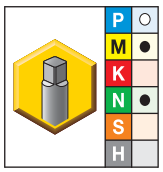


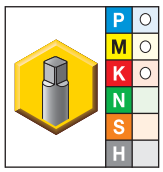




T820 • Form B Plug Chamfer • Machine Screw and Fractional • ANSI





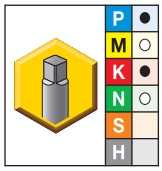


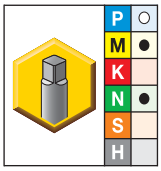
● first choice
○ alternate choice

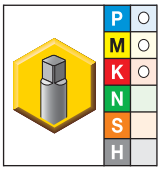
KSP32	KSMN34	KSP39	inch dimensions D1 TPI	L	L3	L2	D	number of flutes	pitch diameter limit
–	–	T820NC#02-56RH2-A	2 - 56	1.75	.39	.50	.141	2	H2
–	–	T820NC#02-56RH3-A	2 - 56	1.75	.39	.50	.141	2	H3
–	–	T820NC#02-56RH4-A	2 - 56	1.75	.39	.50	.141	2	H4
–	–	T820NC#03-48RH2-A	3 - 48	1.82	.45	.57	.141	2	H2
T820NC#04-40RH2-A	T820NC#04-40RH2-A	T820NC#04-40RH2-A	4 - 40	1.88	.51	.69	.141	2	H2
–	–	T820NC#04-40RH3-A	4 - 40	1.88	.51	.69	.141	2	H3
–	–	T820NC#04-40RH4-A	4 - 40	1.88	.51	.69	.141	2	H4
T820NC#04-40RH5-A	–	T820NC#04-40RH5-A	4 - 40	1.88	.51	.69	.141	2	H5
–	–	T820NC#04-40RH6-A	4 - 40	1.88	.51	.69	.141	2	H6
–	–	T820NF#04-48RH2-A	4 - 48	1.88	.51	.69	.141	2	H2
–	–	T820NF#04-48RH4-A	4 - 48	1.88	.51	.69	.141	2	H4
–	–	T820NC#05-40RH2-A	5 - 40	1.94	.58	.75	.141	2	H2
–	–	T820NC#06-32RH2-A	6 - 32	1.99	.38	.71	.141	2	H2
T820NC#06-32RH3-A	T820NC#06-32RH3-A	T820NC#06-32RH3-A	6 - 32	1.99	.38	.71	.141	2	H3
–	–	T820NC#06-32RH4-A	6 - 32	1.99	.38	.71	.141	2	H4
–	–	T820NC#06-32RH5-A	6 - 32	1.99	.38	.71	.141	2	H5
–	–	T820NC#06-32RH6-A	6 - 32	1.99	.38	.71	.141	2	H6
–	–	T820NC#06-32RH7-A *	6 - 32	1.99	.38	.71	.141	2	H7
–	–	T820NF#06-40RH2-A	6 - 40	1.99	.38	.71	.141	2	H2
–	–	T820NF#06-40RH3-A	6 - 40	1.99	.38	.76	.141	2	H3
–	–	T820NF#08-36RH2-A	8 - 36	2.11	.38	.76	.168	2	H2
–	–	T820NC#08-32RH2-A	8 - 32	2.12	.38	.76	.168	2	H2
T820NC#08-32RH3-A	T820NC#08-32RH3-A	T820NC#08-32RH3-A	8 - 32	2.12	.38	.76	.168	2	H3
T820NC#08-32RH4-A	–	–	8 - 32	2.12	.38	.76	.168	2	H4
–	–	T820NC#08-32RH5-A	8 - 32	2.12	.38	.76	.168	2	H5
–	–	T820NC#08-32RH6-A	8 - 32	2.12	.38	.76	.168	2	H6
–	–	T820NC#08-32RH7-A	8 - 32	2.12	.38	.76	.168	2	H7
T820NF#10-32RH3-A	T820NF#10-32RH3-A	T820NF#10-32RH3-A	10 - 32	2.36	.50	.91	.194	2	H3
–	–	T820NF#10-32RH4-A	10 - 32	2.36	.50	.91	.194	2	H4
–	–	T820NF#10-32RH5-A	10 - 32	2.36	.50	.91	.194	2	H5
–	–	T820NF#10-32RH6-A	10 - 32	2.36	.50	.91	.194	2	H6
–	–	T820NF#10-32RH7-A	10 - 32	2.36	.50	.91	.194	2	H7

(continued)

(T820 • Form B Plug Chamfer • Machine Screw and Fractional • ANSI — continued)





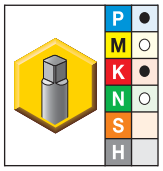


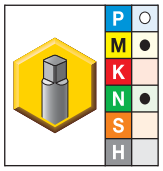
● first choice
○ alternate choice

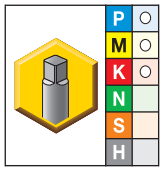
KSP32	KSMN34	KSP39	inch dimensions D1 TPI	L	L3	L2	D	number of flutes	pitch diameter limit
T820NC#10-24RH3-A	T820NC#10-24RH3-A	T820NC#10-24RH3-A	10 - 24	2.37	.50	.91	.194	2	H3
—	—	T820NC#10-24RH5-A	10 - 24	2.37	.50	.91	.194	2	H5
—	—	T820NC#10-24RH7-A	10 - 24	2.37	.50	.91	.194	2	H7
—	—	T820NF#12-28RH3-A	12 - 28	2.37	.50	.96	.220	2	H3
—	—	T820NC02500-20RH2-A	1/4 - 20	2.50	.63	1.00	.255	3	H2
T820NC02500-20RH3-A	T820NC02500-20RH3-A	T820NC02500-20RH3-A	1/4 - 20	2.50	.63	1.00	.255	3	H3
—	—	T820NC02500-20RH5-A	1/4 - 20	2.50	.63	1.00	.255	3	H5
—	—	T820NC02500-20RH7-A	1/4 - 20	2.50	.63	1.00	.255	3	H7
—	—	T820NF02500-28RH2-A	1/4 - 28	2.50	.63	1.00	.255	3	H2
T820NF02500-28RH3-A	T820NF02500-28RH3-A	T820NF02500-28RH3-A	1/4 - 28	2.50	.63	1.00	.255	3	H3
—	—	T820NF02500-28RH4-A	1/4 - 28	2.50	.63	1.00	.255	3	H4
—	—	T820NF02500-28RH5-A	1/4 - 28	2.50	.63	1.01	.255	3	H5
—	—	T820NF02500-28RH6-A	1/4 - 28	2.50	.63	1.01	.255	3	H6
—	—	T820NF02500-28RH7-A	1/4 - 28	2.50	.63	1.01	.255	3	H7
T820NC03125-18RH3-A	T820NC03125-18RH3-A	T820NC03125-18RH3-A	5/16 - 18	2.72	.69	1.14	.318	3	H3
—	—	T820NC03125-18RH5-A	5/16 - 18	2.72	.69	1.14	.318	3	H5
—	—	T820NC03125-18RH7-A	5/16 - 18	2.72	.69	1.14	.318	3	H7
T820NF03125-24RH3-A	T820NF03125-24RH3-A	T820NF03125-24RH3-A	5/16 - 24	2.72	.69	1.14	.318	3	H3
—	—	T820NF03125-24RH4-A	5/16 - 24	2.72	.69	1.14	.318	3	H4
—	—	T820NF03125-24RH5-A	5/16 - 24	2.72	.69	1.14	.318	3	H5
—	—	T820NF03125-24RH6-A	5/16 - 24	2.72	.69	1.14	.318	3	H6
—	—	T820NF03125-24RH7-A	5/16 - 24	2.72	.69	1.14	.318	3	H7
T820NC03750-16RH3-A	T820NC03750-16RH3-A	T820NC03750-16RH3-A	3/8 - 16	2.94	.75	1.27	.381	3	H3
—	—	T820NC03750-16RH5-A	3/8 - 16	2.94	.75	1.27	.381	3	H5
—	—	T820NC03750-16RH7-A	3/8 - 16	2.94	.75	1.27	.381	3	H7
T820NF03750-24RH3-A	T820NF03750-24RH3-A	T820NF03750-24RH3-A	3/8 - 24	2.94	.75	1.27	.381	3	H3
—	—	T820NF03750-24RH4-A	3/8 - 24	2.94	.75	1.27	.381	3	H4
—	—	T820NF03750-24RH5-A	3/8 - 24	2.94	.75	1.27	.381	3	H5
—	—	T820NF03750-24RH6-A	3/8 - 24	2.94	.75	1.27	.381	3	H6
—	—	T820NF03750-24RH7-A	3/8 - 24	2.94	.75	1.27	.381	3	H7
—	T820NC04375-14RH3-A	T820NC04375-14RH3-A	7/16 - 14	3.16	.88	1.49	.323	3	H3
—	—	T820NC04375-14RH5-A	7/16 - 14	3.16	.88	1.49	.323	3	H5
—	T820NF04375-20RH3-A	T820NF04375-20RH3-A	7/16 - 20	3.16	.88	1.49	.323	3	H3
—	—	T820NF04375-20RH5-A	7/16 - 20	3.16	.88	1.49	.323	3	H5
—	—	T820NF04375-20RH6-A	7/16 - 20	3.16	.88	1.49	.323	3	H6
—	—	T820NF04375-20RH7-A	7/16 - 20	3.16	.88	1.49	.323	3	H7
T820NC05000-13RH3-A	T820NC05000-13RH3-A	T820NC05000-13RH3-A	1/2 - 13	3.38	.94	1.74	.367	3	H3
—	—	T820NC05000-13RH5-A	1/2 - 13	3.38	.94	1.74	.367	3	H5
—	—	T820NC05000-13RH7-A	1/2 - 13	3.38	.94	1.74	.367	3	H7
T820NF05000-20RH3-A	T820NF05000-20RH3-A	T820NF05000-20RH3-A	1/2 - 20	3.38	.94	1.74	.367	3	H3
—	—	T820NF05000-20RH5-A	1/2 - 20	3.38	.94	1.74	.367	3	H5
—	—	T820NF05000-20RH6-A	1/2 - 20	3.38	.94	1.74	.367	3	H6
—	—	T820NF05000-20RH7-A	1/2 - 20	3.38	.94	1.74	.367	3	H7
T820NC05625-12RH3-A	—	T820NC05625-12RH3-A	9/16 - 12	3.59	1.00	1.74	.429	3	H3
—	T820NF05625-18RH3-A	T820NF05625-18RH3-A	9/16 - 18	3.59	1.00	1.74	.429	3	H3
T820NC06250-11RH3-A	T820NC06250-11RH3-A	T820NC06250-11RH3-A	5/8 - 11	3.81	1.09	1.89	.480	3	H3
—	—	T820NC06250-11RH5-A	5/8 - 11	3.81	1.09	1.89	.480	3	H5
—	—	T820NC06250-11RH7-A	5/8 - 11	3.81	1.09	1.89	.480	3	H7
T820NF06250-18RH3-A	—	T820NF06250-18RH3-A	5/8 - 18	3.81	1.09	1.89	.480	3	H3
T820NF06250-18RH5-A *	—	T820NF06250-18RH5-A	5/8 - 18	3.81	1.09	1.89	.480	3	H5
—	—	T820NF06250-18RH6-A	5/8 - 18	3.81	1.09	1.89	.480	3	H6
T820NC07500-10RH3-A	T820NC07500-10RH3-A	T820NC07500-10RH3-A	3/4 - 10	4.25	1.22	2.08	.590	3	H3

(continued)

(T820 • Form B Plug Chamfer • Machine Screw and Fractional • ANSI — continued)







● first choice
○ alternate choice

KSP32	KSMN34	KSP39	inch dimensions D1 TPI	L	L3	L2	D	number of flutes	pitch diameter limit
T820NF07500-16RH3-A	**T820NF07500-16RH3-A**	**T820NF07500-16RH3-A**	3/4 - 16	4.25	1.22	2.08	.590	3	H3
T820NC08750-9RH4-A	**T820NC08750-9RH4-A**	**—**	7/8 - 9	4.69	1.34	2.30	.697	3	H4
—	**—**	**T820NF08750-14RH4-A**	7/8 - 14	4.69	1.34	2.30	.697	3	H4
T820NC10000-8RH5-A	**T820NC10000-8RH5-A**	**T820NC10000-8RH5-A**	1 - 8	5.13	1.50	2.58	.800	3	H5
—	**—**	**T820NF10000-12RH4-A**	1 - 12	5.13	1.50	2.58	.800	3	H4
—	**—**	**T820NC11250-7RH6-A**	1 1/8 - 7	5.44	1.71	2.56	.895	4	H6
—	**—**	**T820NF11250-12RH5-A**	1 1/8 - 12	5.44	1.71	2.56	.895	4	H5
—	**—**	**T820NC12500-7RH6-A**	1 1/4 - 7	5.75	1.71	2.56	1.021	4	H6

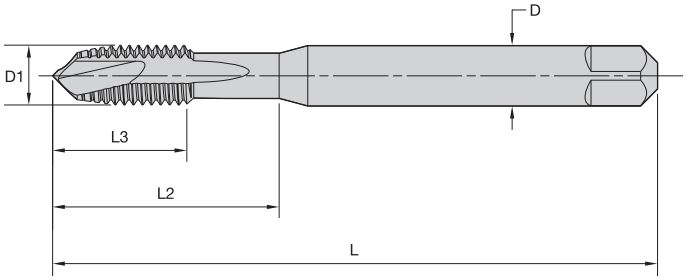
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
**Bright taps (KSU30) available.

Shank Tolerance

D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

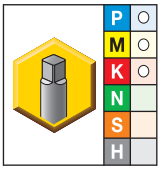
• KSP39 oxide







T820 • DIN 371 and 376 • Form B Plug Chamfer • UNC/UNF



● first choice
○ alternate choice

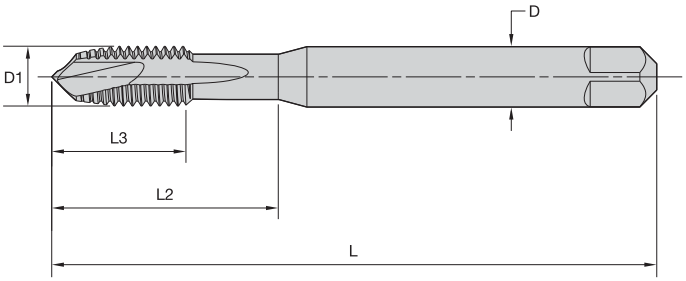
KSP39	D1 size	metric dimensions L	L3	L2	D	number of flutes	dimension standard	class of fit
T820NC#04-40R2B-D1	4 - 40	56	8	18	3,5	2	DIN 371	2B
T820NC#05-40R2B-D1	5 - 40	56	9	20	4,0	2	DIN 371	2B
T820NC#06-32R2B-D1	6 - 32	56	9	20	4,0	2	DIN 371	2B
T820NF#06-40R2B-D1	6 - 40	56	9	20	4,0	2	DIN 371	2B
T820NC#08-32R2B-D1	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

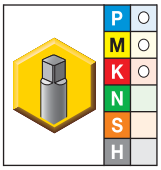
• KSP39 oxide







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

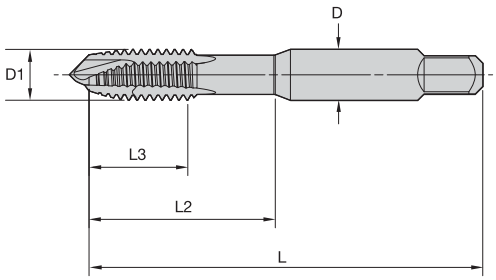
NOTE: Internal UNJC/UNJF threads may be produced with ground thread UNC/UNF taps.

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

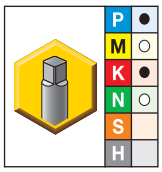
- KSP32 TiCN/TiN
- KSMN34 TiN + CrC/C
- KSP39 oxide
- KSU30 bright**

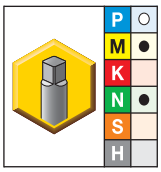


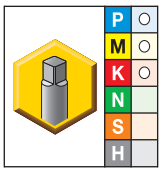




T822 • Form B Plug Chamfer • Machine Screw • 3 Flute • ANSI







● first choice
○ alternate choice

KSP32	KSMN34	KSP39	inch dimensions D1 TPI	L	L3	L2	D	number of flutes	pitch diameter limit
–	–	T822NC#05-40RH2-A	5 - 40	1.94	.58	.75	.141	3	H2
–	–	T822NC#06-32RH2-A	6 - 32	1.99	.38	.71	.141	3	H2
T822NC#06-32RH3-A	T822NC#06-32RH3-A	T822NC#06-32RH3-A	6 - 32	1.99	.38	.71	.141	3	H3
–	–	T822NC#06-32RH4-A	6 - 32	1.99	.38	.71	.141	3	H4
–	–	T822NC#06-32RH5-A	6 - 32	1.99	.38	.71	.141	3	H5
–	–	T822NC#06-32RH6-A	6 - 32	1.99	.38	.71	.141	3	H6
–	–	T822NC#06-32RH7-A	6 - 32	1.99	.38	.71	.141	3	H7
–	–	T822NF#06-40RH2-A	6 - 40	1.99	.38	.71	.141	3	H2
–	–	T822NF#06-40RH3-A	6 - 40	1.99	.38	.71	.141	3	H3
–	–	T822NC#08-32RH2-A	8 - 32	2.12	.38	.76	.168	3	H2
T822NC#08-32RH3-A *	T822NC#08-32RH3-A	T822NC#08-32RH3-A	8 - 32	2.12	.38	.76	.168	3	H3
T822NC#08-32RH4-A	–	–	8 - 32	2.12	.38	.76	.168	3	H4
–	–	T822NC#08-32RH5-A	8 - 32	2.12	.38	.76	.168	3	H5
–	–	T822NC#08-32RH6-A	8 - 32	2.12	.38	.76	.168	3	H6
–	–	T822NC#08-32RH7-A	8 - 32	2.12	.38	.76	.168	3	H7
–	–	T822NF#08-36RH2-A	8 - 36	2.12	.38	.76	.168	3	H2
T822NF#10-32RH3-A	T822NF#10-32RH3-A *	T822NF#10-32RH3-A	10 - 32	2.36	.50	.91	.194	3	H3
–	–	T822NF#10-32RH4-A	10 - 32	2.36	.50	.91	.194	3	H4
–	–	T822NF#10-32RH5-A	10 - 32	2.36	.50	.91	.194	3	H5
–	–	T822NF#10-32RH6-A	10 - 32	2.36	.50	.91	.194	3	H6
–	–	T822NF#10-32RH7-A	10 - 32	2.36	.50	.91	.194	3	H7
T822NC#10-24RH3-A	T822NC#10-24RH3-A	T822NC#10-24RH3-A *	10 - 24	2.37	.50	.91	.194	3	H3
–	–	T822NC#10-24RH5-A	10 - 24	2.37	.50	.91	.194	3	H5
–	–	T822NC#10-24RH7-A	10 - 24	2.37	.50	.91	.194	3	H7
–	–	T822NF#12-28RH3-A *	12 - 28	2.37	.50	.96	.220	3	H3

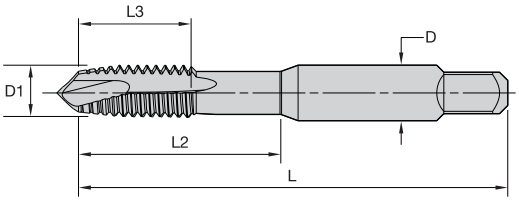
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
**Bright taps (KSU30) available.

Shank Tolerance

D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

- KSP32 TiCN/TiN
- KSMN34 TiN + CrC/C
- KSP39 oxide
- KSU30 bright**







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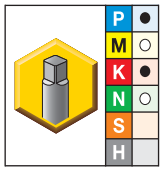
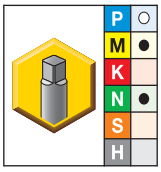
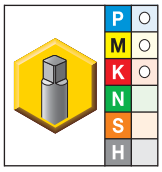






● first choice
○ alternate choice

KSP32	KSMN34	KSP39	D1 size	inch dimensions L	L3	L2	D	number of flutes	pitch diameter limit
T820M030X050RD3-A	**T820M030X050RD3-A**	**T820M030X050RD3-A**	M3 X 0,5	1.94	.58	.75	.141	2	D3
–	**–**	**T820M035X060RD4-A**	M3,5 X 0,6	1.99	.38	.71	.141	2	D4
T820M040X070RD4-A	**T820M040X070RD4-A**	**T820M040X070RD4-A**	M4 X 0,7	2.12	.38	.76	.168	2	D4
T820M050X080RD4-A	**T820M050X080RD4-A**	**T820M050X080RD4-A**	M5 X 0,8	2.37	.50	.91	.194	2	D4
T820M060X100RD5-A	**T820M060X100RD5-A**	**T820M060X100RD5-A**	M6 X 1	2.50	.63	1.00	.255	3	D5
–	**–**	**T820M070X100RD5-A**	M7 X 1	2.72	.69	1.15	.318	3	D5
–	**–**	**T820MF080X100RD5-A**	M8 X 1,0	2.71	.69	1.12	.318	3	D5
T820M080X125RD5-A	**T820M080X125RD5-A**	**T820M080X125RD5-A**	M8 X 1,25	2.71	.69	1.13	.318	3	D5
–	**–**	**T820MF100X125RD5-A**	M10 X 1,25	2.92	.74	1.25	.381	3	D5
T820M100X150RD6-A	**T820M100X150RD6-A ***	**T820M100X150RD6-A**	M10 X 1,50	2.92	.75	1.26	.381	3	D6
–	**–**	**T820MF120X125RD6-A**	M12 X 1,25	3.38	.94	1.74	.367	3	D6
–	**–**	**T820MF120X150RD6-A**	M12 X 1,5	3.38	.94	1.74	.367	3	D6
T820M120X175RD6-A	**T820M120X175RD6-A**	**T820M120X175RD6-A**	M12 X 1,75	3.38	.94	1.74	.367	3	D6
–	**–**	**T820MF140X150RD6-A**	M14 X 1,5	3.59	1.00	1.74	.429	3	D6
–	**–**	**T820M140X200RD7-A**	M14 X 2,0	3.59	1.00	1.74	.429	3	D7
–	**T820MF160X150RD6-A**	**T820MF160X150RD6-A**	M16 X 1,5	3.81	1.09	1.89	.480	3	D6
T820M160X200RD7-A	**T820M160X200RD7-A**	**T820M160X200RD7-A**	M16 X 2,0	3.81	1.09	1.89	.480	3	D7

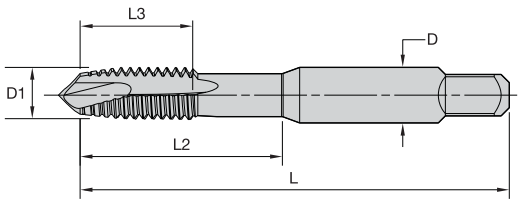
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
**Bright taps (KSU30) available.

Shank Tolerance

D inch	tolerance
0.141–0.635	+0, -.0015
>0.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

- KSP32 TiCN/TiN
- KSMN34 TiN + CrC/C
- KSP39 oxide
- KSU30 bright**







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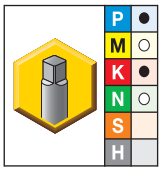
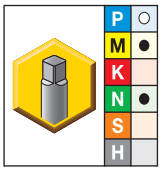
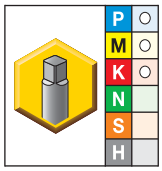






● first choice
○ alternate choice

KSP32	KSMN34	KSP39	D1 size	inch dimensions L	L3	L2	D	number of flutes	pitch diameter limit
T822M030X050RD3-A	T822M030X050RD3-A	T822M030X050RD3-A	M3 X 0,5	1.94	.58	.75	.141	3	D3
–	–	T822M035X060RD4-A *	M3,5 X 0,6	1.99	.38	.71	.141	3	D4
T822M040X070RD4-A *	T822M040X070RD4-A *	T822M040X070RD4-A *	M4 X 0,7	2.12	.38	.76	.168	3	D4
T822M050X080RD4-A	T822M050X080RD4-A	T822M050X080RD4-A	M5 X 0,8	2.37	.50	.91	.194	3	D4

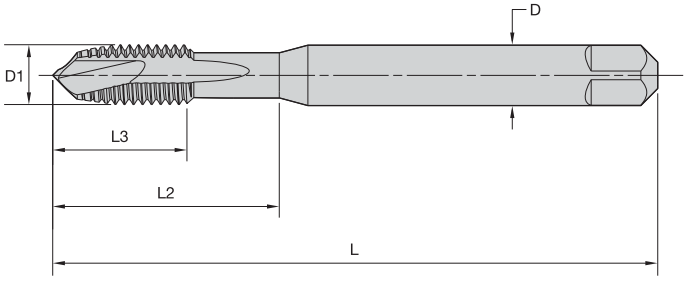
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
**Bright taps (KSU30) available.

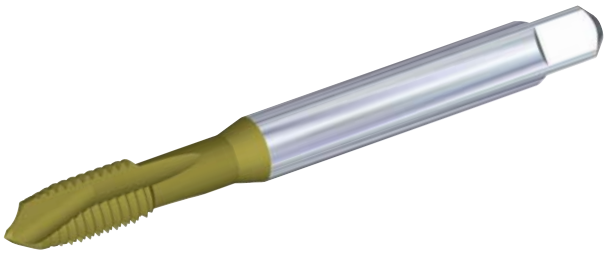
Shank Tolerance

D inch	tolerance
0.141–0.635	+0, -.0015
>0.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

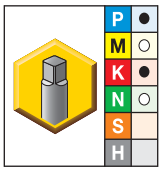
- KSP32 TiCN/TiN
- KSP39 oxide

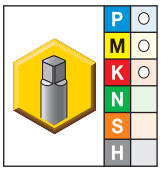






T820 • DIN 371, 374, and 376 • Form B Plug Chamfer • Metric



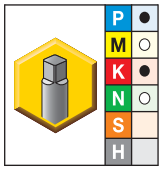


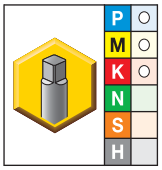
● first choice
○ alternate choice

KSP32	KSP39	metric dimensions 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

(continued)

(T820 • DIN 371, 374, and 376 • Form B Plug Chamfer • Metric — continued)





● first choice
○ alternate choice

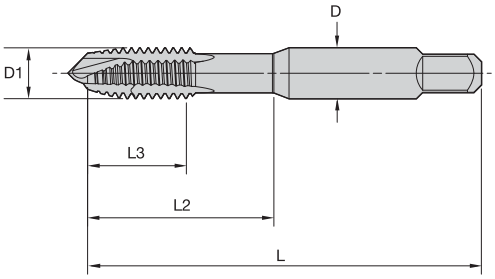
KSP32	KSP39	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
–	**T820M100X150R6G-D1**	M10 X 1,5	100	18	39	10,0	3	DIN 371	6G
–	**T820MF120X100R6H-D4**	M12 X 1	100	21	39	9,0	3	DIN 374	6H
–	**T820MF120X125R6H-D4**	M12 X 1,25	100	21	39	9,0	3	DIN 374	6H
–	**T820MF120X150R6H-D4**	M12 X 1,5	100	21	39	9,0	3	DIN 374	6H
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

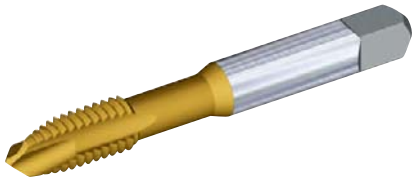
Shank Tolerance

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

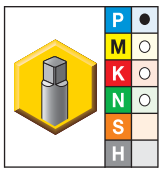
- KSU31 TiN
- KSU30 bright

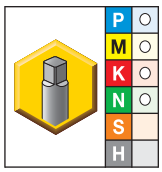






T820 • Form B Plug Chamfer • Metric • JIS





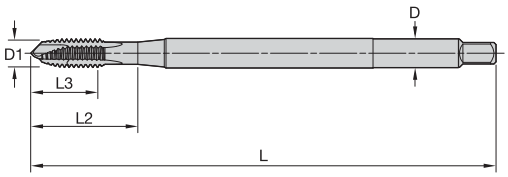
● first choice
○ alternate choice

KSU31	KSU30	metric dimensions 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

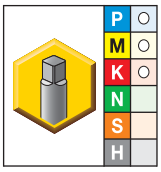
D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052







T820 • Form B Plug Chamfer • Machine Screw and Fractional • 4" Length • ANSI



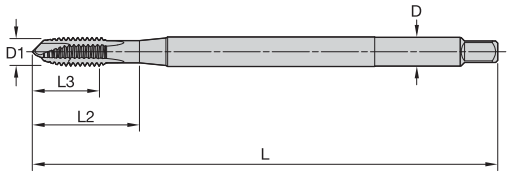
● first choice
○ alternate choice

KSP39	inch dimensions D1 TPI	L	L3	L2	D	number of flutes	pitch diameter limit
T820NC#04-40RH2-XL4	4 - 40	4.00	.56	.87	.141	2	H2
T820NC#06-32RH3-XL4	6 - 32	4.00	.38	.71	.141	2	H3
T820NC#08-32RH3-XL4	8 - 32	4.00	.38	.76	.168	2	H3
T820NC#10-24RH4-XL4	10 - 24	4.00	.50	.91	.194	2	H3
T820NF#10-32RH3-XL4	10 - 32	4.00	.50	.91	.194	2	H3
T820NC02500-20RH3-XL4	1/4 - 20	4.00	.63	1.01	.255	3	H3

Shank Tolerance

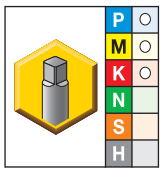
D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030







T820 • Form B Plug Chamfer • Machine Screw and Fractional • 6" Length • ANSI



● first choice
○ alternate choice

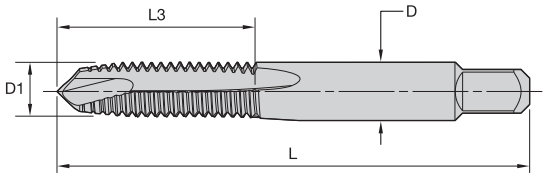
KSP39	D1 TPI	inch dimensions L	L3	L2	D	number of flutes	pitch diameter limit
T820NC#04-40RH2-XL6	4 - 40	6.00	.56	.87	.141	2	H2
T820NC#06-32RH3-XL6 *	6 - 32	6.00	.38	.71	.168	2	H3
T820NC#08-32RH3-XL6	8 - 32	6.00	.38	.76	.168	2	H3
T820NC#10-24RH3-XL6	10 - 24	6.00	.50	.91	.194	2	H3
T820NF#10-32RH3-XL6	10 - 32	6.00	.50	.91	.194	2	H3
T820NC02500-20RH3-XL6	1/4 - 20	6.00	.63	1.01	.255	3	H3
T820NF02500-28RH3-XL6	1/4 - 28	6.00	.63	1.01	.255	3	H3
T820NC03125-18RH3-XL6	5/16 - 18	6.00	.69	1.13	.318	3	H3
T820NF03125-24RH3-XL6	5/16 - 24	6.00	.69	1.13	.318	3	H3
T820NC03750-16RH3-XL6	3/8 - 16	6.00	.75	1.27	.381	3	H3
T820NF03750-24RH3-XL6 *	3/8 - 24	6.00	.75	1.27	.381	3	H3
T820NC04375-14RH3-XL6 *	7/16 - 14	6.00	.88	1.49	.323	3	H3
T820NF04375-20RH3-XL6 *	7/16 - 20	6.00	.88	1.49	.323	3	H3
T820NC05000-13RH3-XL6	1/2 - 13	6.00	.94	1.74	.367	3	H3
T820NF05000-20RH3-XL6	1/2 - 20	6.00	.94	1.74	.367	3	H3
T820NC06250-11RH3-XL6	5/8 - 11	6.00	1.09	1.89	.480	3	H3

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

Shank Tolerance

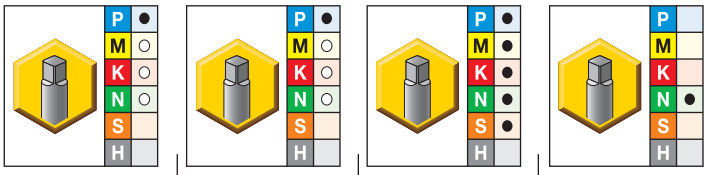
D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030







KHSST Spiral Point • Machine Screw and Fractional Sizes • Plug Chamfer Tap

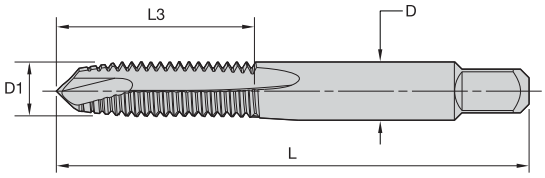


● first choice
○ alternate choice

TiCN	TiN	oxide	uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
KHSST28732	KHSST28733	–	KHSST28731	0 - 80	1.63	.31	.141	2	H2
–	–	–	KHSST28757	1 - 72	1.69	.38	.141	2	H2
–	KHSST09101	KHSST28252	KHSST08043	2 - 56	1.75	.44	.141	2	H2
–	–	–	KHSST08061	3 - 48	1.81	.50	.141	2	H2
KHSST28274	KHSST09103	KHSST28253	KHSST08090	4 - 40	1.88	.56	.141	2	H2
–	–	–	KHSST08104	4 - 48	1.88	.56	.141	2	H2
–	KHSST09104	–	KHSST08119	5 - 40	1.94	.63	.141	2	H2
–	KHSST09105	KHSST28254	KHSST08156	6 - 32	2.00	.69	.141	2	H2
KHSST28276	KHSST09106	KHSST28255	KHSST08157	6 - 32	2.00	.69	.141	2	H3
–	–	–	KHSST08175	6 - 40	2.00	.69	.141	2	H2
–	KHSST09108	KHSST28256	KHSST08203	8 - 32	2.13	.75	.168	2	H2
KHSST28277	KHSST09109	KHSST28257	KHSST08205	8 - 32	2.13	.75	.168	2	H3
–	–	–	KHSST28244 *	8 - 36	2.13	.75	.168	2	H2
–	–	–	KHSST08243	10 - 24	2.38	.88	.194	2	H2
KHSST09608	KHSST28113	KHSST28262	KHSST08245	10 - 24	2.38	.88	.194	2	H3
–	KHSST09111	KHSST28263	KHSST08280	10 - 32	2.38	.88	.194	2	H2
KHSST09609	KHSST09112	KHSST28264	KHSST08282	10 - 32	2.38	.88	.194	2	H3
–	–	–	KHSST28248	10 - 32	2.38	.88	.194	2	H7
–	KHSST09113	–	KHSST08296	12 - 24	2.38	.94	.220	2	H3
–	KHSST09114	–	KHSST08331	1/4 - 20	2.50	1.00	.255	2	H2
–	KHSST09115	KHSST28260	KHSST08332	1/4 - 20	2.50	1.00	.255	2	H3
KHSST09611	KHSST09116	–	KHSST08334	1/4 - 20	2.50	1.00	.255	3	H3
–	KHSST28111	–	KHSST08336	1/4 - 20	2.50	1.00	.255	2	H5
–	KHSST28112	KHSST28261	KHSST08364	1/4 - 28	2.50	1.00	.255	2	H3
–	KHSST09119	KHSST28267	KHSST08391	5/16 - 18	2.72	1.13	.318	2	H3
KHSST28275	–	–	KHSST08393	5/16 - 18	2.72	1.13	.318	3	H3
–	KHSST09120	KHSST28268	KHSST08419	5/16 - 24	2.72	1.13	.318	2	H3
KHSST09615	KHSST09121	KHSST28266	KHSST08443	3/8 - 16	2.94	1.25	.381	3	H3
–	–	–	KHSST08444	3/8 - 16	2.94	1.25	.381	3	H5
–	KHSST09122	–	KHSST08467	3/8 - 24	2.94	1.25	.381	3	H3
–	KHSST09123	KHSST28270	KHSST08484	7/16 - 14	3.16	1.44	.323	3	H3
–	KHSST09124	KHSST28271	KHSST08498	7/16 - 20	3.16	1.44	.323	3	H3
KHSST28272	KHSST09125	KHSST28258	KHSST08516	1/2 - 13	3.38	1.66	.367	3	H3
–	–	–	KHSST28245	1/2 - 13	3.38	1.66	.367	3	H5
–	KHSST09126	KHSST28259	KHSST08537	1/2 - 20	3.38	1.66	.367	3	H3
KHSST28273	KHSST09127	KHSST28269	KHSST08566	5/8 - 11	3.81	1.81	.480	3	H3
–	–	–	KHSST08578	5/8 - 18	3.81	1.81	.480	3	H3
–	KHSST09128	KHSST28265	KHSST08599	3/4 - 10	4.25	2.00	.590	3	H3
–	–	–	KHSST28249	3/4 - 10	4.25	2.00	.590	3	H5

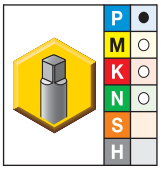
NOTE: Spiral-Point taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.







KHSST Oversized Spiral Point • Fractional Sizes • Plug Chamfer Taps

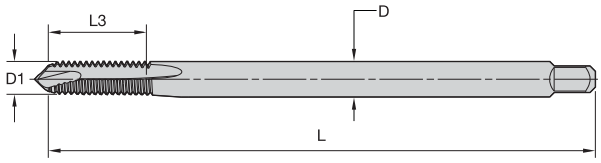


● first choice
○ alternate choice

uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
KHSST28247	1/4 - 20	2.50	1.00	.255	2	H11
KHSST28251	5/16 - 18	2.72	1.13	.318	2	H11
KHSST28250	3/8 - 16	2.94	1.25	.381	3	H11
KHSST28246	1/2 - 13	3.38	1.66	.367	3	H11

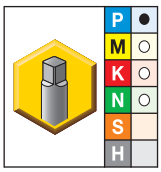
NOTE: Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.







KHSST Spiral Point 6" • Fractional Sizes • Plug Chamfer Taps

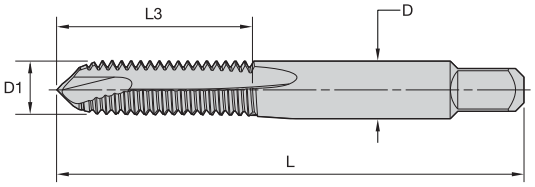


● first choice
○ alternate choice

uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
KHSST28776	6 - 32	6.00	.69	.141	2	H3
KHSST28784	8 - 32	6.00	.75	.168	2	H3
KHSST28737	10 - 24	6.00	.88	.194	2	H3
KHSST28744	10 - 32	6.00	.88	.194	2	H3
KHSST28072	1/4 - 20	6.00	1.00	.255	2	H3
KHSST28080 *	1/4 - 28	6.00	1.00	.255	2	H3
KHSST28209	5/16 - 18	6.00	1.13	.318	2	H3
KHSST28220 *	5/16 - 24	6.00	1.13	.318	2	H3
KHSST28192	3/8 - 16	6.00	1.25	.381	3	H3
KHSST28204	3/8 - 24	6.00	1.25	.381	3	H3

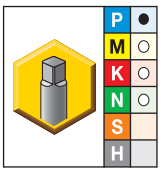
NOTE: Spiral-point taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.







KHSST Heavy-Duty Spiral Point • Machine Screw and Fractional • Plug Chamfer Taps

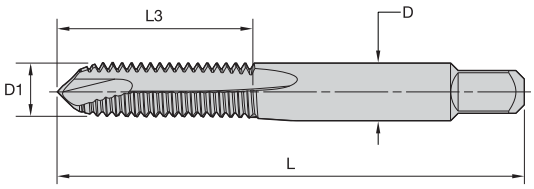


● first choice
○ alternate choice

oxide/nitride	D1 size	L	L3	D	number of flutes	pitch diameter limit
KHSST28526	6 - 32	2.00	.69	.141	3	H3
KHSST28527	8 - 32	2.13	.75	.168	3	H3
KHSST28531	10 - 24	2.38	.88	.194	3	H3
KHSST28532	10 - 32	2.38	.88	.194	3	H3
KHSST28529	1/4 - 20	2.50	1.00	.255	3	H3
KHSST28534	5/16 - 18	2.72	1.13	.318	3	H3
KHSST28528	1/2 - 13	3.38	1.66	.367	3	H3
KHSST28228 *	5/8 - 11	3.81	1.81	.480	3	H3
KHSST28162	3/4 - 10	4.25	2.00	.590	3	H3

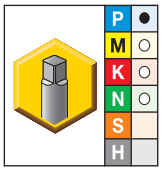
NOTE: Spiral-point taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.







KHSST Spiral Point • Machine Screw and Fractional • Bottoming-Chamfer Taps

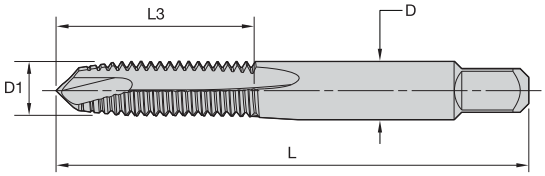


● first choice
○ alternate choice

uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
KHSST28730	0 - 80	1.63	.31	.141	2	H2
KHSST08044	2 - 56	1.75	.44	.141	3	H2
KHSST08091	4 - 40	1.88	.56	.141	2	H2
KHSST08159	6 - 32	2.00	.69	.141	2	H2
KHSST08160	6 - 32	2.00	.69	.141	2	H3
KHSST08246	10 - 24	2.38	.88	.194	2	H3
KHSST28743	10 - 32	2.38	.88	.194	2	H2
KHSST08333	1/4 - 20	2.50	1.00	.255	2	H3
KHSST28219	5/16 - 24	2.72	1.13	.318	2	H3

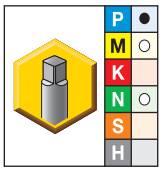
NOTE: Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.

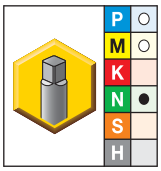






KHSST Spiral Point • Plug Chamfer Taps • Metric ANSI





● first choice
○ alternate choice

TiN	uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
–	**KHSST28681**	M1,6 X 0,35	1.63	.31	.1410	2	D3
–	**KHSST27711**	M2 X 0,4	1.75	.44	.1410	2	D3
–	**KHSST27719**	M2,5 X 0,45	1.81	.50	.1410	2	D3
KHSST09129	**KHSST27723**	M3 X 0,5	1.94	.63	.1410	2	D3
KHSST09130	**KHSST27731**	M4 X 0,7	2.13	.75	.1680	2	D4
KHSST09131	**KHSST27739**	M5 X 0,8	2.38	.88	.1940	2	D4
KHSST09132	**KHSST27743**	M6 X 1	2.50	1.00	.2550	2	D5
KHSST09133	**KHSST27751**	M8 X 1,25	2.72	1.13	.3180	2	D5
KHSST28152	**KHSST27759**	M10 X 1,5	2.94	1.25	.3810	3	D6
KHSST09135	**KHSST27767**	M12 X 1,75	3.38	1.66	.3670	3	D6
–	**KHSST28447**	M14 X 2	3.59	1.66	.4290	3	D7
–	**KHSST27787 ***	M16 X 2	3.81	1.81	.4800	3	D6
–	**KHSST28448**	M16 X 2	3.81	1.81	.4800	3	D7
–	**KHSST27798**	M20 X 2,5	4.47	2.00	.6520	3	D7

NOTE: Metric taps for 6H class of fit are suitable for MJ aerospace internal threading applications.
Metric taps are manufactured to USCTI specifications and dimensions.
Metric tap blank dimensions are equivalent to inch taps.
Refer to table on page M203 for the recommended pitch diameter limit for 6H class of fit.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

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.
- Aluminum.
- 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 optimized 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.

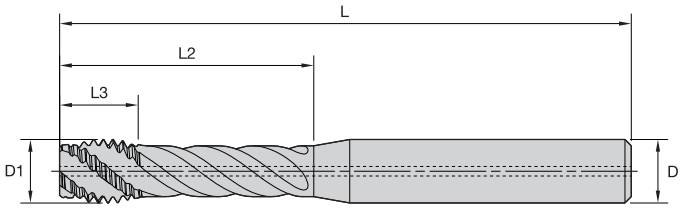


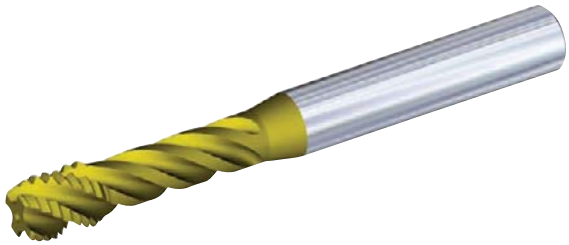
General-Purpose Taps

- HSS spiral-flute taps with a neck design for improved chip flow in blind holes.
- Wide range of sizes and pitch limits offered with PVD coatings and surface treatments.
- Heavy-duty spiral-flute taps ideal for blind-hole tapping in materials up to 30 Rc.

- KC7542 TiAlN + TiN for steel.

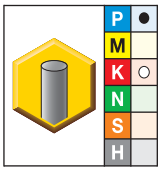






beyond

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

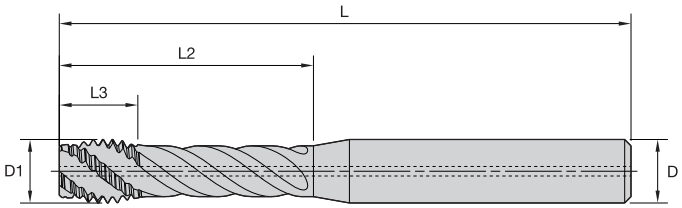
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

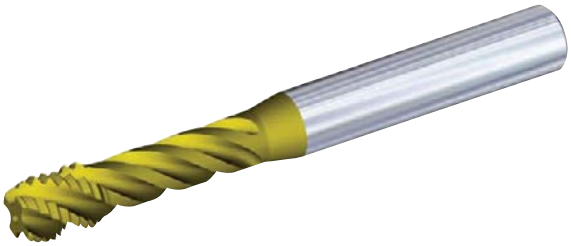
Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

• KC7542 TiAlN + TiN for steel.

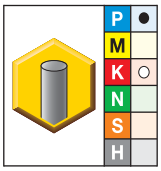






beyond

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

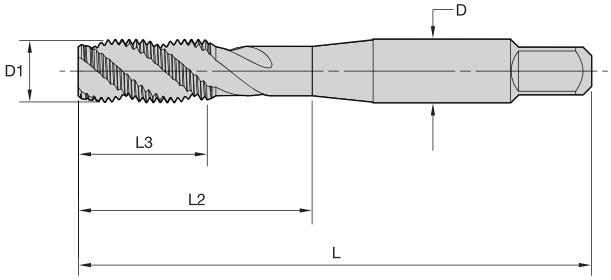
NOTE: Proprietary technology.

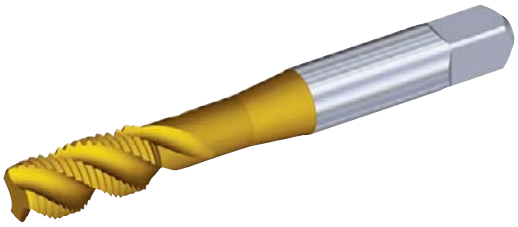
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

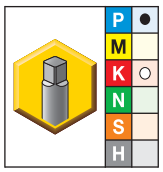
- KM6515 TiN + CrC/C for tapping stainless steel.
- KP6525 TiCN + TiN for tapping steel.

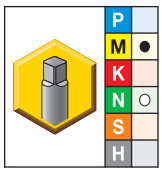






T630 • Form C Semi-Bottoming Chamfer • Metric ANSI • For Steel and Stainless Steel • Rigid and Synchronous Holders





● first choice
○ alternate choice

KP6525	KM6515	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T630NC#02-56R3BX-A *	T630NC#02-56R3BX-A	2 - 56	1.75	.44	.49	.141	2	ANSI	3BX
T630NC#04-40R3BX-A *	T630NC#04-40R3BX-A *	4 - 40	1.88	.56	.68	.141	2	ANSI	3BX
T630NC#04-40R2BX-A	T630NC#04-40R2BX-A *	4 - 40	1.88	.56	.68	.141	2	ANSI	2BX
T630NC#06-32R3BX-A	T630NC#06-32R3BX-A	6 - 32	1.99	.36	.71	.141	3	ANSI	3BX
T630NC#06-32R2BX-A *	T630NC#06-32R2BX-A	6 - 32	1.99	.36	.71	.141	3	ANSI	2BX
T630NC#08-32R3BX-A	T630NC#08-32R3BX-A	8 - 32	2.12	.31	.76	.168	3	ANSI	3BX
T630NF#10-32R2BX-A	T630NF#10-32R2BX-A	10 - 32	2.37	.47	.91	.194	3	ANSI	2BX
T630NF#10-32R3BX-A	T630NF#10-32R3BX-A	10 - 32	2.37	.47	.91	.194	3	ANSI	3BX
T630NC#10-24R3BX-A	T630NC#10-24R3BX-A	10 - 24	2.37	.47	.91	.194	3	ANSI	3BX
T630NF02500-28R2BX-A	T630NF02500-28R2BX-A *	1/4 - 28	2.50	.44	1.00	.255	3	ANSI	2BX
T630NF02500-28R3BX-A	T630NF02500-28R3BX-A	1/4 - 28	2.50	.44	1.00	.255	3	ANSI	3BX
T630NC02500-20R2BX-A	T630NC02500-20R2BX-A	1/4 - 20	2.50	.44	1.01	.255	3	ANSI	2BX
T630NC02500-20R3BX-A	T630NC02500-20R3BX-A	1/4 - 20	2.50	.44	1.01	.255	3	ANSI	3BX
T630NF03125-24R2BX-A	T630NF03125-24R2BX-A	5/16 - 24	2.72	.49	1.13	.318	3	ANSI	2BX
T630NF03125-24R3BX-A	T630NF03125-24R3BX-A	5/16 - 24	2.72	.49	1.13	.318	3	ANSI	3BX
T630NC03125-18R2BX-A	T630NC03125-18R2BX-A	5/16 - 18	2.72	.49	1.13	.318	3	ANSI	2BX
T630NC03125-18R3BX-A	T630NC03125-18R3BX-A	5/16 - 18	2.72	.49	1.13	.318	3	ANSI	3BX
T630NF03750-24R3BX-A	T630NF03750-24R3BX-A	3/8 - 24	2.93	.59	1.26	.381	3	ANSI	3BX
T630NC03750-16R2BX-A	T630NC03750-16R2BX-A	3/8 - 16	2.94	.60	1.27	.381	3	ANSI	2BX
T630NC03750-16R3BX-A	T630NC03750-16R3BX-A	3/8 - 16	2.94	.60	1.27	.381	3	ANSI	3BX
T630NC04375-14R3BX-A	T630NC04375-14R3BX-A *	7/16 - 14	3.16	.71	1.49	.323	5	ANSI	3BX
T630NF04375-20R3BX-A	T630NF04375-20R3BX-A *	7/16 - 20	3.16	.71	1.49	.323	5	ANSI	3BX
T630NC05000-13R3BX-A	T630NC05000-13R3BX-A	1/2 - 13	3.38	.77	1.74	.367	5	ANSI	3BX
T630NC05000-13R2BX-A	T630NC05000-13R2BX-A	1/2 - 13	3.38	.77	1.74	.367	4	ANSI	2BX
T630NF05000-20R3BX-A	T630NF05000-20R3BX-A	1/2 - 20	3.38	.77	1.74	.367	4	ANSI	3BX
T630NC06250-11R3BX-A	T630NC06250-11R3BX-A	5/8 - 11	3.81	.91	1.89	.480	5	ANSI	3BX
T630NC06250-11R2BX-A	T630NC06250-11R2BX-A	5/8 - 11	3.81	.91	1.89	.480	4	ANSI	2BX
—	T630NC07500-10R3BX-A *	3/4 - 10	4.25	1.00	2.08	.590	4	ANSI	3BX
T630NC07500-10R3BX-A	—	3/4 - 10	4.25	1.00	2.08	.590	5	ANSI	3BX
T630NC07500-10R2BX-A	T630NC07500-10R2BX-A	3/4 - 10	4.25	1.00	2.08	.590	4	ANSI	2BX
T630NC10000-08R3BX-A	T630NC10000-08R3BX-A *	1 - 8	5.13	1.25	2.58	.800	5	ANSI	3BX

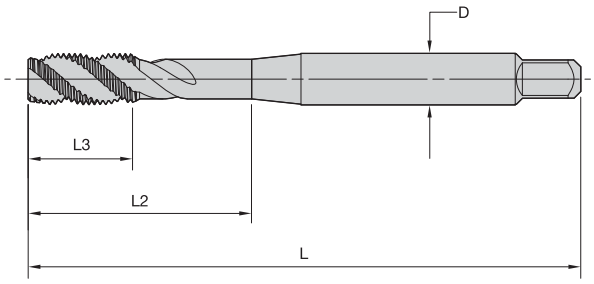
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

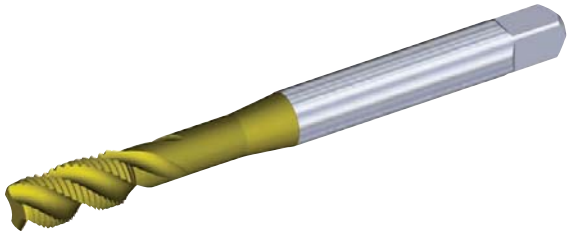
NOTE: Suggested for use in rigid and synchronous holders.

Shank Tolerance	
D fractional	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

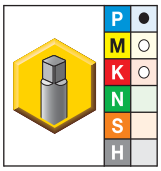
- KP6525 TiCN + TiN for steel.







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	metric dimensions 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

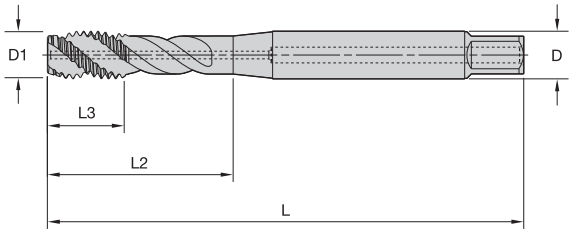
NOTE: Suggested for use in rigid and synchronous holders.

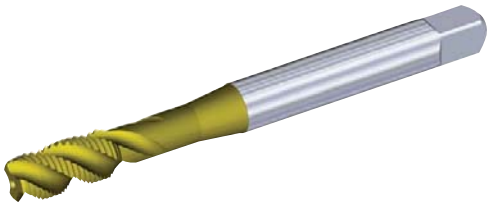
Shank Tolerance

D fractional	tolerance h6
>3–6	+0, -0,008
>6–10	+0, -0,009
<10–18	+0, -0,011

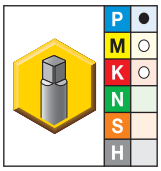
• KP6525 TiCN + TiN for steel.







T631 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Through Coolant • Fractional • For Steel • Rigid and Synchronous Holders



● first choice
○ alternate choice

KP6525	metric dimensions 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

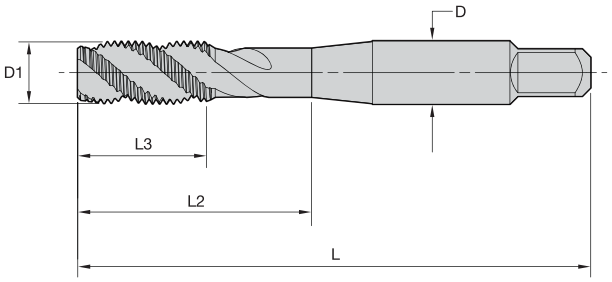
NOTE: Suggested for use in rigid and synchronous holders.

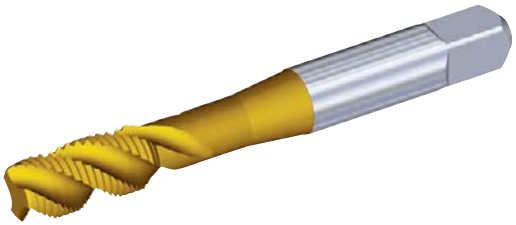
Shank Tolerance

D fractional	tolerance h6
>3–6	+0, -0,008
>6–10	+0, -0,009
<10–18	+0, -0,011

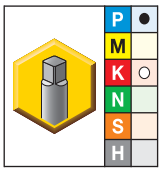
- KM6515 TiN + CrC/C for tapping stainless steel.
- KP6525 TiCN + TiN for tapping steel.

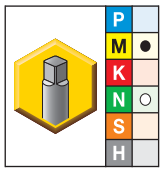






T630 • Form C Semi-Bottoming Chamfer • Metric ANSI • For Steel and Stainless Steel • Rigid and Synchronous Holders





● first choice
○ alternate choice

KP6525	KM6515	D1 size	L	L3	L2	D	number of flutes	class of fit
T630M030X050R6HX-A	T630M030X050R6HX-A *	M3 X 0,5	1.94	.63	.75	.141	2	6HX
T630M040X070R6HX-A	T630M040X070R6HX-A	M4 X 0,7	2.12	.32	.76	.168	3	6HX
T630M050X080R6HX-A	T630M050X080R6HX-A *	M5 X 0,8	2.37	.47	.91	.194	3	6HX
T630M060X100R6HX-A	T630M060X100R6HX-A	M6 X 1	2.50	.46	1.01	.255	3	6HX
T630M080X125R6HX-A	T630M080X125R6HX-A	M8 X 1,25	2.71	.48	1.12	.318	3	6HX
T630M100X150R6HX-A	T630M100X150R6HX-A	M10 X 1,5	2.92	.53	1.26	.381	3	6HX
T630M120X175R6HX-A	T630M120X175R6HX-A	M12 X 1,75	3.38	.77	1.74	.367	5	6HX
T630M140X200R6HX-A	T630M140X200R6HX-A	M14 X 2	3.59	.83	1.74	.429	5	6HX
T630M160X200R6HX-A	T630M160X200R6HX-A	M16 X 2	3.81	.91	1.89	.480	5	6HX

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

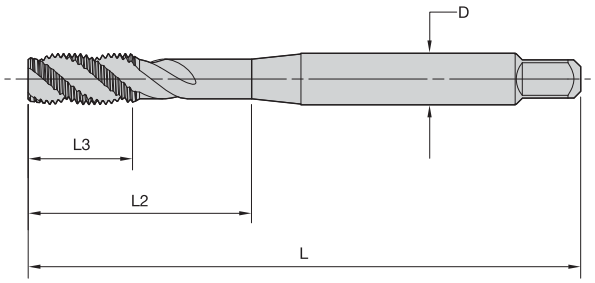
NOTE: Suggested for use in rigid and synchronous holders.

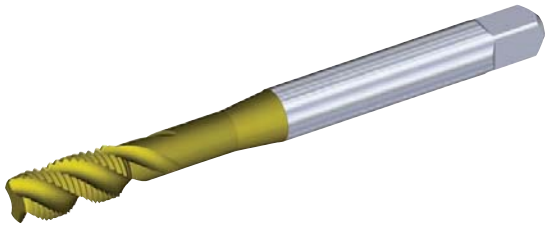
Shank Tolerance

D fractional	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

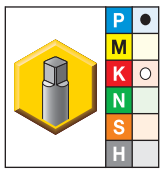
- KM6515 TiN + CrC/C for stainless steel.
- KP6525 TiCN + TiN for steel.

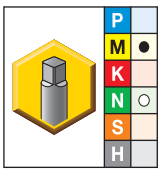






T630 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • For Steel and Stainless Steel • Rigid and Synchronous Holders





● 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

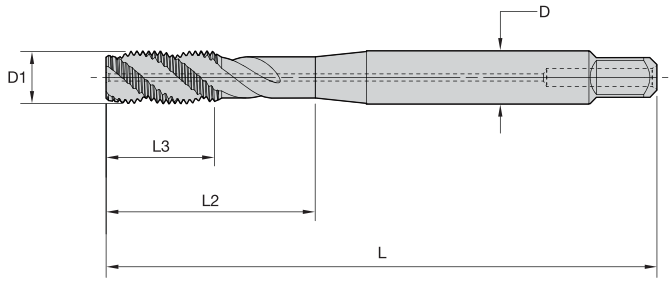
NOTE: Suggested for use in rigid and synchronous holders.

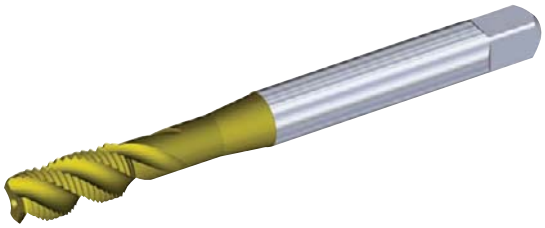
Shank Tolerance

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.







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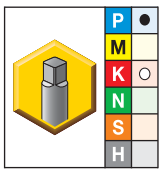
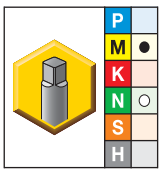




● first choice
○ alternate choice

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

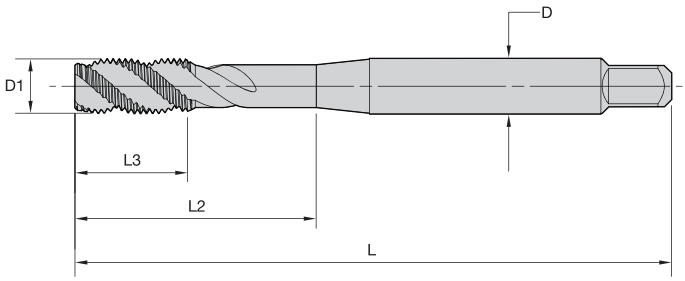
NOTE: Suggested for use in rigid and synchronous holders.

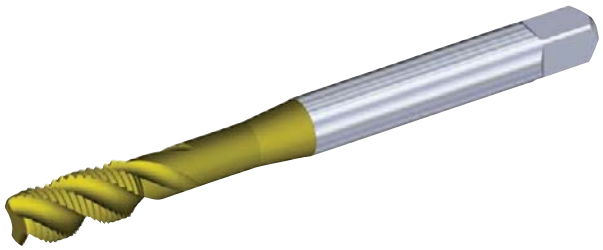
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

- KP6525 TiCN + TiN for tapping steel.







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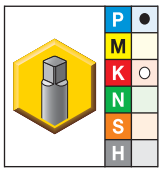


● first choice
○ alternate choice

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

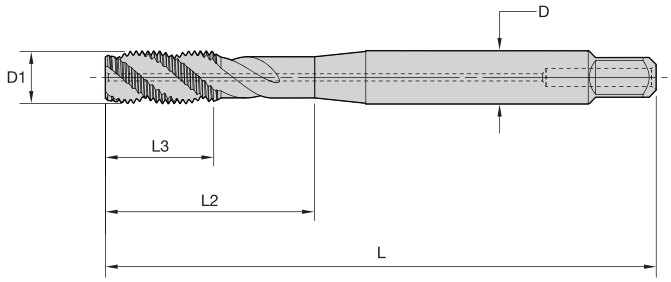
NOTE: Suggested for use in rigid and synchronous holders.

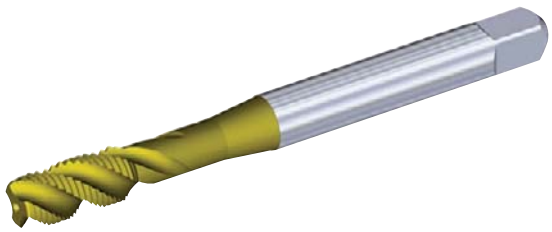
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

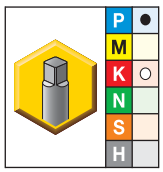
- KP6525 TiCN + TiN for tapping steel.







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

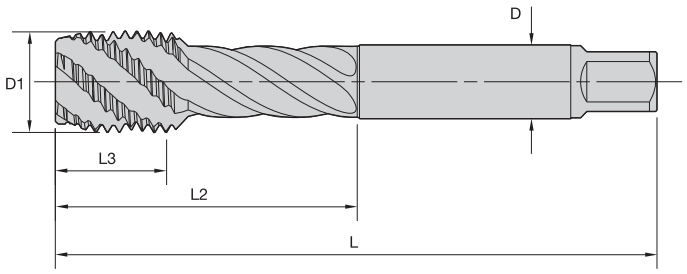
NOTE: Suggested for use in rigid and synchronous holders.

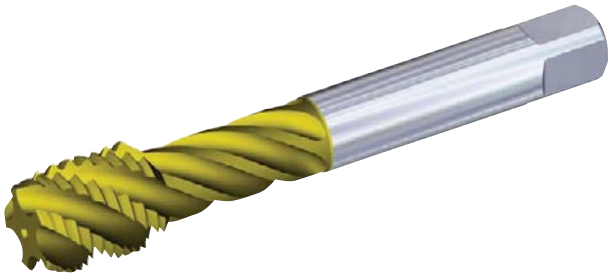
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

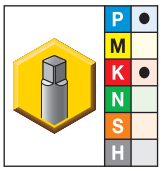
- KP6525 TiCN + TiN for tapping steel and cast iron.







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

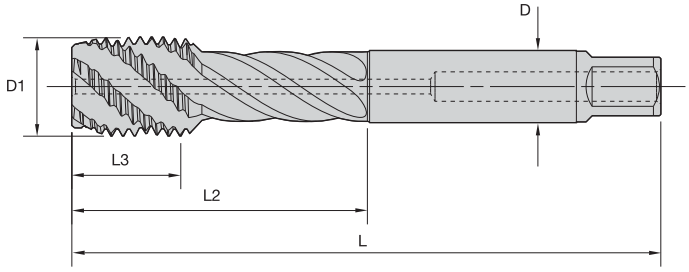
NOTE: Suggested for use in rigid and synchronous holders.

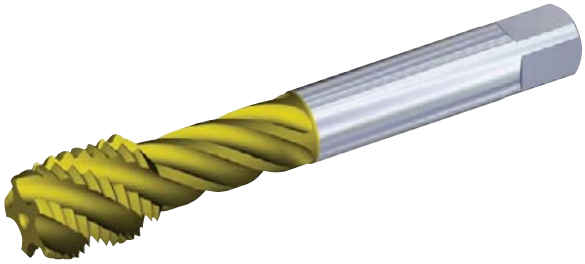
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

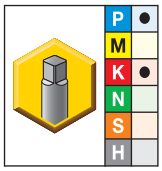
- KP6525 TiCN + TiN for tapping steel and cast iron.







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

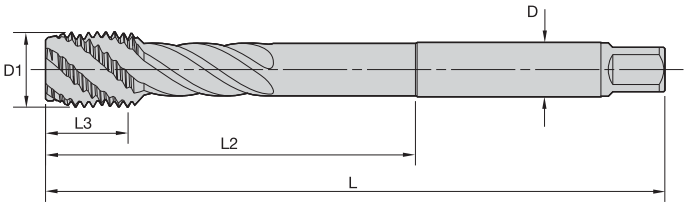
NOTE: Suggested for use in rigid and synchronous holders.

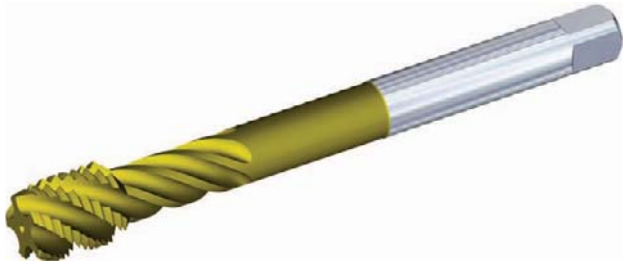
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

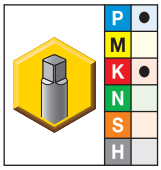
- KP6525 TiCN + TiN for tapping steel and cast iron.







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

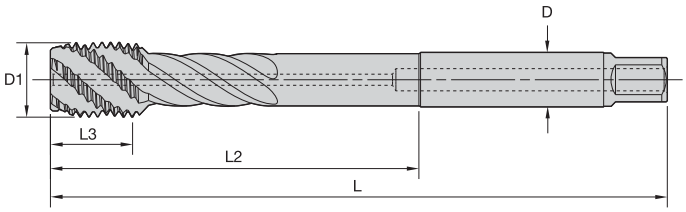
NOTE: Suggested for use in rigid and synchronous holders.

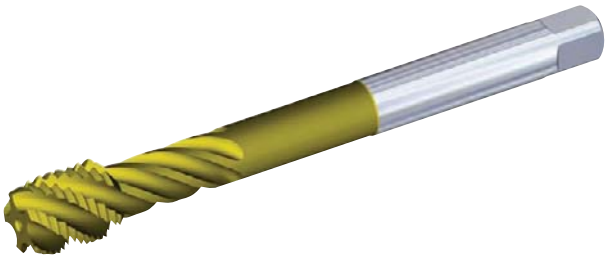
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

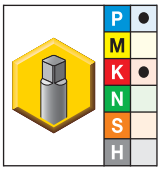
- KP6525 TiCN + TiN for tapping steel and cast iron.







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

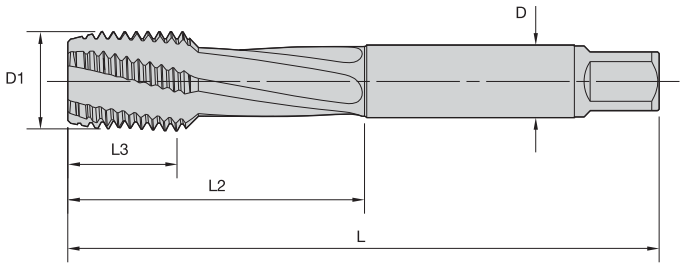
NOTE: Suggested for use in rigid and synchronous holders.

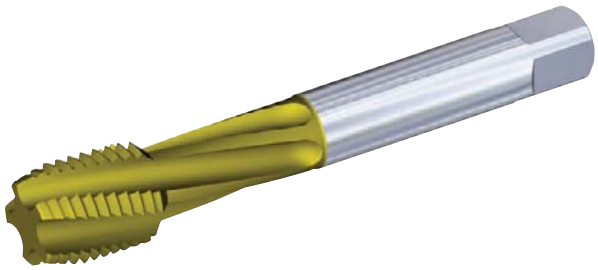
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

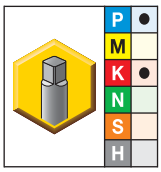
- KP6525 TiCN + TiN for tapping steel and cast iron.







T650 • DIN 376 • Form C Semi-Bottoming Chamfer • Larger Sizes • Metric • For Steel and Cast Iron



● first choice
○ alternate choice

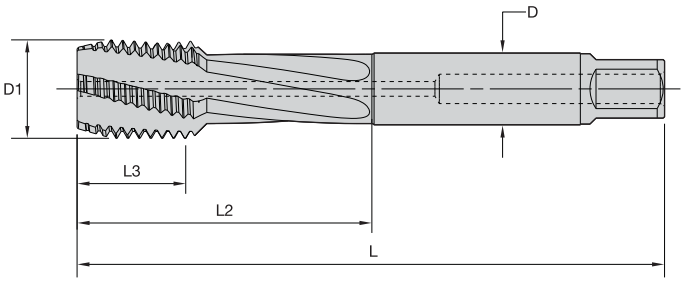
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T650M240X300R6HX-D6	M24 X 3	160	30	77	18,0	4	DIN 376	6HX
T650M300X350R6HX-D6	M30 X 3,5	180	35	91	22,0	5	DIN 376	6HX
T650M330X350R6HX-D6	M33 X 3,5	180	35	100	25,0	5	DIN 376	6HX
T650M360X400R6HX-D6	M36 X 4	200	40	110	28,0	5	DIN 376	6HX
T650M420X450R6HX-D6	M42 X 4,5	200	45	120	32,0	6	DIN 376	6HX

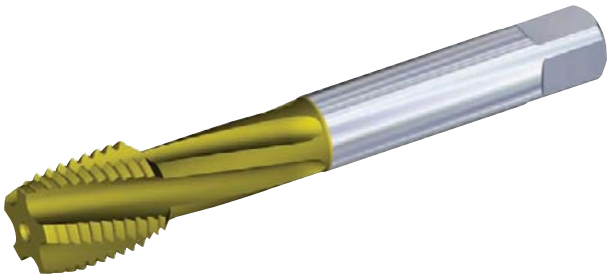
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

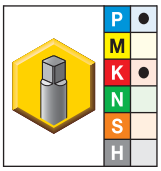
- KP6525 TiCN + TiN for tapping steel and cast iron.







T651 • DIN 376 • Form C Semi-Bottoming Chamfer • Through Coolant • Larger Sizes • Metric • For Steel and Cast Iron



● first choice
○ alternate choice

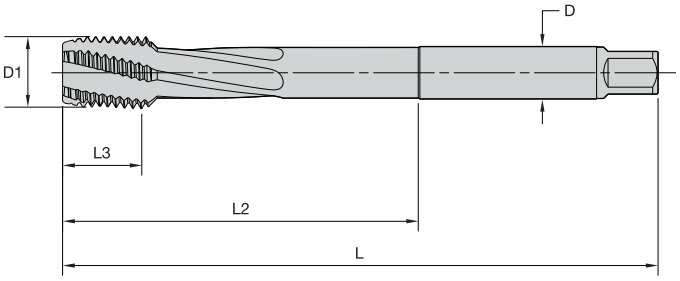
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T651M240X300R6HX-D6	M24 X 3	160	30	77	18,0	4	DIN 376	6HX
T651M300X350R6HX-D6	M30 X 3,5	180	35	91	22,0	5	DIN 376	6HX
T651M330X350R6HX-D6	M33 X 3,5	180	35	100	25,0	5	DIN 376	6HX
T651M360X400R6HX-D6	M36 X 4	200	40	110	28,0	5	DIN 376	6HX
T651M420X450R6HX-D6	M42 X 4,5	200	45	120	32,0	6	DIN 376	6HX

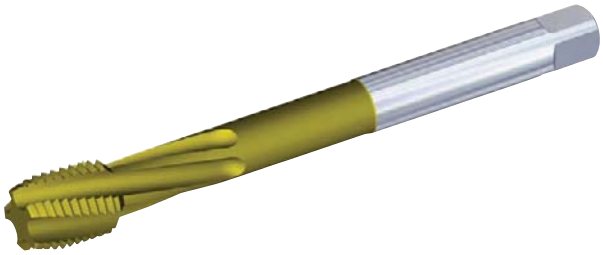
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

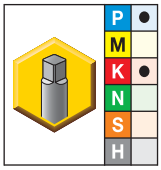
- KP6525 TiCN + TiN for tapping steel and cast iron.







T650 • Extra Long • Form C Semi-Bottoming Chamfer • Larger Sizes • Metric • For Steel and Cast Iron



● first choice
○ alternate choice

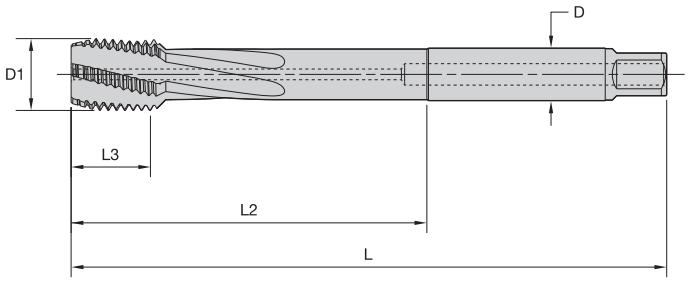
KP6525	D1 size	L	L3	L2	D	number of flutes	class of fit
T650M240X300R6HX-XL	M24 X 3	200	30	120	18,0	4	6HX
T650M300X350R6HX-XL	M30 X 3,5	250	35	150	22,0	5	6HX
T650M330X350R6HX-XL	M33 X 3,5	250	35	150	25,0	5	6HX
T650M360X400R6HX-XL	M36 X 4	250	40	150	28,0	5	6HX
T650M420X450R6HX-XL	M42 X 4,5	300	45	180	32,0	6	6HX

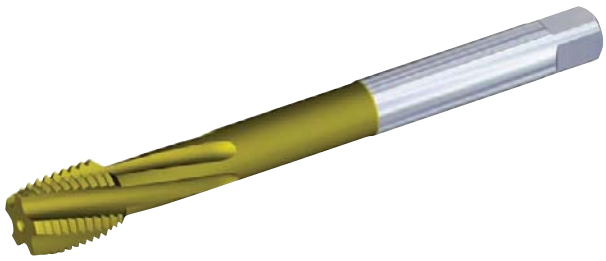
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

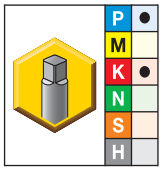
- KP6525 TiCN + TiN for tapping steel and cast iron.







T651 • Extra Long • Form C Semi-Bottoming Chamfer • Through Coolant • Larger Sizes • Metric • For Steel and Cast Iron



● first choice
○ alternate choice

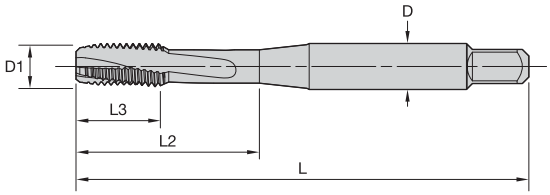
KP6525	D1 size	L	L3	L2	D	number of flutes	class of fit
T651M240X300R6HX-XL	M24 X 3	200	30	120	18,0	4	6HX
T651M300X350R6HX-XL	M30 X 3,5	250	35	150	22,0	5	6HX
T651M330X350R6HX-XL	M33 X 3,5	250	35	150	25,0	5	6HX
T651M360X400R6HX-XL	M36 X 4	250	40	150	28,0	5	6HX
T651M420X450R6HX-XL	M42 X 4,5	300	45	180	32,0	6	6HX

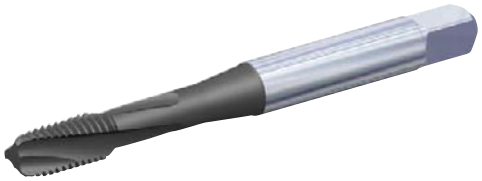
Shank Tolerance

D	tolerance h6
12–18	+0, -0,011
20–30	+0, -0,013
32–36	+0, -0,016

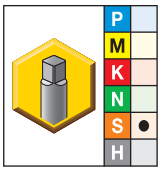
- KSS29 oxide/nitride for nickel- and cobalt-based alloys.
- KSP27 AlCrTiN for nickel- and cobalt-based alloys.

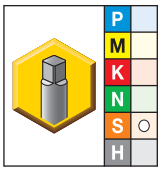






T692 • Machine Screw and Fractional • 3–4 Pitches Chamfer • ANSI • For Nickel- and Cobalt-Based Alloys



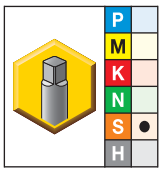


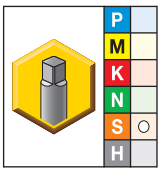
● first choice
○ alternate choice

KSP27	KSS29	D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T692NC#02-56RH2-A *	T692NC#02-56RH2-A	2 - 56	1.75	.44	.50	.141	3	H2
—	T692NC#03-48RH2-A	3 - 48	1.81	.50	.56	.141	3	H2
T692NC#04-40RH2-A	T692NC#04-40RH2-A	4 - 40	1.88	.56	.69	.141	3	H2
T692NC#04-40RH3-A	T692NC#04-40RH3-A	4 - 40	1.88	.56	.69	.141	3	H3
—	T692NF#04-40RH5-A	4 - 40	1.88	.56	.69	.141	3	H5
—	T692NC#05-40RH2-A	5 - 40	1.95	.63	.76	.141	3	H2
—	T692NC#06-32RH2-A	6 - 32	1.99	.36	.71	.141	3	H2
T692NC#06-32RH3-A	T692NC#06-32RH3-A	6 - 32	1.99	.36	.71	.141	3	H3
—	T692NC#06-32RH5-A	6 - 32	2.03	.36	.71	.141	3	H5
T692NC#06-32RH7-A	T692NC#06-32RH7-A	6 - 32	2.03	.36	.71	.141	3	H7
—	T692NF#06-40RH2-A	6 - 40	2.03	.36	.71	.141	3	H2
—	T692NC#08-32RH2-A	8 - 32	2.16	.31	.76	.168	3	H2
T692NC#08-32RH3-A	T692NC#08-32RH3-A	8 - 32	2.12	.31	.76	.168	3	H3
T692NC#08-32RH4-A	T692NC#08-32RH4-A	8 - 32	2.16	.31	.76	.168	3	H4
T692NC#08-32RH5-A *	T692NC#08-32RH5-A	8 - 32	2.16	.31	.76	.168	3	H5
—	T692NC#08-32RH6-A	8 - 32	2.16	.31	.76	.168	3	H6
—	T692NC#10-24RH3-A	10 - 24	2.37	.47	.91	.194	3	H3
T692NC#10-24RH5-A	T692NC#10-24RH5-A	10 - 24	2.42	.47	.91	.194	3	H5
T692NF#10-32RH2-A	T692NF#10-32RH2-A	10 - 32	2.37	.47	.91	.194	3	H2
T692NF#10-32RH3-A	T692NF#10-32RH3-A	10 - 32	2.37	.47	.91	.194	3	H3
—	T692NF#10-32RH5-A	10 - 32	2.42	.47	.91	.194	3	H5
—	T692NF#10-32RH7-A	10 - 32	2.42	.47	.91	.194	3	H7
T692NC02500-20RH3-A	T692NC02500-20RH3-A	1/4 - 20	2.50	.44	1.00	.255	3	H3
—	T692NC02500-20RH5-A	1/4 - 20	2.50	.44	1.00	.255	3	H5
T692NF02500-28RH3-A	T692NF02500-28RH3-A	1/4 - 28	2.50	.44	1.00	.255	3	H3
—	T692NF02500-28RH5-A	1/4 - 28	2.50	.44	1.00	.255	3	H5
—	T692NF02500-28RH6-A	1/4 - 28	2.50	.44	1.00	.255	3	H6
—	T692NF02500-28RH7-A	1/4 - 28	2.50	.44	1.00	.255	3	H7
T692NC03125-18RH3-A	T692NC03125-18RH3-A	5/16 - 18	2.72	.49	1.13	.318	3	H3
T692NC03125-18RH5-A	T692NC03125-18RH5-A	5/16 - 18	2.72	.49	1.13	.318	3	H5
—	T692NC03125-18RH7-A	5/16 - 18	2.72	.49	1.13	.318	3	H7
T692NF03125-24RH3-A	T692NF03125-24RH3-A	5/16 - 24	2.72	.49	1.13	.318	3	H3

(continued)

(T692 • Machine Screw and Fractional • 3–4 Pitches Chamfer • ANSI • For Nickel- and Cobalt-Based Alloys — continued)





● first choice
○ alternate choice

KSP27	KSS29	D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
—	T692NF03125-24RH4-A	5/16 - 24	2.72	.49	1.13	.318	3	H4
—	T692NF03125-24RH5-A	5/16 - 24	2.72	.49	1.13	.318	3	H5
—	T692NF03125-24RH6-A	5/16 - 24	2.72	.49	1.13	.318	3	H6
—	T692NF03125-24RH7-A	5/16 - 24	2.72	.49	1.13	.318	3	H7
T692NC03750-16RH3-A	T692NC03750-16RH3-A	3/8 - 16	2.94	.60	1.27	.381	3	H3
T692NC03750-16RH5-A *	T692NC03750-16RH5-A	3/8 - 16	2.94	.60	1.27	.381	3	H5
T692NF03750-24RH3-A	T692NF03750-24RH3-A	3/8 - 24	2.94	.60	1.27	.381	3	H3
T692NF03750-24RH4-A	T692NF03750-24RH4-A	3/8 - 24	2.94	.60	1.27	.381	3	H4
T692NF03750-24RH5-A	T692NF03750-24RH5-A	3/8 - 24	2.94	.60	1.27	.381	3	H5
—	T692NF03750-24RH6-A	3/8 - 24	2.94	.60	1.27	.381	3	H6
—	T692NC04375-14RH3-A	7/16 - 14	3.16	.71	1.49	.323	3	H3
—	T692NC04375-14RH5-A	7/16 - 14	3.16	.71	1.49	.323	3	H5
T692NF04375-20RH3-A	T692NF04375-20RH3-A	7/16 - 20	3.16	.71	1.49	.323	3	H3
—	T692NF04375-20RH5-A	7/16 - 20	3.16	.71	1.49	.323	3	H5
T692NC05000-13RH3-A	T692NC05000-13RH3-A	1/2 - 13	3.38	.77	1.74	.367	3	H3
T692NC05000-13RH5-A	T692NC05000-13RH5-A	1/2 - 13	3.38	.77	1.74	.367	3	H5
T692NF05000-20RH3-A	T692NF05000-20RH3-A	1/2 - 20	3.38	.77	1.74	.367	3	H3
T692NF05000-20RH5-A	T692NF05000-20RH5-A	1/2 - 20	3.38	.77	1.74	.367	3	H5
—	T692NF05000-20RH7-A	1/2 - 20	3.38	.77	1.74	.367	3	H7
T692NC06250-11RH3-A	T692NC06250-11RH3-A	5/8 - 11	3.81	.91	1.89	.480	3	H3
—	T692NC06250-11RH5-A	5/8 - 11	3.81	1.31	1.89	.480	3	H5
—	T692NC06250-11RH7-A	5/8 - 11	3.81	.91	1.89	.480	3	H7
—	T692NF06250-18RH3-A	5/8 - 18	3.81	1.31	1.89	.480	3	H3
—	T692NC07500-10RH3-A	3/4 - 10	4.25	1.59	2.08	.590	3	H3
—	T692NC07500-10RH5-A	3/4 - 10	4.25	1.00	2.08	.590	3	H5
—	T692NF07500-16RH3-A	3/4 - 16	4.25	1.00	2.08	.590	3	H3
—	T692NF07500-16RH5-A	3/4 - 16	4.25	1.00	2.08	.590	3	H5

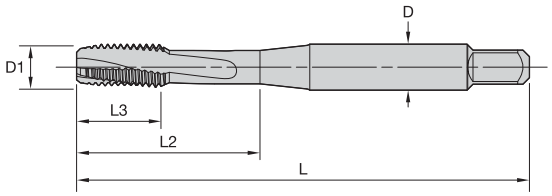
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

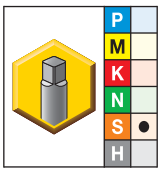
- KSS29 oxide/nitride for nickel- and cobalt-based alloys.
- KSP27 AlCrTiN for nickel- and cobalt-based alloys.

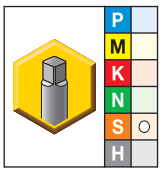






T692 • 3–4 Pitches Chamfer • Metric ANSI • For Nickel- and Cobalt-Based Alloys





● first choice
○ alternate choice

KSP27	KSS29	D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T692M025X045RD3-A	**T692M025X045RD3-A**	M2,5 X 0,45	1.81	.50	.56	.141	3	D3
T692M030X050RD3-A	**T692M030X050RD3-A** *	M3 X 0,5	1.94	.63	.75	.141	3	D3
T692M040X070RD4-A *	**T692M040X070RD4-A**	M4 X 0,7	2.12	.32	.76	.168	3	D4
T692M050X080RD4-A	**T692M050X080RD4-A**	M5 X 0,8	2.37	.47	.91	.194	3	D4
T692M060X100RD5-A	**T692M060X100RD5-A**	M6 X 1	2.50	.46	1.00	.255	3	D5
T692MF080X100RD5-A	**T692MF080X100RD5-A**	M8 X 1	2.70	.48	1.12	.318	3	D5
T692M080X125RD5-A	**T692M080X125RD5-A**	M8 X 1,25	2.70	.48	1.12	.318	3	D5
T692MF100X125RD5-A	**T692MF100X125RD5-A**	M10 X 1,25	2.92	.53	1.26	.381	3	D5
T692M100X150RD6-A	**T692M100X150RD6-A**	M10 X 1,5	2.92	.53	1.26	.381	3	D6
T692M120X175RD6-A *	**T692M120X175RD6-A**	M12 X 1,75	3.38	.77	1.74	.367	3	D6

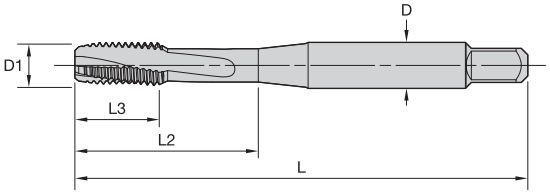
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

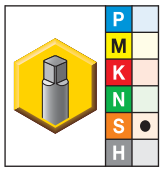
- KSS29 oxide/nitride for nickel- and cobalt-based alloys.
- KSP27 AlCrTiN for nickel- and cobalt-based alloys.

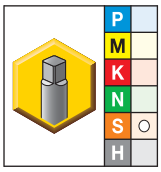






T694 • Machine Screw and Fractional • Form E Bottoming Chamfer • ANSI • For Nickel- and Cobalt-Based Alloys





● first choice
○ alternate choice

KSP27	KSS29	D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T694NC#04-40RH2-A	T694NC#04-40RH2-A	4 - 40	1.88	.56	.70	.141	3	H2
—	T694NC#04-40RH3-A	4 - 40	1.88	.56	.69	.141	3	H3
—	T694NC#05-40RH2-A	5 - 40	1.95	.63	.76	.141	3	H2
T694NC#06-32RH3-A	T694NC#06-32RH3-A	6 - 32	1.99	.36	.71	.141	3	H3
—	T694NC#06-32RH5-A	6 - 32	2.03	.36	.71	.141	3	H5
—	T694NF#06-40RH2-A	6 - 40	2.03	.36	.71	.141	3	H2
T694NC#08-32RH3-A	T694NC#08-32RH3-A	8 - 32	2.12	.31	.76	.168	3	H3
T694NC#10-24RH3-A	T694NC#10-24RH3-A	10 - 24	2.42	.47	.91	.194	3	H3
T694NF#10-32RH3-A	T694NF#10-32RH3-A	10 - 32	2.37	.47	.91	.194	3	H3
T694NC02500-20RH3-A *	T694NC02500-20RH3-A	1/4 - 20	2.50	.44	1.00	.255	3	H3
—	T694NC02500-20RH5-A *	1/4 - 20	2.50	.44	1.00	.255	3	H5
T694NF02500-28RH3-A	T694NF02500-28RH3-A	1/4 - 28	2.50	.44	1.00	.255	3	H3
—	T694NF02500-28RH4-A	1/4 - 28	2.50	.44	1.00	.255	3	H4
T694NC03125-18RH3-A *	T694NC03125-18RH3-A	5/16 - 18	2.72	.49	1.13	.318	3	H3
T694NF03125-24RH3-A *	T694NF03125-24RH3-A	5/16 - 24	2.72	.49	1.13	.318	3	H3
—	T694NF03125-24RH4-A	5/16 - 24	2.72	.49	1.13	.318	3	H4
T694NC03750-16RH3-A	T694NC03750-16RH3-A	3/8 - 16	2.94	.60	1.27	.381	3	H3
—	T694NC03750-16RH5-A	3/8 - 16	2.94	.60	1.27	.381	3	H5
T694NF03750-24RH3-A	T694NF03750-24RH3-A	3/8 - 24	2.94	.60	1.27	.381	3	H3
—	T694NF03750-24RH4-A	3/8 - 24	2.94	.60	1.27	.381	3	H4
—	T694NC04375-14RH5-A	7/16 - 14	3.16	.71	1.49	.323	3	H5
T694NF04375-20RH3-A	T694NF04375-20RH3-A	7/16 - 20	3.16	.71	1.49	.323	3	H3
—	T694NF04375-20RH5-A	7/16 - 20	3.16	.71	1.49	.323	3	H5
—	T694NC05000-13RH5-A	1/2 - 13	3.38	.77	1.74	.367	3	H5
—	T694NF05000-20RH5-A	1/2 - 20	3.38	.77	1.74	.367	3	H5
T694NC06250-11RH3-A	T694NC06250-11RH3-A	5/8 - 11	3.81	.91	1.89	.480	3	H3
T694NF06250-18RH3-A	T694NF06250-18RH3-A	5/8 - 18	3.81	.91	1.89	.480	3	H3

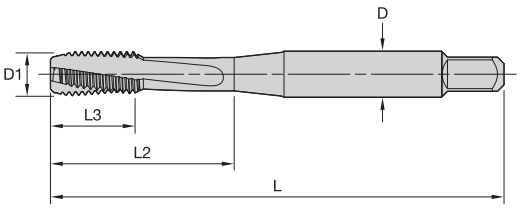
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

- KSS20 nitride for titanium and titanium alloys.
- KSSM24 TiN + CrC/C for titanium and titanium alloys.







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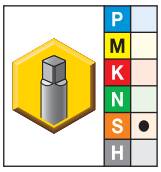
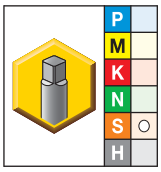


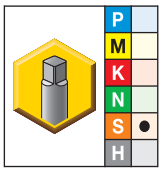


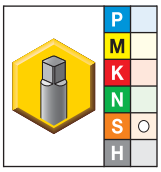
● first choice
○ alternate choice

KSSM24	KSS20	D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T662NC#02-56RH2-A	T662NC#02-56RH2-A *	2 - 56	1.75	.44	.50	.141	3	H2
T662NC#04-40RH2-A	T662NC#04-40RH2-A	4 - 40	1.88	.56	.69	.142	3	H2
T662NC#06-32RH2-A *	T662NC#06-32RH2-A *	6 - 32	1.99	.36	.71	.141	3	H2
T662NC#06-32RH3-A *	T662NC#06-32RH3-A	6 - 32	1.99	.36	.71	.141	3	H3
T662NF#06-40RH2-A	T662NF#06-40RH2-A	6 - 40	1.99	.36	.71	.141	3	H2
T662NC#08-32RH2-A	T662NC#08-32RH2-A	8 - 32	2.12	.31	.77	.168	3	H2
T662NC#08-32RH3-A	T662NC#08-32RH3-A	8 - 32	2.12	.31	.77	.168	3	H3
T662NF#08-36RH2-A *	T662NF#08-36RH2-A	8 - 36	2.12	.31	.77	.168	3	H2
T662NC#10-24RH3-A	T662NC#10-24RH3-A	10 - 24	2.37	.47	.92	.194	3	H3
T662NF#10-32RH2-A *	T662NF#10-32RH2-A	10 - 32	2.37	.47	.91	.194	3	H2
T662NF#10-32RH3-A *	T662NF#10-32RH3-A	10 - 32	2.37	.47	.91	.194	3	H3
T662NC02500-20RH3-A	T662NC02500-20RH3-A	1/4 - 20	2.50	.44	1.01	.255	3	H3
T662NC02500-20RH5-A	T662NC02500-20RH5-A	1/4 - 20	2.50	.44	1.00	.255	3	H5
T662NF02500-28RH3-A	T662NF02500-28RH3-A	1/4 - 28	2.50	.44	1.01	.255	3	H3
T662NF02500-28RH4-A *	T662NF02500-28RH4-A	1/4 - 28	2.50	.44	1.01	.255	3	H4
T662NF02500-28RH5-A	T662NF02500-28RH5-A	1/4 - 28	2.50	.44	1.01	.255	3	H5
T662NC03125-18RH3-A	T662NC03125-18RH3-A	5/16 - 18	2.72	.49	1.13	.318	3	H3
T662NC03125-18RH5-A	T662NC03125-18RH5-A *	5/16 - 18	2.72	.49	1.13	.318	3	H5
T662NF03125-24RH3-A	T662NF03125-24RH3-A *	5/16 - 24	2.72	.49	1.13	.318	3	H3
T662NF03125-24RH4-A	T662NF03125-24RH4-A	5/16 - 24	2.72	.49	1.13	.318	3	H4
T662NC03750-16RH3-A	T662NC03750-16RH3-A	3/8 - 16	2.93	.59	1.26	.381	3	H3
T662NC03750-16RH5-A *	T662NC03750-16RH5-A	3/8 - 16	2.93	.59	1.26	.381	3	H5
T662NF03750-24RH3-A *	T662NF03750-24RH3-A *	3/8 - 24	2.93	.59	1.26	.381	3	H3
T662NF03750-24RH4-A	T662NF03750-24RH4-A	3/8 - 24	2.93	.59	1.26	.381	3	H4
T662NC04375-14RH3-A	T662NC04375-14RH3-A	7/16 - 14	3.16	.71	1.49	.323	3	H3
T662NC04375-14RH5-A	T662NC04375-14RH5-A	7/16 - 14	3.16	.71	1.49	.323	3	H5
T662NF04375-20RH3-A	T662NF04375-20RH3-A *	7/16 - 20	3.16	.71	1.49	.323	3	H3
T662NF04375-20RH5-A	T662NF04375-20RH5-A	7/16 - 20	3.16	.71	1.49	.323	3	H5

(continued)

(T662 • Machine Screw and Fractional • Form C Semi-Bottoming Chamfer • ANSI • For Titanium and Titanium Alloys — continued)





● first choice
○ alternate choice

KSSM24	KSS20	D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T662NC05000-13RH3-A	T662NC05000-13RH3-A *	1/2 - 13	3.38	.77	1.74	.367	3	H3
T662NC05000-13RH5-A	T662NC05000-13RH5-A	1/2 - 13	3.38	.77	1.74	.367	3	H5
T662NF05000-20RH3-A	T662NF05000-20RH3-A	1/2 - 20	3.38	.77	1.74	.367	3	H3
T662NF05000-20RH5-A	T662NF05000-20RH5-A	1/2 - 20	3.38	.77	1.74	.367	3	H5
T662NF05625-18RH3-A	—	9/16 - 18	3.59	.83	1.74	.429	4	H3
T662NF05625-18RH5-A	—	9/16 - 18	3.59	.83	1.74	.429	4	H5
T662NC06250-11RH3-A	—	5/8 - 11	3.81	.91	1.89	.480	4	H3
T662NF06250-18RH3-A	—	5/8 - 18	3.81	.91	1.89	.480	4	H3
T662NF06250-18RH5-A	—	5/8 - 18	3.81	.91	1.89	.480	4	H5
T662NC07500-10RH5-A	—	3/4 - 10	4.25	1.00	2.08	.590	4	H5
T662NF07500-16RH3-A	—	3/4 - 16	4.25	1.00	2.08	.590	4	H3
T662NF07500-16RH5-A	—	3/4 - 16	4.25	1.00	2.08	.590	4	H5
T662NC10000-08RH5-A	—	1 - 8	5.12	1.25	2.58	.800	4	H5

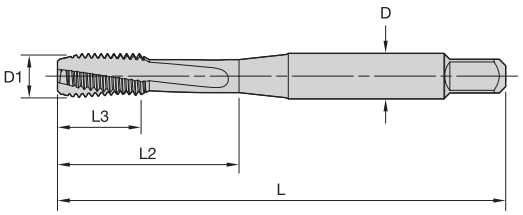
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

- KSS20 nitride for titanium and titanium alloys.
- KSSM24 TiN + CrC/C for titanium and titanium alloys.







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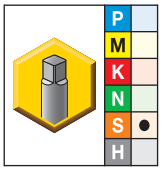
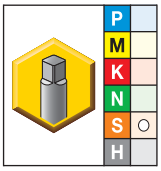




● first choice
○ alternate choice

KSSM24	KSS20	D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T662M025X045RD3-A	**T662M025X045RD3-A ***	M2,5 X 0,45	1.81	.50	.56	.141	3	D3
T662M030X050RD3-A	**T662M030X050RD3-A**	M3 X 0,5	1.94	.63	.75	.141	3	D3
T662M040X070RD4-A	**T662M040X070RD4-A**	M4 X 0,7	2.12	.32	.76	.168	3	D4
T662M050X080RD4-A	**T662M050X080RD4-A**	M5 X 0,8	2.37	.46	.91	.194	3	D4
T662M060X100RD5-A	**T662M060X100RD5-A**	M6 X 1	2.50	.46	1.00	.255	3	D5
T662M070X100RD5-A	**T662M070X100RD5-A**	M7 X 1	2.72	.52	1.15	.318	3	D5
T662M080X125RD5-A	**T662M080X125RD5-A ***	M8 X 1,25	2.70	.48	1.12	.318	3	D5
T662MF100X125RD5-A *	**T662MF100X125RD5-A ***	M10 X 1,25	2.93	.53	1.26	.381	3	D5
T662M100X150RD6-A *	**T662M100X150RD6-A**	M10 X 1,5	2.93	.53	1.26	.381	3	D6
T662M120X175RD6-A	**T662M120X175RD6-A**	M12 X 1,75	3.38	.77	1.74	.367	3	D6

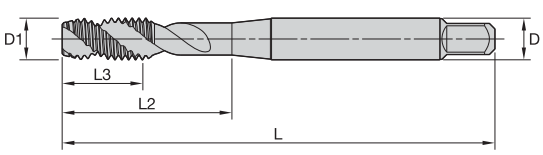
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

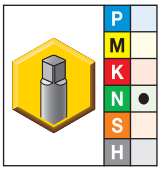
• KSMN34 TiN + CrC/C for aluminum.







T682 • Machine Screw and Fractional • Form C Semi-Bottoming Chamfer • DIN Length ANSI Shank • For Wrought Aluminum



● first choice
○ alternate choice

KSMN34	D1 size	L	L3	L2	D	number of flutes	class of fit
T682NC#02-56R2B-DA	2 - 56	1.77	.31	.71	.141	2	2B
T682NC#04-40R3B-DA	4 - 40	2.20	.31	.71	.141	2	3B
T682NC#05-40R3B-DA	5 - 40	2.20	.31	.71	.141	2	3B
T682NC#06-32R2B-DA	6 - 32	2.20	.35	.79	.141	2	2B
T682NC#08-32R2B-DA	8 - 32	2.48	.43	.83	.168	2	2B
T682NC#10-24R2B-DA	10 - 24	2.76	.47	.98	.194	2	2B
T682NF#10-32R2B-DA	10 - 32	2.76	.47	.98	.194	2	2B
T682NC02500-20R2B-DA	1/4 - 20	3.15	.59	1.18	.255	2	2B
T682NC02500-20R3B-DA	1/4 - 20	3.15	.59	1.18	.255	2	3B
T682NF02500-28R2B-DA	1/4 - 28	3.15	.59	1.18	.255	2	2B
T682NF02500-28R3B-DA	1/4 - 28	3.15	.59	1.18	.255	2	3B
T682NC03125-18R2B-DA	5/16 - 18	3.54	.59	1.38	.318	2	2B
T682NC03125-18R3B-DA	5/16 - 18	3.54	.59	1.38	.318	2	3B
T682NF03125-24R2B-DA	5/16 - 24	3.54	.59	1.38	.318	2	2B
T682NF03125-24R3B-DA	5/16 - 24	3.54	.59	1.38	.318	2	3B
T682NC03750-16R2B-DA	3/8 - 16	3.94	.75	1.54	.381	2	2B
T682NC03750-16R3B-DA	3/8 - 16	3.94	.75	1.54	.381	2	3B
T682NF03750-24R2B-DA *	3/8 - 24	3.94	.75	1.54	.381	2	2B
T682NF03750-24R3B-DA	3/8 - 24	3.94	.75	1.54	.381	2	3B
T682NC04375-14R2B-DA	7/16 - 14	3.94	.71	1.61	.323	3	2B
T682NC04375-14R3B-DA	7/16 - 14	3.94	.71	1.61	.323	3	3B
T682NF04375-20R2B-DA	7/16 - 20	3.94	.71	1.61	.323	3	2B
T682NF04375-20R3B-DA	7/16 - 20	3.94	.71	1.61	.323	3	3B
T682NC05000-13R2B-DA	1/2 - 13	4.33	.91	1.85	.367	3	2B
T682NC05000-13R3B-DA	1/2 - 13	4.33	.91	1.85	.367	3	3B
T682NF05000-20R2B-DA	1/2 - 20	4.33	.91	1.85	.367	3	2B
T682NF05000-20R3B-DA	1/2 - 20	4.33	.91	1.85	.367	3	3B

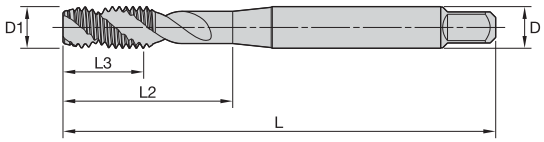
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D inch	tolerance h9
.141–.635	+0, -.0015
<.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

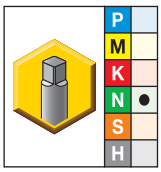
- KSMN34 TiN + CrC/C for aluminum.







T682 • Form C Semi-Bottoming • Metric • DIN Length ANSI Shank • For Wrought Aluminum



● first choice
○ alternate choice

KSMN34	D1 size	L	L3	L2	D	number of flutes	class of fit
T682M030X050R6H-DA	M3 X 0,5	2.20	.31	.71	.141	2	6H
T682M035X060R6H-DA	M3,5 X 0,6	2.20	.35	.79	.141	2	6H
T682M040X070R6H-DA	M4 X 0,7	2.48	.43	.83	.168	2	6H
T682M050X080R6H-DA	M5 X 0,8	2.76	.47	.98	.194	2	6H
T682M060X100R6H-DA	M6 X 1	3.15	.47	1.18	.255	2	6H
T682M070X100R6H-DA *	M7 X 1	3.54	.59	1.38	.318	2	6H
T682MF080X100R6H-DA	M8 X 1	3.54	.59	1.38	.318	2	6H
T682M080X125R6H-DA	M8 X 1,25	3.54	.59	1.38	.318	2	6H
T682MF100X125R6H-DA	M10 X 1,25	3.94	.71	1.54	.381	2	6H
T682M100X150R6H-DA	M10 X 1,5	3.94	.71	1.54	.381	2	6H
T682MF120X125R6H-DA	M12 X 1,25	4.33	.83	1.73	.367	3	6H
T682MF120X150R6H-DA	M12 X 1,5	4.33	.83	1.73	.367	3	6H
T682M120X175R6H-DA	M12 X 1,75	4.33	.83	1.73	.367	3	6H

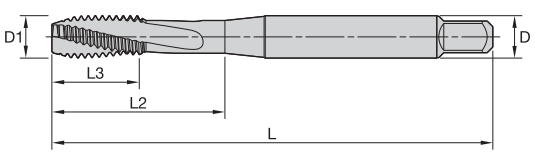
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D inch	tolerance h9
.141–.635	+0, -.0015
<.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

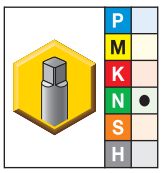
• KSMN34 TiN + CrC/C for aluminum.







T686 • Machine Screw and Fractional • Form C Semi-Bottoming Chamfer • DIN Length ANSI Shank • For Cast Aluminum



● first choice
○ alternate choice

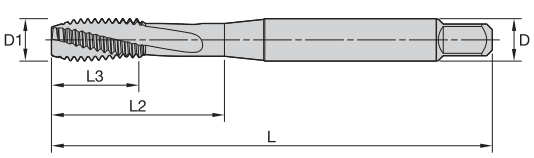
KSMN34	D1 size	L	L3	L2	D	number of flutes	class of fit
T686NC#02-56R2B-DA	2 - 56	1.77	.31	.71	.141	3	2B
T686NC#04-40R3B-DA	4 - 40	2.20	.31	.71	.141	3	3B
T686NC#06-32R2B-DA	6 - 32	2.20	.35	.79	.141	3	2B
T686NC#08-32R2B-DA	8 - 32	2.48	.43	.83	.168	3	2B
T686NC#10-24R2B-DA	10 - 24	2.76	.47	.98	.194	3	2B
T686NF#10-32R2B-DA	10 - 32	2.76	.47	.98	.194	3	2B
T686NC02500-20R3B-DA	1/4 - 20	3.15	.59	1.18	.255	3	3B
T686NF02500-28R3B-DA	1/4 - 28	3.15	.59	1.18	.255	3	3B
T686NC03125-18R3B-DA	5/16 - 18	3.54	.59	1.38	.318	3	3B
T686NF03125-24R3B-DA	5/16 - 24	3.54	.59	1.38	.318	3	3B
T686NC03750-16R3B-DA	3/8 - 16	3.94	.75	1.54	.381	3	3B
T686NF03750-24R3B-DA	3/8 - 24	3.94	.75	1.54	.381	3	3B
T686NC04375-14R3B-DA	7/16 - 14	3.94	.71	1.61	.323	3	3B
T686NF04375-20R3B-DA	7/16 - 20	3.94	.71	1.61	.323	3	3B
T686NC05000-13R3B-DA	1/2 - 13	4.33	.91	1.85	.367	3	3B
T686NF05000-20R3B-DA	1/2 - 20	4.33	.91	1.85	.367	3	3B

Shank Tolerance

D inch	tolerance h9
.141–.635	+0, -.0015
<.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

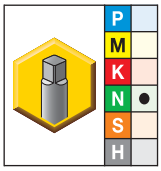
• KSMN34 TiN + CrC/C for aluminum.







T686 • Form C Semi-Bottoming Chamfer • Metric • DIN Length ANSI Shank • For Cast Aluminum



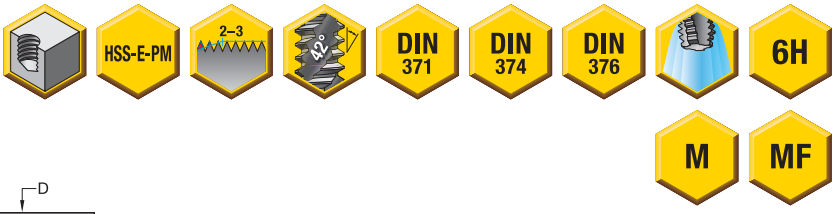
● first choice
○ alternate choice

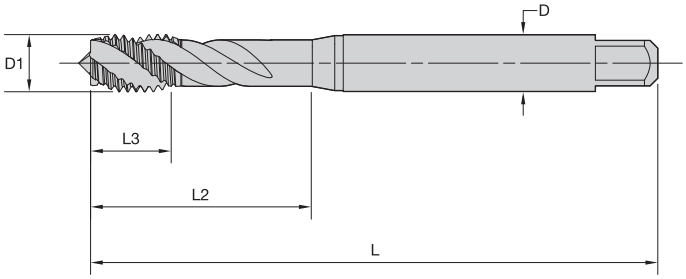
KSMN34	D1 size	L	L3	L2	D	number of flutes	class of fit
T686M030X050R6H-DA	M3 X 0,5	2.20	.31	.71	.141	3	6H
T686M040X070R6H-DA	M4 X 0,7	2.48	.43	.83	.168	3	6H
T686M050X080R6H-DA	M5 X 0,8	2.76	.47	.98	.194	3	6H
T686M060X100R6H-DA	M6 X 1	3.15	.47	1.18	.255	3	6H
T686M080X125R6H-DA	M8 X 1,25	3.54	.59	1.38	.318	3	6H
T686M100X150R6H-DA	M10 X 1,5	3.94	.71	1.54	.381	3	6H
T686MF120X150R6H-DA	M12 X 1,5	4.33	.83	1.73	.367	3	6H

Shank Tolerance

D inch	tolerance h9
.141–.635	+0, -.0015
<.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

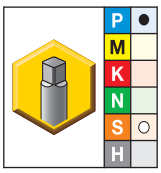
- KSH26 TiAlN/MoS_2 for tapping steel 32–44 HRC (3 x D).







T604 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • For Hard Steel



● first choice
○ alternate choice

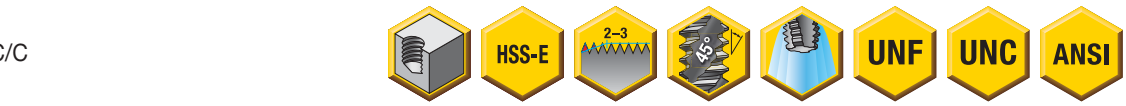
KSH26	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T604M030X050R6H-D1	M3 X 0,5	56	6	18	3,5	3	DIN 371	6H
T604M040X070R6H-D1	M4 X 0,7	63	7	21	4,5	3	DIN 371	6H
T604M050X080R6H-D1	M5 X 0,8	70	8	25	6,0	3	DIN 371	6H
T604M060X100R6H-D1	M6 X 1	80	10	30	6,0	3	DIN 371	6H
T604MF080X100R6H-D4	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

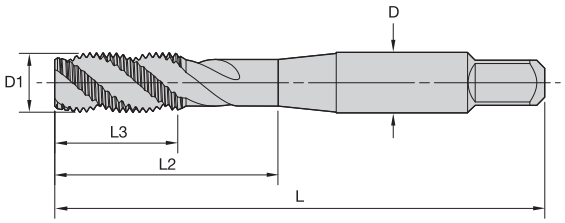
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

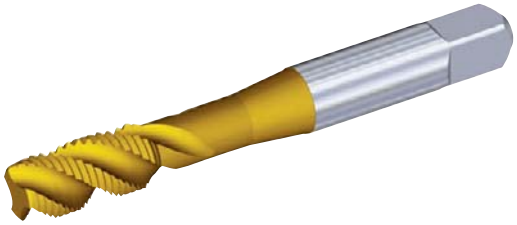
Shank Tolerance

D	tolerance h9
1–3	+0, -0,025
3,5–6	+0, -0,030
7–10	+0, -0,036
11–18	+0, -0,043

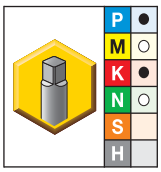
- KSP32 TiCN/TiN
- KSMN34 TiN + CrC/C
- KSP39 oxide

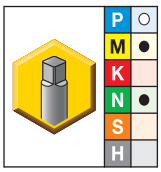


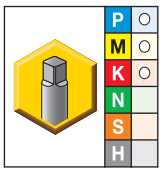




T830 • Form C Semi-Bottoming Chamfer • Machine Screw and Fractional • ANSI • Rigid and Synchronous Holders





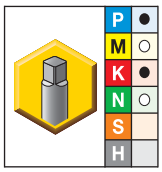


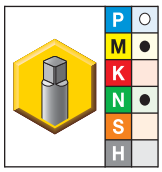
● first choice
○ alternate choice

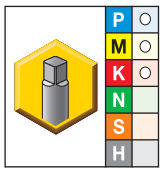
KSP32	KSMN34	KSP39	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
–	–	T830NC#02-56RH2-A	2 - 56	1.76	.40	.50	.141	2	H2
–	–	T830NC#03-48RH2-A	3 - 48	1.82	.46	.57	.141	2	H2
T830NC#04-40RH2-A	T830NC#04-40RH2-A	T830NC#04-40RH2-A	4 - 40	1.88	.52	.70	.141	2	H2
–	–	T830NC#04-40RH3-A	4 - 40	1.88	.52	.70	.141	2	H3
–	–	T830NC#04-40RH4-A	4 - 40	1.88	.52	.70	.141	2	H4
–	–	T830NC#04-40RH5-A	4 - 40	1.88	.52	.70	.141	2	H5
–	–	T830NF#04-48RH2-A	4 - 48	1.88	.53	.70	.141	2	H2
–	–	T830NC#05-40RH2-A	5 - 40	1.95	.59	.76	.141	2	H2
–	–	T834NC#05-40RH2-A *	5 - 40	1.95	.58	.76	.141	3	H2
–	–	T830NC#06-32RH2-A	6 - 32	2.00	.39	.72	.141	2	H2
T830NC#06-32RH3-A	T830NC#06-32RH3-A	T830NC#06-32RH3-A	6 - 32	2.00	.39	.72	.141	2	H3
–	–	T830NC#06-32RH4-A *	6 - 32	2.00	.39	.72	.141	2	H4
–	–	T830NC#06-32RH5-A	6 - 32	2.00	.39	.72	.141	2	H5
–	–	T830NC#06-32RH7-A	6 - 32	2.00	.39	.72	.141	2	H7
–	–	T834NC#06-32RH2-A	6 - 32	2.00	.38	.72	.141	3	H2
T834NC#06-32RH3-A	T834NC#06-32RH3-A	T834NC#06-32RH3-A	6 - 32	2.00	.38	.72	.141	3	H3
–	–	T834NC#06-32RH4-A	6 - 32	2.00	.38	.72	.141	3	H4
–	–	T834NC#06-32RH5-A	6 - 32	2.00	.38	.72	.141	3	H5
–	–	T834NC#06-32RH7-A	6 - 32	2.00	.38	.72	.141	3	H7
–	–	T830NF#06-40RH2-A	6 - 40	2.00	.39	.72	.140	2	H2
–	–	T830NF#06-40RH3-A	6 - 40	2.00	.39	.72	.141	2	H3
–	–	T834NF#06-40RH2-A	6 - 40	2.00	.38	.72	.141	3	H2
–	–	T834NF#06-40RH3-A	6 - 40	2.00	.38	.72	.141	3	H3
–	–	T830NC#08-32RH2-A	8 - 32	2.13	.38	.77	.168	3	H2
T830NC#08-32RH3-A	T830NC#08-32RH3-A	T830NC#08-32RH3-A	8 - 32	2.13	.38	.77	.168	3	H3
–	–	T830NC#08-32RH4-A	8 - 32	2.13	.38	.77	.168	3	H4
–	–	T830NC#08-32RH5-A	8 - 32	2.13	.38	.77	.168	3	H5
–	–	T830NC#08-32RH6-A	8 - 32	2.13	.38	.77	.168	3	H6
–	–	T830NC#08-32RH7-A	8 - 32	2.13	.38	.77	.168	3	H7
–	–	T830NC#10-24RH2-A	10 - 24	2.38	.50	.92	.194	3	H2
T830NC#10-24RH3-A	T830NC#10-24RH3-A	T830NC#10-24RH3-A	10 - 24	2.38	.50	.92	.194	3	H3
–	–	T830NC#10-24RH4-A *	10 - 24	2.38	.50	.92	.194	3	H4

(continued)

(T830 • Form C Semi-Bottoming Chamfer • Machine Screw and Fractional • ANSI • Rigid and Synchronous Holders — continued)





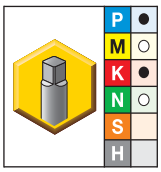


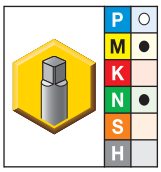
● first choice
○ alternate choice

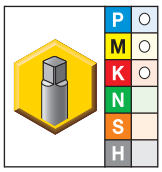
KSP32	KSMN34	KSP39	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
–	–	T830NC#10-24RH5-A	10 - 24	2.38	.50	.92	.194	3	H5
–	–	T830NC#10-24RH7-A	10 - 24	2.38	.50	.92	.194	3	H7
–	–	T830NF#10-32RH2-A	10 - 32	2.38	.50	.92	.194	3	H2
T830NF#10-32RH3-A	T830NF#10-32RH3-A	T830NF#10-32RH3-A	10 - 32	2.38	.50	.92	.194	3	H3
–	–	T830NF#10-32RH4-A	10 - 32	2.38	.50	.92	.194	3	H4
–	–	T830NF#10-32RH5-A	10 - 32	2.37	.50	.91	.194	3	H5
–	–	T830NF#10-32RH6-A	10 - 32	2.38	.50	.92	.194	3	H6
–	–	T830NF#10-32RH7-A	10 - 32	2.38	.50	.92	.193	3	H7
–	–	T830NC#12-24RH3-A	12 - 24	2.43	.50	.96	.219	3	H3
–	–	T830NF#12-28RH3-A	12 - 28	2.43	.50	.96	.219	3	H3
–	–	T830NC02500-20RH2-A	1/4 - 20	2.50	.63	1.00	.255	3	H2
T830NC02500-20RH3-A	T830NC02500-20RH3-A	T830NC02500-20RH3-A	1/4 - 20	2.50	.63	1.00	.255	3	H3
–	–	T830NC02500-20RH5-A	1/4 - 20	2.50	.63	1.00	.255	3	H5
–	–	T830NC02500-20RH7-A	1/4 - 20	2.50	.63	1.00	.255	3	H7
–	–	T830NF02500-28RH2-A	1/4 - 28	2.50	.63	1.00	.255	3	H2
T830NF02500-28RH3-A	T830NF02500-28RH3-A	T830NF02500-28RH3-A	1/4 - 28	2.49	.62	1.00	.255	3	H3
–	–	T830NF02500-28RH4-A	1/4 - 28	2.49	.62	1.00	.255	3	H4
–	–	T830NF02500-28RH5-A	1/4 - 28	2.49	.62	1.00	.255	3	H5
–	–	T830NF02500-28RH6-A *	1/4 - 28	2.49	.62	1.00	.255	3	H6
–	–	T830NF02500-28RH7-A	1/4 - 28	2.49	.62	1.00	.255	3	H7
T830NC03125-18RH3-A	T830NC03125-18RH3-A	T830NC03125-18RH3-A	5/16 - 18	2.72	.69	1.13	.318	3	H3
–	–	T830NC03125-18RH5-A	5/16 - 18	2.72	.69	1.13	.318	3	H5
–	–	T830NC03125-18RH7-A	5/16 - 18	2.72	.69	1.13	.318	3	H7
T830NF03125-24RH3-A	T830NF03125-24RH3-A	T830NF03125-24RH3-A	5/16 - 24	2.71	.68	1.13	.318	3	H3
–	–	T830NF03125-24RH5-A	5/16 - 24	2.71	.68	1.12	.318	3	H5
–	–	T830NF03125-24RH7-A	5/16 - 24	2.71	.68	1.12	.318	3	H7
T830NC03750-16RH3-A	T830NC03750-16RH3-A	T830NC03750-16RH3-A	3/8 - 16	2.94	.75	1.27	.381	3	H3
–	–	T830NC03750-16RH5-A	3/8 - 16	2.94	.75	1.27	.381	3	H5
–	–	T830NC03750-16RH7-A	3/8 - 16	2.94	.75	1.27	.381	3	H7
T830NF03750-24RH3-A	T830NF03750-24RH3-A	T830NF03750-24RH3-A	3/8 - 24	2.92	.74	1.25	.381	3	H3
–	–	T830NF03750-24RH4-A	3/8 - 24	2.92	.74	1.25	.381	3	H4
–	–	T830NF03750-24RH5-A	3/8 - 24	2.92	.74	1.25	.381	3	H5
–	–	T830NF03750-24RH6-A	3/8 - 24	2.92	.74	1.25	.381	3	H6
T830NC04375-14RH3-A	T830NC04375-14RH3-A	T830NC04375-14RH3-A	7/16 - 14	3.16	.88	1.49	.323	3	H3
–	–	T830NC04375-14RH5-A	7/16 - 14	3.16	.88	1.49	.323	3	H5
–	–	T830NC04375-14RH7-A	7/16 - 14	3.16	.88	1.49	.323	3	H7
T830NF04375-20RH3-A	T830NF04375-20RH3-A	T830NF04375-20RH3-A	7/16 - 20	3.16	.88	1.49	.323	3	H3
–	–	T830NF04375-20RH5-A *	7/16 - 20	3.16	.88	1.49	.323	3	H5
–	–	T830NF04375-20RH6-A *	7/16 - 20	3.16	.88	1.49	.323	3	H6
–	–	T830NF04375-20RH7-A	7/16 - 20	3.16	.88	1.49	.323	3	H7
T830NC05000-13RH3-A	T830NC05000-13RH3-A	T830NC05000-13RH3-A	1/2 - 13	3.38	.94	1.74	.367	3	H3
–	–	T830NC05000-13RH5-A	1/2 - 13	3.38	.94	1.74	.367	3	H5
–	–	T830NC05000-13RH7-A	1/2 - 13	3.38	.94	1.74	.367	3	H7
T830NF05000-20RH3-A	T830NF05000-20RH3-A	T830NF05000-20RH3-A	1/2 - 20	3.38	.94	1.74	.367	3	H3
–	–	T830NF05000-20RH5-A	1/2 - 20	3.38	.94	1.74	.367	3	H5
–	–	T830NF05000-20RH6-A	1/2 - 20	3.38	.94	1.74	.367	3	H6
–	–	T830NF05000-20RH7-A	1/2 - 20	3.38	.94	1.74	.367	3	H7
T830NC05625-12RH3-A	T830NC05625-12RH3-A	T830NC05625-12RH3-A	9/16 - 12	3.59	1.00	1.74	.429	3	H3

(continued)

(T830 • Form C Semi-Bottoming Chamfer • Machine Screw and Fractional • ANSI • Rigid and Synchronous Holders — continued)







● first choice
○ alternate choice

KSP32	KSMN34	KSP39	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
—	—	T830NC05625-12RH5-A *	9/16 - 12	3.59	1.00	1.74	.429	3	H5
—	T830NF05625-18RH3-A	T830NF05625-18RH3-A	9/16 - 18	3.59	1.00	1.74	.429	3	H3
—	—	T830NF05625-18RH5-A	9/16 - 18	3.59	1.00	1.74	.429	3	H5
T830NC06250-11RH3-A	T830NC06250-11RH3-A	T830NC06250-11RH3-A	5/8 - 11	3.81	1.09	1.89	.480	3	H3
—	—	T830NC06250-11RH5-A	5/8 - 11	3.81	1.09	1.89	.480	3	H5
—	—	T830NC06250-11RH7-A	5/8 - 11	3.81	1.09	1.89	.480	3	H7
T830NF06250-18RH3-A	T830NF06250-18RH3-A	T830NF06250-18RH3-A	5/8 - 18	3.81	1.09	1.89	.480	3	H3
—	—	T830NF06250-18RH5-A *	5/8 - 18	3.81	1.09	1.89	.480	3	H5
—	—	T830NF06250-18RH6-A	5/8 - 18	3.81	1.09	1.89	.480	3	H6
—	—	T830NF06250-18RH7-A	5/8 - 18	3.81	1.09	1.89	.480	3	H7
T830NC07500-10RH3-A	T830NC07500-10RH3-A	T830NC07500-10RH3-A	3/4 - 10	4.25	1.22	2.08	.590	4	H3
—	—	T830NC07500-10RH5-A	3/4 - 10	4.25	1.22	2.08	.590	4	H5
T830NF07500-16RH3-A	T830NF07500-16RH3-A	T830NF07500-16RH3-A	3/4 - 16	4.25	1.22	2.08	.590	4	H3
—	—	T830NF07500-16RH5-A	3/4 - 16	4.25	1.22	2.08	.590	4	H5
—	T830NC08750-9RH4-A	T830NC08750-9RH4-A	7/8 - 9	4.69	1.34	2.30	.697	4	H4
—	T830NF08750-14RH4-A	T830NF08750-14RH4-A	7/8 - 14	4.69	1.34	2.30	.697	4	H4
—	T830NC10000-8RH4-A	—	1 - 8	5.13	1.50	2.58	.800	4	H4
T830NC10000-8RH5-A	—	T830NC10000-8RH5-A	1 - 8	5.13	1.50	2.58	.800	4	H5
—	—	T830NF1000-12RH4-A	1 - 12	5.13	1.50	2.58	.800	4	H4
—	—	T830NC11250-7RH6-A	1 1/8 - 7	5.44	1.71	2.56	.896	4	H6

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

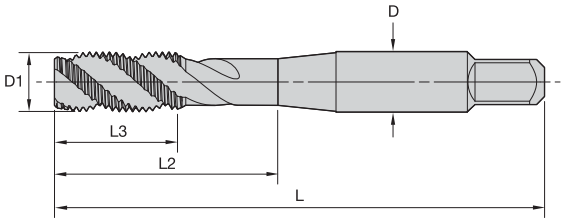
NOTE: Suggested for use in rigid and synchronous holders.

Shank Tolerance

D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

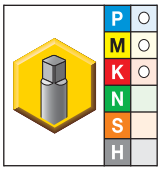
• KSP39 oxide







T832 • Form E Bottoming Chamfer • Machine Screw and Fractional • ANSI • Rigid and Synchronous Holders

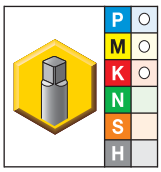


● first choice
○ alternate choice

KSP39	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T832NC#04-40RH2-A	4 - 40	1.88	.51	.69	.141	2	H2
T832NC#04-40RH3-A	4 - 40	1.88	.51	.69	.141	2	H3
T832NC#04-40RH5-A	4 - 40	1.88	.51	.69	.141	2	H5
T832NC#05-40RH2-A	5 - 40	1.94	.58	.75	.141	2	H2
T832NC#06-32RH2-A	6 - 32	1.99	.38	.71	.141	2	H2
T832NC#06-32RH3-A	6 - 32	1.99	.38	.71	.141	2	H3
T832NC#06-32RH5-A	6 - 32	1.99	.38	.71	.141	2	H5
T832NF#06-40RH2-A	6 - 40	1.99	.37	.71	.141	2	H2
T832NF#06-40RH3-A	6 - 40	1.99	.37	.71	.141	2	H3
T832NC#08-32RH2-A	8 - 32	2.12	.38	.76	.168	3	H2
T832NC#08-32RH3-A	8 - 32	2.12	.38	.76	.168	3	H3
T832NC#08-32RH5-A	8 - 32	2.12	.38	.76	.168	3	H5
T832NC#10-24RH3-A	10 - 24	2.37	.50	.91	.194	3	H3
T832NC#10-24RH5-A	10 - 24	2.37	.50	.91	.194	3	H5
T832NF#10-32RH3-A	10 - 32	2.36	.49	.91	.194	3	H3
T832NF#10-32RH5-A	10 - 32	2.36	.49	.91	.194	3	H5
T832NC02500-20RH3-A	1/4 - 20	2.50	.63	1.00	.255	3	H3
T832NC02500-20RH5-A	1/4 - 20	2.50	.63	1.00	.255	3	H5
T832NF02500-28RH3-A	1/4 - 28	2.49	.62	1.00	.255	3	H3
T832NF02500-28RH5-A	1/4 - 28	2.49	.62	1.00	.255	3	H5
T832NC03125-18RH3-A	5/16 - 18	2.72	.69	1.13	.318	3	H3
T832NC03125-18RH5-A	5/16 - 18	2.72	.69	1.13	.318	3	H5
T832NF03125-24RH3-A	5/16 - 24	2.71	.68	1.13	.318	3	H3
T832NF03125-24RH5-A	5/16 - 24	2.71	.68	1.13	.318	3	H5
T832NC03750-16RH3-A	3/8 - 16	2.94	.75	1.27	.381	3	H3
T832NC03750-16RH5-A	3/8 - 16	2.94	.75	1.27	.381	3	H5
T832NF03750-24RH3-A	3/8 - 24	2.92	.74	1.25	.381	3	H3
T832NF03750-24RH4-A	3/8 - 24	2.92	.74	1.25	.381	3	H4

(continued)

(T832 • Form E Bottoming Chamfer • Machine Screw and Fractional • ANSI • Rigid and Synchronous Holders — continued)



● first choice
○ alternate choice

KSP39	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T832NF03750-24RH5-A	3/8 - 24	2.92	.74	1.25	.381	3	H5
T832NC04375-14RH3-A	7/16 - 14	3.16	.88	1.49	.323	3	H3
T832NC04375-14RH5-A	7/16 - 14	3.16	.88	1.49	.323	3	H5
T832NF04375-20RH3-A	7/16 - 20	3.16	.88	1.49	.323	3	H3
T832NF04375-20RH5-A	7/16 - 20	3.16	.88	1.49	.323	3	H5
T832NC05000-13RH3-A	1/2 - 13	3.38	.94	1.74	.367	3	H3
T832NC05000-13RH5-A	1/2 - 13	3.38	.94	1.74	.367	3	H5
T832NF05000-20RH3-A	1/2 - 20	3.38	.94	1.74	.367	3	H3
T832NC05625-12RH3-A	9/16 - 12	3.59	1.00	1.74	.429	3	H3
T832NC05625-12RH5-A	9/16 - 12	3.59	1.00	1.74	.429	3	H5
T832NF05625-18RH3-A	9/16 - 18	3.59	1.00	1.74	.429	3	H3
T832NC06250-11RH3-A	5/8 - 11	3.81	1.09	1.89	.480	3	H3
T832NC06250-11RH5-A	5/8 - 11	3.81	1.09	1.89	.480	3	H5
T832NF06250-18RH3-A	5/8 - 18	3.81	1.09	1.89	.480	3	H3
T832NF06250-18RH5-A	5/8 - 18	3.81	1.09	1.89	.480	3	H5
T832NC07500-10RH3-A	3/4 - 10	4.25	1.22	2.08	.590	4	H3
T832NF07500-16RH3-A	3/4 - 16	4.25	1.22	2.08	.590	4	H3

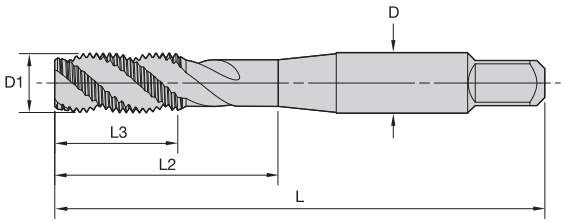
NOTE: Suggested for use in rigid and synchronous holders.

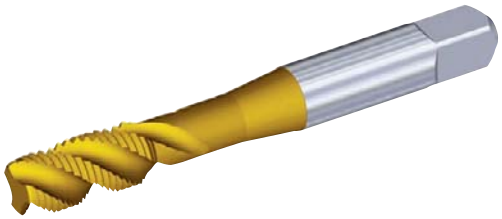
Shank Tolerance

D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

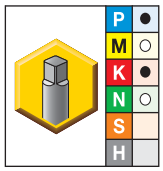
- KSP32 TiCN/TiN
- KSP39 oxide

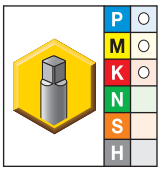






T838 • Form C Semi-Bottoming Chamfer • Machine Screw and Fractional • ANSI • Tension/Compression Holders



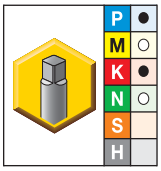


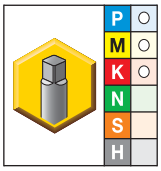
● first choice
○ alternate choice

KSP32	KSP39	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
–	T838NC#02-56RH2-A	2 - 56	1.76	.39	.50	.141	2	H2
–	T838NC#03-48RH2-A	3 - 48	1.82	.46	.57	.141	2	H2
T838NC#04-40RH2-A	T838NC#04-40RH2-A	4 - 40	1.88	.52	.70	.141	2	H2
–	T838NC#04-40RH3-A	4 - 40	1.88	.52	.70	.141	2	H3
–	T838NC#04-40RH4-A	4 - 40	1.88	.52	.70	.141	2	H4
–	T838NC#04-40RH5-A	4 - 40	1.88	.52	.70	.141	2	H5
–	T838NF#04-48RH2-A	4 - 48	1.88	.53	.70	.141	2	H2
–	T838NC#05-40RH2-A	5 - 40	1.95	.59	.76	.141	2	H2
–	T838NC#06-32RH2-A	6 - 32	2.00	.39	.72	.141	2	H2
T838NC#06-32RH3-A	T838NC#06-32RH3-A	6 - 32	2.00	.39	.72	.141	2	H3
–	T838NC#06-32RH4-A	6 - 32	2.00	.39	.72	.141	2	H4
–	T838NC#06-32RH5-A	6 - 32	2.00	.39	.72	.141	2	H5
–	T838NC#06-32RH7-A	6 - 32	2.00	.39	.72	.141	2	H7
–	T838NF#06-40RH2-A	6 - 40	2.00	.39	.72	.141	2	H2
–	T838NF#06-40RH3-A	6 - 40	2.00	.39	.72	.141	2	H3
–	T838NC#08-32RH2-A	8 - 32	2.13	.38	.77	.168	3	H2
T838NC#08-32RH3-A	T838NC#08-32RH3-A	8 - 32	2.13	.38	.77	.168	3	H3
–	T838NC#08-32RH4-A	8 - 32	2.13	.38	.77	.168	3	H4
–	T838NC#08-32RH5-A	8 - 32	2.13	.38	.77	.168	3	H5
–	T838NC#08-32RH6-A	8 - 32	2.13	.38	.77	.168	3	H6
–	T838NC#08-32RH7-A	8 - 32	2.13	.38	.77	.168	3	H7
–	T838NC#10-24RH2-A	10 - 24	2.38	.50	.92	.194	3	H2
T838NC#10-24RH3-A	T838NC#10-24RH3-A	10 - 24	2.38	.50	.92	.194	3	H3
–	T838NC#10-24RH4-A	10 - 24	2.38	.50	.92	.194	3	H4
–	T838NC#10-24RH5-A	10 - 24	2.38	.50	.92	.194	3	H5
–	T838NC#10-24RH7-A	10 - 24	2.38	.50	.92	.194	3	H7
–	T838NF#10-32RH2-A	10 - 32	2.38	.50	.92	.194	3	H2
T838NF#10-32RH3-A	T838NF#10-32RH3-A	10 - 32	2.38	.50	.92	.194	3	H3

(continued)

(T838 • Form C Semi-Bottoming Chamfer • Machine Screw and Fractional • ANSI • Tension/Compression Holders — continued)



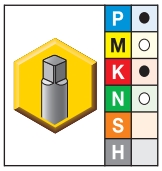


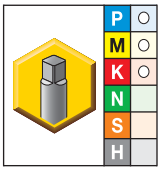
● first choice
○ alternate choice

KSP32	KSP39	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
—	T838NF#10-32RH4-A	10 - 32	2.38	.50	.92	.194	3	H4
—	T838NF#10-32RH5-A	10 - 32	2.38	.50	.91	.194	3	H5
—	T838NF#10-32RH6-A	10 - 32	2.38	.50	.92	.194	3	H6
—	T838NF#10-32RH7-A	10 - 32	2.38	.50	.92	.194	3	H7
—	T838NC#12-24RH3-A	12 - 24	2.43	.50	.96	.220	3	H3
—	T838NF#12-28RH3-A	12 - 28	2.43	.50	.96	.220	3	H3
—	T838NC02500-20RH2-A	1/4 - 20	2.50	.63	1.00	.255	3	H2
T838NC02500-20RH3-A	T838NC02500-20RH3-A	1/4 - 20	2.50	.63	1.00	.255	3	H3
—	T838NC02500-20RH5-A	1/4 - 20	2.50	.63	1.00	.255	3	H5
—	T838NC02500-20RH7-A	1/4 - 20	2.50	.63	1.00	.255	3	H7
—	T838NF02500-28RH2-A	1/4 - 28	2.50	.63	1.00	.255	3	H2
T838NF02500-28RH3-A	T838NF02500-28RH3-A	1/4 - 28	2.50	.63	1.00	.255	3	H3
—	T838NF02500-28RH4-A	1/4 - 28	2.50	.63	1.00	.255	3	H4
—	T838NF02500-28RH5-A	1/4 - 28	2.50	.63	1.00	.255	3	H5
—	T838NF02500-28RH6-A	1/4 - 28	2.50	.63	1.00	.255	3	H6
—	T838NF02500-28RH7-A	1/4 - 28	2.50	.63	1.00	.255	3	H7
T838NC03125-18RH3-A	T838NC03125-18RH3-A	5/16 - 18	2.72	.69	1.13	.318	3	H3
—	T838NC03125-18RH5-A	5/16 - 18	2.72	.69	1.13	.318	3	H5
—	T838NC03125-18RH7-A	5/16 - 18	2.72	.69	1.13	.318	3	H7
T838NF03125-24RH3-A	T838NF03125-24RH3-A	5/16 - 24	2.72	.69	1.13	.318	3	H3
—	T838NF03125-24RH5-A	5/16 - 24	2.72	.69	1.12	.318	3	H5
—	T838NF03125-24RH7-A	5/16 - 24	2.72	.69	1.12	.318	3	H7
T838NC03750-16RH3-A	T838NC03750-16RH3-A	3/8 - 16	2.94	.75	1.27	.381	3	H3
—	T838NC03750-16RH5-A	3/8 - 16	2.94	.75	1.27	.381	3	H5
—	T838NC03750-16RH7-A	3/8 - 16	2.94	.75	1.27	.381	3	H7
T838NF03750-24RH3-A	T838NF03750-24RH3-A	3/8 - 24	2.94	.75	1.27	.381	3	H3
—	T838NF03750-24RH4-A	3/8 - 24	2.94	.75	1.27	.381	3	H4
—	T838NF03750-24RH5-A	3/8 - 24	2.94	.75	1.27	.381	3	H5
—	T838NF03750-24RH6-A	3/8 - 24	2.94	.75	1.27	.381	3	H6
T838NC04375-14RH3-A	T838NC04375-14RH3-A	7/16 - 14	3.16	.88	1.49	.323	3	H3
—	T838NC04375-14RH5-A	7/16 - 14	3.16	.88	1.49	.323	3	H5
—	T838NC04375-14RH7-A	7/16 - 14	3.16	.88	1.49	.323	3	H7
T838NF04375-20RH3-A	T838NF04375-20RH3-A	7/16 - 20	3.16	.88	1.49	.323	3	H3
—	T838NF04375-20RH5-A	7/16 - 20	3.16	.88	1.49	.323	3	H5
—	T838NF04375-20RH6-A	7/16 - 20	3.16	.88	1.49	.323	3	H6
—	T838NF04375-20RH7-A	7/16 - 20	3.16	.88	1.49	.323	3	H7
T838NC05000-13RH3-A	T838NC05000-13RH3-A	1/2 - 13	3.38	.94	1.74	.367	3	H3
—	T838NC05000-13RH5-A	1/2 - 13	3.38	.94	1.74	.367	3	H5
—	T838NC05000-13RH7-A	1/2 - 13	3.38	.94	1.74	.367	3	H7
T838NF05000-20RH3-A	T838NF05000-20RH3-A	1/2 - 20	3.38	.94	1.74	.367	3	H3
—	T838NF05000-20RH5-A	1/2 - 20	3.38	.94	1.74	.367	3	H5
—	T838NF05000-20RH6-A	1/2 - 20	3.38	.94	1.74	.367	3	H6
—	T838NF05000-20RH7-A	1/2 - 20	3.38	.94	1.74	.367	3	H7
T838NC05625-12RH3-A	T838NC05625-12RH3-A	9/16 - 12	3.59	1.00	1.74	.429	3	H3
—	T838NC05625-12RH5-A	9/16 - 12	3.59	1.00	1.74	.429	3	H5
—	T838NF05625-18RH3-A	9/16 - 18	3.59	1.00	1.74	.429	3	H3
—	T838NF05625-18RH5-A	9/16 - 18	3.59	1.00	1.74	.429	3	H5
T838NC06250-11RH3-A	T838NC06250-11RH3-A	5/8 - 11	3.81	1.09	1.89	.480	3	H3
—	T838NC06250-11RH5-A	5/8 - 11	3.81	1.09	1.89	.480	3	H5
—	T838NC06250-11RH7-A	5/8 - 11	3.81	1.09	1.89	.480	3	H7
T838NF06250-18RH3-A	T838NF06250-18RH3-A	5/8 - 18	3.81	1.09	1.89	.480	3	H3
—	T838NF06250-18RH5-A	5/8 - 18	3.81	1.09	1.89	.480	3	H5

(continued)

(T838 • Form C Semi-Bottoming Chamfer • Machine Screw and Fractional • ANSI • Tension/Compression Holders — continued)





● first choice
○ alternate choice

KSP32	KSP39	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
—	**T838NF06250-18RH6-A**	5/8 - 18	3.81	1.09	1.89	.480	3	H6
—	**T838NF06250-18RH7-A**	5/8 - 18	3.81	1.09	1.89	.480	3	H7
T838NC07500-10RH3-A	**T838NC07500-10RH3-A**	3/4 - 10	4.25	1.22	2.08	.590	4	H3
—	**T838NC07500-10RH5-A**	3/4 - 10	4.25	1.22	2.08	.590	4	H5
T838NF07500-16RH3-A	**T838NF07500-16RH3-A**	3/4 - 16	4.25	1.22	2.08	.590	4	H3
—	**T838NF07500-16RH5-A**	3/4 - 16	4.25	1.22	2.08	.590	4	H5
—	**T838NC08750-9RH4-A**	7/8 - 9	4.69	1.34	2.30	.697	4	H4
—	**T838NF08750-14RH4-A**	7/8 - 14	4.69	1.34	2.30	.697	4	H4
T838NC10000-8RH5-A	**T838NC10000-8RH5-A**	1 - 8	5.13	1.50	2.58	.800	4	H5
—	**T838NF1000-12RH4-A**	1 - 12	5.12	1.50	2.58	.800	4	H4
—	**T838NC11250-7RH6-A**	1 1/8 - 7	5.44	1.71	2.56	.896	4	H6

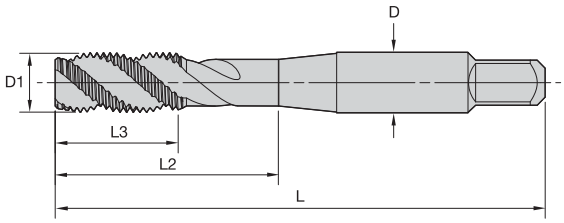
NOTE: Suitable for tension/compression holders.

Shank Tolerance

D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

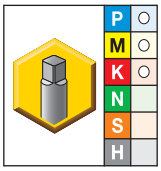
• KSP39 oxide







T839 • Form E Bottoming Chamfer • Machine Screw and Fractional • ANSI • Tension/Compression Holders

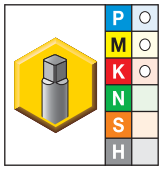


● first choice
○ alternate choice

KSP39	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T839NC#04-40RH2-A	4 - 40	1.88	.51	.69	.141	2	H2
T839NC#04-40RH3-A	4 - 40	1.88	.51	.69	.141	2	H3
T839NC#04-40RH5-A	4 - 40	1.88	.51	.69	.141	2	H5
T839NC#05-40RH2-A	5 - 40	1.94	.58	.75	.141	2	H2
T839NC#06-32RH2-A	6 - 32	1.99	.38	.71	.141	2	H2
T839NC#06-32RH3-A	6 - 32	1.99	.38	.71	.141	2	H3
T839NC#06-32RH5-A	6 - 32	1.99	.38	.71	.141	2	H5
T839NF#06-40RH2-A	6 - 40	1.99	.37	.71	.141	2	H2
T839NF#06-40RH3-A	6 - 40	1.99	.37	.71	.141	2	H3
T839NC#08-32RH2-A	8 - 32	2.12	.38	.76	.168	3	H2
T839NC#08-32RH3-A	8 - 32	2.12	.38	.76	.168	3	H3
T839NC#08-32RH5-A	8 - 32	2.12	.38	.76	.168	3	H5
T839NC#10-24RH3-A	10 - 24	2.37	.50	.91	.194	3	H3
T839NC#10-24RH5-A	10 - 24	2.37	.50	.91	.194	3	H5
T839NF#10-32RH3-A	10 - 32	2.36	.49	.91	.194	3	H3
T839NF#10-32RH5-A	10 - 32	2.36	.49	.91	.194	3	H5
T839NC02500-20RH3-A	1/4 - 20	2.50	.63	1.00	.255	3	H3
T839NC02500-20RH5-A	1/4 - 20	2.50	.63	1.00	.255	3	H5
T839NF02500-28RH3-A	1/4 - 28	2.49	.62	1.00	.255	3	H3
T839NF02500-28RH5-A	1/4 - 28	2.49	.62	1.00	.255	3	H5
T839NC03125-18RH3-A	5/16 - 18	2.72	.69	1.13	.318	3	H3
T839NC03125-18RH5-A	5/16 - 18	2.72	.69	1.13	.318	3	H5
T839NF03125-24RH3-A	5/16 - 24	2.71	.68	1.13	.318	3	H3
T839NF03125-24RH5-A	5/16 - 24	2.71	.68	1.12	.318	3	H5
T839NC03750-16RH3-A	3/8 - 16	2.94	.75	1.27	.381	3	H3
T839NC03750-16RH5-A	3/8 - 16	2.94	.75	1.27	.381	3	H5
T839NF03750-24RH3-A	3/8 - 24	2.94	.75	1.27	.381	3	H3
T839NF03750-24RH4-A	3/8 - 24	2.94	.75	1.27	.381	3	H4

(continued)

(T839 • Form E Bottoming Chamfer • Machine Screw and Fractional • ANSI • Tension/Compression Holders — continued)



● first choice
○ alternate choice

KSP39	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T839NF03750-24RH5-A	3/8 - 24	2.94	.75	1.27	.381	3	H5
T839NC04375-14RH3-A	7/16 - 14	3.16	.88	1.49	.323	3	H3
T839NC04375-14RH5-A	7/16 - 14	3.16	.88	1.49	.323	3	H5
T839NF04375-20RH3-A	7/16 - 20	3.16	.88	1.49	.323	3	H3
T839NF04375-20RH5-A	7/16 - 20	3.16	.88	1.49	.323	3	H5
T839NC05000-13RH3-A	1/2 - 13	3.38	.94	1.74	.367	3	H3
T839NC05000-13RH5-A	1/2 - 13	3.38	.94	1.74	.367	3	H5
T839NF05000-20RH3-A	1/2 - 20	3.38	.94	1.74	.367	3	H3
T839NC05625-12RH3-A	9/16 - 12	3.59	1.00	1.74	.429	3	H3
T839NC05625-12RH5-A	9/16 - 12	3.59	1.00	1.74	.429	3	H5
T839NF05625-18RH3-A	9/16 - 18	3.59	1.00	1.74	.429	3	H3
T839NC06250-11RH3-A	5/8 - 11	3.81	1.09	1.89	.480	3	H3
T839NC06250-11RH5-A	5/8 - 11	3.81	1.09	1.89	.480	3	H5
T839NF06250-18RH3-A	5/8 - 18	3.81	1.09	1.89	.480	3	H3
T839NF06250-18RH5-A	5/8 - 18	3.81	1.09	1.89	.480	3	H5
T839NC07500-10RH3-A	3/4 - 10	4.25	1.22	2.08	.590	4	H3
T839NF07500-16RH3-A	3/4 - 16	4.25	1.22	2.08	.590	4	H3

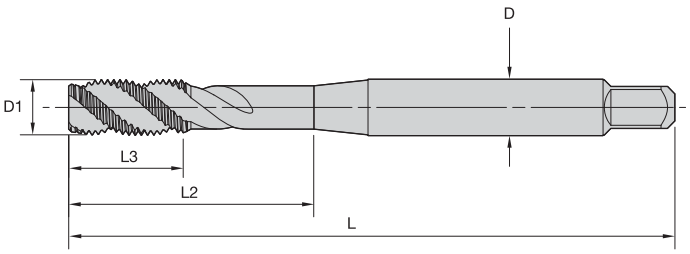
NOTE: Suitable for tension/compression holders.

Shank Tolerance

D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

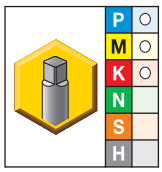
• KSP39 oxide







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

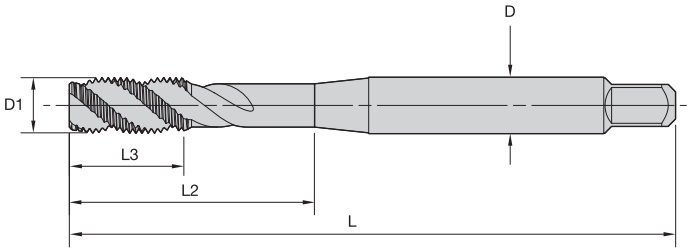
NOTE: Suggested for use in rigid and synchronous holders.

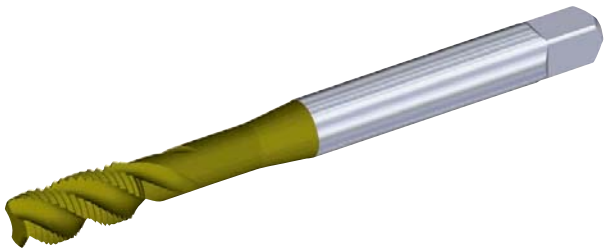
Shank Tolerance

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

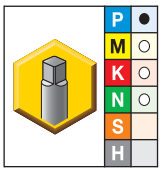
- KSU31 TiN
- KSP39 oxide

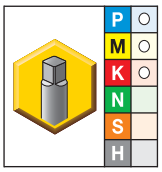






T838 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • UNC/UNF • Tension/Compression Holders



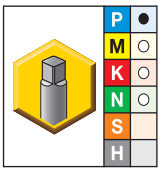


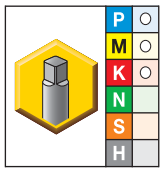
● first choice
○ alternate choice

KSU31	KSP39	metric dimensions 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

(continued)

(T838 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • UNC/UNF • Tension/Compression Holders — continued)





● first choice
○ alternate choice

KSU31	KSP39	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
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
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

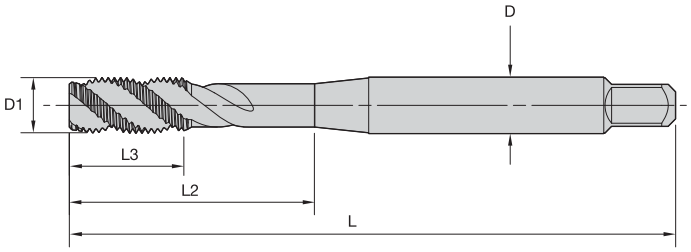
NOTE: Suitable for tension/compression holders.

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

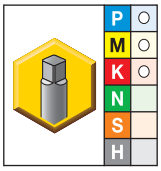
• KSP39 oxide







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.

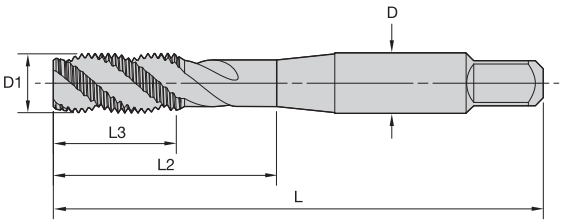
NOTE: Suggested for use in rigid and synchronous holders.

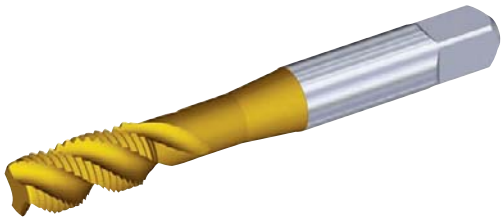
Shank Tolerance

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

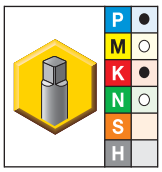
- KSP32 TiCN/TiN
- KSMN34 TiN + CrC/C
- KSP39 oxide

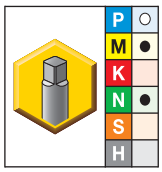


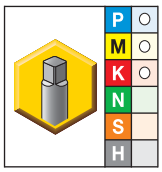




T830 • Form C Semi-Bottoming Chamfer • Metric • ANSI • Rigid and Synchronous Holders







● first choice
○ alternate choice

KSP32	KSMN34	KSP39	D1 size	inch dimensions L	L3	L2	D	number of flutes	pitch diameter limit
T830M030X050RD3-A	–	T830M030X050RD3-A	M3 X 0,5	1.94	.58	.75	.141	2	D3
T834M030X050RD3-A	–	T834M030X050RD3-A	M3 X 0.5	1.94	.58	.76	.141	3	D3
–	–	T830M035X060RD4-A	M3,5 X 0,6	1.99	.38	.71	.141	2	D4
–	–	T834M035X060RD4-A	M3.5 X 0.6	2.00	.38	.72	.141	3	D4
T830M040X070RD4-A	–	T830M040X070RD4-A	M4 X 0,7	2.12	.38	.76	.168	3	D4
T830M050X080RD4-A	T830M050X080RD4-A	T830M050X080RD4-A	M5 X 0,8	2.37	.50	.91	.194	3	D4
T830M060X100RD5-A	T830M060X100RD5-A	T830M060X100RD5-A	M6 X 1	2.50	.63	1.00	.255	3	D5
–	–	T830M070X100RD5-A	M7 X 1	2.72	.69	1.15	.318	3	D5
–	–	T830MF080X100RD5-A	M8 X 1	2.70	.69	1.12	.318	3	D5
T830M080X125RD5-A	T830M080X125RD5-A	T830M080X125RD5-A	M8 X 1,25	2.70	.69	1.12	.318	3	D5
–	–	T830MF100X125RD5-A	M10 X 1,25	2.92	.74	1.25	.381	3	D5
T830M100X150RD6-A	T830M100X150RD6-A	T830M100X150RD6-A	M10 X 1,5	2.93	.75	1.26	.381	3	D6
–	–	T830MF120X125RD5-A	M12 X 1,25	3.38	.94	1.74	.367	3	D5
–	–	T830MF120X150RD5-A	M12 X 1,5	3.38	.94	1.74	.367	3	D5
T830M120X175RD6-A	T830M120X175RD6-A	T830M120X175RD6-A	M12 X 1,75	3.38	.94	1.74	.367	3	D6
–	–	T830MF140X150RD6-A	M14 X 1,5	3.59	1.00	1.74	.429	3	D6
–	–	T830M140X200RD7-A	M14 X 2	3.59	1.00	1.74	.429	3	D7
–	–	T830MF160X150RD6-A	M16 X 1,5	3.81	1.09	1.89	.480	3	D6
–	–	T830M160X200RD7-A	M16 X 2	3.81	1.09	1.89	.480	3	D7
–	–	T830MF180X150RD6-A	M18 X 1,5	4.03	1.09	1.89	.542	4	D6
–	–	T830M180X250RD7-A	M18 X 2,5	4.03	1.09	1.89	.542	4	D7

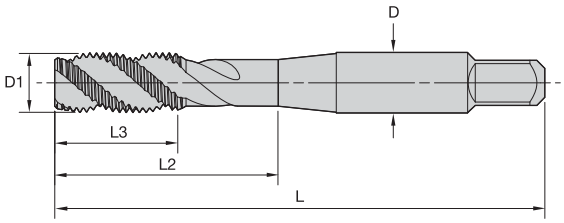
NOTE: Suggested for use in rigid and synchronous holders.

Shank Tolerance

D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

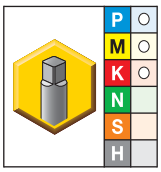
• KSP39 oxide







T832 • Form E Bottoming Chamfer • Metric • ANSI • Rigid and Synchronous Holders



● first choice
○ alternate choice

KSP39	D1 size	inch dimensions L	L3	L2	D	number of flutes	pitch diameter limit
T832M030X050RD3-A	M3 X 0,5	1.94	.58	.75	.141	2	D3
T832M035X060RD4-A	M3,5 X 0,6	2.00	.38	.71	.141	2	D4
T832M040X070RD4-A	M4 X 0,7	2.13	.38	.76	.168	3	D4
T832M050X080RD4-A	M5 X 0,8	2.38	.50	.91	.194	3	D4
T832M060X100RD5-A	M6 X 1	2.50	.63	1.00	.255	3	D5
T832M070X100RD5-A	M7 X 1	2.72	.69	1.15	.318	3	D5
T832MF080X100RD5-A	M8 X 1	2.72	.69	1.12	.318	3	D5
T832M080X125RD5-A	M8 X 1,25	2.72	.69	1.12	.318	3	D5
T832MF100X125RD5-A	M10 X 1,25	2.94	.75	1.26	.381	3	D5
T832M100X150RD6-A	M10 X 1,5	2.94	.75	1.26	.381	3	D6
T832MF120X125RD5-A	M12 X 1,25	3.38	.94	1.74	.367	3	D5
T832MF120X150RD5-A *	M12 X 1,5	3.38	.94	1.74	.367	3	D5
T832M120X175RD6-A	M12 X 1,75	3.38	.94	1.74	.367	3	D6
T832MF140X150RD6-A	M14 X 1,5	3.59	1.00	1.74	.429	3	D6
T832M140X200RD7-A	M14 X 2	3.59	1.00	1.74	.429	3	D7
T832MF160X150RD6-A	M16 X 1,5	3.81	1.09	1.89	.480	3	D6
T832M160X200RD7-A	M16 X 2	3.81	1.09	1.89	.480	3	D7
T832MF180X150RD6-A	M18 X 1,5	4.03	1.09	1.89	.542	4	D6

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

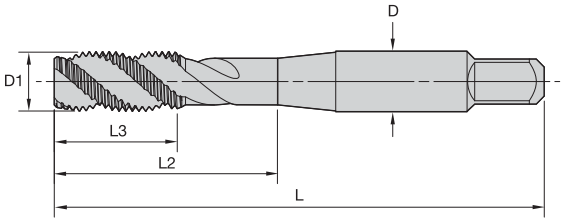
NOTE: Suggested for use in rigid and synchronous holders.

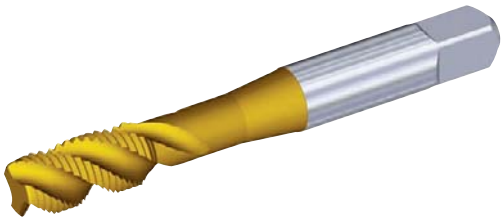
Shank Tolerance

D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

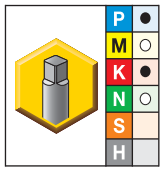
- KSP32 TiCN/TiN
- KSP39 oxide

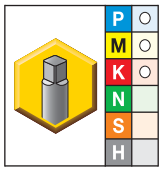






T838 • Form C Semi-Bottoming Chamfer • Metric • ANSI • Tension/Compression Holders





● first choice
○ alternate choice

KSP32	KSP39	inch dimensions D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
T838M030X050RD3-A	T838M030X050RD3-A	M3 X 0,5	1.94	.58	.75	.141	2	D3
–	T838M035X060RD4-A	M3,5 X 0,6	1.99	.38	.71	.141	2	D4
T838M040X070RD4-A	T838M040X070RD4-A	M4 X 0,7	2.12	.38	.76	.168	3	D4
T838M050X080RD4-A	T838M050X080RD4-A	M5 X 0,8	2.37	.50	.91	.194	3	D4
T838M060X100RD5-A	T838M060X100RD5-A	M6 X 1	2.50	.63	1.01	.255	3	D5
–	T838M070X100RD5-A	M7 X 1	2.73	.69	1.15	.318	3	D5
–	T838MF080X100RD5-A	M8 X 1	2.71	.69	1.12	.318	3	D5
T838M080X125RD5-A	T838M080X125RD5-A	M8 X 1,25	2.71	.69	1.12	.318	3	D5
–	T838MF100X125RD5-A	M10 X 1,25	2.92	.74	1.25	.381	3	D5
T838M100X150RD6-A	T838M100X150RD6-A	M10 X 1,5	2.92	.75	1.26	.381	3	D6
–	T838MF120X125RD5-A	M12 X 1,25	3.38	.94	1.74	.367	3	D5
–	T838MF120X150RD5-A	M12 X 1,5	3.38	.94	1.74	.367	3	D5
T838M120X175RD6-A	T838M120X175RD6-A	M12 X 1,75	3.38	.94	1.74	.367	3	D6
–	T838MF140X150RD6-A	M14 X 1,5	3.59	1.00	1.74	.429	3	D6
–	T838M140X200RD7-A	M14 X 2	3.59	1.00	1.74	.429	3	D7
–	T838MF160X150RD6-A	M16 X 1,5	3.81	1.09	1.89	.480	3	D6
–	T838M160X200RD7-A	M16 X 2	3.81	1.09	1.89	.480	3	D7
–	T838MF180X150RD6-A	M18 X 1,5	4.03	1.09	1.89	.542	4	D6
–	T838M180X250RD7-A	M18 X 2,5	4.03	1.09	1.89	.542	4	D7

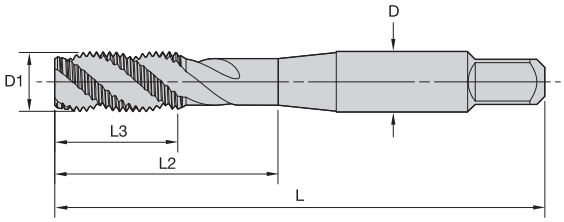
NOTE: Suitable for tension/compression holders.

Shank Tolerance

D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

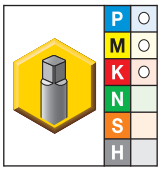
• KSP39 oxide







T839 • Form E Bottoming Chamfer • Metric • ANSI • Tension/Compression Holders



● first choice
○ alternate choice

KSP39	D1 size	inch dimensions L	L3	L2	D	number of flutes	pitch diameter limit
T839M030X050RD3-A	M3 X 0,5	1.94	.58	.75	.141	2	D3
T839M035X060RD4-A	M3,5 X 0,6	2.00	.38	.71	.141	2	D4
T839M040X070RD4-A	M4 X 0,7	2.13	.38	.76	.168	3	D4
T839M050X080RD4-A	M5 X 0,8	2.38	.50	.91	.194	3	D4
T839M060X100RD5-A	M6 X 1	2.50	.63	1.00	.255	3	D5
T839M070X100RD5-A	M7 X 1	2.72	.69	1.15	.318	3	D5
T839MF080X100RD5-A	M8 X 1	2.72	.69	1.12	.318	3	D5
T839M080X125RD5-A	M8 X 1,25	2.72	.69	1.12	.318	3	D5
T839MF100X125RD5-A	M10 X 1,25	2.94	.75	1.26	.381	3	D5
T839M100X150RD6-A	M10 X 1,5	2.94	.75	1.26	.381	3	D6
T839MF120X125RD5-A	M12 X 1,25	3.38	.94	1.74	.367	3	D5
T839MF120X150RD5-A	M12 X 1,5	3.38	.94	1.74	.367	3	D5
T839M120X175RD6-A	M12 X 1,75	3.38	.94	1.74	.367	3	D6
T839MF140X150RD6-A	M14 X 1,5	3.59	1.00	1.74	.429	3	D6
T839M140X200RD7-A	M14 X 2	3.59	1.00	1.74	.429	3	D7
T839MF160X150RD6-A	M16 X 1,5	3.81	1.09	1.89	.480	3	D6
T839M160X200RD7-A	M16 X 2	3.81	1.09	1.89	.480	3	D7
T839MF180X150RD6-A	M18 X 1,5	4.03	1.09	1.89	.542	4	D6

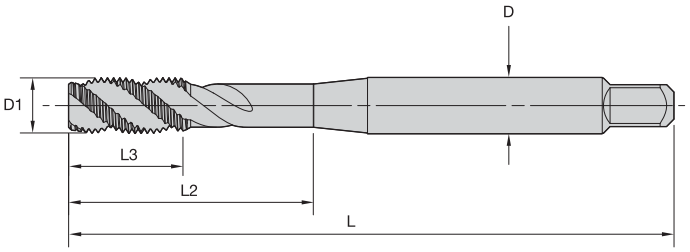
NOTE: Suitable for tension/compression holders.

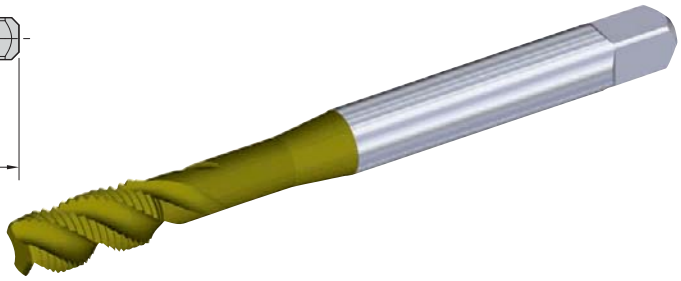
Shank Tolerance

D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

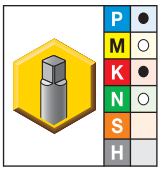
- KSP32 TiCN/TiN
- KSP39 oxide

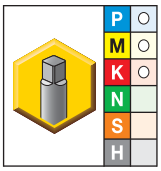






T830 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • Rigid and Synchronous Holders



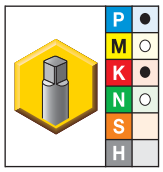


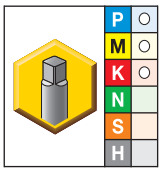
● first choice
○ alternate choice

KSP32	KSP39	metric dimensions 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

(continued)

(T830 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • Rigid and Synchronous Holders — continued)





● first choice
○ alternate choice

KSP32	KSP39	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
–	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
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

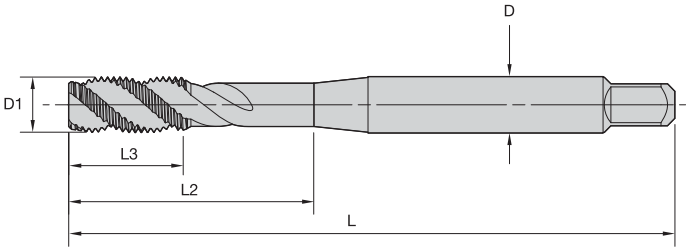
NOTE: Suggested for use in rigid and synchronous holders.

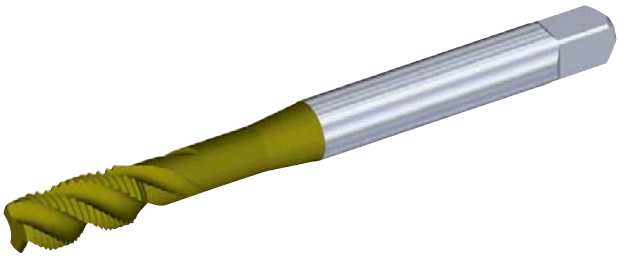
Shank Tolerance

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

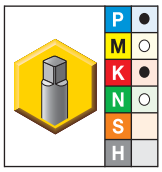
- KSP32 TiCN/TiN
- KSP39 oxide

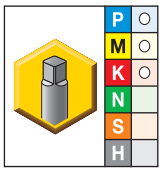






T832 • DIN 371, 374, and 376 • Form E Bottoming Chamfer • Metric • Rigid and Synchronous Holders





● first choice
○ alternate choice

KSP32	KSP39	metric dimensions 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

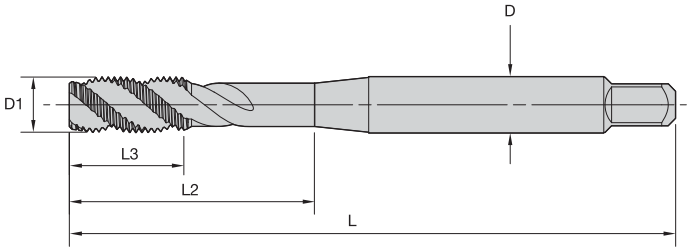
NOTE: Suggested for use in rigid and synchronous holders.

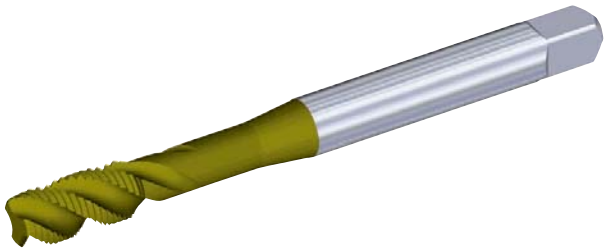
Shank Tolerance

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

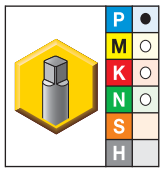
- KSU31 TiN
- KSP39 oxide

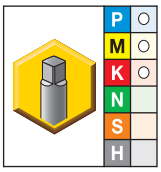






T838 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • Tension/Compression Holders



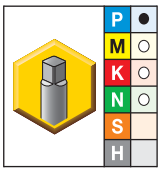


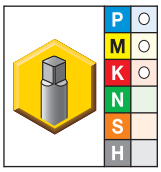
● first choice
○ alternate choice

KSU31	KSP39	metric dimensions 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

(continued)

(T838 • DIN 371, 374, and 376 • Form C Semi-Bottoming Chamfer • Metric • Tension/Compression Holders — continued)





● first choice
○ alternate choice

KSU31	KSP39	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
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
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

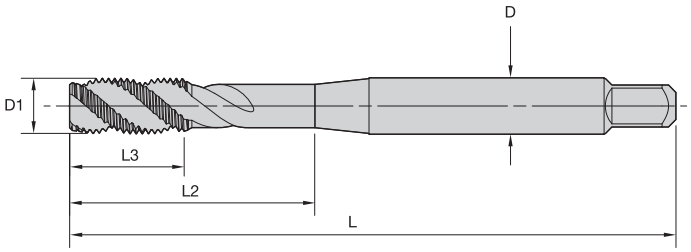
NOTE: Suitable for tension/compression holders.

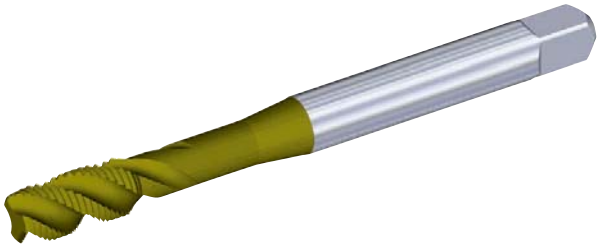
Shank Tolerance

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

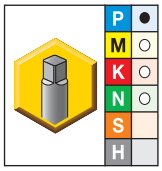
- KSU31 TiN
- KSP39 oxide

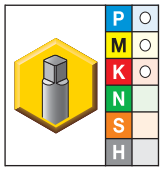






T839 • DIN 371 and 376 • Form E Bottoming Chamfer • Metric • Tension/Compression Holders





● first choice
○ alternate choice

KSU31	KSP39	metric dimensions 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

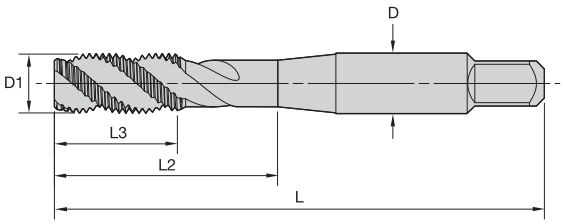
NOTE: Suitable for tension/compression holders.

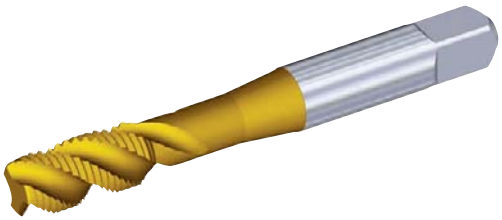
Shank Tolerance

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

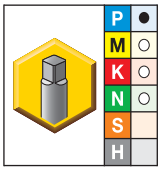
- KSU31 TiN
- KSU30 bright

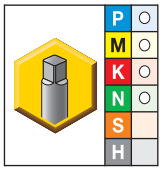






T830 • Form C Semi-Bottoming Chamfer • Metric • JIS • Rigid and Synchronous Holders





● first choice
○ alternate choice

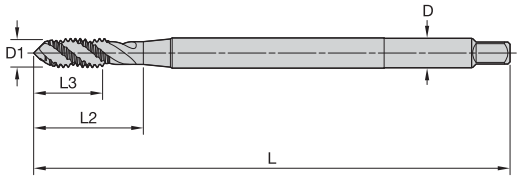
KSU31	KSU30	metric dimensions D1 size	L	L3	L2	D	number of flutes	dimension standard	tap class
T830M030X050R6H-J	**T830M030X050R6H-J**	M3 X 0,5	46	11	19	4,0	2	JIS	ISO 2
T830M040X070R6H-J	**T830M040X070R6H-J**	M4 X 0,7	52	13	21	5,0	3	JIS	ISO 2
T830M050X080R6H-J	**T830M050X080R6H-J**	M5 X 0,8	60	16	24	5,5	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

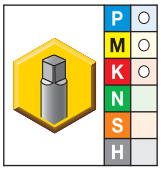
D mm	tolerance h9
1–3	+0, -0,025
>3–6	+0, -0,030
>6–10	+0, -0,036
>10–18	+0, -0,043
>18–30	+0, -0,052







T830 • Form C Semi-Bottoming Chamfer • Machine Screw and Fractional • 4" Length • ANSI • Tension/Compression Holders



● first choice
○ alternate choice

KSP39	D1 TPI	inch dimensions L	L3	L2	D	number of flutes	pitch diameter limit
T830NC#04-40RH2-XL4	4 - 40	4.00	.56	.87	.141	2	H2
T830NC#06-32RH3-XL4 *	6 - 32	4.00	.38	.71	.141	2	H3
T830NC#08-32RH3-XL4	8 - 32	4.00	.38	.76	.168	3	H3
T830NF#10-32RH3-XL4	10 - 32	4.00	.50	.91	.194	3	H3
T830NC02500-20RH3-XL4	1/4 20	4.00	.63	1.00	.255	3	H3

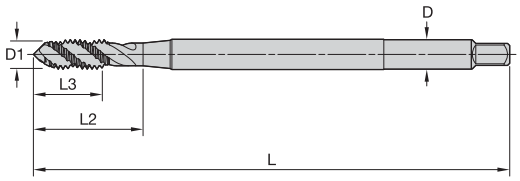
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

NOTE: Suitable for tension/compression holders.

Shank Tolerance

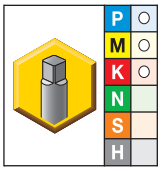
D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030







T830 • Form C Semi-Bottoming Chamfer • Machine Screw and Fractional • 6" Length • ANSI • Tension/Compression Holders



● first choice
○ alternate choice

KSP39	inch dimensions D1 TPI	L	L3	L2	D	number of flutes	pitch diameter limit
T830NC#04-40RH2-XL6 *	4 - 40	6.00	.56	.87	.141	2	H2
T830NC#06-32RH3-XL6	6 - 32	6.00	.38	.71	.141	2	H3
T830NC#08-32RH3-XL6	8 - 32	6.00	.38	.76	.168	3	H3
T830NC#10-24RH3-XL6 *	10 - 24	6.00	.50	.91	.194	3	H3
T830NF#10-32RH3-XL6	10 - 32	6.00	.50	.91	.194	3	H3
T830NC02500-20RH3-XL6	1/4 20	6.00	.63	1.00	.255	3	H3
T860NF02500-28RH3-XL6	1/4 - 28	6.00	.63	1.01	.255	3	H3
T830NC03125-18RH3-XL6	5/16 - 18	6.00	.69	1.13	.318	3	H3
T830NF03125-24RH3-XL6	5/16 - 24	6.00	.69	1.13	.318	3	H3
T830NC03750-16RH3-XL6	3/8 - 16	6.00	.75	1.27	.381	3	H3
T830NF03750-24RH3-XL6 *	3/8 - 24	6.00	.75	1.26	.381	3	H3
T830NC04375-14RH3-XL6 *	7/16 - 14	6.00	.88	1.49	.323	3	H3
T830NF04375-20RH3-XL6	7/16 - 20	6.00	.88	1.49	.323	3	H3
T830NC05000-13RH3-XL6	1/2 - 13	6.00	.94	1.74	.367	3	H3
T830NF05000-20RH3-XL6	1/2 - 20	6.00	.94	1.74	.367	3	H3
T830NC06250-11RH3-XL6	5/8 - 11	6.00	1.09	1.89	.480	3	H3

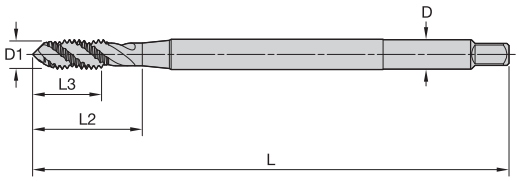
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

NOTE: Suitable for tension/compression holders.

Shank Tolerance

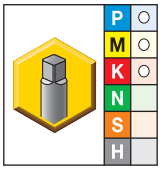
D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030







T832 • Form E Bottoming Chamfer • Machine Screw and Fractional • 6" Length • ANSI • Tension/Compression Holders



● first choice
○ alternate choice

KSP39	D1 TPI	inch dimensions L	L3	L2	D	number of flutes	pitch diameter limit
T832NC#04-40RH2-XL6	4 - 40	6.00	.56	.87	.141	2	H2
T832NC#06-32RH3-XL6	6 - 32	6.00	.38	.71	.141	2	H3
T832NC#08-32RH3-XL6	8 - 32	6.00	.38	.76	.168	3	H3
T832NF#10-32RH3-XL6 *	10 - 32	6.00	.50	.91	.194	3	H3
T832NC02500-20RH3-XL6	1/4 20	6.00	.63	1.00	.255	3	H3
T832NF02500-28RH3-XL6	1/4 - 28	6.00	.63	1.01	.255	3	H3
T832NC03125-18RH3-XL6	5/16 - 18	6.00	.69	1.13	.318	3	H3
T832NC03750-16RH3-XL6	3/8 - 16	6.00	.75	1.27	.381	3	H3
T832NF03750-24RH3-XL6	3/8 - 24	6.00	.75	1.26	.381	3	H3
T832NC04375-14RH3-XL6	7/16 - 14	6.00	.88	1.49	.323	3	H3

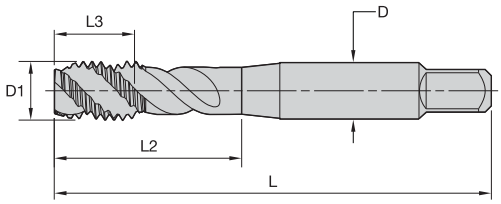
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

NOTE: Suitable for tension/compression holders.

Shank Tolerance

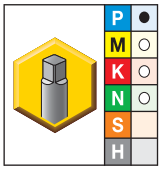
D inch	tolerance
.141–.635	+0, -.0015
>.635–1.51	+0, -.0020
>1.51–2.01	+0, -.0030

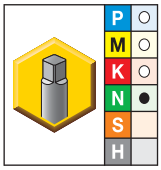






KHSST Spiral Flute • Machine Screw and Fractional • Bottoming Chamfer Tap



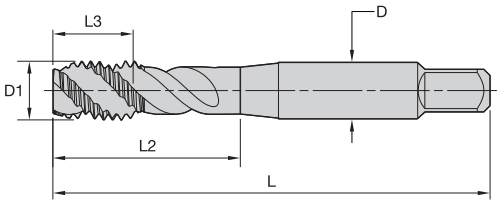


● first choice
○ alternate choice

TiN	uncoated	D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
KHSST28761	**KHSST28762**	4 - 40	1.88	.56	—	.141	2	H2
KHSST28779	**KHSST28774**	6 - 32	2.00	.38	.69	.141	2	H3
KHSST28785	**KHSST28787**	8 - 32	2.13	.38	.75	.168	3	H3
KHSST28738	**KHSST28740**	10 - 24	2.38	.50	.88	.194	3	H3
KHSST28745	**KHSST28747**	10 - 32	2.38	.50	.88	.194	3	H3
KHSST28137	**KHSST28074**	1/4 - 20	2.50	.63	1.00	.255	3	H3
KHSST28081	**KHSST28083**	1/4 - 28	2.50	.63	1.00	.255	3	H3
KHSST28211	**KHSST28213**	5/16 - 18	2.72	.69	1.12	.318	3	H3
KHSST28221	**KHSST28223**	5/16 - 24	2.72	.69	1.12	.318	3	H3
KHSST28187	**KHSST28189**	3/8 - 16	2.94	.75	1.25	.381	3	H3
KHSST28201	—	3/8 - 24	2.94	.75	1.25	.381	3	H3
KHSST28670	**KHSST28672**	7/16 - 14	3.16	.88	—	.323	3	H3
—	**KHSST28674**	7/16 - 20	3.16	.88	—	.323	3	H3
KHSST28047	**KHSST28049**	1/2 - 13	3.38	.94	—	.367	3	H3
—	**KHSST28062**	1/2 - 20	3.38	.94	—	.367	3	H3
—	**KHSST28231**	5/8 - 11	3.81	1.09	—	.480	4	H3
—	**KHSST28165**	3/4 - 10	4.25	1.22	—	.590	4	H3

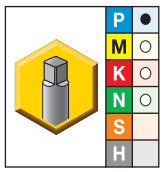
NOTE: Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.

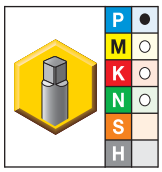


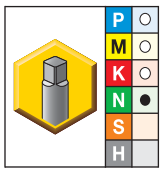




KHSST Spiral Flute • Bottoming Chamfer Tap • Metric ANSI





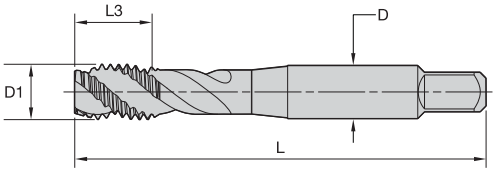


● first choice
○ alternate choice

TiCN	TiN	uncoated	D1 size	L	L3	L2	D	number of flutes	pitch diameter limit
KHSST28478	**KHSST28700**	**KHSST28692**	M3 X 0,5	1.94	.31	—	.141	2	D3
KHSST28709	**—**	**KHSST28707**	M4 X 0,7	2.13	.38	.75	.168	3	D4
—	**—**	**KHSST28716**	M5 X 0,8	2.38	.50	.88	.194	3	D4
KHSST28723	**—**	**KHSST28721**	M6 X 1	2.50	.38	.75	.255	3	D5
—	**—**	**KHSST28726**	M8 X 1,25	2.72	.69	1.12	.318	3	D5
KHSST28476	**—**	**KHSST28683**	M10 X 1,5	2.94	.75	1.25	.381	3	D6

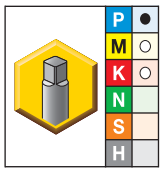
NOTE: Metric D limits are suitable for ISO 6H tolerance class.
Metric taps are manufactured to USCTI specifications and dimensions.
Metric tap blank dimensions are equivalent to inch taps.
Refer to table on page M203 for the recommended pitch diameter limit for 6H class of fit.







KHSST Heavy-Duty Spiral Flute • Machine Screw and Fractional • Bottoming Chamfer Taps



● first choice
○ alternate choice

oxide	D1 size	L	L3	D	number of flutes	pitch diameter limit
KHSST28780	6 - 32	2.00	.38	.141	3	H3
KHSST28786	8 - 32	2.13	.38	.168	3	H3
KHSST28739	10 - 24	2.38	.50	.194	3	H3
KHSST28746	10 - 32	2.38	.50	.194	3	H3
KHSST28073	1/4 - 20	2.50	.63	.255	3	H3
KHSST28082	1/4 - 28	2.50	.63	.255	3	H3
KHSST28212	5/16 - 18	2.72	.69	.318	3	H3
KHSST28188	3/8 - 16	2.94	.75	.381	3	H3
KHSST28671 *	7/16 - 14	3.16	.88	.323	3	H3
KHSST28048	1/2 - 13	3.38	.94	.367	3	H3
KHSST28163	3/4 - 10	4.25	1.22	.590	4	H3

NOTE: KHSST taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

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

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High-Performance Beyond™ Solid Carbide Taps

- Straight-flute design for through- and blind-hole tapping in cast iron, cast aluminum, 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 aluminum.
- 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.

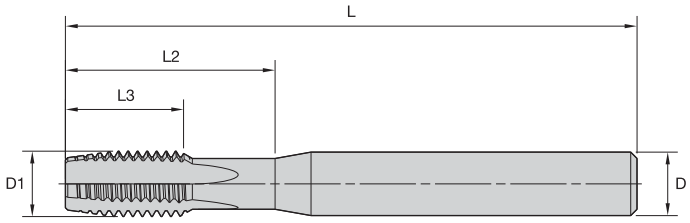
General-Purpose Taps

- HSS straight-flute hand taps for use by hand or tapping under power.
- Plug and bottoming chamfers for through- and blind-hole tapping.
- Wide range of sizes and pitch limits offered with PVD coatings and surface treatments.



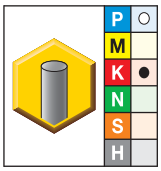
- KCK17 AlCrTiN for cast iron.







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

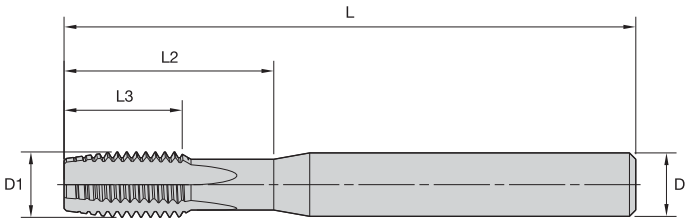
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

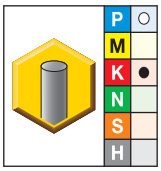
- KCK17 AlCrTiN for cast iron.







T340 • Form D Plug • Metric • Solid Carbide • For Cast Iron



● first choice
○ alternate choice

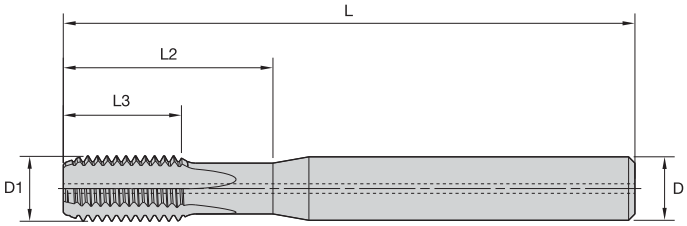
KCK17	D1 size	L	L3	L2	D	number of flutes	class of fit
T340M040X070R6HX	M4 X 0,7	60	6	16	6,0	3	6HX
T340M050X080R6HX	M5 X 0,8	60	7	20	6,0	3	6HX
T340M060X100R6HX	M6 X 1	70	12	24	6,0	4	6HX
T340M080X125R6HX	M8 X 1,25	80	15	32	8,0	4	6HX
T340MF100X100R6HX	M10 X 1	90	18	40	10,0	4	6HX
T340M100X150R6HX	M10 X 1,5	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

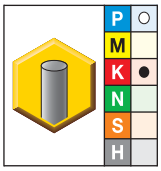
- KCK17 AlCrTiN for cast iron.







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

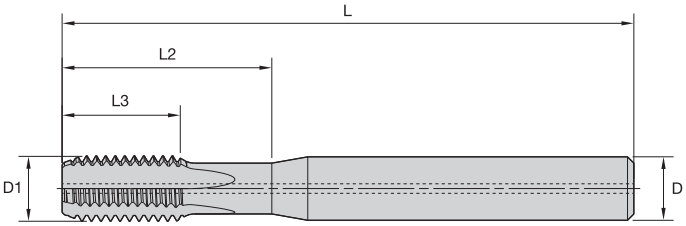
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

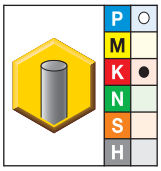
- KCK17 AlCrTiN for cast iron.







T351 • Form E Bottoming Chamfer • Through Coolant M6 and Larger • Metric • Solid Carbide • For Cast Iron



● first choice
○ alternate choice

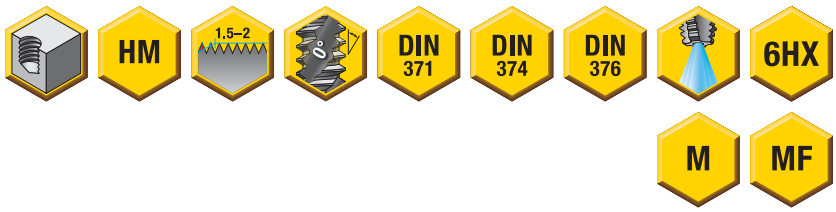
KCK17	D1 size	L	L3	L2	D	number of flutes	class of fit
T351M040X070R6HX *	M4 X 0,7	60	6	16	6,0	3	6HX
T351M050X080R6HX	M5 X 0,8	60	7	20	6,0	3	6HX
T351M060X100R6HX	M6 X 1	70	12	24	6,0	4	6HX
T351M080X125R6HX	M8 X 1,25	80	15	32	8,0	4	6HX
T351MF100X100R6HX	M10 X 1	90	18	40	10,0	4	6HX
T351M100X150R6HX	M10 X 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

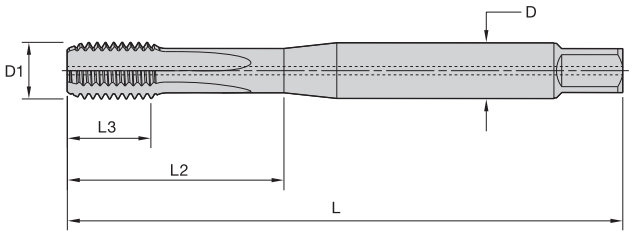
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

• KCK17 AlCrTiN for cast iron.

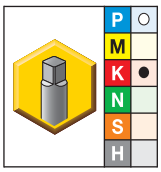






beyond

T351 • DIN 371, 374, and 376 • Form E Bottoming Chamfer • Through Coolant • Metric • Solid Carbide • For Cast Iron



● first choice
○ alternate choice

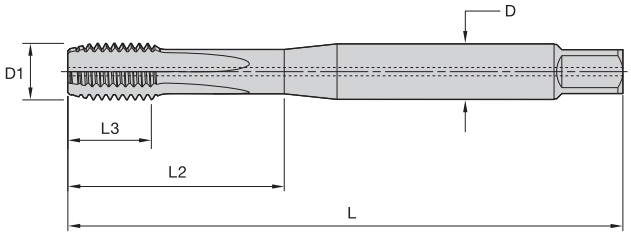
KCK17	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T351M060X100R6HX-D1	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
T351M070X100R6HX-D1	M7 X 1	80	10	30	7,0	4	DIN 371	6HX
T351M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
T351M090X125R6HX-D1	M9 X 1,25	90	13	35	9,0	4	DIN 371	6HX
T351MF100X100R6HX-D4	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.

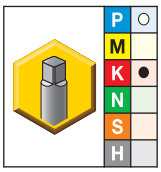






beyond

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

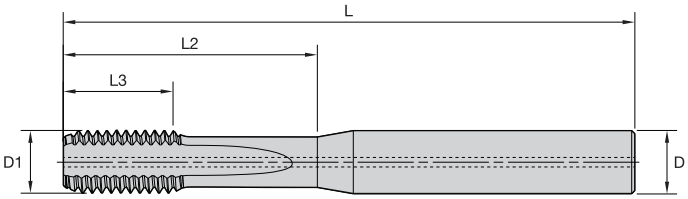
KCK17	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T353M040X070R6HX-D1	M4 X 0,7	63	10	21	4,5	3	DIN 371	6HX
T353M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T353M060X100R6HX-D1	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
T353M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
T353M100X150R6HX-D1	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

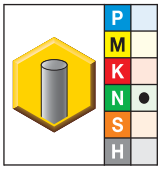
• KCN14 TiN + CrC/C for aluminum.







T471 • Form E Bottoming Chamfer • Through Coolant • Metric • Solid Carbide • For Aluminum



● first choice
○ alternate choice

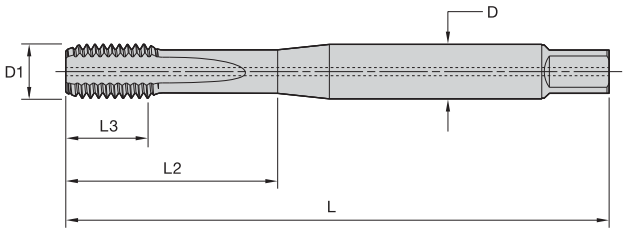
KCN14	D1 size	L	L3	L2	D	number of flutes	class of fit
T471M060X100R6HX	M6 X 1	70	12	24	6,0	3	6HX
T471M080X125R6HX	M8 X 1,25	80	15	32	8,0	3	6HX
T471M100X150R6HX	M10 X 1,5	90	18	40	10,0	3	6HX
T471M120X175R6HX	M12 X 1,75	100	21	48	12,0	3	6HX
T471M140X200R6HX	M14 X 2	110	24	56	12,0	4	6HX

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

• KCN14 TiN + CrC/C for aluminum.

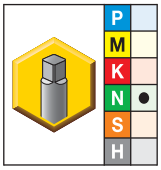






beyond

T471 • DIN 371 • Form E Bottoming Chamfer • Through Coolant • Metric • Solid Carbide • For Aluminum



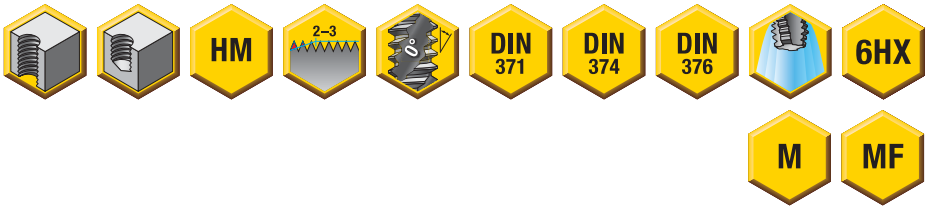
● first choice
○ alternate choice

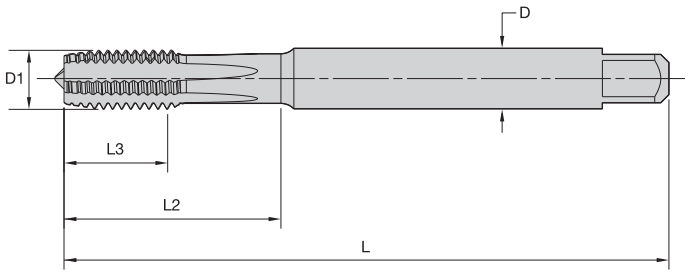
KCN14	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T471M060X100R6HX-D1	M6 X 1	80	10	30	6,0	3	DIN 371	6HX
T471M080X125R6HX-D1	M8 X 1,25	90	10	35	8,0	3	DIN 371	6HX
T471M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	3	DIN 371	6HX

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

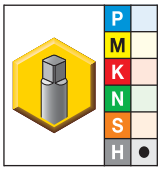
- KCU36 TiAlN/MoS_2 for tapping steel 55–63 HRC.







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

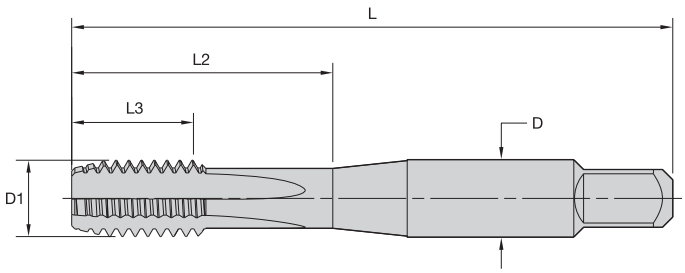
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

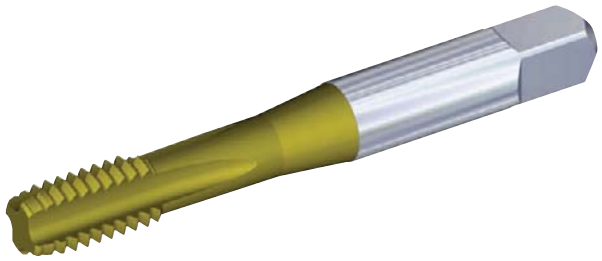
Shank Tolerance

D	tolerance h9
1–3	+0, -0,025
3,5–6	+0, -0,030
7–10	+0, -0,036
11–18	+0, -0,043

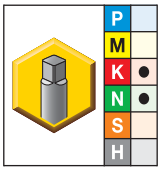
- KP6525 TiCN + TiN for cast iron and cast aluminum.







T640 • Machine Screw and Fractional • Form C Semi-Bottoming Chamfer • ANSI • For Cast Iron and Cast Aluminum



● first choice
○ alternate choice

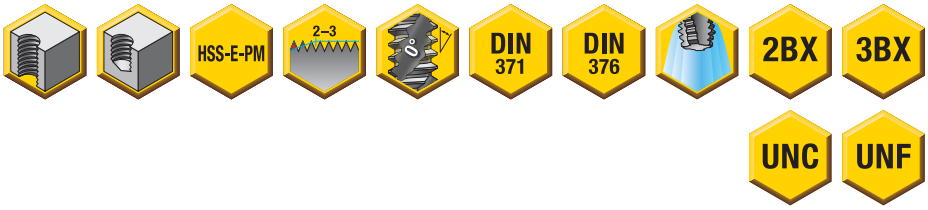
KP6525	D1 size	L	L3	L2	D	number of flutes	class of fit
T640NC#10-24R3BX-A *	10 - 24	2.37	.47	.91	.194	3	3BX
T640NF#10-32R3BX-A	10 - 32	2.36	.47	.91	.194	3	3BX
T640NC02500-20R2BX-A	1/4 - 20	2.50	.44	1.01	.255	4	2BX
T640NC02500-20R3BX-A *	1/4 - 20	2.50	.44	1.01	.255	4	3BX
T640NF02500-28R2BX-A	1/4 - 28	2.49	.43	1.00	.255	4	2BX
T640NF02500-28R3BX-A	1/4 - 28	2.49	.43	1.00	.255	4	3BX
T640NC03125-18R2BX-A	5/16 - 18	2.72	.49	1.13	.318	4	2BX
T640NC03125-18R3BX-A *	5/16 - 18	2.72	.49	1.13	.318	4	3BX
T640NF03125-24R3BX-A *	5/16 - 24	2.71	.48	1.13	.318	4	3BX
T640NC03750-16R2BX-A	3/8 - 16	2.94	.60	1.27	.381	4	2BX
T640NC03750-16R3BX-A	3/8 - 16	2.94	.60	1.27	.381	4	3BX
T640NF03750-24R3BX-A	3/8 - 24	2.92	.58	1.25	.381	4	3BX
T640NC04375-14R3BX-A	7/16 - 14	3.16	.71	1.49	.323	4	3BX
T640NF04375-20R3BX-A	7/16 - 20	3.16	.71	1.49	.323	4	3BX
T640NC05000-13R3BX-A	1/2 - 13	3.38	.77	1.74	.367	4	3BX
T640NF05000-20R3BX-A	1/2 - 20	3.38	.77	1.74	.367	4	3BX
T640NC06250-11R3BX-A	5/8 - 11	3.81	.91	1.89	.480	4	3BX
T640NC07500-10R3BX-A	3/4 - 10	4.25	1.00	2.08	.590	4	3BX

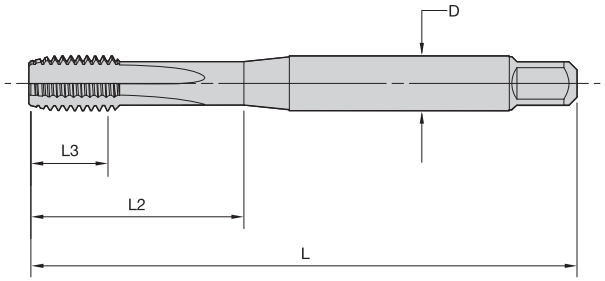
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

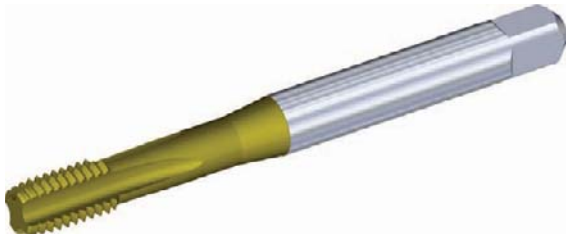
Shank Tolerance

D fractional	D inch
.250–.375	+0, -.0004
.438–.625	+0, -.0004

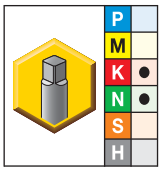
- KP6525 TiCN + TiN for cast iron and cast aluminum.







T640 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Machine Screw and Fractional • For Cast Iron and Cast Aluminum



● first choice
○ alternate choice

KP6525	metric dimensions 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

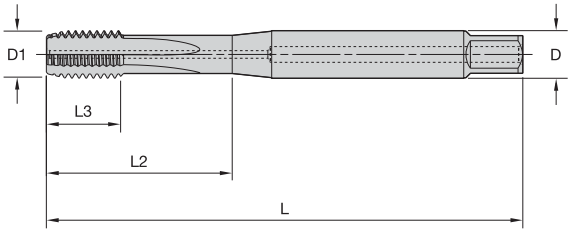
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

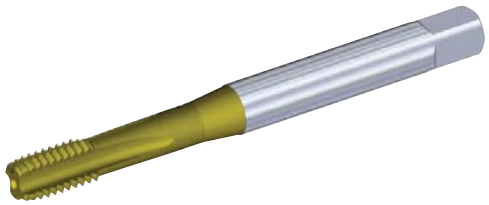
Shank Tolerance

D fractional	tolerance h6
>3–6	+0, -0,008
>6–10	+0, -0,009
<10–18	+0, -0,011

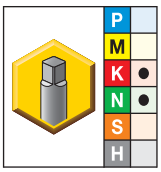
- KP6525 TiCN + TiN for cast iron and cast aluminum.







T641 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Through Coolant • Fractional • For Cast Iron and Cast Aluminum



● first choice
○ alternate choice

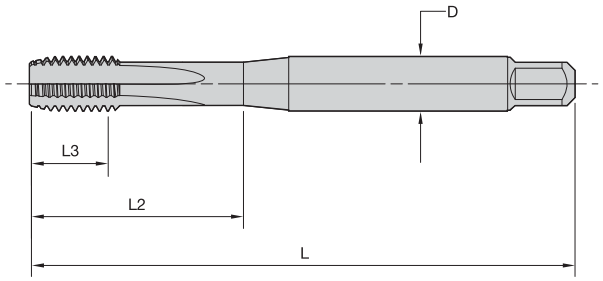
KP6525	D1 size	metric dimensions L	L3	L2	D	number of flutes	dimension standard	class of fit
T641NC02500-20R3BX-D1	1/4 - 20	80	13	30	7,0	4	DIN 371	3BX
T641NF02500-28R3BX-D1	1/4 - 28	80	13	30	7,0	4	DIN 371	3BX
T641NC03125-18R3BX-D1	5/16 - 18	90	13	35	8,0	4	DIN 371	3BX
T641NF03125-24R3BX-D1	5/16 - 24	90	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

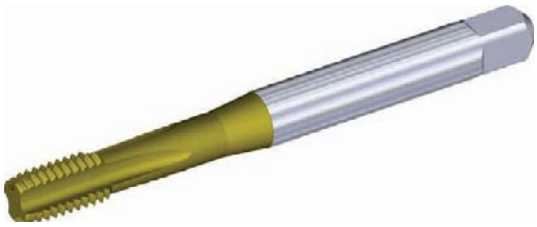
Shank Tolerance

D fractional	tolerance h6
>3–6	+0, -0,008
>6–10	+0, -0,009
<10–18	+0, -0,011

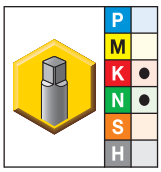
- KP6525 TiCN + TiN for cast iron and cast aluminum.







T640 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Metric • For Cast Iron and Cast Aluminum



● first choice
○ alternate choice

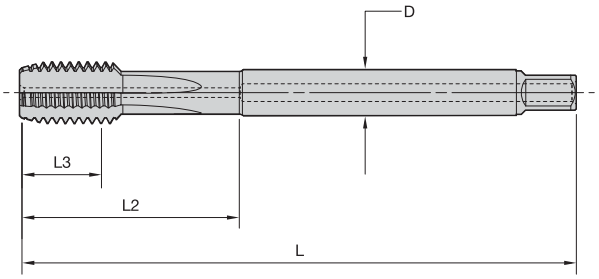
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T640M040X070R6HX-D1	M4 X 0,7	63	10	21	4,5	3	DIN 371	6HX
T640M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T640M060X100R6HX-D1	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
T640M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
T640M100X150R6HX-D1	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

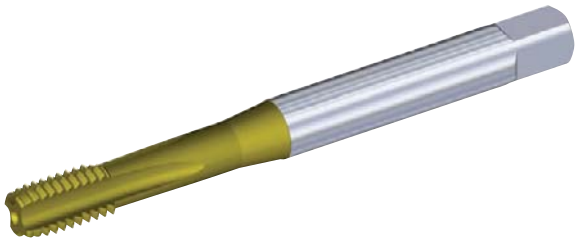
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

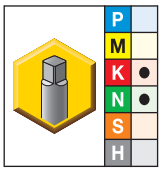
- KP6525 TiCN + TiN for cast iron and cast aluminum.







T641 • DIN 371 and 376 • Form C Semi-Bottoming Chamfer • Through Coolant • Metric • For Cast Iron and Cast Aluminum



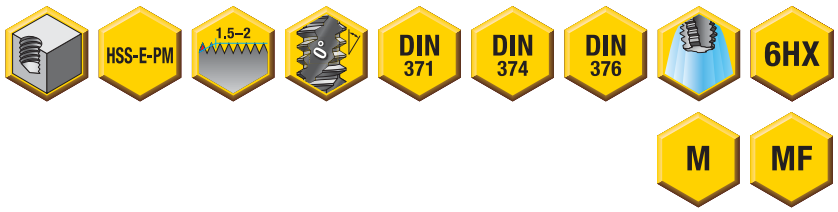
● first choice
○ alternate choice

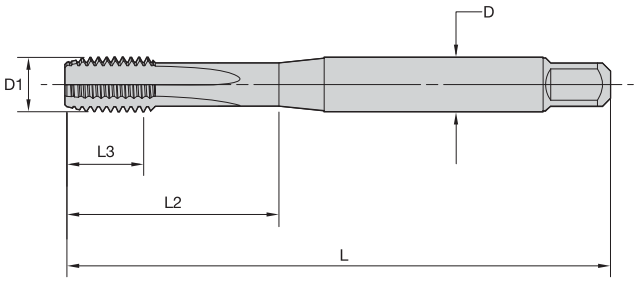
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T641M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T641M060X100R6HX-D1	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
T641M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
T641M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	4	DIN 371	6HX
T641M120X175R6HX-D6	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

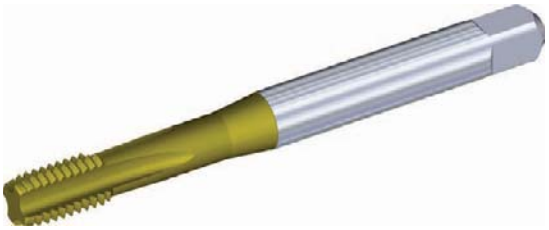
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

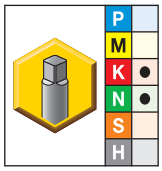
- KP6525 TiCN + TiN for cast iron and cast silicon aluminum.







T642 • DIN 371, 374, and 376 • Form E Bottoming Chamfer • Metric • For Cast Iron and Cast Silicon Aluminum



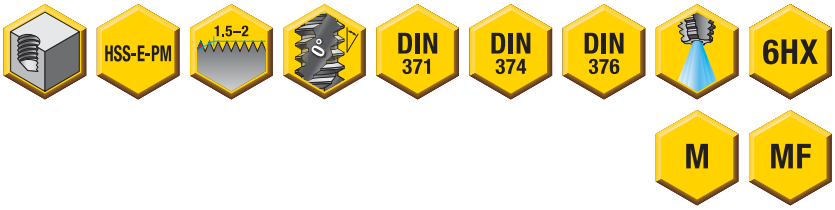
● first choice
○ alternate choice

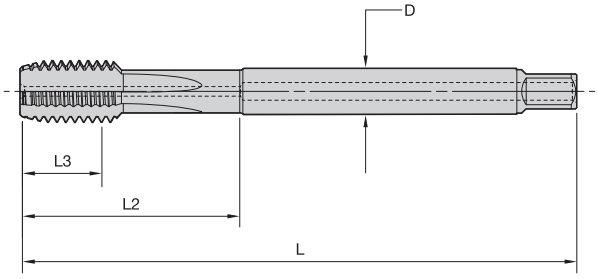
KP6525	D1 size	L	L3	L2	D	number of flutes	dimension standard	class of fit
T642M050X080R6HX-D1	M5 X 0,8	70	10	25	6,0	3	DIN 371	6HX
T642M060X100R6HX-D1	M6 X 1	80	10	30	6,0	4	DIN 371	6HX
T642M080X125R6HX-D1	M8 X 1,25	90	13	35	8,0	4	DIN 371	6HX
T642M100X150R6HX-D1	M10 X 1,5	100	15	39	10,0	4	DIN 371	6HX
T642MF120X150R6HX-D4	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

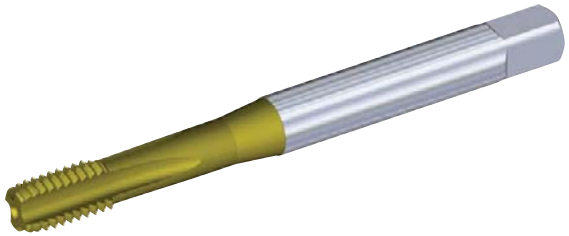
Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

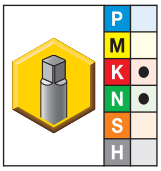
- KP6525 TiCN + TiN for tapping cast iron and cast silicon aluminum.







T643 • DIN 371, 374, and 376 • Form E Bottoming Chamfer • Through Coolant • Metric • For Cast Iron and Cast Silicon Aluminum



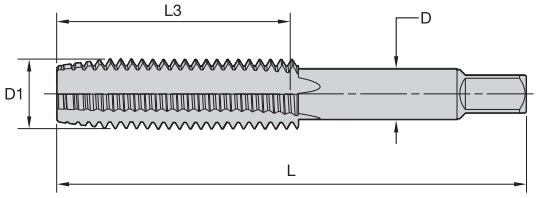
● first choice
○ alternate choice

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

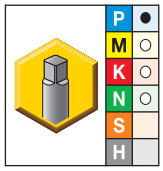
D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

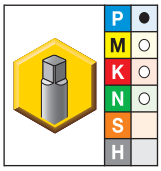


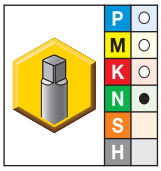




KHSST Hand • Machine Screw Sizes • Plug Chamfer Tap





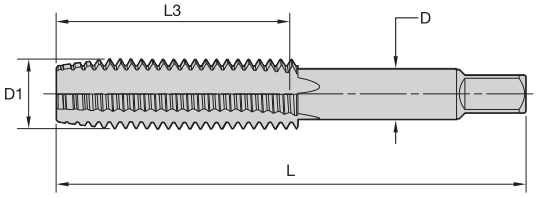


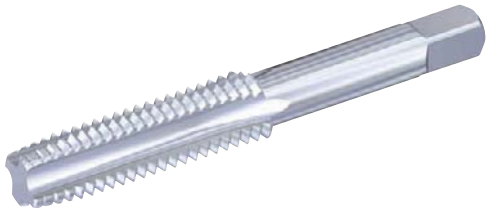
● first choice
○ alternate choice

TiCN	TiN	uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
–	–	KHSST28372	0 - 80	1.63	.31	.141	2	H1
–	KHSST09000	KHSST08003	0 - 80	1.63	.31	.141	2	H2
–	–	KHSST08015	1 - 64	1.69	.38	.141	2	H2
–	KHSST28129	KHSST28376	2 - 56	1.75	.44	.141	2	H2
–	KHSST28426	KHSST08039	2 - 56	1.75	.44	.141	3	H2
–	KHSST28134	–	3 - 48	1.81	.50	.141	2	H2
–	–	KHSST28380	3 - 48	1.81	.50	.141	3	H2
–	–	KHSST08067	3 - 56	1.81	.50	.141	3	H2
–	KHSST28427	KHSST08082	4 - 40	1.88	.56	.141	2	H2
KHSST28433	KHSST09004	KHSST08087	4 - 40	1.88	.56	.141	3	H2
–	–	KHSST08101	4 - 48	1.88	.56	.141	3	H2
–	–	KHSST08112	5 - 40	1.94	.63	.141	2	H2
–	–	KHSST08116	5 - 40	1.94	.63	.141	3	H2
–	–	KHSST08140	6 - 32	2.00	.69	.141	2	H2
–	KHSST28428	KHSST28389	6 - 32	2.00	.69	.141	2	H3
–	KHSST09008	KHSST08148	6 - 32	2.00	.69	.141	3	H2
KHSST28440	–	KHSST08151	6 - 32	2.00	.69	.141	3	H3
–	–	KHSST08172	6 - 40	2.00	.69	.141	3	H2
–	–	KHSST28396	8 - 32	2.13	.75	.168	2	H2
–	–	KHSST28400	8 - 32	2.13	.75	.168	2	H3
–	KHSST28136	KHSST28401	8 - 32	2.13	.75	.168	3	H3
–	KHSST09010	KHSST28397	8 - 32	2.13	.75	.168	4	H2
–	–	KHSST08192	8 - 32	2.13	.75	.168	4	H3
–	–	KHSST08218	8 - 36	2.13	.75	.168	4	H2
–	–	KHSST08238	10 - 24	2.38	.88	.194	2	H3
–	–	KHSST28410	10 - 32	2.38	.88	.194	2	H2
–	KHSST28425	KHSST08272	10 - 32	2.38	.88	.194	2	H3
–	–	KHSST28407	10 - 24	2.38	.88	.194	3	H3
–	–	KHSST28413	10 - 32	2.38	.88	.194	3	H3
–	KHSST09012	KHSST08234	10 - 24	2.38	.88	.194	4	H3
–	–	KHSST08261	10 - 32	2.38	.88	.194	4	H2
–	KHSST09014	KHSST08268	10 - 32	2.38	.88	.194	4	H3
–	KHSST28132	KHSST08294	12 - 24	2.38	.94	.220	4	H3
–	–	KHSST28417	12 - 28	2.38	.94	.220	4	H3

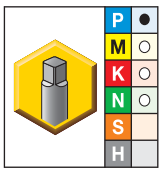
NOTE: Hand taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.

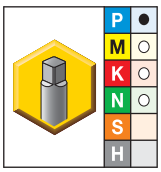


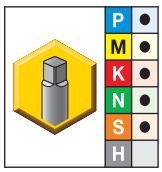


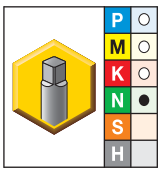


KHSST Hand • Fractional Sizes • Plug Chamfer Tap







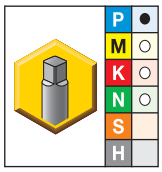


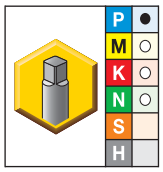
● first choice
○ alternate choice

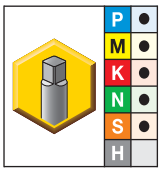
TiCN	TiN	oxide	uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
–	–	–	KHSST08316	1/4 - 20	2.50	1.00	.255	4	H2
–	KHSST28358	–	KHSST08324	1/4 - 20	2.50	1.00	.255	2	H3
–	–	–	KHSST28296	1/4 - 20	2.50	1.00	.255	3	H3
KHSST28364	KHSST09018	KHSST28343	KHSST08320	1/4 - 20	2.50	1.00	.255	4	H3
–	–	–	KHSST28298	1/4 - 20	2.50	1.00	.255	4	H5
–	–	–	KHSST08355	1/4 - 28	2.50	1.00	.255	3	H3
–	–	–	KHSST08353	1/4 - 28	2.50	1.00	.255	4	H3
–	–	–	KHSST28293	1/4 - 20	3.38	1.66	.367	4	H5
–	KHSST28356	–	KHSST28318	5/16 - 18	2.72	1.13	.318	2	H3
–	KHSST28127	–	KHSST28314	5/16 - 18	2.72	1.13	.318	3	H3
–	KHSST09022	–	KHSST08380	5/16 - 18	2.72	1.13	.318	4	H3
–	–	–	KHSST08411 *	5/16 - 24	2.72	1.13	.318	3	H3
–	–	KHSST28349	KHSST08409	5/16 - 24	2.72	1.13	.318	4	H3
–	KHSST28359	–	KHSST28309	3/8 - 16	2.94	1.25	.381	3	H3
–	KHSST09026	KHSST28348	KHSST08434	3/8 - 16	2.94	1.25	.381	4	H3
–	–	–	KHSST08461	3/8 - 24	2.94	1.25	.381	3	H3
–	KHSST09028	–	KHSST08459	3/8 - 24	2.94	1.25	.381	4	H3
–	KHSST09030	–	KHSST08477	7/16 - 14	3.16	1.44	.323	4	H3
–	KHSST28123	–	KHSST08493	7/16 - 20	3.16	1.44	.323	4	H3
–	–	–	KHSST08510	1/2 - 13	3.38	1.66	.367	3	H3
KHSST28361	KHSST28116	KHSST28341	KHSST08508	1/2 - 13	3.38	1.66	.367	4	H3
–	–	–	KHSST28291	1/2 - 20	3.38	1.66	.367	3	H3
–	–	–	KHSST08530	1/2 - 20	3.38	1.66	.367	4	H3
–	–	–	KHSST08545	9/16 - 12	3.59	1.66	.429	4	H3
–	–	–	KHSST08553	9/16 - 18	3.59	1.66	.429	4	H3
KHSST28366	KHSST28120	KHSST28351	KHSST08561	5/8 - 11	3.81	1.81	.480	4	H3
–	–	–	KHSST28323	5/8 - 11	3.81	1.81	.480	4	H5
–	KHSST28121	–	KHSST08574	5/8 - 18	3.81	1.81	.480	4	H3

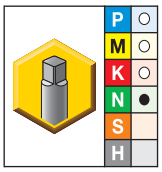
(continued)

(KHSST Hand • Fractional Sizes • Plug Chamfer Tap — continued)







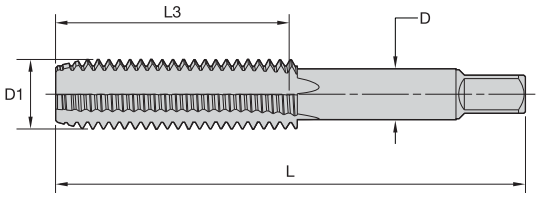


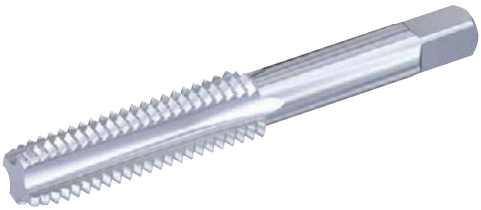
● first choice
○ alternate choice

TiCN	TiN	oxide	uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
–	–	–	**KHSST28242**	5/8 - 18	3.81	1.81	.480	4	H5
KHSST28365	**KHSST09042**	**KHSST28345**	**KHSST08595**	3/4 - 10	4.25	2.00	.590	4	H3
–	–	–	**KHSST28302**	3/4 - 10	4.25	2.00	.590	4	H5
–	**KHSST28118**	**KHSST28346**	**KHSST08608**	3/4 - 16	4.25	2.00	.590	4	H3
–	–	–	**KHSST28305**	3/4 - 16	4.25	2.00	.590	4	H5
–	**KHSST28125**	**KHSST28352**	**KHSST08616**	7/8 - 9	4.69	2.22	.697	4	H4
–	**KHSST09048**	–	**KHSST28330**	7/8 - 14	4.69	2.22	.697	4	H4
–	**KHSST28115**	**KHSST28339**	**KHSST08630**	1 - 8	5.13	2.50	.800	4	H4
–	–	–	**KHSST28286**	1 - 8	5.13	2.50	.800	4	H6
–	–	–	**KHSST28279**	1 - 12	5.13	2.50	.800	4	H4
–	–	–	**KHSST28281**	1 - 14	5.13	2.50	.800	4	H2
–	–	–	**KHSST28283**	1 - 14	5.13	2.50	.800	4	H4
–	–	–	**KHSST28033**	1 1/8 - 7	5.44	2.56	.896	4	H4
–	–	–	**KHSST28029**	1 1/8 - 12	5.44	2.56	.896	4	H4
–	–	–	**KHSST28021**	1 1/4 - 7	5.75	2.56	1.021	4	H4
–	–	–	**KHSST28016**	1 1/4 - 12	5.75	2.56	1.021	6	H4
–	–	–	**KHSST28043**	1 3/8 - 6	6.06	3.00	1.108	4	H4
–	–	–	**KHSST28040**	1 3/8 - 12	6.06	3.00	1.108	6	H4
–	–	–	**KHSST28009**	1 1/2 - 6	6.38	3.00	1.233	4	H4
–	–	–	**KHSST28004**	1 1/2 - 12	6.38	3.00	1.233	6	H4

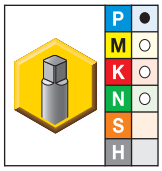
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
Hand taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.

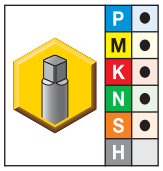


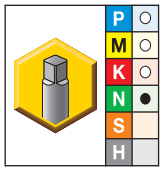




KHSST Hand • Machine Screw Sizes • Bottoming Chamfer Tap





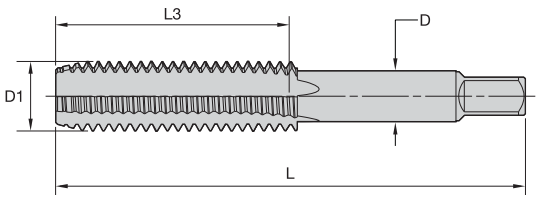


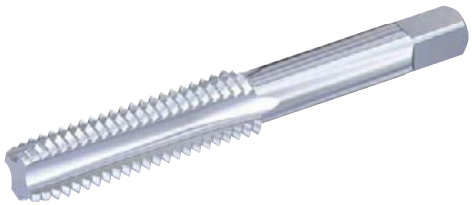
● first choice
○ alternate choice

TiN	oxide	uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
–	–	KHSST28368	0 - 80	1.63	.31	.141	2	H1
KHSST28128	–	KHSST28371	0 - 80	1.63	.31	.141	2	H2
–	–	KHSST28373	1 - 72	1.69	.38	.141	2	H1
–	–	KHSST28374	2 - 56	1.75	.44	.141	2	H2
KHSST09003	–	KHSST28375	2 - 56	1.75	.44	.141	3	H2
–	–	KHSST28379	3 - 48	1.81	.50	.141	3	H2
–	–	KHSST08083	4 - 40	1.88	.56	.141	2	H2
KHSST28130	KHSST28420	KHSST08088	4 - 40	1.88	.56	.141	3	H2
–	–	KHSST28384	4 - 48	1.88	.56	.141	3	H2
–	–	KHSST08117	5 - 40	1.94	.63	.141	3	H2
KHSST09009	–	KHSST08149	6 - 32	2.00	.69	.141	3	H2
KHSST28135	–	KHSST28388	6 - 32	2.00	.69	.141	2	H3
–	–	KHSST08152	6 - 32	2.00	.69	.141	3	H3
–	–	KHSST08173	6 - 40	2.00	.69	.141	3	H2
–	–	KHSST28394	8 - 32	2.13	.75	.168	2	H2
KHSST09011	–	KHSST28395	8 - 32	2.13	.75	.168	4	H2
–	–	KHSST08197	8 - 32	2.13	.75	.168	2	H3
KHSST28429	–	KHSST28399	8 - 32	2.13	.75	.168	3	H3
–	KHSST28423	KHSST08193	8 - 32	2.13	.75	.168	4	H3
–	–	KHSST28403	8 - 36	2.13	.75	.168	4	H2
–	–	KHSST08239	10 - 24	2.38	.88	.194	2	H3
–	–	KHSST28406	10 - 24	2.38	.88	.194	3	H3
KHSST09013	–	KHSST08235	10 - 24	2.38	.88	.194	4	H3
KHSST28133	–	–	10 - 32	2.38	.88	.194	3	H2
–	–	KHSST08262	10 - 32	2.38	.88	.194	4	H2
–	–	KHSST08273	10 - 32	2.38	.88	.194	2	H3
–	–	KHSST28412	10 - 32	2.38	.88	.194	3	H3
KHSST09015	KHSST28419	KHSST08269	10 - 32	2.38	.88	.194	4	H3
KHSST28131	–	KHSST08295	12 - 24	2.38	.94	.220	4	H3
–	–	KHSST28416	12 - 28	2.38	.94	.220	4	H3

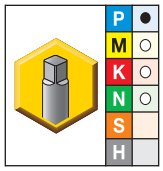
NOTE: Hand taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.

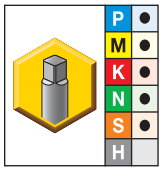


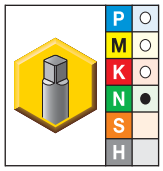




KHSST Hand • Fractional Sizes • Bottoming Chamfer Tap





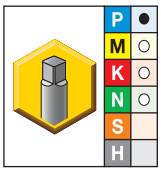


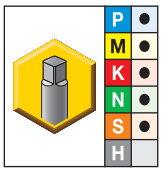
● first choice
○ alternate choice

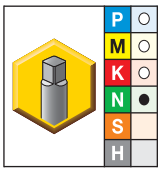
TiN	oxide	uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
–	–	KHSST08317	1/4 - 20	2.50	1.00	.255	4	H2
KHSST28353	–	KHSST28294	1/4 - 20	2.50	1.00	.255	2	H3
–	–	KHSST28295	1/4 - 20	2.50	1.00	.255	3	H3
KHSST09019	KHSST28342	KHSST08321	1/4 - 20	2.50	1.00	.255	4	H3
–	–	KHSST08327	1/4 - 20	2.50	1.00	.255	4	H5
–	–	KHSST08356	1/4 - 28	2.50	1.00	.255	3	H3
KHSST09021	–	KHSST08354	1/4 - 28	2.50	1.00	.255	4	H3
–	–	KHSST08392	5/16 - 18	2.72	1.13	.318	2	H3
–	–	KHSST28313	5/16 - 18	2.72	1.13	.318	3	H3
KHSST28119	–	KHSST08381	5/16 - 18	2.72	1.13	.318	4	H3
–	–	KHSST28317	5/16 - 18	2.72	1.13	.318	4	H5
KHSST09025	–	KHSST28319	5/16 - 24	2.72	1.13	.318	4	H3
–	–	KHSST28308	3/8 - 16	2.94	1.25	.381	3	H3
KHSST09027	KHSST28347	KHSST08435	3/8 - 16	2.94	1.25	.381	4	H3
–	–	KHSST28311	3/8 - 16	2.94	1.25	.381	4	H5
KHSST09029	–	KHSST08460	3/8 - 24	2.94	1.25	.381	4	H3
–	–	KHSST08478	7/16 - 14	3.16	1.44	.323	4	H3
KHSST28122	–	KHSST08494	7/16 - 20	3.16	1.44	.323	4	H3
–	–	KHSST28290	1/2 - 13	3.38	1.66	.367	3	H3
KHSST09035	KHSST28340	KHSST28287	1/2 - 13	3.38	1.66	.367	4	H3
–	–	KHSST28289	1/2 - 13	3.38	1.66	.367	4	H5
–	–	KHSST08531	1/2 - 20	3.38	1.66	.367	4	H3
–	–	KHSST08546	9/16 - 12	3.59	1.66	.429	4	H3
–	–	KHSST08554	9/16 - 18	3.59	1.66	.429	4	H3
KHSST09039	KHSST28350	KHSST08562	5/8 - 11	3.81	1.81	.480	4	H3
–	–	KHSST28235	5/8 - 11	3.81	1.81	.480	4	H5
KHSST09041	–	KHSST08575	5/8 - 18	3.81	1.81	.480	4	H3
–	–	KHSST28102	11/16 - 16	4.03	1.06	.542	4	H3
KHSST09043	KHSST28344	KHSST08596	3/4 - 10	4.25	2.00	.590	4	H3
–	–	KHSST28301	3/4 - 10	4.25	2.00	.590	4	H5
KHSST28117	–	KHSST08609	3/4 - 16	4.25	2.00	.590	4	H3
–	–	KHSST28304	3/4 - 16	4.25	2.00	.590	4	H5

(continued)

(KHSST Hand • Fractional Sizes • Bottoming Chamfer Tap — continued)





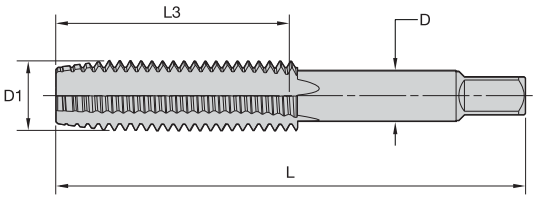


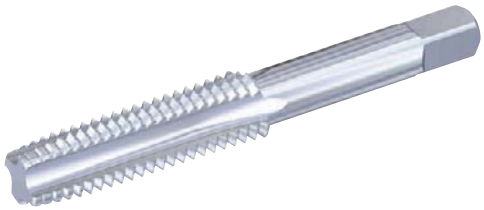
● first choice
○ alternate choice

TiN	oxide	uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
KHSST09047	–	**KHSST08617**	7/8 - 9	4.69	2.22	.697	4	H4
KHSST28124	–	**KHSST28329**	7/8 - 14	4.69	2.22	.697	4	H4
KHSST28114	**KHSST28338**	**KHSST08631**	1 - 8	5.13	2.50	.800	4	H4
–	–	**KHSST28278**	1 - 12	5.13	2.50	.800	4	H4
–	–	**KHSST28282**	1 - 14	5.13	2.50	.800	4	H4
–	–	**KHSST28032**	1 1/8 - 7	5.44	2.56	.896	4	H4
–	–	**KHSST28028**	1 1/8 - 12	5.44	2.56	.896	4	H4
–	–	**KHSST28020**	1 1/4 - 7	5.75	2.56	1.021	4	H4
–	–	**KHSST28015**	1 1/4 - 12	5.75	2.56	1.021	6	H4
–	–	**KHSST28008**	1 1/2 - 6	6.38	3.00	1.233	4	H4
–	–	**KHSST28003**	1 1/2 - 12	6.38	3.00	1.233	6	H4

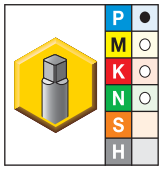
NOTE: Hand taps for 3B class of fit are suitable for UNJ aerospace internal threading applications.
Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.

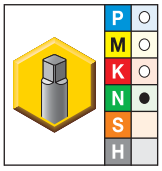






KHSST Hand • Plug Chamfer Tap • Metric ANSI



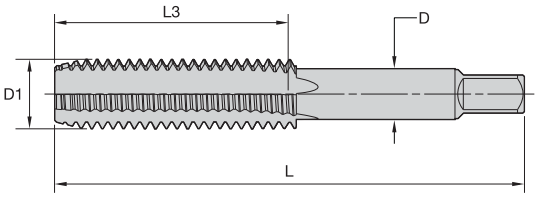


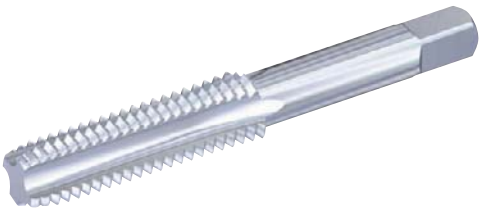
● first choice
○ alternate choice

TiN	uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
–	**KHSST28682 ***	M1,6 X 0,35	1.63	.31	.141	2	D3
–	**KHSST27709**	M2 X 0,4	1.75	.44	.141	3	D3
–	**KHSST27721**	M3 X 0,5	1.94	.63	.141	3	D3
–	**KHSST27729**	M4 X 0,7	2.13	.75	.168	4	D4
–	**KHSST27737**	M5 X 0,8	2.38	.88	.194	4	D4
KHSST09054	**KHSST27741**	M6 X 1	2.50	1.00	.255	4	D5
–	**KHSST27749**	M8 X 1,25	2.72	1.13	.318	4	D5
–	**KHSST27757**	M10 X 1,5	2.94	1.25	.381	4	D6
–	**KHSST27765**	M12 X 1,75	3.38	1.66	.367	4	D6
–	**KHSST27773**	M14 X 2	3.59	1.66	.429	4	D7
–	**KHSST27781**	M16 X 2	3.81	1.81	.480	4	D7
–	**KHSST27793**	M18 X 2,5	4.03	1.06	.542	4	D7
–	**KHSST27800**	M20 X 1,5	4.47	2.00	.652	4	D6
–	**KHSST27796**	M20 X 2,5	4.47	2.00	.652	4	D7
–	**KHSST27809**	M24 X 3	4.91	2.22	.760	4	D8
–	**KHSST28695**	M30 X 3,5	5.44	2.56	1.021	4	D9
–	**KHSST28698**	M36 X 4	6.06	3.00	1.233	4	D9

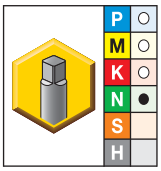
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
Metric taps for 6H class of fit are suitable for MJ aerospace internal threading applications.
Metric taps are manufactured to USCTI specifications and dimensions.
Metric tap blank dimensions are equivalent to inch taps.
Refer to table on page M203 for the recommended pitch diameter limit for 6H class of fit.







KHSST Hand • Bottoming Chamfer Tap • Metric ANSI

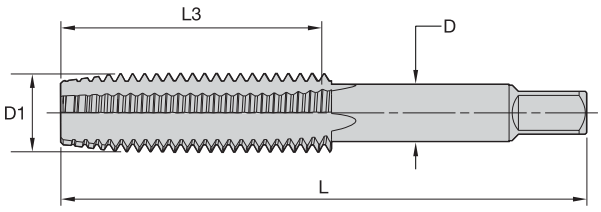


● first choice
○ alternate choice

uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
KHSST27710	M2 X 0,4	1.75	.44	.141	3	D3
KHSST27722	M3 X 0,5	1.94	.63	.141	3	D3
KHSST27730	M4 X 0,7	2.13	.75	.168	4	D4
KHSST27738	M5 X 0,8	2.38	.88	.194	4	D4
KHSST27742	M6 X 1	2.50	1.00	.255	4	D5
KHSST27750	M8 X 1,25	2.72	1.13	.318	4	D5
KHSST27758	M10 X 1,5	2.94	1.25	.381	4	D6
KHSST27766	M12 X 1,75	3.38	1.66	.367	4	D6
KHSST28455	M14 X 2	3.59	1.66	.429	4	D7
KHSST28458	M16 X 2	3.81	1.81	.480	4	D7
KHSST28462	M20 X 2,5	4.47	2.00	.652	4	D7
KHSST28465	M24 X 3	4.91	2.22	.760	4	D8

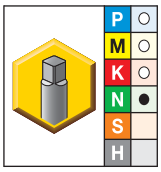
NOTE: Metric taps for 6H class of fit are suitable for MJ aerospace internal threading applications.
Metric taps are manufactured to USCTI specifications and dimensions.
Metric tap blank dimensions are equivalent to inch taps.
Refer to table on page M203 for the recommended pitch diameter limit for 6H class of fit.







KHSST Left Hand • Fractional Sizes • Plug Chamfer Taps

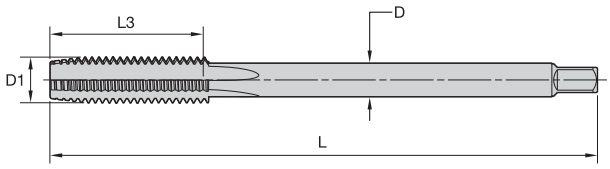


● first choice
○ alternate choice

uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
KHSST28086	1/4 - 28	2.50	1.00	.255	4	H3
KHSST28207	3/8 - 24	2.94	1.25	.381	4	H3
KHSST28675	7/16 - 20	3.16	1.44	.323	4	H3
KHSST28053	1/2 - 13	3.38	1.66	.367	4	H3
KHSST28064	1/2 - 20	3.38	1.66	.367	4	H3
KHSST28233	5/8 - 11	3.81	1.81	.480	4	H3
KHSST28239	5/8 - 18	3.81	1.81	.480	4	H3
KHSST28167	3/4 - 10	4.25	2.00	.590	4	H3
KHSST28184	3/4 - 16	4.25	2.00	.590	4	H3

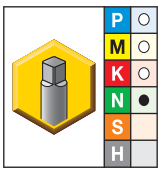
NOTE: Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.







KHSST Extended-Length Hand Taps • Machine Screw and Fractional • Plug Chamfer Tap

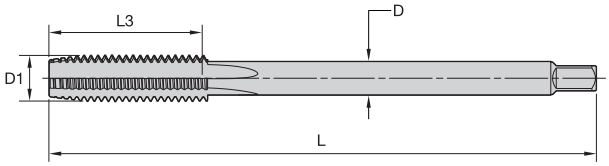


● first choice
○ alternate choice

uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
KHSST28781	6 - 32	6.00	.69	.141	3	H3
KHSST28791	8 - 32	6.00	.75	.168	4	H3
KHSST28742	10 - 24	6.00	.88	.194	4	H3
KHSST28752	10 - 32	6.00	.88	.194	4	H3
KHSST28078	1/4 - 20	6.00	1.00	.255	4	H3
KHSST28085	1/4 - 28	6.00	1.00	.255	4	H3
KHSST28218	5/16 - 18	6.00	.67	.318	4	H3
KHSST28195	3/8 - 16	6.00	1.25	.381	4	H3

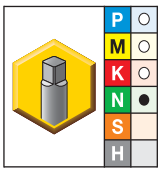
NOTE: Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.







KHSST Extended-Length Hand Taps • Machine Screw and Fractional • Bottoming Chamfer Tap



● first choice
○ alternate choice

uncoated	D1 size	L	L3	D	number of flutes	pitch diameter limit
KHSST28751 *	10 - 32	6.00	.88	.194	4	H3
KHSST28077	1/4 - 20	6.00	1.00	.255	4	H3
KHSST28217	5/16 - 18	6.00	.67	.318	4	H3
KHSST28226	5/16 - 24	6.00	.59	.318	4	H3
KHSST28194	3/8 - 16	6.00	1.25	.381	4	H3

NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.
Refer to table on pages M202–M203 for the recommended pitch diameter limit for 2B or 3B class of fit.

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- Grade and geometry optimized for form tapping blind holes in aluminum.
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- For use on CNC machines with synchronous or rigid controls and precision toolholders.

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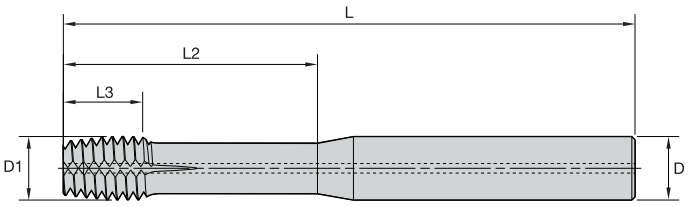
• KCN14 TiN + CrC/C for aluminum.

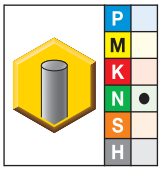






beyond

T491 • Form E Bottoming Entry Taper • Through Coolant M6 and Larger • Metric • Solid Carbide • For Aluminum



● first choice
○ alternate choice

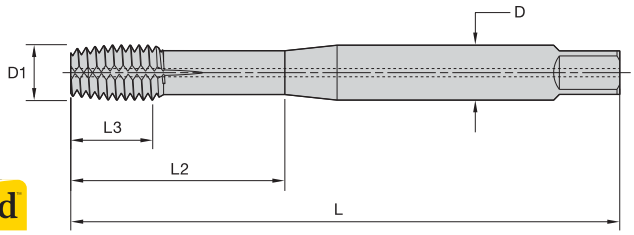
KCN14	D1 size	L	L3	L2	D	number of lube grooves	class of fit
T491M050X080R6HX	M5 X 0,8	60	7	20	6,0	2	6HX
T491M060X100R6HX	M6 X 1	70	8	24	6,0	2	6HX
T491M080X125R6HX	M8 X 1,25	80	10	32	8,0	2	6HX
T491M100X150R6HX	M10 X 1,5	90	12	40	10,0	3	6HX
T491M120X175R6HX	M12 X 1,75	100	14	48	12,0	3	6HX

Shank Tolerance

D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–16	+0, -0,011

• KCN14 TiN + CrC/C for aluminum.

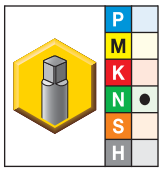






beyond

T491 • DIN 2174 • Form E Bottoming Chamfer • Through Coolant • Metric • Solid Carbide • For Aluminum



● first choice
○ alternate choice

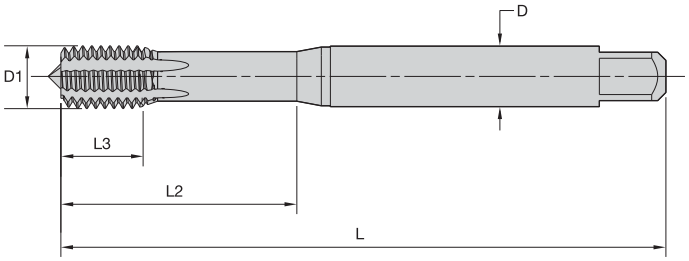
KCN14	D1 size	L	L3	L2	D	number of lube grooves	dimension standard	class of fit
T491M060X100R6HX-D74	M6 X 1	80	10	30	6,0	2	DIN 2174	6HX
T491M080X125R6HX-D74	M8 X 1,25	90	13	35	8,0	2	DIN 2174	6HX
T491M100X150R6HX-D74	M10 X 1,5	100	15	39	10,0	3	DIN 2174	6HX

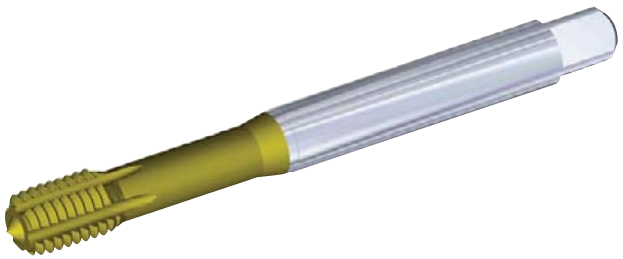
Shank Tolerance

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

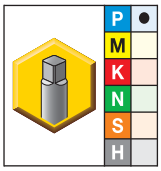
- KSP21 TiN for tapping steel.
- KSN28 DLC for tapping aluminum.

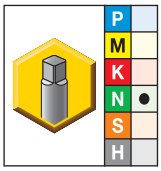






T622 • DIN 2174 • Form C Semi-Bottoming Entry Taper • Metric • For Steel and Aluminum





● 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

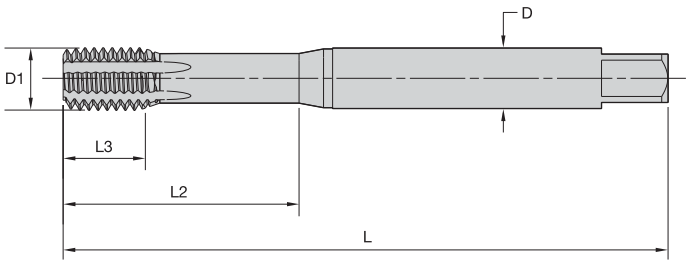
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

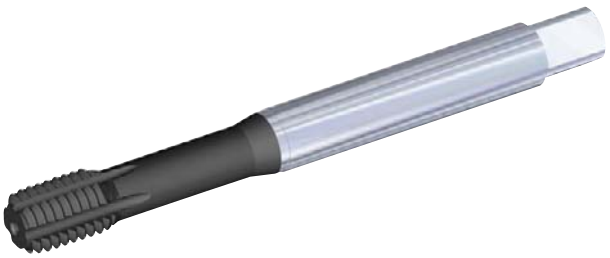
Shank Tolerance

D	tolerance h9
1–3	+0, -0,025
3,5–6	+0, -0,030
7–10	+0, -0,036
11–18	+0, -0,043

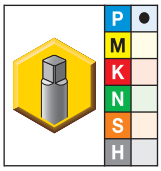
- KSP21 TiN for tapping steel.
- KSN28 DLC for tapping aluminum.

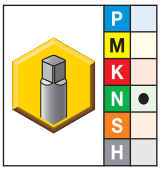






T623 • DIN 2174 • Form C Semi-Bottoming Entry Taper • Through Coolant • Metric • For Steel and Aluminum





● 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

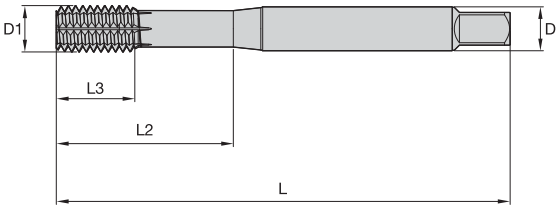
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

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

• KSP27 AlCrTiN for steel and stainless steel.

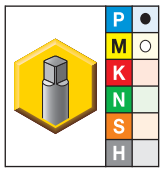






beyond

T624 • DIN Length ANSI Shank • Form C Semi-Bottoming Entry Taper • Machine Screw and Fractional • For Steel and Stainless Steel



● first choice
○ alternate choice

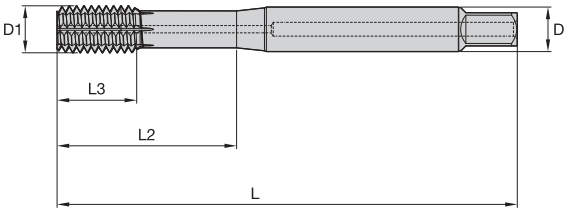
KSP27	D1 size	L	L3	L2	D	number of lube grooves	pitch diameter limit
T624NC#06-32RH3-DA	6 - 32	2.22	.41	.81	.141	2	H3
T624NC#06-32RH5-DA	6 - 32	2.22	.41	.81	.141	2	H5
T624NC#08-32RH3-DA	8 - 32	2.48	.39	.83	.168	4	H3
T624NC#08-32RH5-DA	8 - 32	2.48	.39	.83	.168	4	H5
T624NC#10-24RH4-DA	10 - 24	2.78	.39	1.01	.194	4	H4
T624NC#10-24RH6-DA	10 - 24	2.78	.39	1.01	.194	4	H6
T624NF#10-32RH4-DA	10 - 32	2.77	.39	1.00	.194	4	H4
T624NF#10-32RH6-DA	10 - 32	2.77	.39	1.00	.194	4	H6
T624NC02500-20RH4-DA	1/4 - 20	3.18	.51	1.22	.255	4	H4
T624NC02500-20RH6-DA	1/4 - 20	3.18	.51	1.21	.255	4	H6
T624NF02500-28RH4-DA	1/4 - 28	3.16	.51	1.20	.255	4	H4
T624NF02500-28RH6-DA	1/4 - 28	3.16	.51	1.20	.255	4	H6
T624NC03125-18RH5-DA	5/16 - 18	3.58	.55	1.42	.318	6	H5
T624NC03125-18RH7-DA	5/16 - 18	3.58	.55	1.42	.318	6	H7
T624NF03125-24RH5-DA	5/16 - 24	3.56	.55	1.40	.318	6	H5
T624NF03125-24RH7-DA	5/16 - 24	3.56	.55	1.38	.318	6	H7
T624NC03750-16RH5-DA	3/8 - 16	3.98	.63	1.54	.381	6	H5
T624NC03750-16RH7-DA	3/8 - 16	3.98	.63	1.54	.381	6	H7
T624NF03750-24RH5-DA	3/8 - 24	3.95	.63	1.54	.381	6	H5
T624NF03750-24RH7-DA	3/8 - 24	3.94	.63	1.54	.381	6	H7
T624NC05000-13RH5-DA	1/2 - 13	4.33	.79	1.85	.367	6	H5
T624NC05000-13RH7-DA	1/2 - 13	4.33	.79	1.85	.367	6	H7
T624NF05000-20RH5-DA	1/2 - 20	4.33	.79	1.85	.367	6	H5
T624NF05000-20RH7-DA	1/2 - 20	4.33	.79	1.85	.367	6	H7
T624NC06250-11RH10-DA	5/8 - 11	4.33	.91	2.01	.480	6	H10
T624NC06250-11RH7-DA	5/8 - 11	4.33	.91	2.01	.480	6	H7
T624NF06250-18RH10-DA	5/8 - 18	4.33	.91	2.01	.480	6	H10
T624NF06250-18RH7-DA	5/8 - 18	4.33	.91	2.01	.480	6	H7
T624NC07500-10RH10-DA	3/4 - 10	4.92	.98	2.52	.590	6	H10
T624NC07500-10RH7-DA	3/4 - 10	4.92	.98	2.52	.590	6	H7
T624NF07500-16RH10-DA	3/4 - 16	4.92	.98	2.52	.590	6	H10
T624NF07500-16RH7-DA	3/4 - 16	4.92	.98	2.52	.590	6	H7

Shank Tolerance

D fractional	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

• KSP27 AlCrTiN for steel and stainless steel.

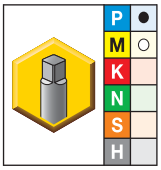






beyond

T625 • DIN Length ANSI Shank • Form C Semi-Bottoming Entry Taper • Through Coolant • Fractional • For Steel and Stainless Steel



● first choice
○ alternate choice

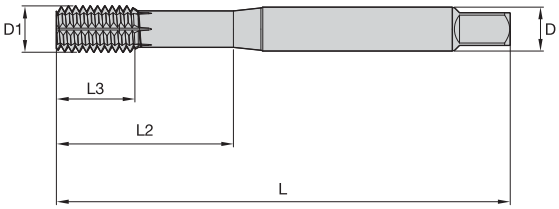
KSP27	D1 size	L	L3	L2	D	number of lube grooves	pitch diameter limit
T625NC02500-20RH4-DA	1/4 - 20	3.15	.51	1.18	.255	4	H4
T625NC02500-20RH6-DA	1/4 - 20	3.15	.51	1.18	.255	4	H6
T625NF02500-28RH4-DA	1/4 - 28	3.15	.51	1.18	.255	4	H4
T625NF02500-28RH6-DA	1/4 - 28	3.15	.51	1.18	.255	4	H6
T625NC03125-18RH5-DA	5/16 - 18	3.54	.55	1.38	.318	6	H5
T625NC03125-18RH7-DA	5/16 - 18	3.54	.55	1.38	.318	6	H7
T625NF03125-24RH5-DA	5/16 - 24	3.54	.55	1.38	.318	6	H5
T625NF03125-24RH7-DA	5/16 - 24	3.54	.55	1.38	.318	6	H7
T625NC03750-16RH5-DA	3/8 - 16	3.94	.63	1.54	.381	6	H5
T625NC03750-16RH7-DA	3/8 - 16	3.94	.63	1.54	.381	6	H7
T625NF03750-24RH5-DA	3/8 - 24	3.94	.63	1.54	.381	6	H5
T625NF03750-24RH7-DA	3/8 - 24	3.94	.63	1.54	.381	6	H7
T625NC05000-13RH5-DA	1/2 - 13	4.33	.79	1.85	.367	6	H5
T625NC05000-13RH7-DA	1/2 - 13	4.33	.79	1.85	.367	6	H7
T625NF05000-20RH5-DA	1/2 - 20	4.33	.79	1.85	.367	6	H5
T625NF05000-20RH7-DA	1/2 - 20	4.33	.79	1.85	.367	6	H7
T625NC06250-11RH10-DA	5/8 - 11	4.33	.79	2.01	.480	6	H10
T625NC06250-11RH7-DA	5/8 - 11	4.33	.79	2.01	.480	6	H7
T625NF06250-18RH10-DA	5/8 - 18	4.33	.79	2.01	.480	6	H10
T625NF06250-18RH7-DA	5/8 - 18	4.33	.79	2.01	.480	6	H7
T625NC07500-10RH10-DA	3/4 - 10	4.92	.98	2.52	.590	6	H10
T625NC07500-10RH7-DA	3/4 - 10	4.92	.98	2.52	.590	6	H7
T625NF07500-16RH10-DA	3/4 - 16	4.92	.98	2.52	.590	6	H10
T625NF07500-16RH7-DA	3/4 - 16	4.92	.98	2.52	.590	6	H7

Shank Tolerance

D fractional	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

• KSP27 AlCrTiN for steel and stainless steel.

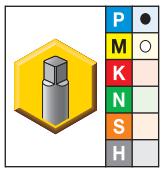






beyond

T626 • DIN Length ANSI Shank • Form E Bottoming Entry Taper • Machine Screw and Fractional • For Steel and Stainless Steel



● first choice
○ alternate choice

KSP27	D1 size	L	L3	L2	D	number of lube grooves	pitch diameter limit
T626NC#02-56RH3-DA	2 - 56	1.75	.44	.50	.141	0	H3
T626NC#03-48RH3-DA	3 - 48	1.97	.39	.71	.141	0	H3
T626NC#04-40RH3-DA	4 - 40	2.20	.39	.71	.141	0	H3
T626NC#04-40RH5-DA	4 - 40	2.20	.39	.71	.141	0	H5
T626NC#06-32RH3-DA	6 - 32	2.21	.39	.79	.141	2	H3
T626NC#06-32RH5-DA	6 - 32	2.21	.39	.79	.141	2	H5
T626NC#08-32RH3-DA	8 - 32	2.48	.39	.83	.168	4	H3
T626NC#08-32RH5-DA	8 - 32	2.48	.39	.83	.168	4	H5
T626NC#10-24RH4-DA	10 - 24	2.76	.39	.98	.194	4	H4
T626NC#10-24RH6-DA	10 - 24	2.76	.39	.98	.194	4	H6
T626NF#10-32RH4-DA	10 - 32	2.76	.39	.98	.194	4	H4
T626NF#10-32RH6-DA	10 - 32	2.76	.39	.98	.194	4	H6
T626NC02500-20RH4-DA	1/4 - 20	3.15	.51	1.18	.255	4	H4
T626NC02500-20RH6-DA	1/4 - 20	3.15	.51	1.18	.255	4	H6
T626NF02500-28RH4-DA	1/4 - 28	3.15	.51	1.18	.255	4	H4
T626NF02500-28RH6-DA *	1/4 - 28	3.15	.51	1.18	.255	4	H6
T626NC03125-18RH5-DA	5/16 - 18	3.54	.55	1.38	.318	6	H5
T626NC03125-18RH7-DA	5/16 - 18	3.54	.55	1.38	.318	6	H7
T626NF03125-24RH5-DA	5/16 - 24	3.54	.55	1.38	.318	6	H5
T626NF03125-24RH7-DA	5/16 - 24	3.54	.55	1.38	.318	6	H7
T626NC03750-16RH5-DA	3/8 - 16	3.94	.63	1.54	.381	6	H5
T626NC03750-16RH7-DA	3/8 - 16	3.94	.63	1.54	.381	6	H7
T626NF03750-24RH5-DA	3/8 - 24	3.94	.63	1.54	.381	6	H5
T626NF03750-24RH7-DA	3/8 - 24	3.94	.63	1.54	.381	6	H7
T626NC05000-13RH5-DA	1/2 - 13	4.33	.79	1.85	.367	6	H5
T626NC05000-13RH7-DA	1/2 - 13	4.33	.79	1.85	.367	6	H7
T626NF05000-20RH5-DA	1/2 - 20	4.33	.79	1.85	.367	6	H5
T626NF05000-20RH7-DA	1/2 - 20	4.33	.79	1.85	.367	6	H7
T626NC06250-11RH10-DA	5/8 - 11	4.33	.79	2.01	.480	6	H10
T626NC06250-11RH7-DA	5/8 - 11	4.33	.79	2.01	.480	6	H7
T626NF06250-18RH10-DA	5/8 - 18	4.33	.79	2.01	.480	6	H10
T626NF06250-18RH7-DA	5/8 - 18	4.33	.79	2.01	.480	6	H7
T626NC07500-10RH10-DA	3/4 - 10	4.92	.98	2.52	.590	6	H10
T626NC07500-10RH7-DA	3/4 - 10	4.92	.98	2.52	.590	6	H7
T626NF07500-16RH10-DA	3/4 - 16	4.92	.98	2.52	.590	6	H10
T626NF07500-16RH7-DA	3/4 - 16	4.92	.98	2.52	.590	6	H7

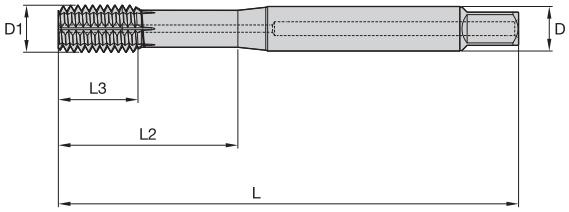
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Shank Tolerance

D fractional	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

- KSP27 AlCrTiN for steel and stainless steel.

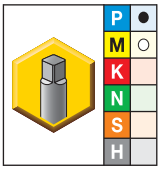






beyond

T627 • DIN Length ANSI Shank • Form E Bottoming Entry Taper • Through Coolant • Fractional • For Steel and Stainless Steel



● first choice
○ alternate choice

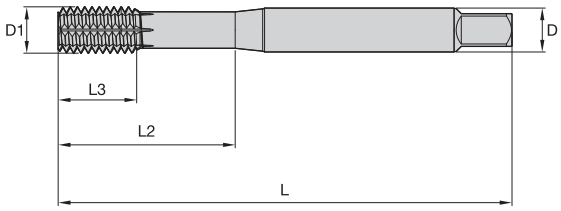
KSP27	D1 size	L	L3	L2	D	number of lube grooves	pitch diameter limit
T627NC02500-20RH4-DA	1/4 - 20	3.15	.51	1.18	.255	4	H4
T627NC02500-20RH6-DA	1/4 - 20	3.15	.51	1.18	.255	4	H6
T627NF02500-28RH4-DA	1/4 - 28	3.15	.51	1.18	.255	4	H4
T627NF02500-28RH6-DA	1/4 - 28	3.15	.51	1.18	.255	4	H6
T627NC03125-18RH5-DA	5/16 - 18	3.54	.55	1.38	.318	6	H5
T627NC03125-18RH7-DA	5/16 - 18	3.54	.55	1.38	.318	6	H7
T627NF03125-24RH5-DA	5/16 - 24	3.54	.55	1.38	.318	6	H5
T627NF03125-24RH7-DA	5/16 - 24	3.54	.55	1.38	.318	6	H7
T627NC03750-16RH5-DA	3/8 - 16	3.94	.63	1.54	.381	6	H5
T627NC03750-16RH7-DA	3/8 - 16	3.94	.63	1.54	.381	6	H7
T627NF03750-24RH5-DA	3/8 - 24	3.94	.63	1.54	.381	6	H5
T627NF03750-24RH7-DA	3/8 - 24	3.94	.63	1.54	.381	6	H7
T627NC05000-13RH5-DA	1/2 - 13	4.33	.79	1.85	.367	6	H5
T627NC05000-13RH7-DA	1/2 - 13	4.33	.79	1.85	.367	6	H7
T627NF05000-20RH5-DA	1/2 - 20	4.33	.79	1.85	.367	6	H5
T627NF05000-20RH7-DA	1/2 - 20	4.33	.79	1.85	.367	6	H7
T627NC06250-11RH10-DA	5/8 - 11	4.33	.79	2.01	.480	6	H10
T627NC06250-11RH7-DA	5/8 - 11	4.33	.79	2.01	.480	6	H7
T627NF06250-18RH10-DA	5/8 - 18	4.33	.79	2.01	.480	6	H10
T627NF06250-18RH7-DA	5/8 - 18	4.33	.79	2.01	.480	6	H7
T627NC07500-10RH10-DA	3/4 - 10	4.92	.98	2.52	.590	6	H10
T627NC07500-10RH7-DA	3/4 - 10	4.92	.98	2.52	.590	6	H7
T627NF07500-16RH10-DA	3/4 - 16	4.92	.98	2.52	.590	6	H10
T627NF07500-16RH7-DA	3/4 - 16	4.92	.98	2.52	.590	6	H7

Shank Tolerance

D fractional	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

- KSP27 AlCrTiN for steel and stainless steel.

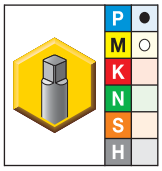






beyond

T624 • DIN Length ANSI Shank • Form C Semi-Bottoming Entry Taper • Metric • For Steel and Stainless Steel



● first choice
○ alternate choice

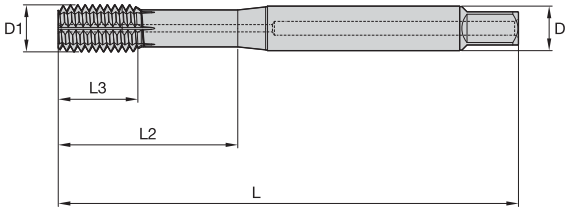
KSP27	D1 size	L	L3	L2	D	number of lube grooves	pitch diameter limit
T624M030X050RD5-DA	M3 X 0,5	2.20	.39	.79	.141	2	D5
T624M040X070RD6-DA	M4 X 0,7	2.48	.39	.83	.168	4	D6
T624M060X100RD8-DA	M6 X 1	3.15	.51	1.18	.255	4	D8
T624M080X125RD9-DA	M8 X 1,25	3.54	.55	1.38	.318	6	D9
T624MF100X125RD9-DA	M10 X 1,25	3.94	.63	1.53	.381	6	D9
T624M100X150RD10-DA	M10 X 1,5	3.94	.63	1.54	.381	6	D10
T624MF120X125RD9-DA	M12 X 1,25	4.33	.71	1.73	.367	6	D9
T624MF120X150RD9-DA	M12 X 1,5	4.33	.71	1.73	.367	6	D9
T624M120X175RD11-DA	M12 X 1,75	4.33	.71	1.73	.367	6	D11
T624MF140X150RD11-DA	M14 X 1,5	4.33	.79	2.05	.429	6	D11
T624M140X200RD12-DA	M14 X 2	4.33	.79	2.05	.429	6	D12
T624MF160X150RD11-DA	M16 X 1,5	4.33	.79	2.01	.480	6	D11
T624M160X200RD12-DA	M16 X 2	4.33	.79	2.01	.480	6	D12

Shank Tolerance

D fractional	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

• KSP27 AlCrTiN for steel and stainless steel.

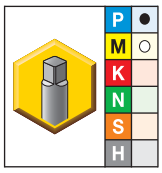






beyond

T625 • DIN Length ANSI Shank • Form C Semi-Bottoming Entry Taper • Through Coolant • Metric • For Steel and Stainless Steel



● first choice
○ alternate choice

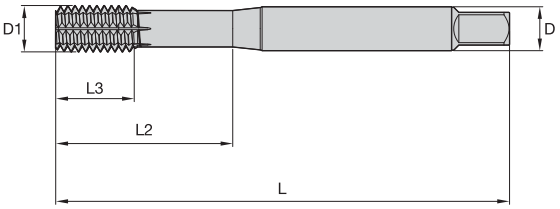
KSP27	D1 size	L	L3	L2	D	number of lube grooves	pitch diameter limit
T625M060X100RD8-DA	M6 X 1	3.15	.51	1.18	.255	4	D8
T625M080X125RD9-DA	M8 X 1,25	3.54	.55	1.38	.318	6	D9
T625MF100X125RD9-DA	M10 X 1,25	3.94	.63	1.54	.381	6	D9
T625M100X150RD10-DA	M10 X 1,5	3.94	.63	1.54	.381	6	D10
T625MF120X125RD9-DA	M12 X 1,25	4.33	.71	1.73	.367	6	D9
T625MF120X150RD9-DA	M12 X 1,5	4.33	.71	1.73	.367	6	D9
T625M120X175RD11-DA	M12 X 1,75	4.33	.71	1.73	.367	6	D11
T625MF140X150RD11-DA	M14 X 1,5	4.33	.79	2.05	.429	6	D11
T625M140X200RD12-DA	M14 X 2	4.33	.79	2.05	.429	6	D12
T625MF160X150RD11-DA	M16 X 1,5	4.33	.79	2.01	.480	6	D11
T625M160X200RD12-DA	M16 X 2	4.33	.79	2.01	.480	6	D12

Shank Tolerance

D fractional	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

• KSP27 AlCrTiN for steel and stainless steel.

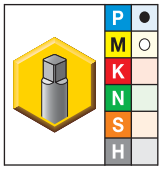






beyond

T626 • DIN Length ANSI Shank • Form E Bottoming Entry Taper • Metric • For Steel and Stainless Steel



● first choice
○ alternate choice

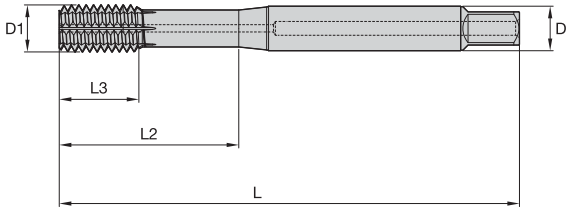
KSP27	D1 size	L	L3	L2	D	number of lube grooves	pitch diameter limit
T626M030X050RD5-DA	M3 X 0,5	2.20	.39	.79	.141	2	D5
T626M035X060RD6-DA	M3,5 X 0,6	2.20	.39	.79	.141	2	D6
T626M040X070RD6-DA	M4 X 0,7	2.48	.39	.83	.168	4	D6
T626M050X080RD7-DA	M5 X 0,8	2.76	.39	.98	.194	4	D7
T626M060X100RD8-DA	M6 X 1	3.15	.51	1.18	.255	4	D8
T626M080X125RD9-DA	M8 X 1,25	3.54	.55	1.38	.318	6	D9
T626MF100X125RD9-DA	M10 X 1,25	3.94	.63	1.53	.381	6	D9
T626M100X150RD10-DA	M10 X 1,5	3.94	.63	1.54	.381	6	D10
T626MF120X125RD9-DA	M12 X 1,25	4.33	.71	1.73	.367	6	D9
T626MF120X150RD9-DA	M12 X 1,5	4.33	.71	1.73	.367	6	D9
T626M120X175RD11-DA	M12 X 1,75	4.33	.71	1.73	.367	6	D11
T626MF140X150RD11-DA	M14 X 1,5	4.33	.79	2.05	.429	6	D11
T626M140X200RD12-DA	M14 X 2	4.33	.79	2.05	.429	6	D12
T626MF160X150RD11-DA	M16 X 1,5	4.33	.79	2.01	.480	6	D11
T626M160X200RD12-DA	M16 X 2	4.33	.79	2.01	.480	6	D12

Shank Tolerance

D fractional	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

- KSP27 AlCrTiN for steel and stainless steel.

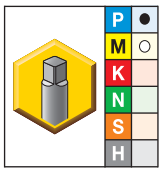






beyond

T627 • DIN Length ANSI Shank • Form E Bottoming Entry Taper • Through Coolant • Metric • For Steel and Stainless Steel



● first choice
○ alternate choice

KSP27	D1 size	L	L3	L2	D	number of lube grooves	pitch diameter limit
T627M060X100RD8-DA	M6 X 1	3.15	.51	1.18	.255	4	D8
T627M080X125RD9-DA	M8 X 1,25	3.54	.55	1.38	.318	6	D9
T627MF100X125RD9-DA	M10 X 1,25	3.94	.63	1.54	.381	6	D9
T627M100X150RD10-DA	M10 X 1,5	3.94	.63	1.54	.381	6	D10
T627MF120X125RD9-DA	M12 X 1,25	4.33	.71	1.73	.367	6	D9
T627MF120X150RD9-DA	M12 X 1,5	4.33	.71	1.73	.367	6	D9
T627M120X175RD11-DA	M12 X 1,75	4.33	.71	1.73	.367	6	D11
T627MF140X150RD11-DA	M14 X 1,5	4.33	.79	2.05	.429	6	D11
T627M140X200RD12-DA	M14 X 2	4.33	.79	2.05	.429	6	D12
T627MF160X150RD11-DA	M16 X 1,5	4.33	.79	2.01	.480	6	D11
T627M160X200RD12-DA	M16 X 2	4.33	.79	2.01	.480	6	D12

Shank Tolerance

D fractional	tolerance h6
.250–.375	+0, -.0004
.438–.625	+0, -.0004

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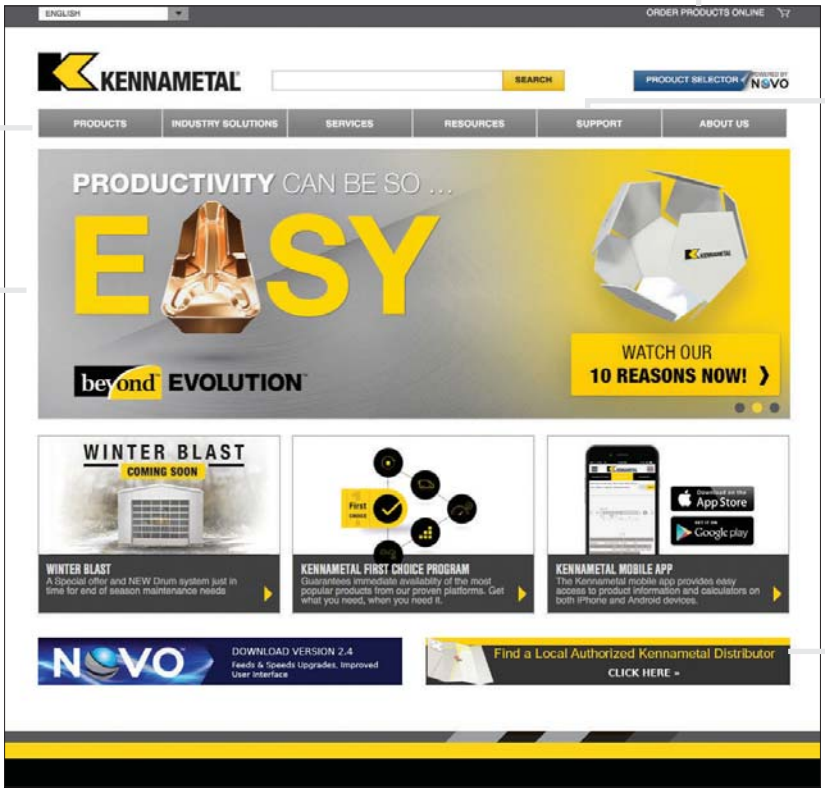

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Pipe Taps



High-Performance Pipe Taps for Through-Hole and Blind-Hole Applications

- Steel and steel alloys.
- Stainless steel.
- Aluminum.

Multipurpose HSS-E GOtap™ Taps

- NPT and NPTF taper pipe taps with standard projections and standard chamfers for ductile materials and mold 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.

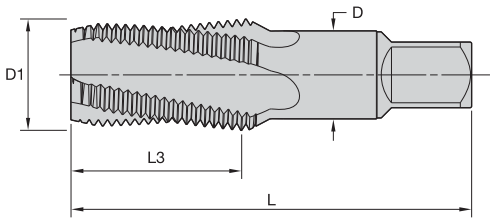
General-Purpose Taps

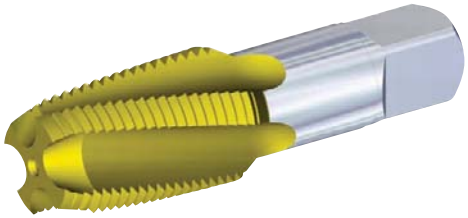
- Manufactured with select high-speed steel (HSS).
- Ground thread pipe taps are standard in American Standard Taper pipe threads (NPT), Dryseal American Standard Taper pipe threads (NPTF), American Standard Straight pipe threads (NPS), and American Standard Dryseal Fuel Straight pipe threads (NPSF).



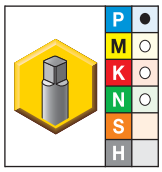
- KSU31 TiN
- KSP39 oxide

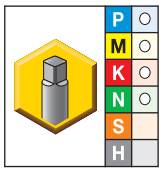






T854 • Standard Chamfer • Standard Projection



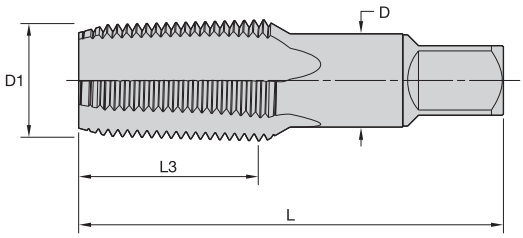


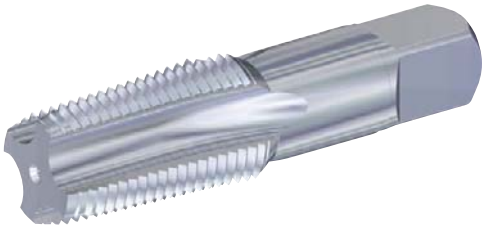
● first choice
○ alternate choice

KSU31	KSP39	D1 size	L	L3	D	number of flutes	thread type
T854NPT00625-27R-A	T854NPT00625-27R-A	1/16 - 27	2.13	.69	.313	4	NPT
–	T854NPTF00625-27R-A	1/16 - 27	2.13	.69	.313	4	NPTF
T854NPT01250-27R-AS	T854NPT01250-27R-AS	1/8 - 27	2.13	.75	.313	4	NPT
T854NPTF01250-27R-AS	T854NPTF01250-27R-AS	1/8 - 27	2.13	.75	.313	4	NPTF
T854NPT01250-27R-A	T854NPT01250-27R-A	1/8 - 27	2.13	.75	.438	4	NPT
T854NPTF01250-27R-A	T854NPTF01250-27R-A	1/8 - 27	2.13	.75	.438	4	NPTF
T854NPT02500-18R-A	T854NPT02500-18R-A	1/4 - 18	2.44	1.03	.563	4	NPT
T854NPTF02500-18R-A	T854NPTF02500-18R-A	1/4 - 18	2.44	1.03	.563	4	NPTF
T854NPT03750-18R-A	T854NPT03750-18R-A	3/8 - 18	2.56	1.03	.700	4	NPT
T854NPTF03750-18R-A	T854NPTF03750-18R-A	3/8 - 18	2.56	1.03	.700	4	NPTF
T854NPT05000-14R-A	T854NPT05000-14R-A	1/2 - 14	3.13	1.38	.688	4	NPT
T854NPTF05000-14R-A	T854NPTF05000-14R-A	1/2 - 14	3.13	1.38	.688	4	NPTF
T854NPT07500-14R-A	T854NPT07500-14R-A	3/4 - 14	3.25	1.38	.906	4	NPT
–	T854NPTF07500-14R-A	3/4 - 14	3.25	1.38	.906	4	NPTF
T854NPT10000-11.5R-A	T854NPT10000-11.5R-A	1 - 11 1/2	3.75	1.75	1.125	4	NPT
–	T854NPTF10000-11.5R-A	1 - 11 1/2	3.75	1.75	1.125	4	NPTF

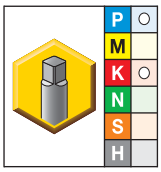
- KSU30 bright







T846 • NPT • Standard Chamfer • Standard Projection

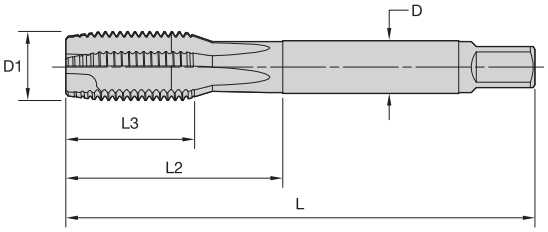


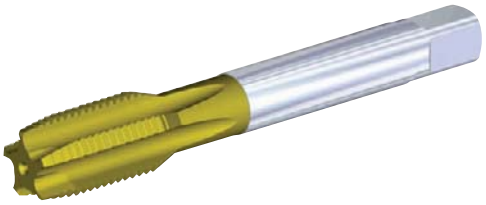
● first choice
○ alternate choice

KSU30	D1 size	L	L3	D	number of flutes	thread type
T846NPT01250-27R-AS	1/8 - 27	2.13	.75	.313	4	NPT
T846NPT02500-18R-A	1/4 - 18	2.44	1.03	.563	4	NPT
T846NPT03750-18R-A	3/8 - 18	2.56	1.03	.700	4	NPT
T846NPT05000-14R-A	1/2 - 14	3.13	1.38	.688	4	NPT
T846NPT07500-14R-A	3/4 - 14	3.25	1.38	.906	5	NPT

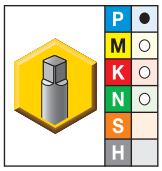
- KSU31 TiN
- KSP39 oxide

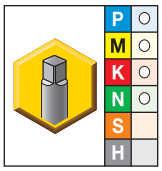






T877 • (G) Whitworth Pipe Thread • DIN EN ISO 228 • Form B



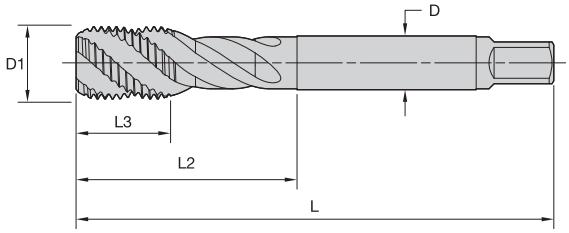


● first choice
○ alternate choice

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

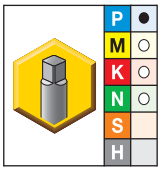
- KSU31 TiN
- KSP39 oxide

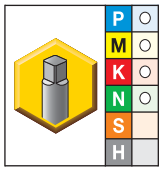






T857 • (G) Whitworth Pipe Thread • DIN EN ISO 228 • Form C • Tension/Compression Holders





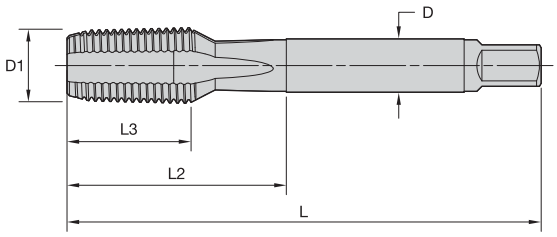
● first choice
○ alternate choice

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.

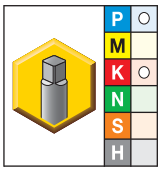
- KSU30 bright







T848 • NPT and NPTF • Standard Projection • Form C



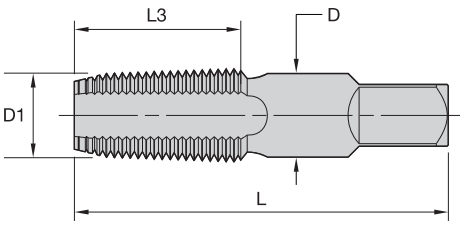
● first choice
○ alternate choice

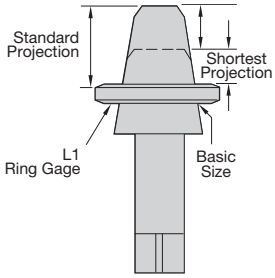
KSU30	D1 size	L	L3	L2	D	number of flutes	thread type
T848NPT00625-27R-D56	1/16 - 27	90	13	35	6	3	NPT
T848NPTF00625-27R-D56	1/16 - 27	90	13	35	6	3	NPTF
T848NPT01250-27R-D56	1/8 - 27	90	13	36	7	4	NPT
T848NPTF01250-27R-D56	1/8 - 27	90	13	36	7	4	NPTF
T848NPT02500-18R-D56	1/4 - 18	100	20	39	11	4	NPT
T848NPTF02500-18R-D56	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

- Manufactured from select high-speed steel.
- Ground thread pipe taps are standard in American Standard Pipe Form (NPT) and American Standard Dryseal Pipe Thread Form (NPTF).
- NPT threads require the use of a sealer, such as Teflon® tape or pipe compound.
- NPTF dryseal threads give a pressure-tight joint without the use of sealer.
- The nominal size of a pipe tap is that of the pipe fitting to be tapped, not the actual size of the tap; thread taper is 3/4" per foot.
- Alternate tap coatings are available as stock modifications.

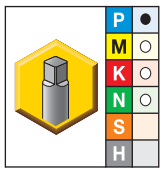


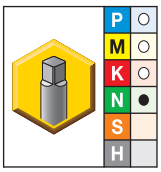






KHSST Taper Pipe Tap • Chamfer 2-1/2–3-1/2 Pitches





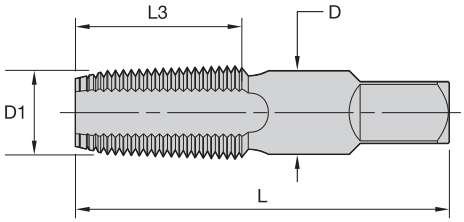
● first choice
○ alternate choice

TiN	uncoated	D1 size	L	L3	D	number of flutes	thread type
KHSST09137	**KHSST28443**	1/16 - 27	2.13	.69	.313	4	NPT/ANPT
KHSST09140	**KHSST08703**	1/8 - 27	2.13	.75	.313	4	NPT/ANPT
KHSST28141	**KHSST08705**	1/8 - 27	2.13	.75	.313	4	NPTF
KHSST28139	**KHSST08704**	1/8 - 27	2.13	.75	.438	4	NPT/ANPT
KHSST28140	**–**	1/8 - 27	2.13	.75	.438	4	NPTF
KHSST09143	**KHSST08709**	1/4 - 18	2.44	1.06	.563	4	NPT/ANPT
–	**KHSST28445**	1/4 - 18	2.44	1.06	.563	4	NPTF
KHSST28142	**KHSST28446**	3/8 - 18	2.56	1.06	.700	4	NPT/ANPT
–	**KHSST08712**	3/8 - 18	2.56	1.06	.700	4	NPTF
KHSST09147	**KHSST08715**	1/2 - 14	3.13	1.66	.687	4	NPT/ANPT
KHSST28060	**KHSST28444**	1/2 - 14	3.13	1.66	.687	4	NPTF
KHSST28178	**KHSST28177**	3/4 - 14	3.25	1.38	.906	5	NPT/ANPT
–	**KHSST28181**	3/4 - 14	3.25	1.38	.906	5	NPTF
–	**KHSST28107**	1 - 11 1/2	3.75	1.75	1.125	5	NPTF
KHSST09151	**KHSST28106**	1 - 11 1/2	3.75	1.75	1.125	5	NPT/ANPT
–	**KHSST08724**	1 1/4 - 11 1/2	4.00	1.75	1.313	5	NPT/ANPT
–	**KHSST28002**	1 1/2 - 11 1/2	4.25	3.00	1.500	7	NPT/ANPT
–	**KHSST28109**	2 - 11 1/2	4.25	1.75	1.875	7	NPT/ANPT

* Pipe tap projection is the distance the small end of the tap projects through an American National Standard Pipe Tap Thread Ring Gage.
NOTE: ANPT Taps marked NPT may be used for NPT and ANPT applications.

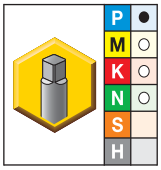
- Manufactured from select tap high-speed steel.
- Ground thread pipe taps are standard in American National Standard Straight Pipe (NPS) thread form and American National Standard Dryseal Straight Pipe (NPSF) thread form.
- NPS threads are suitable for tapping holes or couplings for low-pressure work when used with a sealer; also suitable for NPSC and NPSM work.
- NPSF dryseal taps are intended for low-pressure work, such as fuel and oil lines, where a sealer is not used.
- Dryseal threads give a low-pressure, pressure-tight joint without the use of sealer.







KHSST Straight Pipe • Chamfer 2-1/2–3-1/2 Pitches



● first choice
○ alternate choice

uncoated	D1 size	L	L3	D	number of flutes	thread series
KHSST28091	1/8 - 27	2.13	.75	.313	4	NPS
KHSST28093 *	1/8 - 27	2.13	.75	.313	4	NPSF
KHSST28092 *	1/8 - 27	2.13	.75	.438	4	NPS
KHSST28094	1/8 - 27	2.13	.75	.438	4	NPSF
KHSST28067	1/4 - 18	2.44	1.06	.563	4	NPS
KHSST28068	1/4 - 18	2.44	1.06	.563	4	NPSF
KHSST28196	3/8 - 18	2.56	1.06	.700	4	NPS
KHSST28197	3/8 - 18	2.56	1.06	.700	4	NPSF
KHSST28057	1/2 - 14	3.13	1.66	.688	4	NPS
KHSST28058	1/2 - 14	3.13	1.66	.688	4	NPSF
KHSST28172	3/4 - 14	3.25	1.38	.906	5	NPS
KHSST28173 *	3/4 - 14	3.25	1.38	.906	5	NPSF
KHSST28104	1 - 11 1/2	3.75	1.75	1.125	5	NPS

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

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 catalog, and then manually inputting the tooling information from the catalog 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 maximizes every shift. **kennametal.com/novo**



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.
- Optimized carbide grades.
- Drill, thread, chamfer.

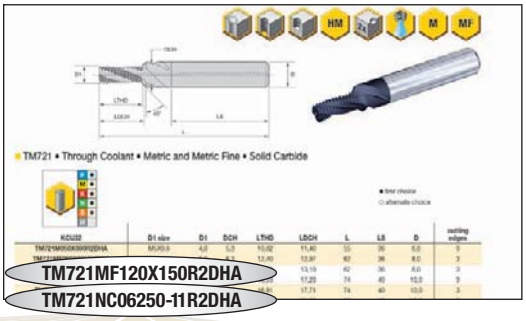




Through and Blind Holes (2 x D)

					
		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



Metric

TM721	MF	120	X	150	R	2D	HA

Inch

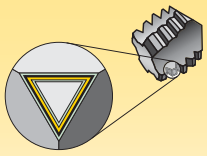
TM721	NC	06250	-	11	R	2D	HA

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

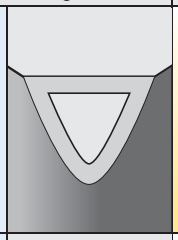
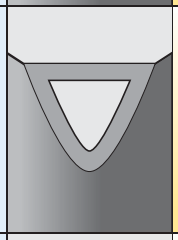
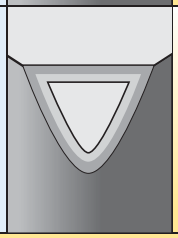


Coatings are designed for optimized tapping performance in specific materials.

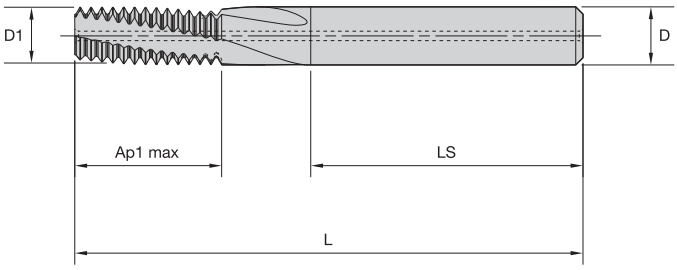
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

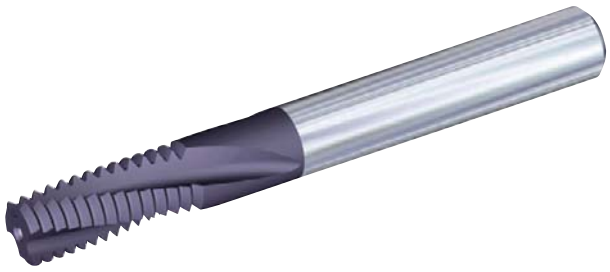
wear resistance ⟷ **toughness**

Grade

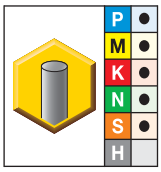
Coating	Grade Description		05	10	15	20	25	30	35	40	45
KCU32 	Coated carbide. PVD — Fine-grain carbide substrate with high hardness TiCN coating. Universal grade for thread milling most materials.	P		■	■	■					
		M		■	■	■					
		K		■	■	■					
		N			■	■	■				
		S		■	■	■					
KCU33 	Coated carbide. PVD — 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 • Solid Carbide



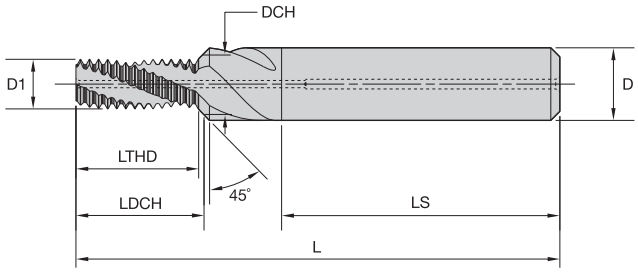
● first choice
○ alternate choice

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

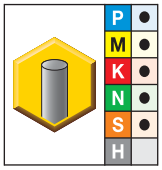
D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–18	+0, -0,011
20–30	+0, -0,013







TM721 • UNC • Through Coolant • Inch • Solid Carbide • Solid Carbide



● first choice
○ alternate choice

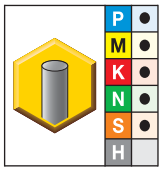
KCU32	D1 size	D1	DCH	LTHD	LDCH	L	LS	D	cutting edges
TM721NC2500-20R2DHA	1/4-20	4,7	6,7	13,36	14,23	62	36	8,0	3
TM721NC3125-18R2DHA	5/16-18	6,2	8,3	16,26	17,19	74	40	10,0	3
TM721NC3750-16R2DHA	3/8-16	7,7	9,8	19,89	20,85	80	45	12,0	3
TM721NC4375-14R2DHA	7/16-14	9,0	11,4	22,72	23,79	80	45	12,0	3
TM721NC0500-13R2DHA	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



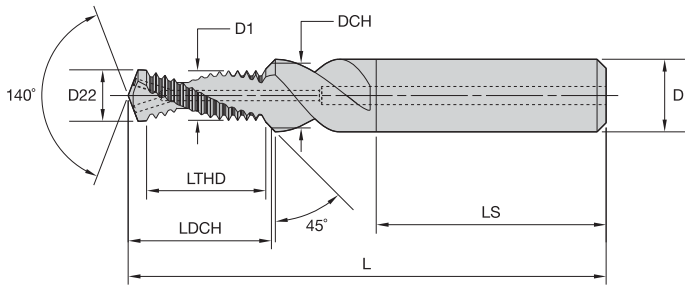
TM721 • Through Coolant • Metric and Metric Fine • Solid Carbide • Solid Carbide



● first choice
○ alternate choice

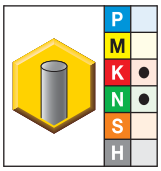
KCU32	D1 size	D1	DCH	LTHD	LDCH	L	LS	D	cutting edges
TM721M060X100R2DHA	M6X1	4,8	6,3	12,52	13,19	62	36	8,0	3
TM721MF080X100R2DHA	M8X1	6,7	8,3	16,53	17,23	74	40	10,0	3
TM721M080X125R2DHA	M8X1.25	6,5	8,3	16,91	17,71	74	40	10,0	3
TM721M100X150R2DHA	M10X1.5	8,2	10,3	20,29	21,22	80	45	12,0	3
TM721MF120X125R2DHA	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







TM731 • Through Coolant • Metric and Metric Fine • Solid Carbide • Solid Carbide



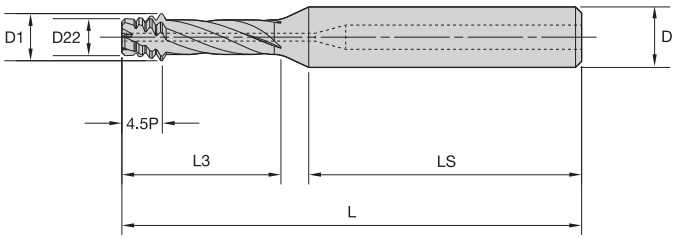
● first choice
○ alternate choice

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	M12X1.75	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

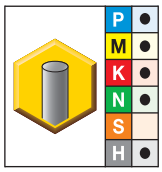
D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–18	+0, -0,011
20–30	+0, -0,013







TM741 • UNC and UNF • Through Coolant • Right Hand • Inch • Solid Carbide



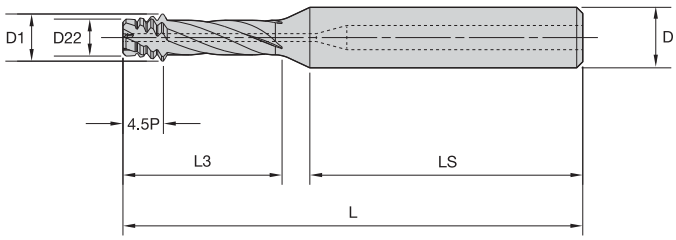
● first choice
○ alternate choice

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

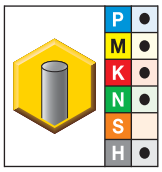
D	tolerance h6
6	+0, -0,008
8–10	+0, -0,009
12–18	+0, -0,011
20–30	+0, -0,013







TM741 • Through Coolant • Right Hand • Metric and Metric Fine • Solid Carbide



● first choice
○ alternate choice

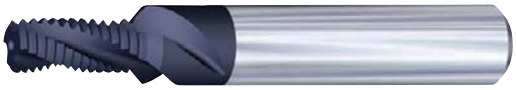
KCU36	D1 size	D1	D22	L3	L	LS	D	cutting edges
TM741M060X100R2DHA	M6X1	4,51	3,41	16,5	60	36	8,0	3
TM741MF080X100R2DHA	M8X1	6,23	5,13	21,9	71	40	10,0	4
TM741M080X125R2DHA	M8X1.25	6,23	4,91	21,9	71	40	10,0	4
TM741MF100X100R2DHA	M10X1	6,23	5,13	21,9	71	40	10,0	4
TM741MF100X125R2DHA	M10X1.25	6,23	4,91	21,9	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

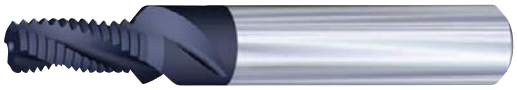


Thread Mill and Chamfer TM721

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

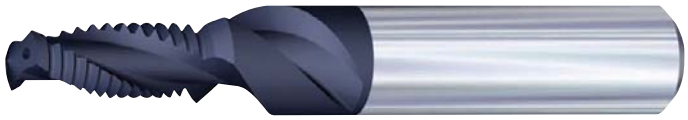


Thread Mill TM711



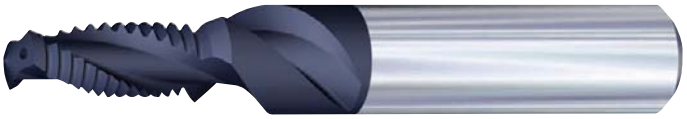
Thread Mill and Chamfer TM721

Material Group		Cutting Speed – vc Range – SFM			Feed/Tooth by Diameter			Cutting Speed – vc Range – SFM			Feed/Tooth by Diameter		
		min	Starting Value	max		<0.375"	>0.375"	min	Starting Value	max		<0.375"	>0.375"
P	1	300	**380**	490	IPR	0.002	0.003	460	**610**	790	IPR	0.002	0.004
	2	300	**380**	490	IPR	0.002	0.003	460	**610**	790	IPR	0.002	0.004
	3	130	**160**	230	IPR	0.001	0.001	230	**300**	390	IPR	0.001	0.001
	4	–	**–**	–	–	–	–	230	**300**	390	IPR	0.001	0.001
	5	200	**260**	330	IPR	0.002	0.002	230	**300**	390	IPR	0.002	0.003
	6	–	**–**	–	–	–	–	–	**–**	–	–	–	–
M	1	200	**260**	330	IPR	0.002	0.002	230	**300**	390	IPR	0.002	0.003
	2	200	**260**	330	IPR	0.002	0.002	230	**300**	390	IPR	0.002	0.003
	3	–	**–**	–	–	–	–	–	**–**	–	–	–	–
K	1	390	**490**	660	IPR	0.002	0.004	430	**560**	720	IPR	0.002	0.004
	2	390	**490**	660	IPR	0.002	0.004	430	**560**	720	IPR	0.002	0.004
	3	300	**380**	490	IPR	0.002	0.003	360	**460**	590	IPR	0.002	0.003
N	1	820	**900**	980	IPR	0.003	0.004	890	**980**	1080	IPR	0.003	0.006
	2	660	**740**	820	IPR	0.002	0.002	890	**980**	1080	IPR	0.003	0.006
	3	560	**620**	690	IPR	0.002	0.002	520	**570**	620	IPR	0.003	0.006
	4	820	**900**	980	IPR	0.003	0.004	890	**980**	1080	IPR	0.003	0.006
	5	890	**980**	1080	IPR	0.005	0.005	820	**900**	980	IPR	0.004	0.008
	6	560	**620**	690	IPR	0.002	0.002	300	**330**	360	IPR	0.004	0.008
S	1	200	**260**	330	IPR	0.002	0.002	230	**300**	390	IPR	0.002	0.003
	2	160	**210**	260	IPR	0.001	0.002	160	**200**	260	IPR	0.001	0.002
	3	160	**210**	260	IPR	0.001	0.002	160	**200**	260	IPR	0.001	0.002
	4	160	**210**	260	IPR	0.001	0.002	160	**200**	260	IPR	0.001	0.002



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



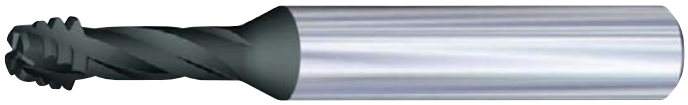
Drill, Chamfer, and Thread Mill TM731

Material Group		Cutting Speed — vc Range — SFM			Drilling Recommended Feed by Diameter				Milling Feed/Tooth by Diameter			
		min	Starting Value	max		<0.250"	0.250–0.375"	0.375–0.625"		<0.250"	0.250–0.375"	0.375–0.625"
K	1	430	**570**	750	IPR	0.004	0.006	0.012	IPR	0.002	0.003	0.004
N	2	890	**980**	1080	IPR	0.006	0.010	0.013	IPR	0.002	0.003	0.005
	3	460	**490**	560	IPR	0.006	0.010	0.013	IPR	0.002	0.003	0.005
	4	890	**980**	1080	IPR	0.006	0.010	0.013	IPR	0.002	0.003	0.005
	5	360	**390**	430	IPR	0.005	0.008	0.013	IPR	0.002	0.003	0.005



Mill, Chamfer, and Thread Mill TM741

Material Group		TM Style	Grade	Cutting Speed — vc Range — m/min			Feed/Tooth by Diameter		
				min	Starting Value	max		<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



Mill, Chamfer, and Thread Mill TM741

Material Group		TM Style	Grade	Cutting Speed — vc Range — SFM			Feed/Tooth By Diameter		
				min	Starting Value	max		<0.375"	>0.375"
P	1	TM741 R	KCU36	560	740	950	IPR	0.002	0.003
	2	TM741 R	KCU36	560	740	950	IPR	0.002	0.003
	3	TM741 R	KCU36	390	490	660	IPR	0.001	0.002
	4	TM741 R	KCU36	330	410	520	IPR	0.001	0.002
	5	TM741 R	KCU36	390	490	660	IPR	0.001	0.002
	6	TM741 R	KCU36	200	260	330	IPR	0.001	0.002
M	1	TM741 R	KCU36	390	490	660	IPR	0.001	0.002
	2	TM741 R	KCU36	390	490	660	IPR	0.001	0.002
	3	TM741 R	KCU36	390	490	660	IPR	0.001	0.002
K	1	TM741 R	KCU36	620	820	1080	IPR	0.002	0.004
	2	TM741 R	KCU36	620	820	1080	IPR	0.002	0.004
	3	TM741 R	KCU36	460	610	790	IPR	0.002	0.003
N	1	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–
	3	TM741 R	KCU36	590	750	980	IPR	0.002	0.003
	4	TM741 R	KCU36	690	900	1180	IPR	0.002	0.003
	5	–	–	–	–	–	–	–	–
	6	TM741 R	KCU36	690	900	1180	IPR	0.002	0.003
S	1	TM741 L	KCU36	390	490	660	IPR	0.001	0.002
	2	TM741 L	KCU36	160	200	260	IPR	0.001	0.001
	3	TM741 L	KCU36	160	200	260	IPR	0.001	0.001
	4	TM741 L	KCU36	230	300	390	IPR	0.001	0.001
H	1	TM741	KCU36	260	330	430	IPR	0.001	0.002
	2	TM741	KCU36	260	330	430	IPR	0.001	0.002
	3	TM741	KCU36	160	210	260	IPR	0.001	0.001
	4	TM741	KCU36	160	210	260	IPR	0.001	0.001

NOTE: For thread depths over 2 x D up to 3 x D, reduce speed and feed by 25%.

Milling Methods

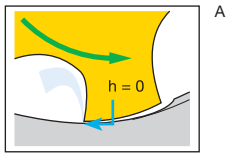
Climb Milling

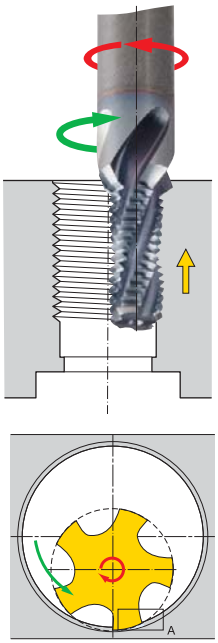
Properties:

- Tool rotation direction clockwise
- Tool moves counter-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





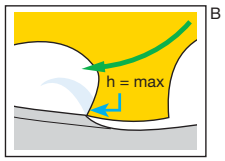
Conventional Milling

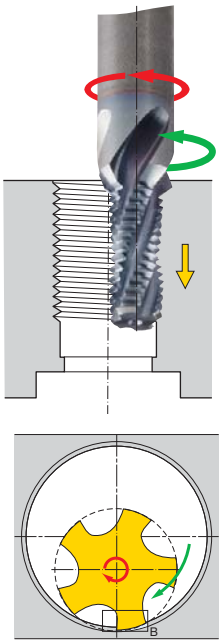
Properties:

- Tool rotation direction clockwise
- Tool moves clockwise
- Pitch “downwards”

- Right-hand thread

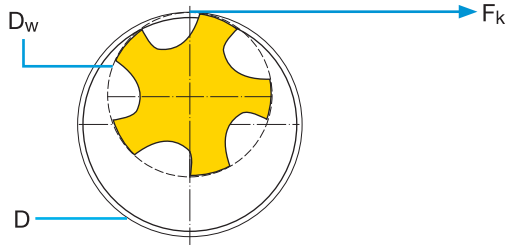
Conventional milling is always when the cutting edge goes out of the material with a chip thickness h = max





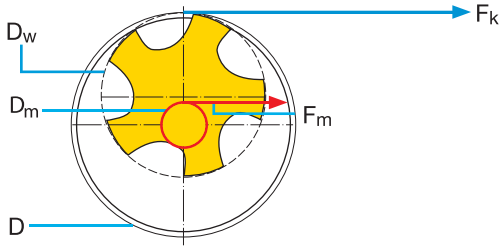
Counter Feed F_k

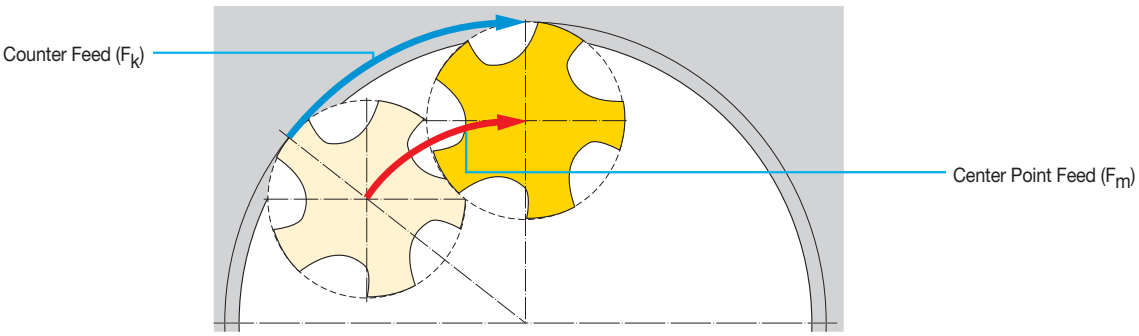
$$F_k = n \bullet f_z \bullet Z \text{ [mm/min]}$$



Center Point Feed F_m

$$F_m = \frac{F_k \bullet (D-Dw)}{D} \text{ [mm/min]}$$



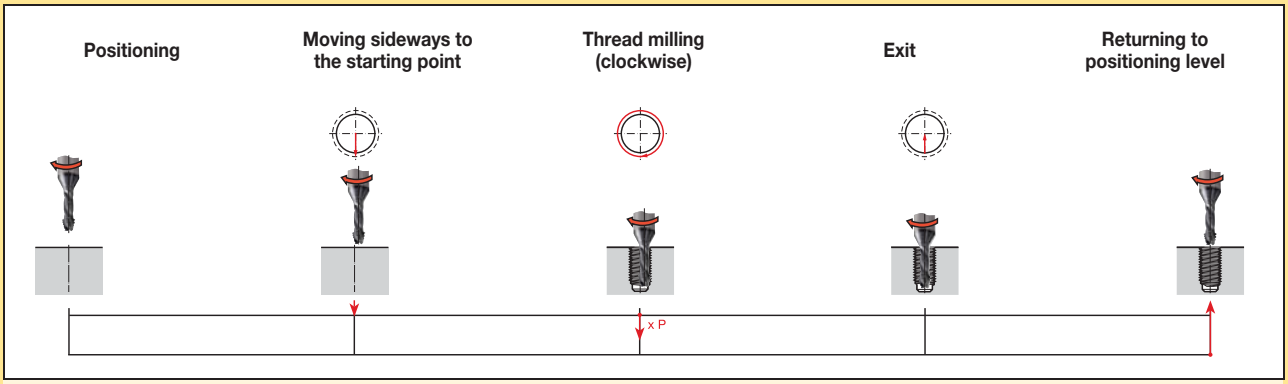


D_W = Tool diameter [mm]
n = RPM [min^{-1}]
f_Z = Feed per tooth [mm]
Z = Number of teeth on tool (radial)
D = Nominal diameter of thread = Diameter of external contour [mm]
D_m = Diameter of the center point (D-D_W) [mm]

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
Catalog 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

$N = \frac{v_c \bullet 1000}{d_1 \bullet \pi}$ **S = 4109**

$v_f = f_z \bullet Z \bullet n$ **F = 657 (contour)**

$N = \frac{v_f \text{ contour} \bullet (D-d_1)}{D}$ **F = 148 (center point)**

*(measured on the cutting part) **(0.01 x D; adjust to application) ***(1/2 d_1 - k)

Program 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] (center 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						

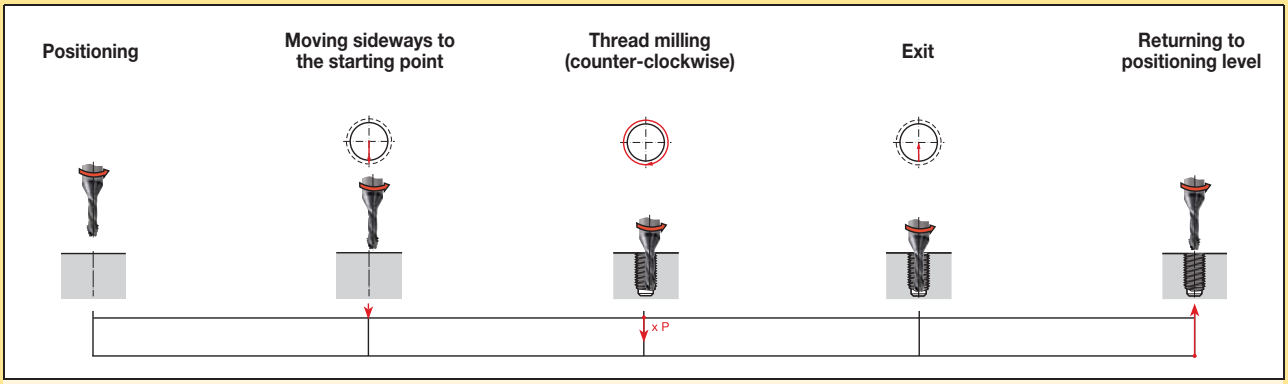
Cutting time t_h	51.6 seconds

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 center 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).

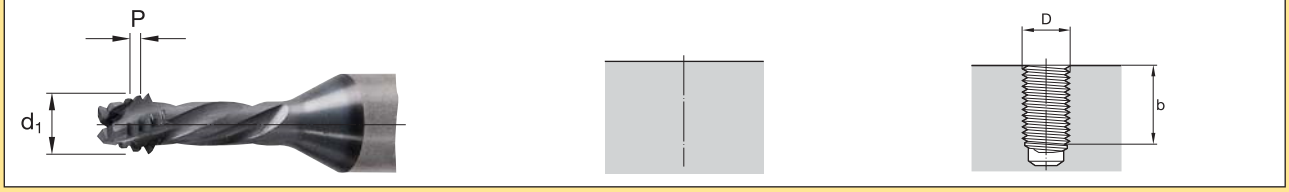
Drill Thread Mill TM741 • Left Hand

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
Catalog 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***
Thread depth b[3] 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 (center point)**

*(measured on the cutting part) **(0.01 x D) ***(1/2 d_1 - k)

Program 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] (center 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

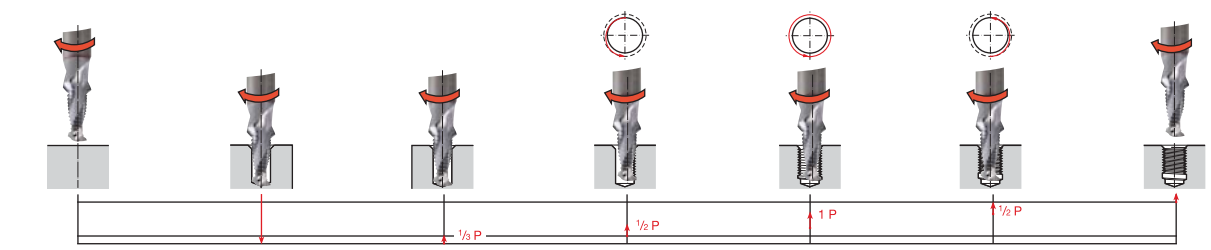
Cutting time t_h	**68.8 seconds**

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 center 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).

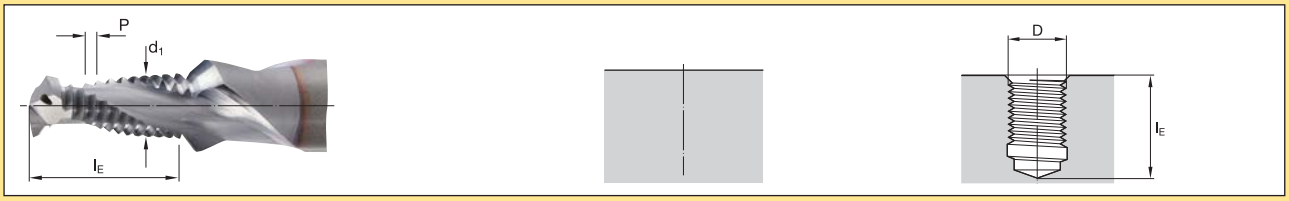
Drill Thread Mill TM731

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 — Gray cast iron
Grade — KCU32

Tool — TM731
Catalog 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***
Dilling/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)

$N = \frac{v_c \bullet 1000}{d_1 \bullet \pi}$ **S = 9709**

$v_b = f_b \bullet n$ **F = 2427 (drilling, countersinking)**

$v_f = f_z \bullet Z \bullet n$ **F = 1942 (contour)**

$v_f = \frac{v_f \text{ contour} \bullet (D - d_1)}{D}$ **F = 350 (center point)**

Program 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 center 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
Run-out loop in arc	N 70 G 03 X 0 Y-9.250 Z 0.750 I 0 J- 4.625 F1942 [F 350] [3] (center point)
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

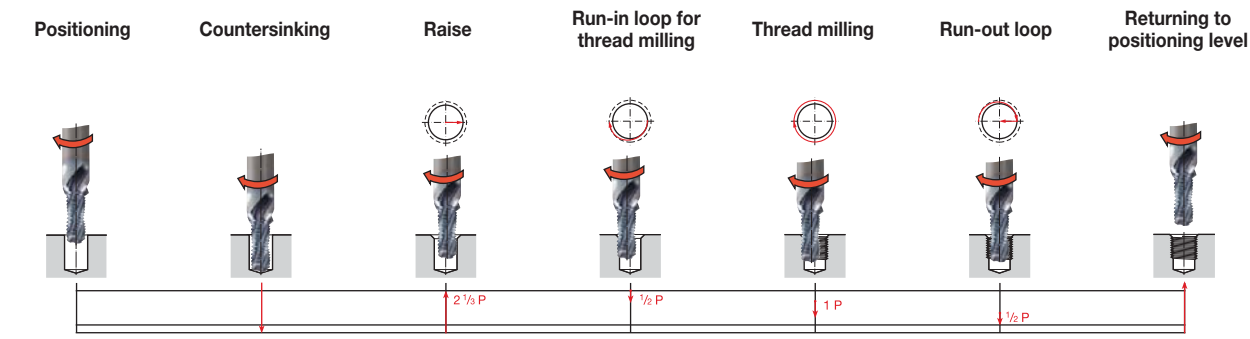
2.3 seconds

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 center point feed themselves.

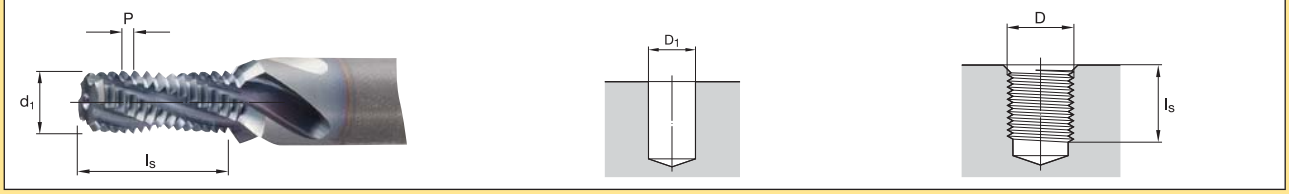
Thread Mill TM721

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 aluminum
Grade — KCU32

Tool — TM721
Catalog 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)

$$N = \frac{V_c \bullet 1000}{d_1 \bullet \pi} \quad S = 9709$$

$$v_s = f_s \bullet n \quad F = 2913 \text{ (countersinking)}$$

$$v_f = f_z \bullet Z \bullet n \quad F = 2622 \text{ (contour)}$$

$$v_f = \frac{v_f \text{ contour} \bullet (D-d_1)}{D} \quad F = 472 \text{ (center point)}$$

Program 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 center 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] (center 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 center 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 • Carbide • Inch

Material Group		Through Holes					Blind Holes				
				Range — SFM					Range — SFM		
		Tap Style	Grade	min	Starting Value	max	Tap Style	Grade	min	Starting Value	max
P	1	T320, T321	KC7542	200	**330**	430	T331	KC7542	160	**230**	300
	2	T320, T321	KC7542	200	**300**	390	T331	KC7542	130	**200**	260
	3	T320, T321	KC7542	160	**260**	330	T331	KC7542	130	**200**	260
K	1	T340, T353	KC7542, KCK17	230	**340**	460	T351, T353	KC7542, KCK17	160	**230**	300
	2	T340, T353	KC7542, KCK17	200	**330**	430	T351, T353	KC7542, KCK17	160	**230**	300
	3	T340, T353	KC7542, KCK17	200	**300**	390	T351, T353	KC7542, KCK17	130	**200**	260
N	2	–	–	–	**–**	–	T471, T491	KCN14	200	**260**	330
	3	–	–	–	**–**	–	T471, T491	KCN14	160	**230**	300
	4	–	–	–	**–**	–	T471, T491	KCN14	130	**200**	260
H	1	T410	KCU36	4	**5**	6	T410	KCU36	3	**3**	4
	2	T410	KCU36	2	**2**	3	T410	KCU36	1	**2**	2

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).

High-Performance Taps • HSS-E-PM • Inch

Material Group		Through Holes					Blind Holes				
				Range — SFM					Range — SFM		
		Tap Style	Grade	min	Starting Value	max	Tap Style	Grade	min	Starting Value	max
P	1	T620	KP6525	70	**100**	150	T630, T632, T650	KP6525	50	**70**	100
		T622	KSP21	60	**100**	160	T622	KSP21	40	**70**	120
		T624	KSP27	70	**100**	150	T624, T626	KSP27	50	**70**	100
	2	T620	KP6525	50	**80**	120	T630, T632, T650	KP6525	40	**60**	90
		T622	KSP21	50	**80**	140	T622	KSP21	30	**60**	100
		T624	KSP27	50	**80**	120	T624, T626	KSP27	40	**60**	90
	3	T620	KP6525	40	**50**	60	T630, T632, T650	KP6525	30	**30**	40
	4	T600	KSP21	15	**20**	26	T604	KSP21	11	**14**	18
	5	T620	KP6525	40	**50**	60	T630, T632, T650	KP6525	30	**30**	40
	6	T600	KSP21	20	**30**	30	T604	KSP21	10	**20**	20
M	1	T620	KM6515	40	**50**	60	T630, T632, T650	KM6515	30	**30**	40
	1	T624	KSP27	20	**30**	30	T624, T626	KSP27	10	**20**	20
	2	T620	KM6515	30	**40**	50	T630, T632, T650	KM6515	20	**30**	40
	3	T620	KM6515	30	**30**	40	T630, T632, T650	KM6515	20	**20**	30
K	1	T640	KP6525	90	**110**	150	T640, T642	KP6525	60	**80**	100
	2	T640	KP6525	80	**100**	130	T640, T642	KP6525	50	**70**	90
	3	T640	KP6525	60	**80**	110	T640, T642	KP6525	40	**60**	70
N	1	T672	KSMN34	110	**160**	210	T682, T686	KSMN34	80	**110**	150
		T622	KSN28	120	**180**	230	T622	KSN28	80	**130**	160
	2	T640	KP6525	100	**150**	190	T640, T642	KP6525	70	**100**	130
		T672	KSMN34	100	**150**	190	T682, T686	KSMN34	70	**100**	130
		T622	KSN28	110	**160**	210	T622	KSN28	80	**110**	150
	4	T640	KP6525	22	**30**	49	T640, T642	KP6525	15	**23**	34
S	1	T620	KP6525	30	**40**	60	T630, T632	KP6525	18	**28**	41
	2	T690	KSP27	11	**16**	25	T692, T694	KSP27	8	**11**	17
	3	T690	KSS29	5	**8**	12	T692, T694	KSS29	4	**6**	9
	4	T660	KSSM24	9	**13**	20	T662	KSSM24	6	**9**	14
		T660	KSS20	4	**7**	10	T662	KSS20	3	**5**	7

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

GOtap™ • Inch

Material Group		Through Holes					Blind Holes				
				Range — SFM					Range — SFM		
		Tap Style	Grade	min	Starting Value	max	Tap Style	Grade	min	Starting Value	max
P	1	T820	KSU31, KSP32	75	**100**	125	T830, T832, T838, T839	KSU31, KSP32	50	**70**	100
		T820	KSP39, KSU30	35	**50**	60	T830, T832, T838, T839	KSP39, KSU30	25	**35**	50
		T854	KSU31	20	**25**	35	T854	KSU31	20	**25**	35
		T854	KSP39	15	**20**	25	T854	KSP39	15	**20**	25
		T877	KSU31	55	**70**	90	T857	KSU31	35	**50**	70
		T877	KSP39	25	**35**	40	T857	KSP39	15	**25**	35
		T848	KSU30	15	**20**	25	T848	KSU30	10	**15**	20
	2	T820	KSU31, KSP32	60	**80**	100	T830, T832, T838, T839	KSU31, KSP32	40	**55**	80
		T820	KSP39, KSU30	35	**45**	55	T830, T832, T838, T839	KSP39, KSU30	25	**30**	45
	3	T820	KSU31, KSP32	55	**70**	90	T830, T832, T838, T839	KSU31, KSP32	35	**50**	70
		T820	KSP39, KSU30	30	**40**	50	T830, T832, T838, T839	KSP39, KSU30	20	**30**	40
		T846	KSU31	20	**25**	35	T846	KSU31	20	**25**	35
		T846	KSU30	10	**15**	20	T846	KSU30	10	**15**	20
M	1	T820	KSMN34, KSP32	45	**60**	75	T830, T832, T838, T839	KSMN34, KSP32	30	**40**	60
		T820	KSP39, KSU30	25	**35**	40	T830, T832, T838, T839	KSP39, KSU30	15	**25**	35
		T854	KSU31	20	**25**	35	T854	KSU31	20	**25**	35
		T854	KSP39	10	**15**	20	T854	KSP39	10	**15**	20
		T877	KSU31	30	**40**	50	T857	KSU31	20	**25**	40
		T877	KSP39	15	**25**	30	T857	KSP39	10	**15**	25
		T848	KSU30	10	**15**	20	T848	KSU30	10	**15**	20
	3	T820	KSMN34, KSP32	35	**50**	60	T830, T832, T838, T839	KSMN34, KSP32	25	**35**	50
		T820	KSP39, KSU30	20	**30**	35	T830, T832, T838, T839	KSP39, KSU30	15	**20**	30
K	1	T846	KSU31	35	**50**	60	T846	KSU31	35	**50**	60
		T846	KSU30	20	**25**	35	T846	KSU30	20	**25**	35
	2	T820	KSU31, KSP32	50	**70**	85	T830, T832, T838, T839	KSU31, KSP32	35	**50**	70
		T820	KSP39, KSU30	30	**40**	50	T830, T832, T838, T839	KSP39, KSU30	20	**30**	40
		T877	KSU31	45	**60**	75	T857	KSU31	30	**40**	60
		T877	KSP39	20	**30**	35	T857	KSP39	15	**20**	30
		T848	KSU30	10	**15**	20	T848	KSU30	10	**10**	15
N	1	T820	KSMN34, KSP32	120	**160**	200	T830, T832, T838, T839	KSMN34, KSP32	80	**115**	160
		T820	KSU30	65	**90**	110	T830, T832	KSU30	45	**60**	90
	2	T820	KSMN34, KSP32	100	**130**	165	T830, T832, T838, T839	KSMN34, KSP32	65	**90**	130
		T820	KSU30	50	**70**	85	T830, T832	KSU30	35	**50**	70
		T877	KSU31	55	**70**	90	T857	KSU31	35	**50**	70
		T877	KSP39	25	**35**	40	T857	KSP39	15	**25**	35
		T848	KSU30	30	**45**	55	T848	KSU30	20	**30**	45
	4	T820	KSMN34, KSP32	55	**70**	90	T830, T832, T838, T839	KSMN34, KSP32	35	**50**	70
		T820	KSU30	25	**35**	40	T830, T832	KSU30	15	**25**	35

KSU30 = Bright
KSP39 = Oxide
KSU31 = TiN
KSP32 = TiCN/TiN
KSMN34 = TiN + CrC/C

General Purpose HSS • Metric

Material Group		Through Holes				Blind Holes			
			Range — m/min				Range — m/min		
		Tap Style	min	Starting Value	max	Tap Style	min	Starting Value	max
P	1	KHSST Spiral Point	13	**17**	21	KHSST Spiral Flute	7	**8**	10
	2	KHSST Spiral Point	10	**12**	15	KHSST Spiral Flute	5	**6**	8
	3	KHSST Spiral Point	6	**8**	10	KHSST Spiral Flute	3	**4**	5
	5	KHSST Spiral Point	5	**6**	8	KHSST Spiral Flute	2	**3**	4
M	1	KHSST Spiral Point	6	**8**	10	KHSST Spiral Flute	3	**4**	5
	2	KHSST Spiral Point	5	**6**	8	KHSST Spiral Flute	2	**3**	4
	3	KHSST Spiral Point	4	**5**	6	KHSST Spiral Flute	2	**2**	3
K	1	KHSST Hand	22	**27**	34	KHSST Hand	11	**14**	17
	2	KHSST Hand	18	**23**	29	KHSST Hand	9	**11**	14
N	1	KHSST Spiral Point	29	**37**	46	KHSST Spiral Flute	15	**18**	23
	2	KHSST Spiral Point	24	**30**	38	KHSST Spiral Flute	12	**15**	19

NOTE: Increase speed by up to 50% when using coated taps (TiN, TiCN).

General Purpose HSS • Inch

Material Group		Through Holes				Blind Holes			
			Range — SFM				Range — SFM		
		Tap Style	min	Starting Value	max	Tap Style	min	Starting Value	max
P	1	KHSST Spiral Point	44	**55**	69	KHSST Spiral Flute	22	**28**	34
	2	KHSST Spiral Point	32	**40**	50	KHSST Spiral Flute	16	**20**	25
	3	KHSST Spiral Point	20	**25**	31	KHSST Spiral Flute	10	**13**	16
	5	KHSST Spiral Point	16	**20**	25	KHSST Spiral Flute	8	**10**	13
M	1	KHSST Spiral Point	20	**25**	31	KHSST Spiral Flute	10	**13**	16
	2	KHSST Spiral Point	16	**20**	25	KHSST Spiral Flute	8	**10**	13
	3	KHSST Spiral Point	12	**15**	19	KHSST Spiral Flute	6	**8**	9
K	1	KHSST Hand	72	**90**	113	KHSST Hand	36	**45**	56
	2	KHSST Hand	60	**75**	94	KHSST Hand	30	**38**	47
N	1	KHSST Spiral Point	96	**120**	150	KHSST Spiral Flute	48	**60**	75
	2	KHSST Spiral Point	80	**100**	125	KHSST Spiral Flute	40	**50**	63

NOTE: Increase speed by up to 50% when using coated taps (TiN, TiCN).

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 maximize the performance of your tools.



How to Apply This Technical Information

Below is an example of how the technical information in this catalog can be useful:

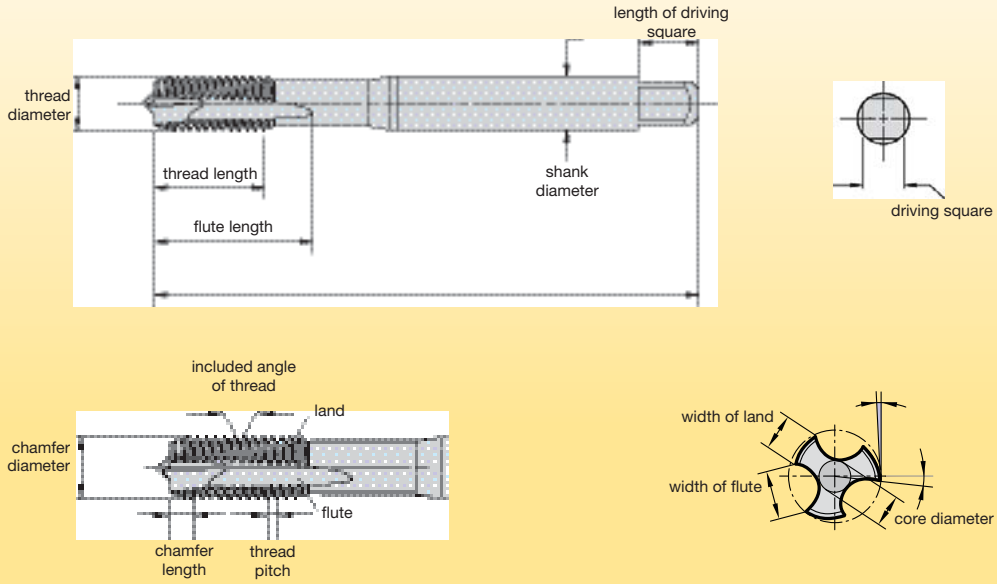
Problem

- 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, Centers, and Flute Forms



Flute Forms



Straight-flute, form C plug chamfer **without spiral point**



Right-hand spiral flute

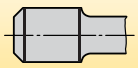
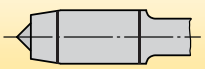
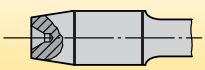


Straight-flute, form B plug chamfer **with spiral point**



Left-hand spiral flute

Types of Centers (Standard to DIN 2197/DIN 2175)

center 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 center removed	full external center	partial external center	internal center

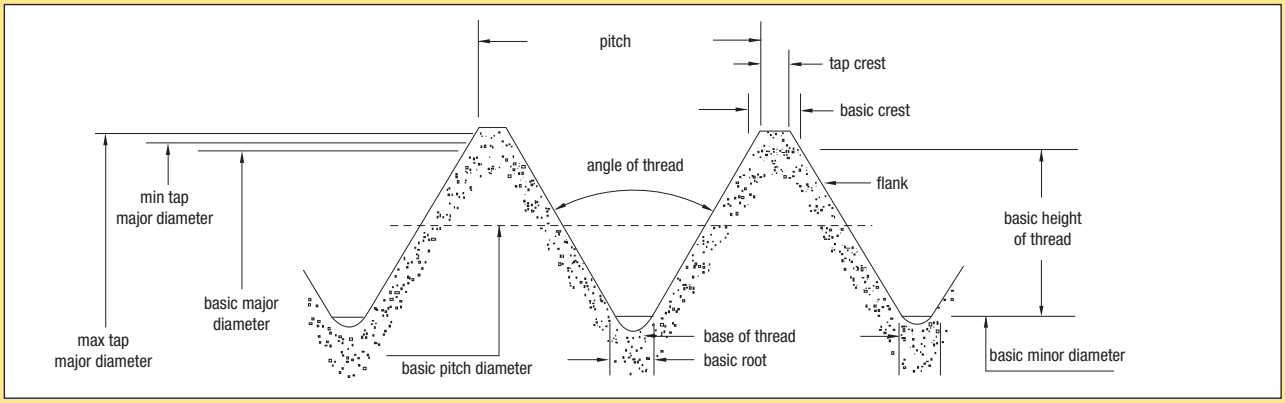
Coolant Hole Types

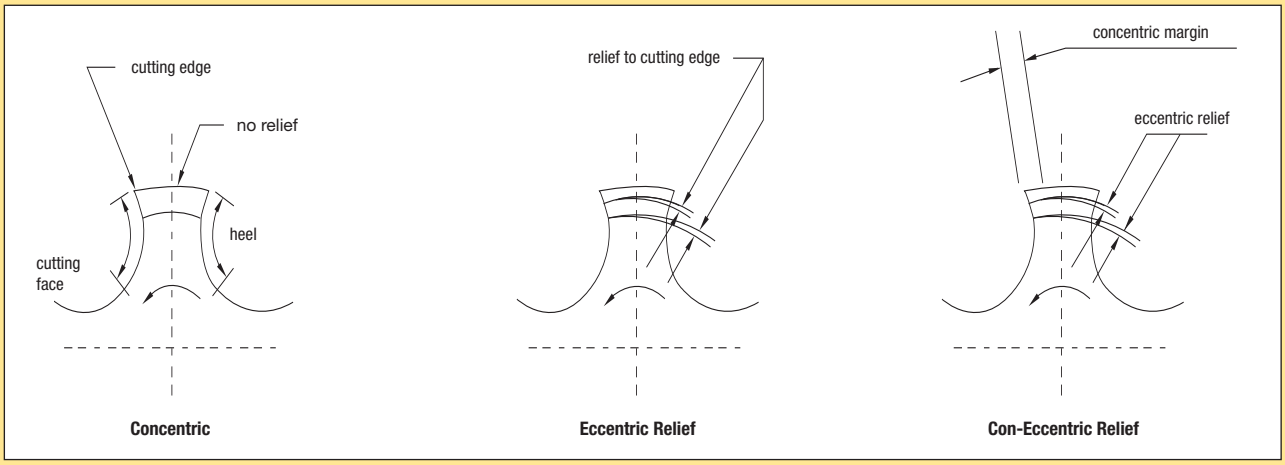


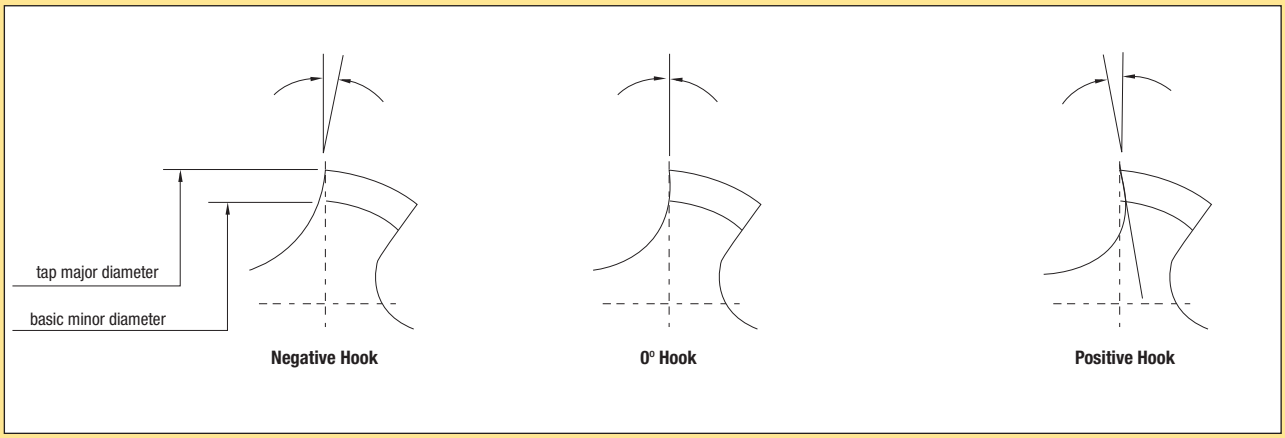
Axial coolant delivery with axial coolant exit hole

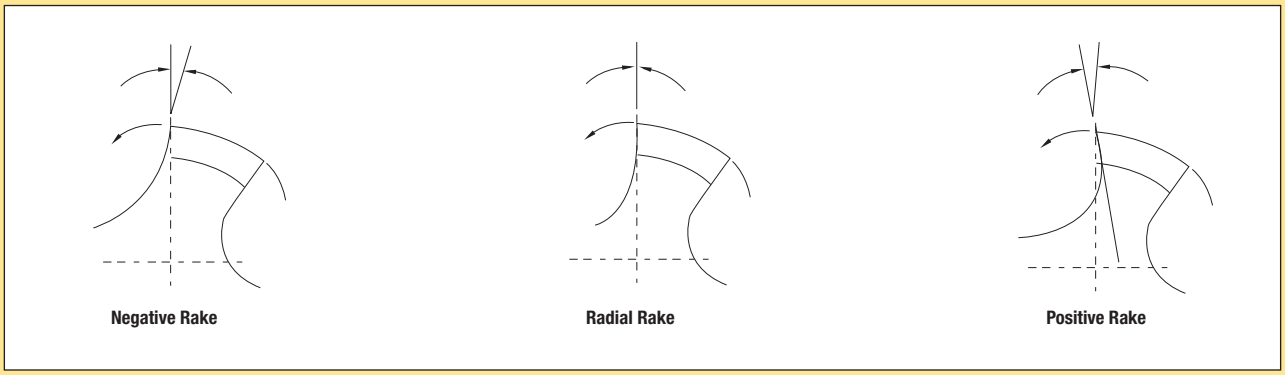


Axial coolant delivery with radial coolant hole exiting in the flutes









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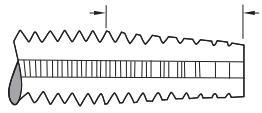
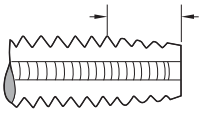
Tap Chamfers • ANSI Taps

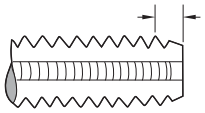
Taper Chamfer
7–10 Pitches



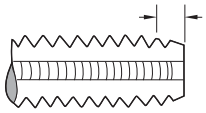
Plug Chamfer
3–5 Pitches



Modified Bottoming Chamfer
2–2.5 Pitches



Full Bottoming Chamfer
1–2 Pitches



Tap Chamfers

Taper (7–10 pitches)

The taper chamfer has the longest standard chamfer ensuring easier starting. It requires less tapping torque because of more working teeth.

Plug (3–5 pitches)

The most common chamfer for use by hand or machine in through or blind holes. This chamfer is more efficient than a bottoming or modified bottoming chamfer.

Semi-Bottom (2–2.5 pitches)

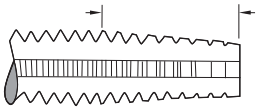
This short chamfer enables threading close to the bottom of blind holes. Due to the slightly longer chamfer and more working teeth, this chamfer is more efficient than a bottoming chamfer.

Bottoming (1–2 pitches)

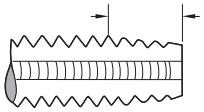
For threading close to the bottom of blind holes, the bottoming chamfer is the least efficient chamfer available.

Tap Chamfers • DIN Taps

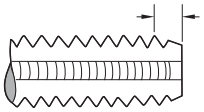
Taper Chamfer
7–10 Pitches



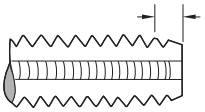
Plug Chamfer
3–5 Pitches



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)

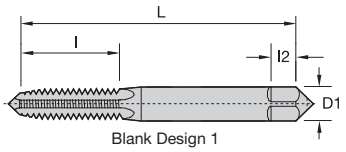
The most common chamfers for use by hand or machine in through or blind holes. Form B applies to spiral-point taps and Form D applies to straight-flute and spiral-flute taps. This chamfer is more efficient than Form E or Form C chamfers.

Form C (2–2.5 pitches)

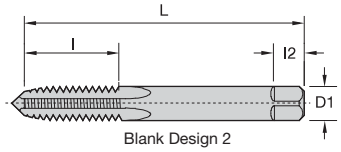
This short chamfer enables threading close to the bottom of blind holes. Due to the slightly longer chamfer and more working teeth, this chamfer is more efficient than a Form E chamfer.

Form E (1.5–2 pitches)

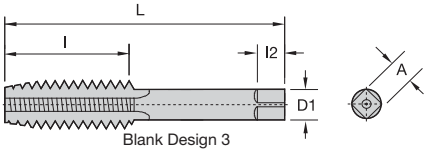
For threading close to the bottom of blind holes, the Form E chamfer is the least efficient chamfer available.



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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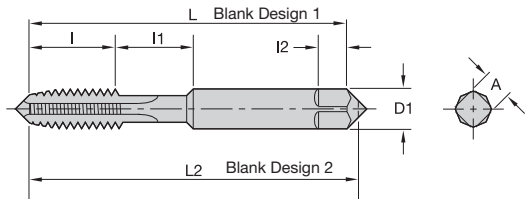

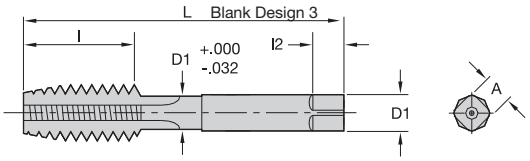

General Dimensions

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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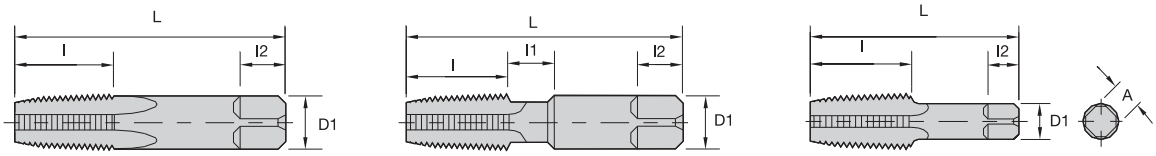
Special Taps

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 center on the shank end. Sizes .224–.395" have truncated partial cone centers on the shank end (length of cone approximately 1/4 of diameter of shank). Sizes over .395" have internal centers 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

dimensions (in)

nominal size (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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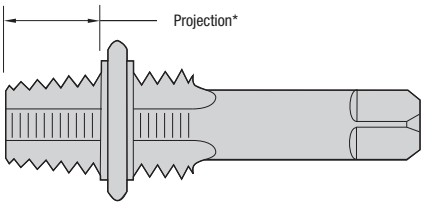
American National Standard Taper Pipe Thread Form (NPT)
Aeronautical National Taper Pipe Thread Form (ANPT)
Dryseal American National Standard Taper Pipe Thread Form (NPTF)



				taper per foot limits			
nominal size (in)	threads per inch	projection* (in)	projection tolerance + / –	min	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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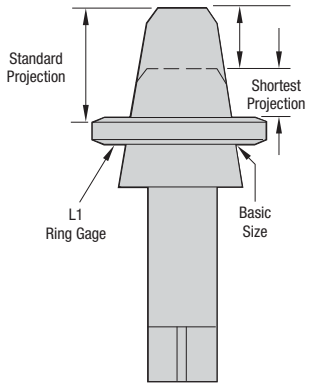
Pipe Taps

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.

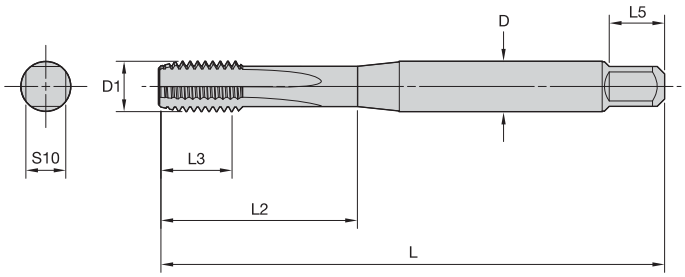
The nominal size of a pipe tap is that of the pipe fitting to be tapped, not the actual size of the tap. The thread tapers 3/4" per foot. All pipe taps are furnished with 2-1/2–3-1/2 thread chamfer.



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).

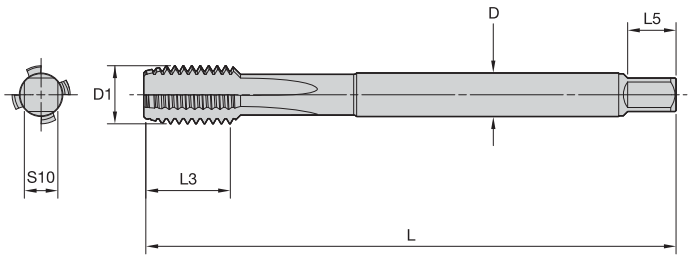
For information on short projection pipe taps and hole preparation for NPT, NPTF, and ANPT internal pipe threads, consult Kennametal Technical Bulletins.



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

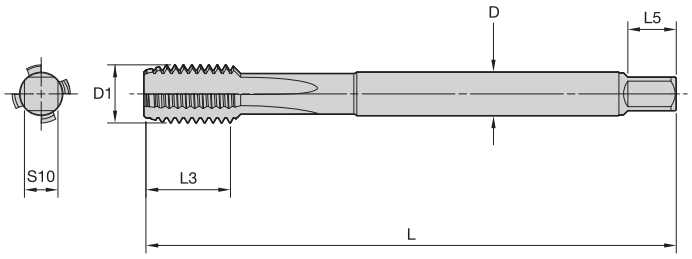
*Maximum



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

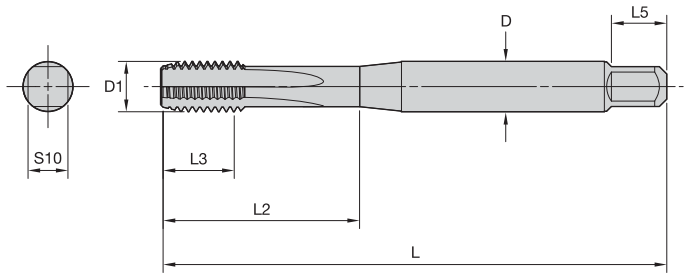
*Maximum



DIN 374

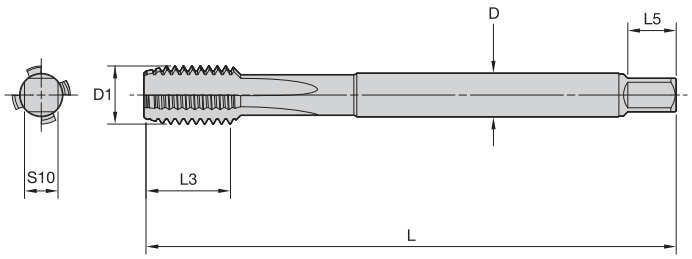
	pitch						
D1	**minimum**	**maximum**	**D**	**L**	**L3***	**L5**	**S10**
M8	0.2	0.75	6	80	18	8	4.9
M8	–	1	6	90	22	8	4.9
M9	0.2	0.75	7	80	18	8	5.5
M9	–	1	7	90	22	8	5.5
M10	0.2	1	7	90	20	8	5.5
M10	–	1.25	7	100	24	8	5.5
M11	0.35	1	8	90	20	9	6.2
M12	0.35	1.5	9	100	22	10	7
M14	0.35	1.5	11	100	22	12	9
M16	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
	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
M8	–	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
	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
M10	–	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
	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
M12	–	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
	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
M20	–	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
	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
M22	–	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
	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
M24	–	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
	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
M27	–	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
	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
M30	–	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
	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
M36	–	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
	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
M42	–	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

[1]Tap H limit selected for 3B will also produce thread to 2B.

(continued)

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

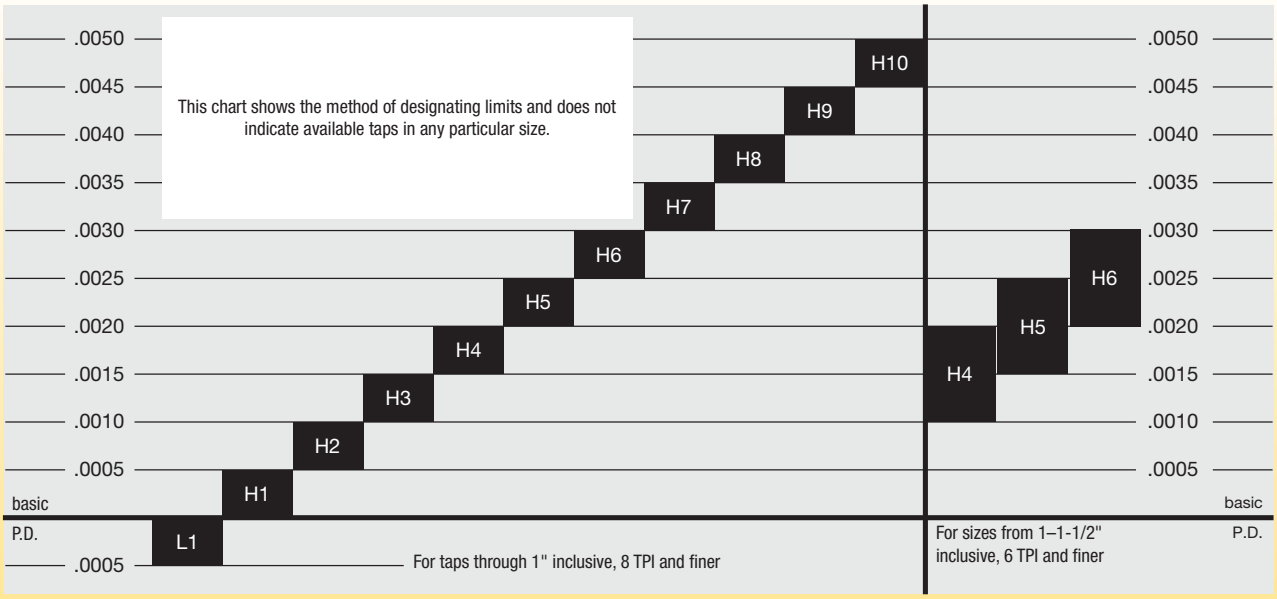
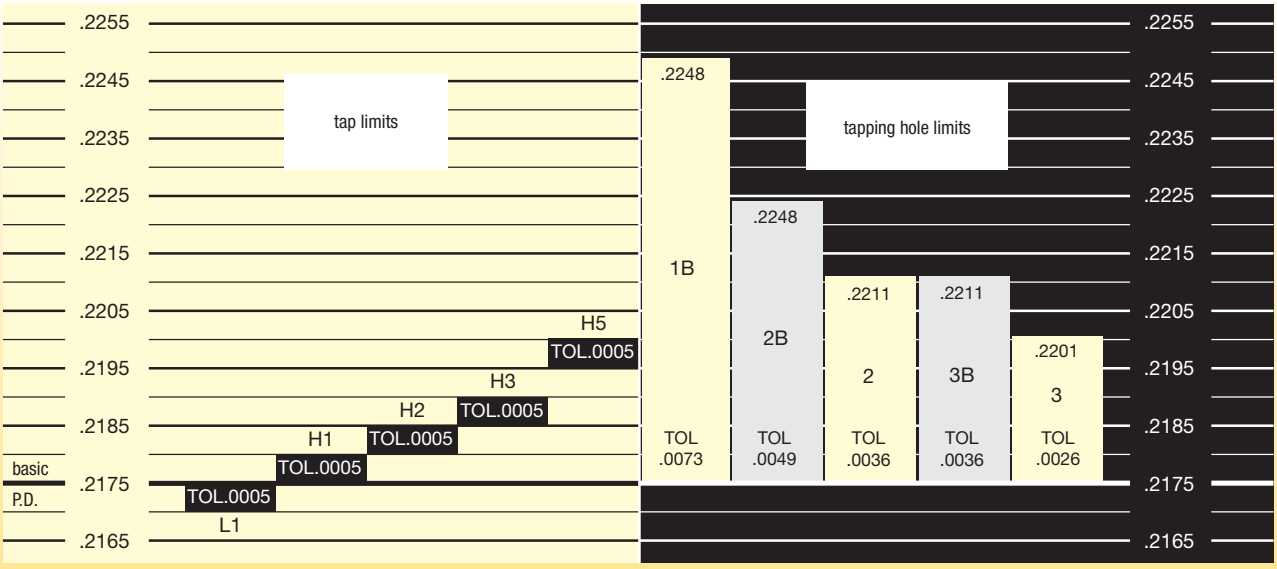
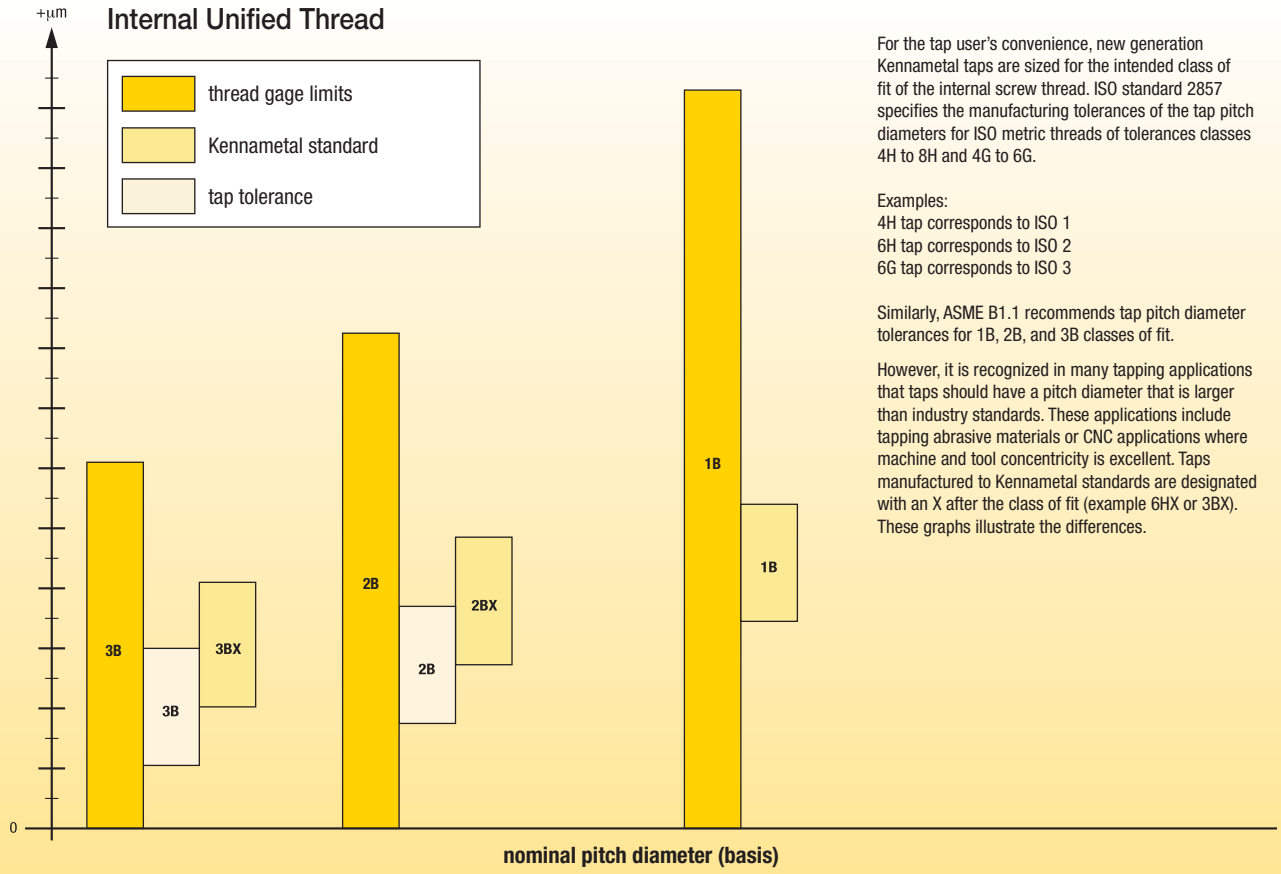


Figure 2

Class of Thread – 1/4–20 UNC and NC



Internal Unified Thread



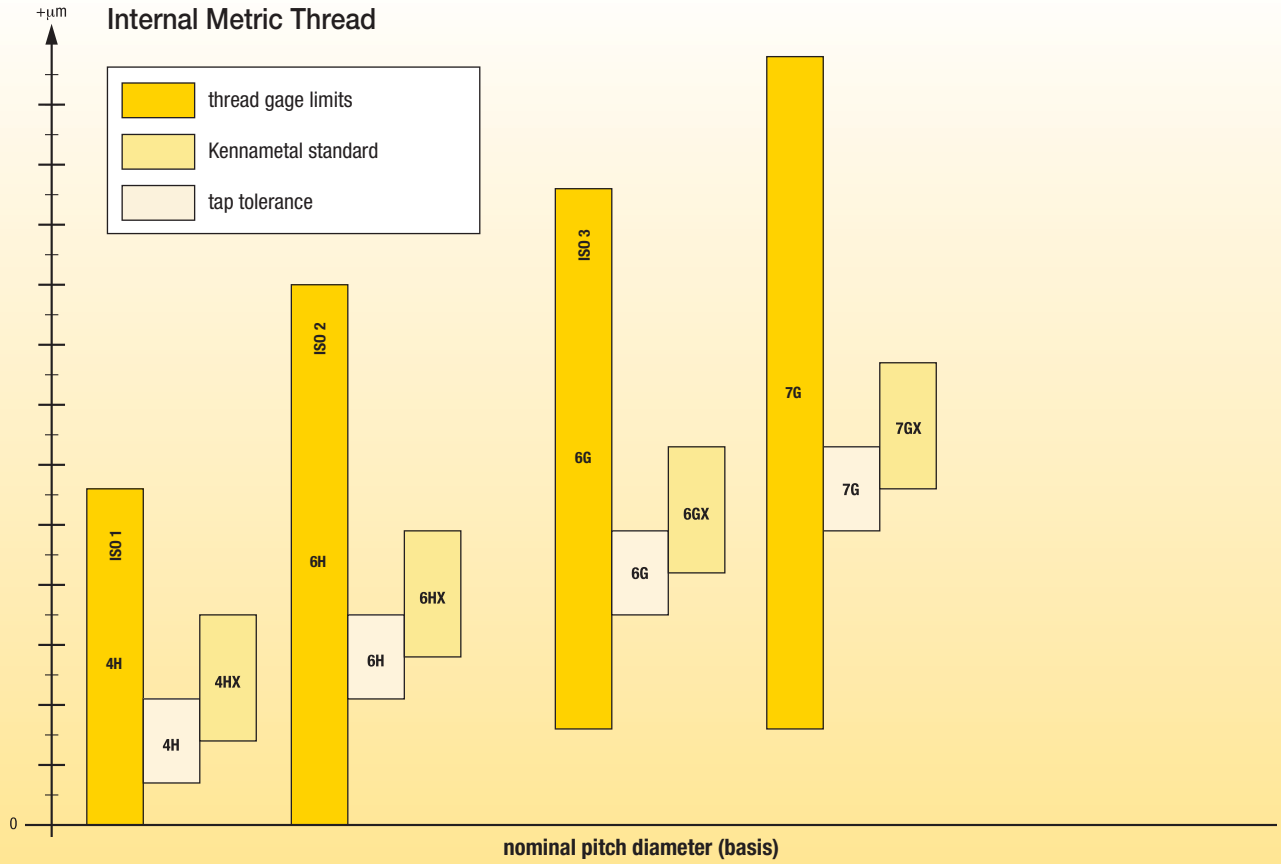
For the tap user's convenience, new generation Kennametal taps are sized for the intended class of fit of the internal screw thread. ISO standard 2857 specifies the manufacturing tolerances of the tap pitch diameters for ISO metric threads of tolerances classes 4H to 8H and 4G to 6G.

Examples:
4H tap corresponds to ISO 1
6H tap corresponds to ISO 2
6G tap corresponds to ISO 3

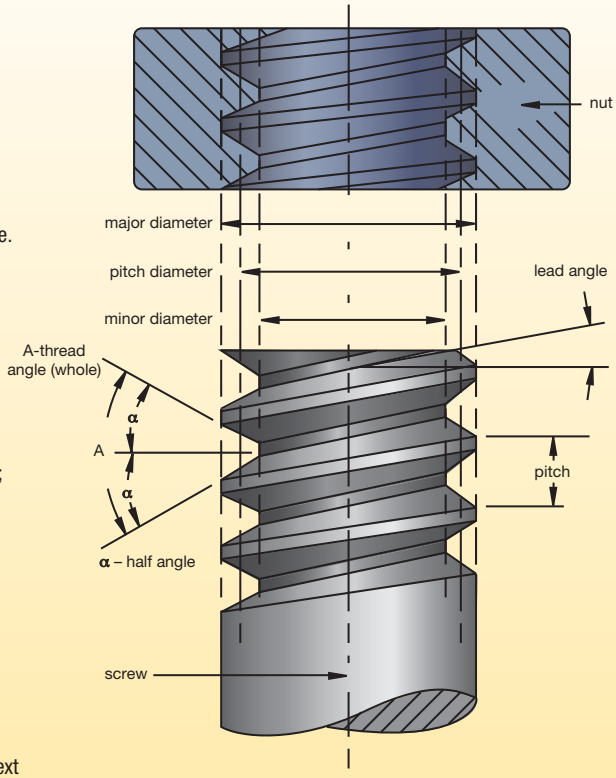
Similarly, ASME B1.1 recommends tap pitch diameter tolerances for 1B, 2B, and 3B classes of fit.

However, it is recognized 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 recognized 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.

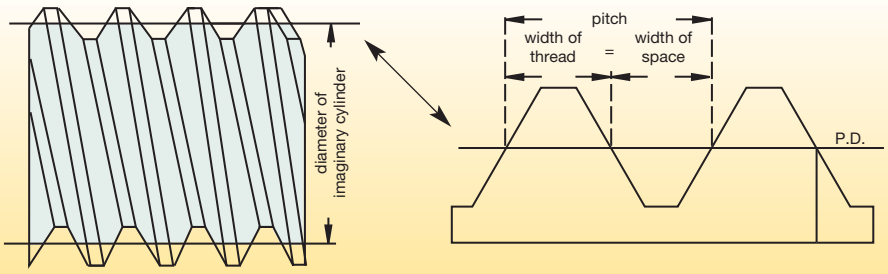
Minor Diameter

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.

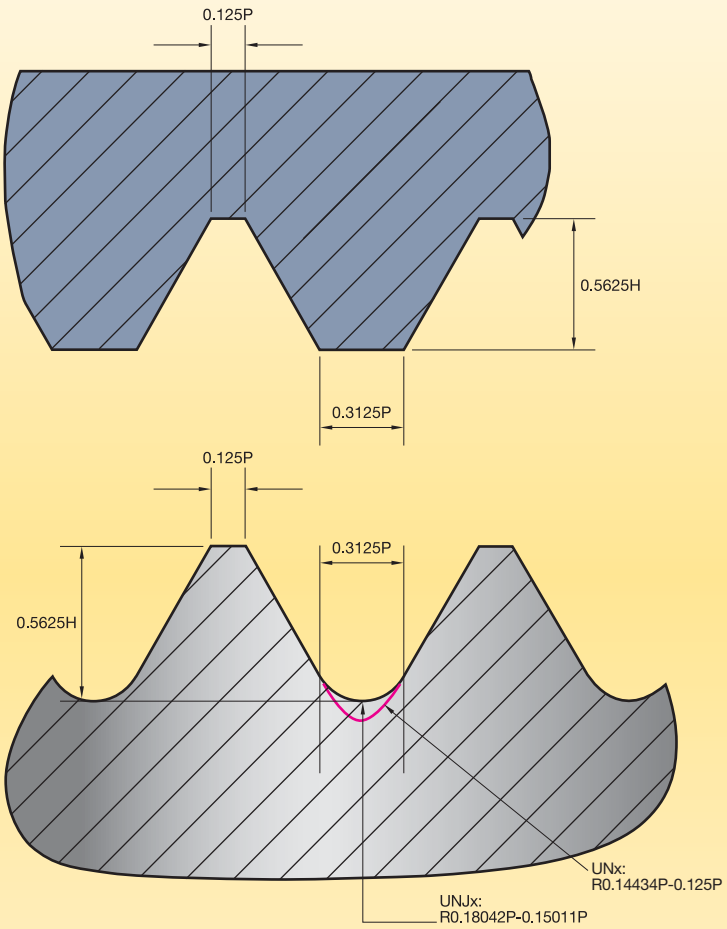
The pitch in inches = $\frac{1}{\text{number of threads per inch}}$



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.

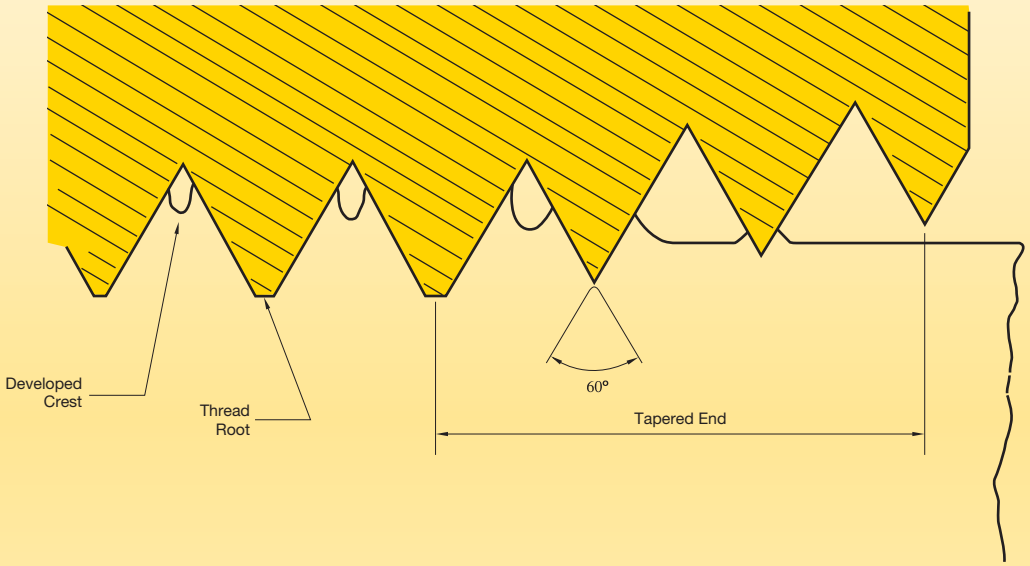
A thread system is available for aerospace and other applications where high fatigue strength is required. The UNJ thread form is defined by ASME B1.15 and is similar to Military Specification MIL-S-8879. Screw thread assemblies consist of external and internal threads. In order to minimize the stress 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 centers 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 color.	Use with caution in non-ferrous materials such as aluminum 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-gray color.	Use with caution in non-ferrous materials such as aluminum 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 aluminum and titanium. Ideal choice for 300 series stainless steels, wrought, and die cast aluminums. Black/gray color.	Effective in both ferrous and non-ferrous materials.
Titanium Aluminum 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/gray color.	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 color.	Ineffective in ferrous materials.
Nitride	Hardened case extends wear life in abrasive materials. Use for aluminum 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 aluminum.
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 Meters per Minute
$\pi = 3.1416$
mm/min = millimeters 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 = meters 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	program, 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)
aluminum, cast	excessive wear	high silicon	T640 KP6525 (TiCN)
aluminum, 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:

catalog number _____ **grade/coating** _____

2. Type of tap needed:

❑ solid carbide ❑ high-performance HSS ❑ general purpose ❑ spiral point

❑ hand ❑ forming ❑ spiral flute

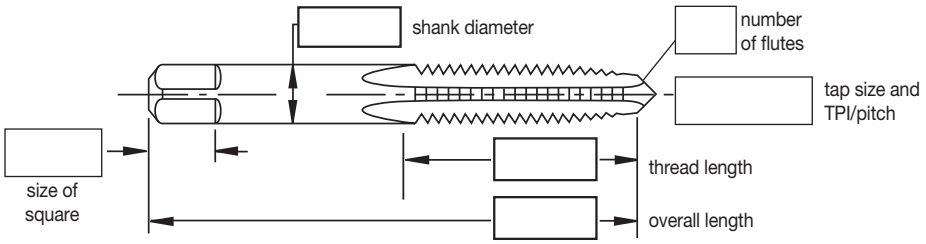
_____ pipe (and style) _____ other

3. Direction of cut (circle one)**:** left hand right hand

4. Material overview:

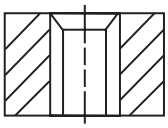
❑ ANSI ❑ DIN ❑ JIS ❑ other

5. Desired dimension:

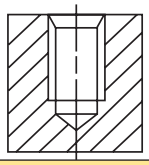


6. Choose one:

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 Authorized 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®	❑ Collet			
	❑ Shrinking	❑ 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 optimized flute geometries and PVD coatings capable of tapping a broad assortment of ductile materials, such as stainless steels, carbon and alloy steels, cast aluminum, 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.
- Optimized 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 Authorized Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

kennametal.com



Solid End Milling

Solid End Milling Introduction N2–N3

Duo-Lock Modular Milling O1–O57

High-Performance Solid Carbide End Mills P1–P171

General Purpose Solid Carbide End Mills Q1–Q47



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 Authorized 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

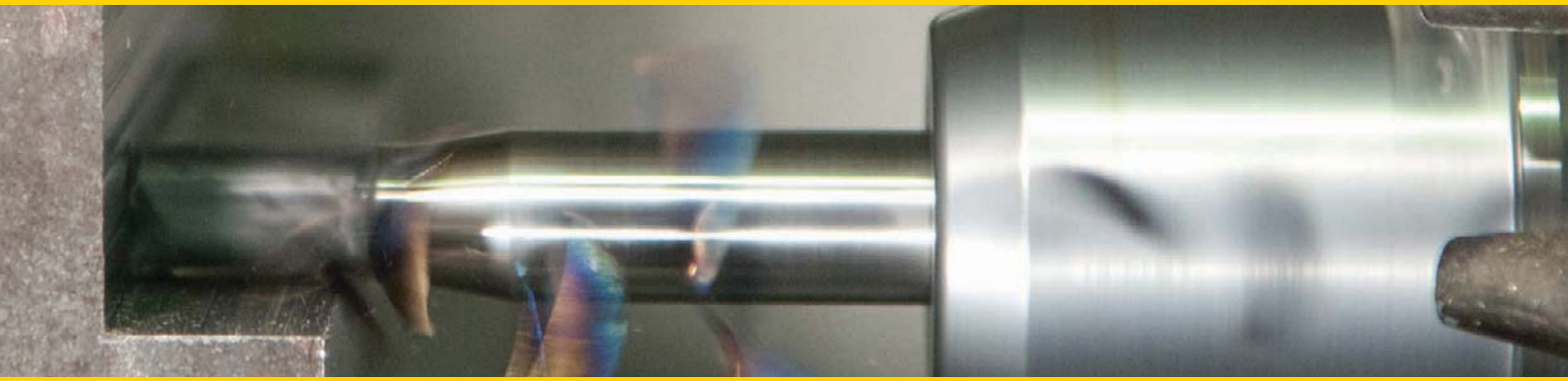


HIGH CAPABILITY END MILLS

See Section P for more details.

HARVI I
HARVI II
HARVI II Long
HARVI III
CXE/CXER





MATERIAL SPECIFIC END MILLS

See Section P for more details.

Aluminum Machining
CFRP Machining
Hard Materials 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™

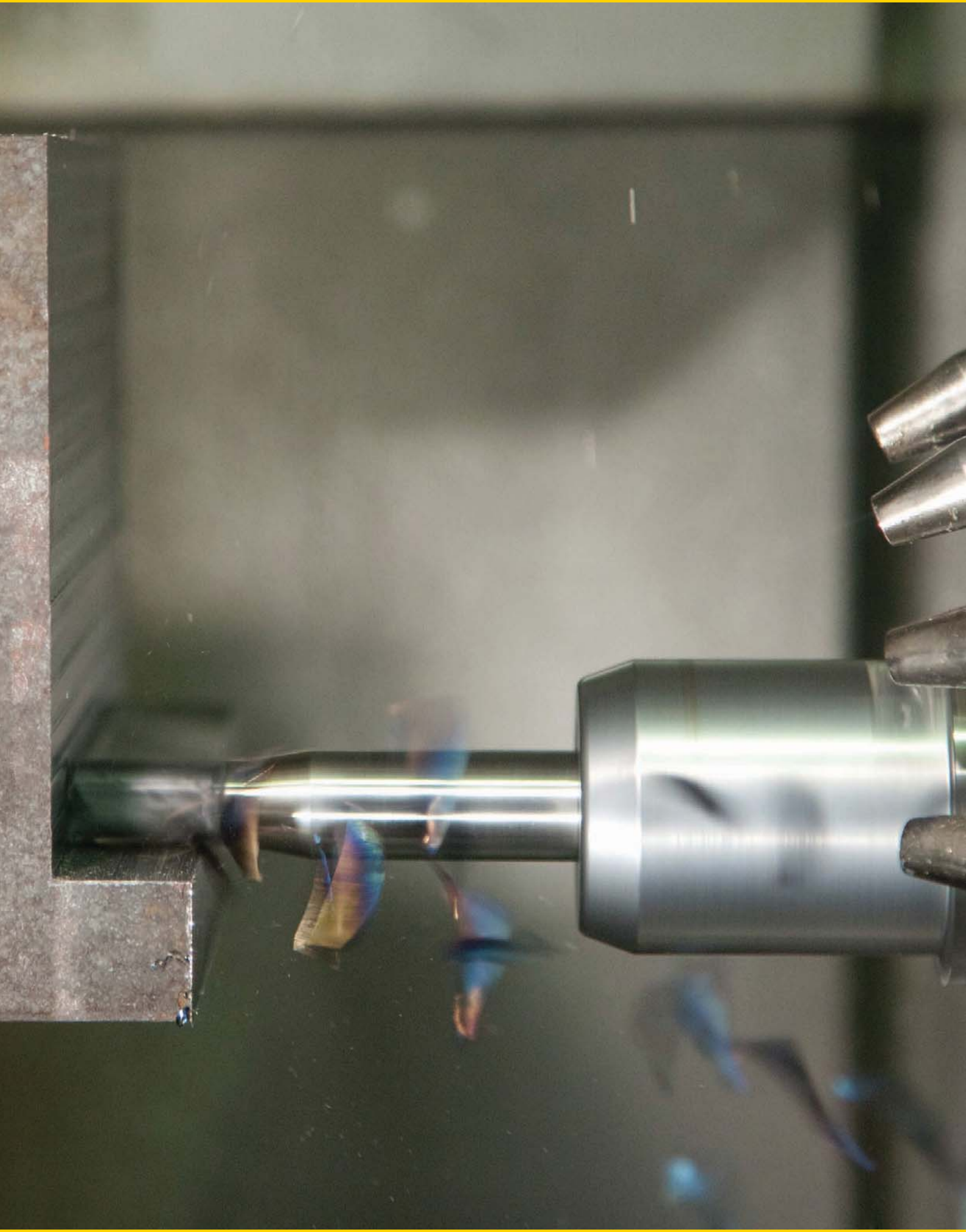


GENERAL PURPOSE END MILLS

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

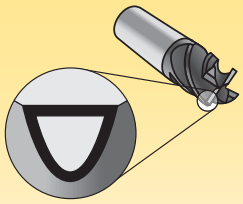
Adapters O52–O56

Assembly Information O57

product line		series	D1 diameter (inch)	length of cut	flute Z	helix	internal coolant	
HARVI™ I		UKDV	3/8–1 1/4	1.5 x D	ZU=4	37.5°		
HARVI I		ULDV	3/8–1 1/4	1.5 x D	ZU=4	37.5°		
HARVI II		UCDV	3/8–1 1/4	1.5 x D	ZU=5	37.5°		
HARVI II		UDDV	3/8–1 1/4	1.5 x D	ZU=5	37.5°		
HARVI III		UJDV	3/8–1 1/4	1.5 x D	ZU=6	37.5°		
HARVI Ball Nose		UKBV	3/8–1	1.5 x D	ZU=4	37.5°		
HARVI III Ball Nose		UJBV	3/8–1	1.5 x D	ZU=6	37.5°		
MaxiMet™		ABDF	3/8–3/4	1.5 x D	ZU=2	45°		
MaxiMet		ABDE	3/8–1	1.5 x D	ZU=3	38°		
KenFeed™		KMDA	3/8–3/4	0.75 x D	ZU=6	20°		
HP Rougher		RQDB	3/8–1	1.5 x D	ZU=X	20°		
HP Rougher		RKDF	3/8–1	1.5 x D	ZU=X	45°		
HP Rougher		RQBB	3/8–1	1.5 x D	ZU=4	30°		
HP Finisher		FMDF	3/8–1	1.5 x D	ZU=6	45°		
HP Finisher		FSDE	3/8–1	1.5 x D	ZU=X	36°		
Corner Tooling		XADA	3/8–5/8	.359–.605	ZU=X	0°		
Corner Tooling		XRDA	3/8–5/8	.359–.730	ZU=X	0°		

							shank	center 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.									
KCPM15	Coated carbide grade with thick PVD coating and optimized 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.									
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.									
KC639M	PVD- (AlTiN) coated carbide on a submicron carbide substrate. This hard coating provides outstanding performance in milling hardened materials (58–65 HRC).									
KCSM15	Coated carbide grade with thick PVD coating and optimized 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.									

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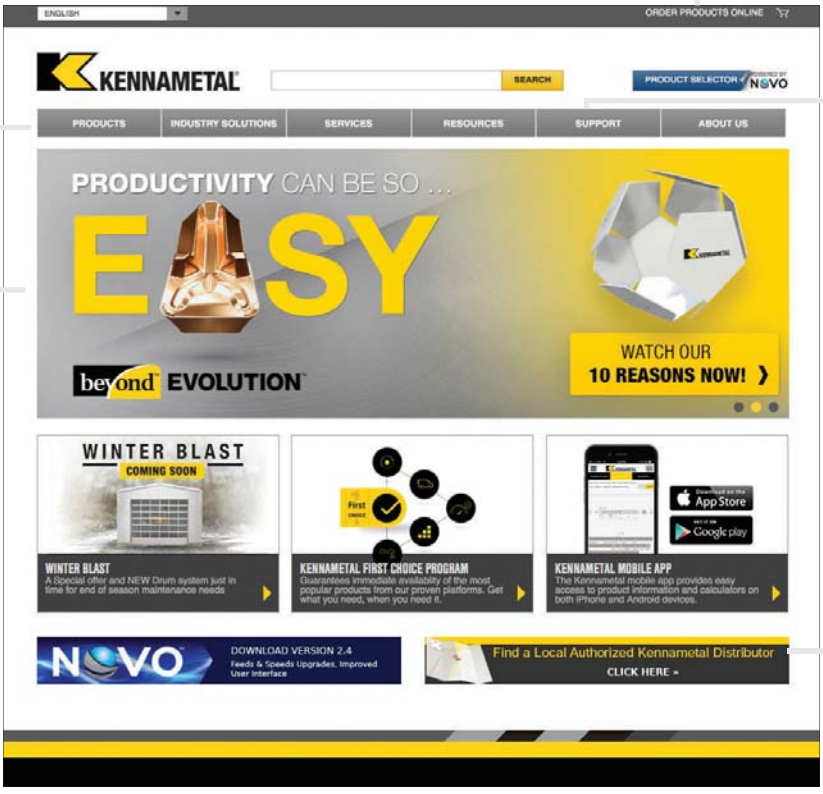

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Kennametal offers world-class products and services globally. Our distributors know us, and more importantly, they know you. They know better than anyone in the industry how to put the global power of Kennametal to work for you — in your industry,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

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 adapters 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).

Customization

- Intermediate diameters are available between 3/8–1 1/4".
- 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 3/8–1 1/4".
- Necked, corner radii, chamfer, and square-end tips available.
- Integral adapters 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.

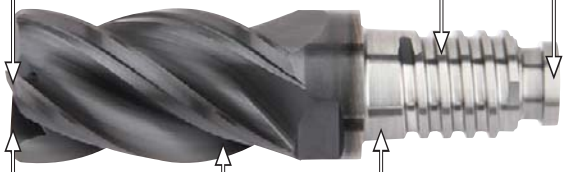
High-performance modular solid carbide end mills.



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 .0002" runout.



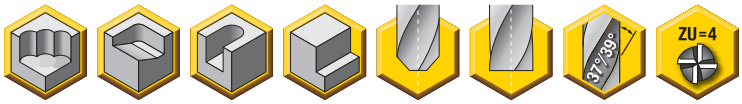
DUO-LOCK® by HAIMER® and Kennametal

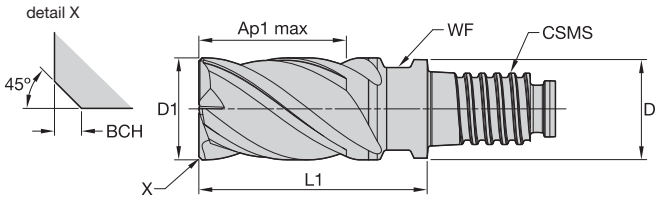
Unequal Flute Spacing
Reduces vibrations. Improves surface finish.

Double Cone
Eliminates expensive presetting processes by providing an axial .0004" repeatability.

37°/ 39° Variable Helix Technology
Minimizes chatter and harmonics for smoother machining.

- Asymmetrical flute spacing and variable helix configuration minimize chatter and harmonics for smoother machining.
- Center cutting.
- Single tool for both roughing and finishing, reducing setups.
- Standard items listed. Additional styles and coatings made-to-order.



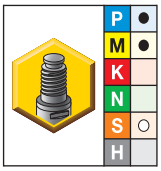




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"
> 1-3/16"	-0,00197"/-0,00350"

UKDV • 4 Flute • Inch

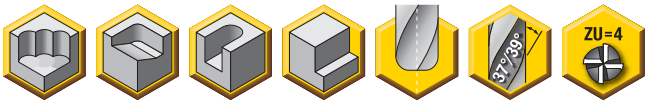


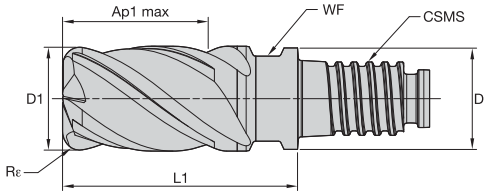
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	BCH
UKDV0375Y4CU	3/8	.359	9/16	.843	DL10	.315	—
UKDV0375Y4CV	3/8	.359	9/16	.843	DL10	.315	.020
UKDV0500Y4CU	1/2	.480	3/4	1.126	DL12	.374	—
UKDV0500Y4CV	1/2	.480	3/4	1.126	DL12	.374	.020
UKDV0625Y4CU	5/8	.605	15/16	1.406	DL16	.512	—
UKDV0625Y4CV	5/8	.605	15/16	1.406	DL16	.512	.020
UKDV0750Y4CU	3/4	.730	1 1/8	1.689	DL20	.630	—
UKDV0750Y4CV	3/4	.730	1 1/8	1.689	DL20	.630	.020
UKDV1000Y4CU	1	.961	1 1/2	2.252	DL25	.827	—
UKDV1000Y4CV	1	.961	1 1/2	2.264	DL25	.827	.020
UKDV1250Y4CU	1 1/4	1.211	1 7/8	2.803	DL32	1.102	—
UKDV1250Y4CV	1 1/4	1.211	1 7/8	2.803	DL32	1.102	.020

NOTE: For application data, please see page O10.

- Asymmetrical flute spacing and variable helix configuration minimize chatter and harmonics for smoother machining.
- Center cutting.
- Single tool for both roughing and finishing, reducing setups.
- Standard items listed. Additional styles and coatings made-to-order.



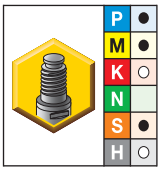




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"
> 1-3/16"	-0,00197"/-0,00350"

ULDV • 4 Flute • Inch



● first choice
○ alternate choice

KCSM15	D1	D	Ap1 max	L1	CSMS system size	WF	Rε
ULDV0375Y4CQA	3/8	.359	9/16	.843	DL10	.315	.015
ULDV0375Y4CQB	3/8	.359	9/16	.843	DL10	.315	.030
ULDV0375Y4CQC	3/8	.359	9/16	.843	DL10	.315	.060
ULDV0375Y4CQD	3/8	.359	9/16	.843	DL10	.315	.090
ULDV0500Y4CQA	1/2	.480	3/4	1.126	DL12	.374	.015
ULDV0500Y4CQB	1/2	.480	3/4	1.126	DL12	.374	.030
ULDV0500Y4CQC	1/2	.480	3/4	1.126	DL12	.374	.060
ULDV0500Y4CQD	1/2	.480	3/4	1.126	DL12	.374	.090
ULDV0500Y4CQE	1/2	.480	3/4	1.126	DL12	.374	.120
ULDV0625Y4CQA	5/8	.605	15/16	1.406	DL16	.512	.015
ULDV0625Y4CQB	5/8	.605	15/16	1.406	DL16	.512	.030
ULDV0625Y4CQD	5/8	.605	15/16	1.406	DL16	.512	.120
ULDV0625Y4CQE	5/8	.605	15/16	1.406	DL16	.512	.120
ULDV0625Y4CQC	5/8	.605	15/16	1.406	DL16	.512	.060
ULDV0750Y4CQB	3/4	.730	1 1/8	1.689	DL20	.630	.030
ULDV0750Y4CQC	3/4	.730	1 1/8	1.689	DL20	.630	.060
ULDV0750Y4CQD	3/4	.730	1 1/8	1.689	DL20	.630	.090
ULDV0750Y4CQE	3/4	.730	1 1/8	1.689	DL20	.630	.120
ULDV1000Y4CQB	1	.961	1 1/2	2.252	DL25	.827	.030
ULDV1000Y4CQC	1	.961	1 1/2	2.252	DL25	.827	.060
ULDV1000Y4CQD	1	.961	1 1/2	2.252	DL25	.827	.090
ULDV1000Y4CQE	1	.961	1 1/2	2.252	DL25	.827	.120
ULDV1000Y4CQF	1	.961	1 1/2	2.252	DL25	.827	.250
ULDV1250Y4CQD	1 1/4	1.211	1 7/8	2.803	DL32	1.102	.090
ULDV1250Y4CQF	1 1/4	1.211	1 7/8	2.803	DL32	1.102	.250

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 (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.						
		A		B	adapter reach									D1 — Diameter						
					KCPM15			KCPM15			KCPM15									
					Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1	1 1/4
		ap	ae	ap	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.0000	1.2500
P	0	1.5 x D	0.5 x D	1 x D	490	–	660	441	–	594	441	–	594	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	1	1.5 x D	0.5 x D	1 x D	490	–	660	441	–	594	441	–	594	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	2	1.5 x D	0.5 x D	1 x D	460	–	620	414	–	558	414	–	558	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	3	1.5 x D	0.5 x D	1 x D	390	–	520	351	–	468	351	–	468	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	4	1.5 x D	0.4 x D	0.75 x D	300	–	490	270	–	441	270	–	441	IPT	.0017	.0022	.0026	.0029	.0034	.0034
	5	1.5 x D	0.4 x D	1 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0016	.0020	.0023	.0026	.0033	.0033
	6	1.5 x D	0.4 x D	0.75 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0013	.0016	.0019	.0021	.0024	.0024
M	1	1.5 x D	0.4 x D	1 x D	300	–	380	240	–	304	210	–	266	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	2	1.5 x D	0.4 x D	1 x D	200	–	260	160	–	208	140	–	182	IPT	.0016	.0020	.0023	.0026	.0033	.0033
	3	1.5 x D	0.4 x D	1 x D	200	–	230	160	–	184	140	–	161	IPT	.0013	.0016	.0019	.0021	.0024	.0024
S	1	1.5 x D	0.3 x D	0.3 x D	160	–	300	128	–	240	96	–	180	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	2	1.5 x D	0.3 x D	0.3 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	3	1.5 x D	0.3 x D	0.3 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	4	1.5 x D	0.4 x D	1 x D	160	–	200	128	–	160	96	–	120	IPT	.0014	.0018	.0021	.0024	.0030	.0030

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

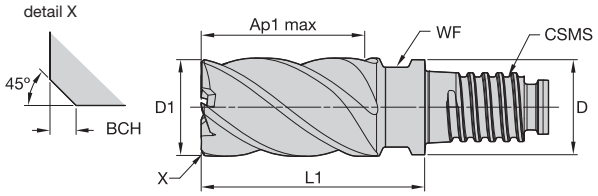


Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.						
		A		B	adapter reach									D1 — Diameter						
					KCSM15			KCSM15			KCSM15									
					Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1	1 1/4
		ap	ae	ap	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.2500	1.2500
P	0	1.5 x D	0.5 x D	1 x D	490	–	660	441	–	594	441	–	594	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	1	1.5 x D	0.5 x D	1 x D	490	–	660	441	–	594	441	–	594	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	2	1.5 x D	0.5 x D	1 x D	460	–	620	414	–	558	414	–	558	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	3	1.5 x D	0.5 x D	1 x D	390	–	520	351	–	468	351	–	468	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	4	1.5 x D	0.4 x D	0.75 x D	300	–	490	270	–	441	270	–	441	IPT	.0017	.0022	.0026	.0029	.0034	.0034
	5	1.5 x D	0.4 x D	1 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0016	.0020	.0023	.0026	.0033	.0033
	6	1.5 x D	0.4 x D	0.75 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0013	.0016	.0019	.0021	.0024	.0024
M	1	1.5 x D	0.4 x D	1 x D	300	–	380	240	–	304	210	–	266	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	2	1.5 x D	0.4 x D	1 x D	200	–	260	160	–	208	140	–	182	IPT	.0016	.0020	.0023	.0026	.0033	.0033
	3	1.5 x D	0.4 x D	1 x D	200	–	230	160	–	184	140	–	161	IPT	.0013	.0016	.0019	.0021	.0024	.0024
K	1	1.5 x D	0.5 x D	1 x D	390	–	490	351	–	441	351	–	441	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	2	1.5 x D	0.5 x D	1 x D	360	–	460	324	–	414	324	–	414	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	3	1.5 x D	0.5 x D	1 x D	360	–	430	324	–	387	324	–	387	IPT	.0016	.0020	.0023	.0026	.0033	.0033
S	1	1.5 x D	0.3 x D	0.3 x D	160	–	300	128	–	240	96	–	180	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	2	1.5 x D	0.3 x D	0.3 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	3	1.5 x D	0.3 x D	0.3 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	4	1.5 x D	0.4 x D	1 x D	160	–	200	128	–	160	96	–	120	IPT	.0014	.0018	.0021	.0024	.0030	.0030
H	1	1.5 x D	0.4 x D	0.75 x D	260	–	460	208	–	368	156	–	276	IPT	.0017	.0022	.0026	.0029	.0034	.0034
	2	1.5 x D	0.2 x D	0.5 x D	230	–	390	184	–	312	138	–	234	IPT	.0013	.0016	.0019	.0021	.0024	.0024

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.

- Unequal flute spacing and variable helix configuration minimize chatter and harmonics for smoother machining.
- Non-center 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.



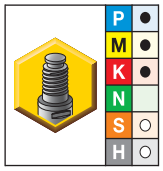




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"
> 1–3/16"	-0,00197"/-0,00350"

UCDV • 5 Flute • Inch

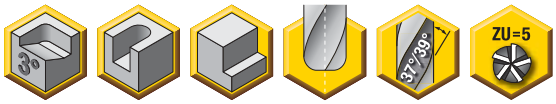


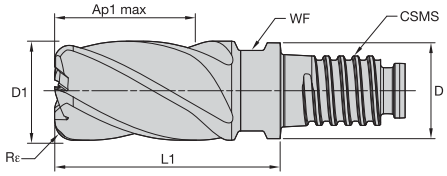
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	BCH
UCDV0375Y5CU	3/8	.359	9/16	.843	DL10	.315	—
UCDV0375Y5CV	3/8	.359	9/16	.843	DL10	.315	.020
UCDV0500Y5CU	1/2	.480	3/4	1.126	DL12	.374	—
UCDV0500Y5CV	1/2	.480	3/4	1.126	DL12	.374	.020
UCDV0625Y5CU	5/8	.605	15/16	1.406	DL16	.512	—
UCDV0625Y5CV	5/8	.605	15/16	1.406	DL16	.512	.020
UCDV0750Y5CU	3/4	.730	1 1/8	1.689	DL20	.630	—
UCDV0750Y5CV	3/4	.730	1 1/8	1.689	DL20	.630	.020
UCDV1000Y5CU	1	.961	1 1/2	2.252	DL25	.827	—
UCDV1000Y5CV	1	.961	1 1/2	2.252	DL25	.827	.020
UCDV1250Y5CU	1 1/4	1.211	1 7/8	2.803	DL32	1.102	—
UCDV1250Y5CV	1 1/4	1.211	1 7/8	2.803	DL32	1.102	.020

NOTE: For application data, please see page O14.

- Unequal flute spacing and variable helix configuration minimize chatter and harmonics for smoother machining.
- Non-center 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.



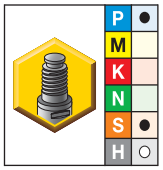




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"
> 1–3/16"	-0,00197"/-0,00350"

UDDV • 5 Flute • Inch



● first choice
○ alternate choice

KC643M	D1	D	Ap1 max	L1	CSMS system size	WF	Rε
UDDV0375Y5CQA	3/8	.359	9/16	.843	DL10	.315	.015
UDDV0375Y5CQB	3/8	.359	9/16	.843	DL10	.315	.030
UDDV0375Y5CQC	3/8	.359	9/16	.843	DL10	.315	.060
UDDV0375Y5CQD	3/8	.359	9/16	.843	DL10	.315	.090
UDDV0500Y5CQA	1/2	.480	3/4	1.126	DL12	.374	.015
UDDV0500Y5CQB	1/2	.480	3/4	1.126	DL12	.374	.030
UDDV0500Y5CQC	1/2	.480	3/4	1.126	DL12	.374	.060
UDDV0500Y5CQD	1/2	.480	3/4	1.126	DL12	.374	.090
UDDV0500Y5CQE	1/2	.480	3/4	1.126	DL12	.374	.120
UDDV0625Y5CQA	5/8	.605	15/16	1.406	DL16	.512	.015
UDDV0625Y5CQB	5/8	.605	15/16	1.406	DL16	.512	.030
UDDV0625Y5CQC	5/8	.605	15/16	1.406	DL16	.512	.060
UDDV0625Y5CQD	5/8	.605	15/16	1.406	DL16	.512	.090
UDDV0625Y5CQE	5/8	.605	15/16	1.406	DL16	.512	.120
UDDV0750Y5CQB	3/4	.730	1 1/8	1.689	DL20	.630	.030
UDDV0750Y5CQC	3/4	.730	1 1/8	1.689	DL20	.630	.060
UDDV0750Y5CQD	3/4	.730	1 1/8	1.689	DL20	.630	.090
UDDV0750Y5CQE	3/4	.730	1 1/8	1.689	DL20	.630	.120
UDDV1000Y5CQB	1	.961	1 1/2	2.252	DL25	.827	.030
UDDV1000Y5CQC	1	.961	1 1/2	2.252	DL25	.827	.060
UDDV1000Y5CQD	1	.961	1 1/2	2.252	DL25	.827	.090
UDDV1000Y5CQE	1	.961	1 1/2	2.252	DL25	.827	.120
UDDV1000Y5CQF	1	.961	1 1/2	2.252	DL25	.827	.250
UDDV1250Y5CQD	1 1/4	1.211	1 7/8	2.803	DL32	1.102	.090
UDDV1250Y5CQF	1 1/4	1.211	1 7/8	2.803	DL32	1.102	.250

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 (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.						
		A		B	adapter reach									D1 — Diameter						
					KCPM15			KCPM15			KCPM15									
					Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1	1 1/4
		ap	ae	ap	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.2500	1.2500
P	0	1.5 x D	0.5 x D	1 x D	490	–	660	441	–	594	441	–	594	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	1	1.5 x D	0.5 x D	1 x D	490	–	660	441	–	594	441	–	594	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	2	1.5 x D	0.5 x D	1 x D	460	–	620	414	–	558	414	–	558	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	3	1.5 x D	0.5 x D	1 x D	390	–	520	351	–	468	351	–	468	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	4	1.5 x D	0.4 x D	0.75 x D	300	–	490	270	–	441	270	–	441	IPT	.0017	.0022	.0026	.0029	.0034	.0034
	5	1.5 x D	0.4 x D	1 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0016	.0020	.0023	.0026	.0033	.0033
	6	1.5 x D	0.4 x D	0.75 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0013	.0016	.0019	.0021	.0024	.0024
M	1	1.5 x D	0.4 x D	1 x D	300	–	380	240	–	304	210	–	266	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	2	1.5 x D	0.4 x D	1 x D	200	–	260	160	–	208	140	–	182	IPT	.0016	.0020	.0023	.0026	.0033	.0033
	3	1.5 x D	0.4 x D	1 x D	200	–	230	160	–	184	140	–	161	IPT	.0013	.0016	.0019	.0021	.0024	.0024
K	1	1.5 x D	0.5 x D	1 x D	390	–	490	351	–	441	351	–	441	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	2	1.5 x D	0.5 x D	1 x D	360	–	460	324	–	414	324	–	414	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	3	1.5 x D	0.5 x D	1 x D	360	–	430	324	–	387	324	–	387	IPT	.0016	.0020	.0023	.0026	.0033	.0033
S	1	1.5 x D	0.3 x D	0.3 x D	160	–	300	128	–	240	96	–	180	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	2	1.5 x D	0.3 x D	0.3 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	3	1.5 x D	0.3 x D	0.3 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	4	1.5 x D	0.4 x D	1 x D	160	–	200	128	–	160	96	–	120	IPT	.0014	.0018	.0021	.0024	.0030	.0030
H	1	1.5 x D	0.4 x D	0.75 x D	260	–	460	208	–	368	156	–	276	IPT	.0017	.0022	.0026	.0029	.0034	.0034
	2	1.5 x D	0.2 x D	0.5 x D	230	–	390	184	–	312	138	–	234	IPT	.0013	.0016	.0019	.0021	.0024	.0024

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.

HARVI II • UDDV • Unequal Flute Spacing

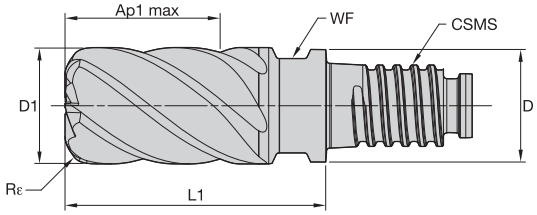


Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.						
		A		B	adapter reach									D1 — Diameter						
					KC643M			KC643M			KC643M									
					Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1	1 1/4
		ap	ae	ap	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.2500	1.2500
P	5	1.5 x D	0.4 x D	1 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0016	.0020	.0023	.0026	.0033	.0033
	6	1.5 x D	0.4 x D	0.75 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0013	.0016	.0019	.0021	.0024	.0024
S	1	1.5 x D	0.3 x D	0.3 x D	160	–	300	128	–	240	96	–	180	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	2	1.5 x D	0.3 x D	0.3 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	3	1.5 x D	0.3 x D	0.3 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	4	1.5 x D	0.4 x D	1 x D	160	–	200	128	–	160	96	–	120	IPT	.0014	.0018	.0021	.0024	.0030	.0030
H	1	1.5 x D	0.4 x D	0.75 x D	260	–	460	208	–	368	156	–	276	IPT	.0017	.0022	.0026	.0029	.0034	.0034
	2	1.5 x D	0.2 x D	0.5 x D	230	–	390	184	–	312	138	–	234	IPT	.0013	.0016	.0019	.0021	.0024	.0024

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.

- Unequal flute spacing and variable helix configuration minimize chatter and harmonics for smoother machining.
- Center cutting.
- Optimized geometry for titanium machining.
- Single tool for both roughing and finishing, reducing setups.
- Standard items listed. Additional styles and coatings made-to-order.



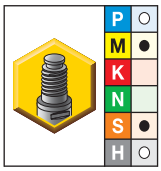




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"
>1–3/16"	-0,00197"/-0,00350"

UJDV • 6 Flute with Eccentric Relief Grind • Inch



● first choice
○ alternate choice

KCSM15	D1	D	Ap1 max	L1	CSMS system size	WF	Rε
UJDV0375Y6CQA	3/8	.359	9/16	.843	DL10	.315	.015
UJDV0375Y6CQB	3/8	.359	9/16	.843	DL10	.315	.030
UJDV0375Y6CQC	3/8	.359	9/16	.843	DL10	.315	.060
UJDV0375Y6CQD	3/8	.359	9/16	.843	DL10	.315	.090
UJDV0500Y6CQA	1/2	.480	3/4	1.126	DL12	.374	.015
UJDV0500Y6CQB	1/2	.480	3/4	1.126	DL12	.374	.030
UJDV0500Y6CQC	1/2	.480	3/4	1.126	DL12	.374	.060
UJDV0500Y6CQD	1/2	.480	3/4	1.126	DL12	.374	.090
UJDV0500Y6CQE	1/2	.480	3/4	1.126	DL12	.374	.120
UJDV0625Y6CQA	5/8	.605	15/16	1.406	DL16	.512	.015
UJDV0625Y6CQB	5/8	.605	15/16	1.406	DL16	.512	.030
UJDV0625Y6CQC	5/8	.605	15/16	1.406	DL16	.512	.060
UJDV0625Y6CQD	5/8	.605	15/16	1.406	DL16	.512	.090
UJDV0625Y6CQE	5/8	.605	15/16	1.406	DL16	.512	.120
UJDV0750Y6CQB	3/4	.730	1 1/8	1.689	DL20	.630	.030
UJDV0750Y6CQC	3/4	.730	1 1/8	1.689	DL20	.630	.060
UJDV0750Y6CQD	3/4	.730	1 1/8	1.689	DL20	.630	.090
UJDV0750Y6CQE	3/4	.730	1 1/8	1.689	DL20	.630	.120
UJDV1000Y6CQB	1	.961	1 1/2	2.252	DL25	.827	.030
UJDV1000Y6CQC	1	.961	1 1/2	2.252	DL25	.827	.090
UJDV1000Y6CQD	1	.961	1 1/2	2.252	DL25	.827	.090
UJDV1000Y6CQE	1	.961	1 1/2	2.252	DL25	.827	.120
UJDV1000Y6CQF	1	.961	1 1/2	2.252	DL25	.827	.030
UJDV1250Y6CQD	1 1/4	1.211	1 7/8	2.803	DL32	1.102	.090
UJDV1250Y6CQF	1 1/4	1.211	1 7/8	2.803	DL32	1.102	.250

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 (IPT = inch/th) for side milling (A).						
		A		adapter reach									D1 — Diameter						
				KCSM15			KCSM15			KCSM15									
				Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1	1 1/4
		ap	ae	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.2500	1.2500
P	4	Ap max	0.4 x D	300	–	490	270	–	441	270	–	441	IPT	.0017	.0022	.0026	.0029	.0034	.0034
	5	Ap max	0.4 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0016	.0020	.0023	.0026	.0033	.0033
M	1	Ap max	0.4 x D	300	–	380	240	–	304	210	–	266	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	2	Ap max	0.4 x D	200	–	260	160	–	208	140	–	182	IPT	.0016	.0020	.0023	.0026	.0033	.0033
	3	Ap max	0.4 x D	200	–	230	160	–	184	140	–	161	IPT	.0013	.0016	.0019	.0021	.0024	.0024
S	1	Ap max	0.4 x D	160	–	300	128	–	240	96	–	180	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	2	Ap max	0.4 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	3	Ap max	0.4 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	4	Ap max	0.4 x D	160	–	200	128	–	160	96	–	120	IPT	.0014	.0018	.0021	.0024	.0030	.0030
H	1	Ap max	0.4 x D	260	–	460	208	–	368	156	–	276	IPT	.0017	.0022	.0026	.0029	.0034	.0034
	2	Ap max	0.4 x D	230	–	390	184	–	312	138	–	234	IPT	.0013	.0016	.0019	.0021	.0024	.0024

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.

HARVI III • UJDV • Unequal Flute Spacing • Finishing

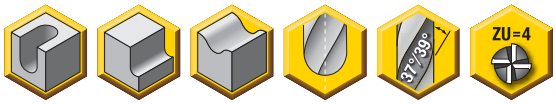


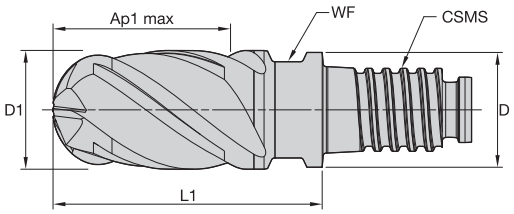


Material Group		Side Milling (A)		short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A).						
		A		adapter reach									D1 — Diameter						
				KCSM15			KCSM15			KCSM15									
				Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1	1 1/4
		ap	ae	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.2500	1.2500
P	4	Ap max	0.06 x D	560	–	940	504	–	846	504	–	846	IPT	.0021	.0026	.0031	.0034	.0041	.0041
	5	Ap max	0.06 x D	370	–	620	314.5	–	527	296	–	496	IPT	.0019	.0024	.0028	.0031	.0040	.0040
M	1	Ap max	0.06 x D	560	–	720	448	–	576	392	–	504	IPT	.0023	.0029	.0035	.0039	.0049	.0049
	2	Ap max	0.06 x D	370	–	500	296	–	400	259	–	350	IPT	.0019	.0024	.0028	.0031	.0040	.0040
	3	Ap max	0.06 x D	370	–	440	296	–	352	259	–	308	IPT	.0016	.0020	.0023	.0025	.0029	.0029
S	1	Ap max	0.06 x D	310	–	560	248	–	448	186	–	336	IPT	.0023	.0029	.0035	.0039	.0049	.0049
	2	Ap max	0.06 x D	160	–	250	128	–	200	96	–	150	IPT	.0012	.0016	.0019	.0021	.0027	.0027
	3	Ap max	0.06 x D	160	–	250	128	–	200	96	–	150	IPT	.0012	.0016	.0019	.0021	.0027	.0027
	4	Ap max	0.06 x D	310	–	370	248	–	296	186	–	222	IPT	.0017	.0022	.0026	.0029	.0036	.0036
H	1	Ap max	0.06 x D	500	–	870	400	–	696	300	–	522	IPT	.0021	.0026	.0031	.0034	.0041	.0041
	2	Ap max	0.06 x D	440	–	750	352	–	600	264	–	450	IPT	.0016	.0020	.0023	.0025	.0029	.0029

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.

- Asymmetrical flute spacing and variable helix configuration minimize chatter and harmonics for smoother machining.
- Center cutting.
- Single tool for both roughing and finishing, reducing setups.
- Standard items listed. Additional styles and coatings made-to-order.



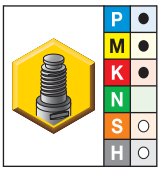




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"

UKBV • 4 Flute Ball Nose • Inch



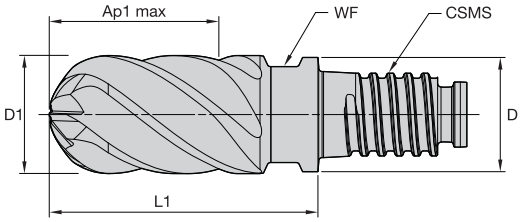
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF
UKBV0375Y4CN	3/8	.359	9/16	.843	DL10	.315
UKBV0500Y4CN	1/2	.480	3/4	1.126	DL12	.374
UKBV0625Y4CN	5/8	.605	15/16	1.406	DL16	.512
UKBV0750Y4CN	3/4	.730	1 1/8	1.689	DL20	.630
UKBV1000Y4CN	1	.961	1 1/2	2.252	DL25	.827

NOTE: For application data, please see page O20.

- Unequal flute spacing and variable helix configuration minimize chatter and harmonics for smoother machining.
- Center cutting.
- Optimized geometry for titanium machining.
- Single tool for both roughing and finishing, reducing setups.
- Standard items listed. Additional styles and coatings made-to-order.



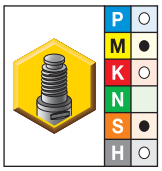




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"

UJBV • 6 Flute Ball Nose with Eccentric Relief Grind • Inch

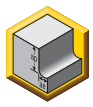


● first choice
○ alternate choice

KCSM15	D1	D	Ap1 max	L1	CSMS system size	WF
UJBV0375Y6CN	3/8	.359	9/16	.843	DL10	.315
UJBV0500Y6CN	1/2	.480	3/4	1.126	DL12	.374
UJBV0625Y6CN	5/8	.605	15/16	1.406	DL16	.512
UJBV0750Y6CN	3/4	.730	1 1/8	1.689	DL20	.630
UJBV1000Y6CN	1	.961	1 1/2	2.252	DL25	.827

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 (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.						
		A		B	adapter reach									D1 — Diameter						
					KCPM15			KCPM15			KCPM15									
					Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1	1 1/4
		ap	ae	ap	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.2500	1.2500
P	0	1.25 x D	0.5 x D	1 x D	490	–	660	441	–	594	441	–	594	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	1	1.25 x D	0.5 x D	1 x D	490	–	660	441	–	594	441	–	594	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	2	1.25 x D	0.5 x D	1 x D	460	–	620	414	–	558	414	–	558	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	3	1.25 x D	0.5 x D	1 x D	390	–	520	351	–	468	351	–	468	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	4	1.25 x D	0.4 x D	0.75 x D	300	–	490	270	–	441	270	–	441	IPT	.0017	.0022	.0026	.0029	.0034	.0034
	5	1.25 x D	0.4 x D	1 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0016	.0020	.0023	.0026	.0033	.0033
	6	1.25 x D	0.4 x D	0.75 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0013	.0016	.0019	.0021	.0024	.0024
M	1	1.25 x D	0.4 x D	1 x D	300	–	380	240	–	304	210	–	266	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	2	1.25 x D	0.4 x D	1 x D	200	–	260	160	–	208	140	–	182	IPT	.0016	.0020	.0023	.0026	.0033	.0033
	3	1.25 x D	0.4 x D	1 x D	200	–	230	160	–	184	140	–	161	IPT	.0013	.0016	.0019	.0021	.0024	.0024
K	1	1.25 x D	0.5 x D	1 x D	390	–	490	351	–	441	351	–	441	IPT	.0023	.0029	.0034	.0037	.0042	.0042
	2	1.25 x D	0.5 x D	1 x D	360	–	460	324	–	414	324	–	414	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	3	1.25 x D	0.5 x D	1 x D	360	–	430	324	–	387	324	–	387	IPT	.0016	.0020	.0023	.0026	.0033	.0033
S	1	1 x D	0.3 x D	0.3 x D	160	–	300	128	–	240	96	–	180	IPT	.0019	.0025	.0029	.0033	.0041	.0041
	2	1 x D	0.3 x D	0.3 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	3	1.25 x D	0.3 x D	0.3 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022	.0022
	4	1.25 x D	0.4 x D	1 x D	160	–	200	128	–	160	96	–	120	IPT	.0014	.0018	.0021	.0024	.0030	.0030
H	1	1.25 x D	0.4 x D	0.75 x D	260	–	460	208	–	368	156	–	276	IPT	.0017	.0022	.0026	.0029	.0034	.0034
	2	1.25 x D	0.2 x D	0.5 x D	230	–	390	184	–	312	138	–	234	IPT	.0013	.0016	.0019	.0021	.0024	.0024

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

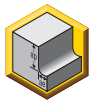




Material Group		Side Milling (A)		short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A).					
		A		adapter reach									D1 — Diameter					
				KCSM15			KCSM15			KCSM15								
				Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1
		ap	ae	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.2500
P	0	Ap max	0.4 x D	490	–	660	441	–	594	441	–	594	IPT	.0023	.0029	.0034	.0037	.0042
	1	Ap max	0.4 x D	490	–	660	441	–	594	441	–	594	IPT	.0023	.0029	.0034	.0037	.0042
	2	Ap max	0.4 x D	460	–	620	414	–	558	414	–	558	IPT	.0023	.0029	.0034	.0037	.0042
	3	Ap max	0.4 x D	390	–	520	351	–	468	351	–	468	IPT	.0019	.0025	.0029	.0033	.0041
	4	Ap max	0.4 x D	300	–	490	270	–	441	270	–	441	IPT	.0017	.0022	.0026	.0029	.0034
	5	Ap max	0.4 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0016	.0020	.0023	.0026	.0033
	6	Ap max	0.4 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0013	.0016	.0019	.0021	.0024
M	1	Ap max	0.4 x D	300	–	380	240	–	304	210	–	266	IPT	.0019	.0025	.0029	.0033	.0041
	2	Ap max	0.4 x D	200	–	260	160	–	208	140	–	182	IPT	.0016	.0020	.0023	.0026	.0033
	3	Ap max	0.4 x D	200	–	230	160	–	184	140	–	161	IPT	.0013	.0016	.0019	.0021	.0024
K	1	Ap max	0.4 x D	390	–	490	351	–	441	351	–	441	IPT	.0023	.0029	.0034	.0037	.0042
	2	Ap max	0.4 x D	360	–	460	324	–	414	324	–	414	IPT	.0019	.0025	.0029	.0033	.0041
	3	Ap max	0.4 x D	360	–	430	324	–	387	324	–	387	IPT	.0016	.0020	.0023	.0026	.0033
S	1	Ap max	0.4 x D	160	–	300	128	–	240	96	–	180	IPT	.0019	.0025	.0029	.0033	.0041
	2	Ap max	0.4 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022
	3	Ap max	0.4 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0022
	4	Ap max	0.4 x D	160	–	200	128	–	160	96	–	120	IPT	.0014	.0018	.0021	.0024	.0030
H	1	Ap max	0.4 x D	260	–	460	208	–	368	156	–	276	IPT	.0017	.0022	.0026	.0029	.0034
	2	Ap max	0.4 x D	230	–	390	184	–	312	138	–	234	IPT	.0013	.0016	.0019	.0021	.0024

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.

HARVI III Ball Nose • UJBV • Unequal Flute Spacing • Finishing





Material Group		Side Milling (A)		short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A).					
		A		adapter reach									D1 — Diameter					
				KCSM15			KCSM15			KCSM15								
				Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1
		ap	ae	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.2500
P	0	Ap max	0.06 x D	940	–	1250	846	–	1125	846	–	1125	IPT	.0028	.0035	.0040	.0045	.0050
	1	Ap max	0.06 x D	940	–	1250	846	–	1125	846	–	1125	IPT	.0028	.0035	.0040	.0045	.0050
	2	Ap max	0.06 x D	870	–	1180	783	–	1062	783	–	1062	IPT	.0028	.0035	.0040	.0045	.0050
	3	Ap max	0.06 x D	750	–	1000	675	–	900	675	–	900	IPT	.0023	.0029	.0035	.0039	.0049
	4	Ap max	0.06 x D	560	–	940	504	–	846	504	–	846	IPT	.0021	.0026	.0031	.0034	.0041
	5	Ap max	0.06 x D	370	–	620	314.5	–	527	296	–	496	IPT	.0019	.0024	.0028	.0031	.0040
	6	Ap max	0.06 x D	310	–	470	263.5	–	399.5	248	–	376	IPT	.0016	.0020	.0023	.0025	.0029
M	1	Ap max	0.06 x D	560	–	720	448	–	576	392	–	504	IPT	.0023	.0029	.0035	.0039	.0049
	2	Ap max	0.06 x D	370	–	500	296	–	400	259	–	350	IPT	.0019	.0024	.0028	.0031	.0040
	3	Ap max	0.06 x D	370	–	440	296	–	352	259	–	308	IPT	.0016	.0020	.0023	.0025	.0029
K	1	Ap max	0.06 x D	750	–	940	675	–	846	675	–	846	IPT	.0028	.0035	.0040	.0045	.0050
	2	Ap max	0.06 x D	690	–	870	621	–	783	621	–	783	IPT	.0023	.0029	.0035	.0039	.0049
	3	Ap max	0.06 x D	690	–	810	621	–	729	621	–	729	IPT	.0019	.0024	.0028	.0031	.0040
S	1	Ap max	0.06 x D	310	–	560	248	–	448	186	–	336	IPT	.0023	.0029	.0035	.0039	.0049
	2	Ap max	0.06 x D	160	–	250	128	–	200	96	–	150	IPT	.0012	.0016	.0019	.0021	.0027
	3	Ap max	0.06 x D	160	–	250	128	–	200	96	–	150	IPT	.0012	.0016	.0019	.0021	.0027
	4	Ap max	0.06 x D	310	–	370	248	–	296	186	–	222	IPT	.0017	.0022	.0026	.0029	.0036
H	1	Ap max	0.06 x D	500	–	870	400	–	696	300	–	522	IPT	.0021	.0026	.0031	.0034	.0041
	2	Ap max	0.06 x D	440	–	750	352	–	600	264	–	450	IPT	.0016	.0020	.0023	.0025	.0029

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 5/8".
- HARVI III UJDV.
- Corner radius R = .015".

CUTTING DATA

- v_c 699 SFM
- f_z .0020 IPT
- a_p .050"
- a_e .472"

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 .630" — cylindrical shank.
- HARVI UKDV.
- Corner radius R = .020".

CUTTING DATA

- v_c 190 SFM
- f_z .0026
- a_p .863"
- a_e .314"

RESULT

- Less wear.
- More stable process.

BENEFIT

- No unpredictable breakage like with competitive solid carbide tool.
- Stable machining process.



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 .630" — cylindrical shank.
- HydroForce™ with reducer sleeve.
- HARVI III UJDV geometry in KCSM15™.
- Corner radius R = .157".

CUTTING DATA

- v_c 1148 SFM
- f_z .0047 IPT
- a_p .020"
- a_e .157"

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 5/8".
- HARVI III UJDV.
- Corner radius R = .015".

CUTTING DATA

- v_c 736 SFM
- f_z .0044 IPT
- a_p .600"
- a_e .030"

RESULT

- 15% increase in cutting speed.
- Good surface finish and minimum wear on edges.

BENEFIT

- Reduced machining time.
- Increased productivity.
- Reduced tooling cost.

CFRP Machining Tooling

KCN05™

Engineered for machining difficult CFRP (Carbon-Fiber 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 minimizes 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 Authorized 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 aluminum 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.

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 aluminum and other non-ferrous materials.

Customization

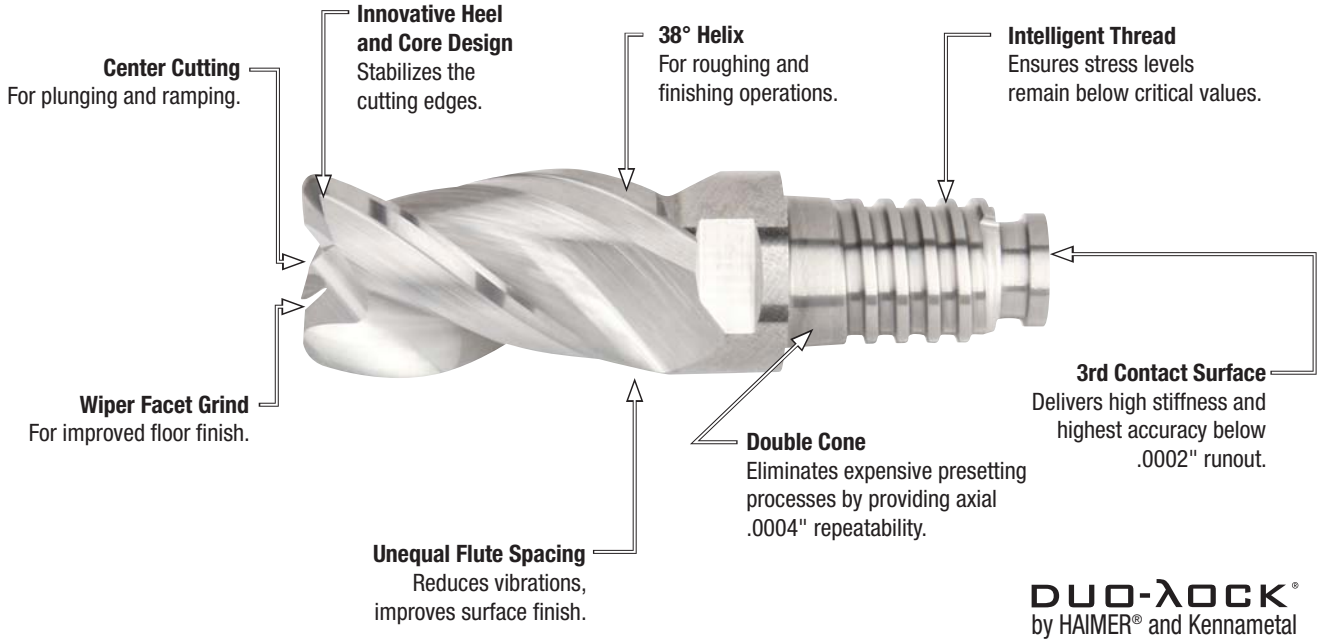
- Intermediate diameters are available between 3/8–1 1/4".

Extensive Standard Offering

- Diameter ranges 3/8–1".
- Necked, corner radii, and square-end tips available.
- Integral adapters 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.

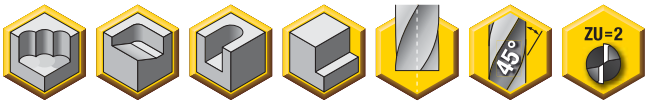
For high metal removal rates and superior surface finishes.

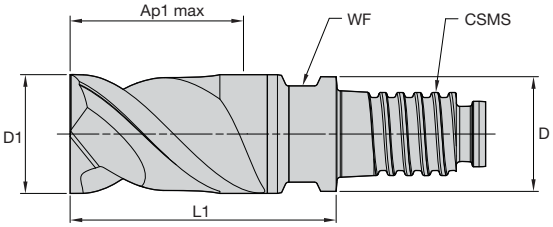




DUO-LOCK®
by HAIMER® and Kennametal

- Center cutting.
- Optimized 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.



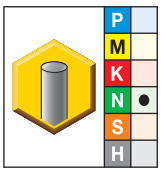




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"

ABDF • 2 Flute • Inch

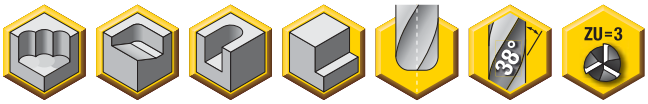


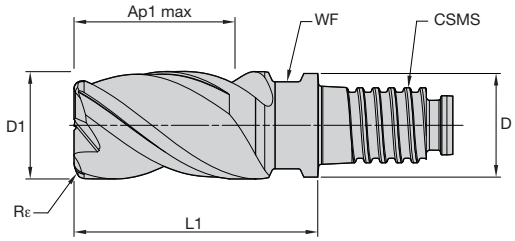
● first choice
○ alternate choice

K600	D1	D	Ap1 max	L1	CSMS system size	WF
ABDF0375Y2CU	3/8	.359	9/16	.843	DL10	.315
ABDF0500Y2CU	1/2	.480	3/4	1.126	DL12	.374
ABDF0625Y2CU	5/8	.605	15/16	1.406	DL16	.512
ABDF0750Y2CU	3/4	.730	1 1/8	1.689	DL20	.630

NOTE: For application data, please see page O30.

- Center cutting.
- Optimized 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.



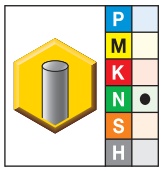




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"

ABDE • 3 Flute • Inch

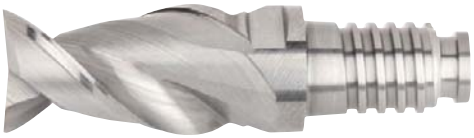


● first choice
○ alternate choice

K600	D1	D	Ap1 max	L1	CSMS system size	WF	Rε
ABDE0375Y3CQA	3/8	.359	9/16	.843	DL10	.315	.015
ABDE0375Y3CQB	3/8	.359	9/16	.843	DL10	.315	.030
ABDE0375Y3CQC	3/8	.359	9/16	.843	DL10	.315	.060
ABDE0375Y3CQD	3/8	.359	9/16	.843	DL10	.315	.090
ABDE0500Y3CQA	1/2	.480	3/4	1.126	DL12	.374	.015
ABDE0500Y3CQB	1/2	.480	3/4	1.126	DL12	.374	.030
ABDE0500Y3CQC	1/2	.480	3/4	1.126	DL12	.374	.060
ABDE0500Y3CQD	1/2	.480	3/4	1.126	DL12	.374	.090
ABDE0500Y3CQE	1/2	.480	3/4	1.126	DL12	.374	.120
ABDE0625Y3CQA	5/8	.605	15/16	1.406	DL16	.512	.015
ABDE0625Y3CQB	5/8	.605	15/16	1.406	DL16	.512	.030
ABDE0625Y3CQC	5/8	.605	15/16	1.406	DL16	.512	.060
ABDE0625Y3CQD	5/8	.605	15/16	1.406	DL16	.512	.090
ABDE0625Y3CQE	5/8	.605	15/16	1.406	DL16	.512	.120
ABDE0750Y3CQB	3/4	.730	1 1/8	1.689	DL20	.630	.030
ABDE0750Y3CQC	3/4	.730	1 1/8	1.689	DL20	.630	.060
ABDE0750Y3CQD	3/4	.730	1 1/8	1.689	DL20	.630	.090
ABDE0750Y3CQE	3/4	.730	1 1/8	1.689	DL20	.630	.120
ABDE1000Y3CQB	1	.961	1 1/2	2.252	DL25	.827	.030
ABDE1000Y3CQC	1	.961	1 1/2	2.252	DL25	.827	.060
ABDE1000Y3CQD	1	.961	1 1/2	2.252	DL25	.827	.090
ABDE1000Y3CQE	1	.961	1 1/2	2.252	DL25	.827	.120
ABDE1000Y3CQF	1	.961	1 1/2	2.252	DL25	.827	.250

NOTE: For application data, please see page O30.

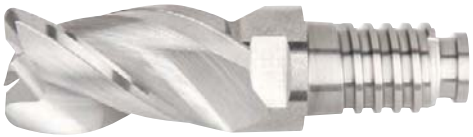
MaxiMet • ABDF • Wiper Facet



Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.				
		A		B	adapter reach									D1 — Diameter				
					K600			K600			K600							
					Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4
		ap	ae	ap	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500
N	1	1.5 x D	0.3 x D	1.0 x D	1640	–	6560	1312	–	3936	984	–	3936	IPT	.0029	.0038	.0048	.0057
	2	1.5 x D	0.3 x D	1.0 x D	1640	–	4920	1312	–	2952	984	–	2952	IPT	.0023	.0031	.0038	.0046
	3	1.5 x D	0.3 x D	1.0 x D	1640	–	4920	1312	–	2952	984	–	2952	IPT	.0020	.0027	.0033	.0040
	4	1.5 x D	0.3 x D	1.0 x D	1310	–	2460	1048	–	1476	786	–	1476	IPT	.0020	.0027	.0033	.0040
	5	1.5 x D	0.3 x D	1.0 x D	820	–	3280	656	–	1968	492	–	1968	IPT	.0026	.0034	.0043	.0052

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 (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.				
		A		B	adapter reach									D1 — Diameter				
					K600			K600			K600							
					Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4
		ap	ae	ap	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500
N	1	1.5 x D	0.3 x D	1.0 x D	1640	–	6560	1312	–	3936	984	–	3936	IPT	.0029	.0038	.0048	.0057
	2	1.5 x D	0.3 x D	1.0 x D	1640	–	4920	1312	–	2952	984	–	2952	IPT	.0023	.0031	.0038	.0046
	3	1.5 x D	0.3 x D	1.0 x D	1640	–	4920	1312	–	2952	984	–	2952	IPT	.0020	.0027	.0033	.0040
	4	1.5 x D	0.3 x D	1.0 x D	1310	–	2460	1048	–	1476	786	–	1476	IPT	.0020	.0027	.0033	.0040
	5	1.5 x D	0.3 x D	1.0 x D	820	–	3280	656	–	1968	492	–	1968	IPT	.0026	.0034	.0043	.0052

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 Authorized Kennametal Distributor.

KENNAMETAL®

kennametal.com

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.
- Center 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.

Customization

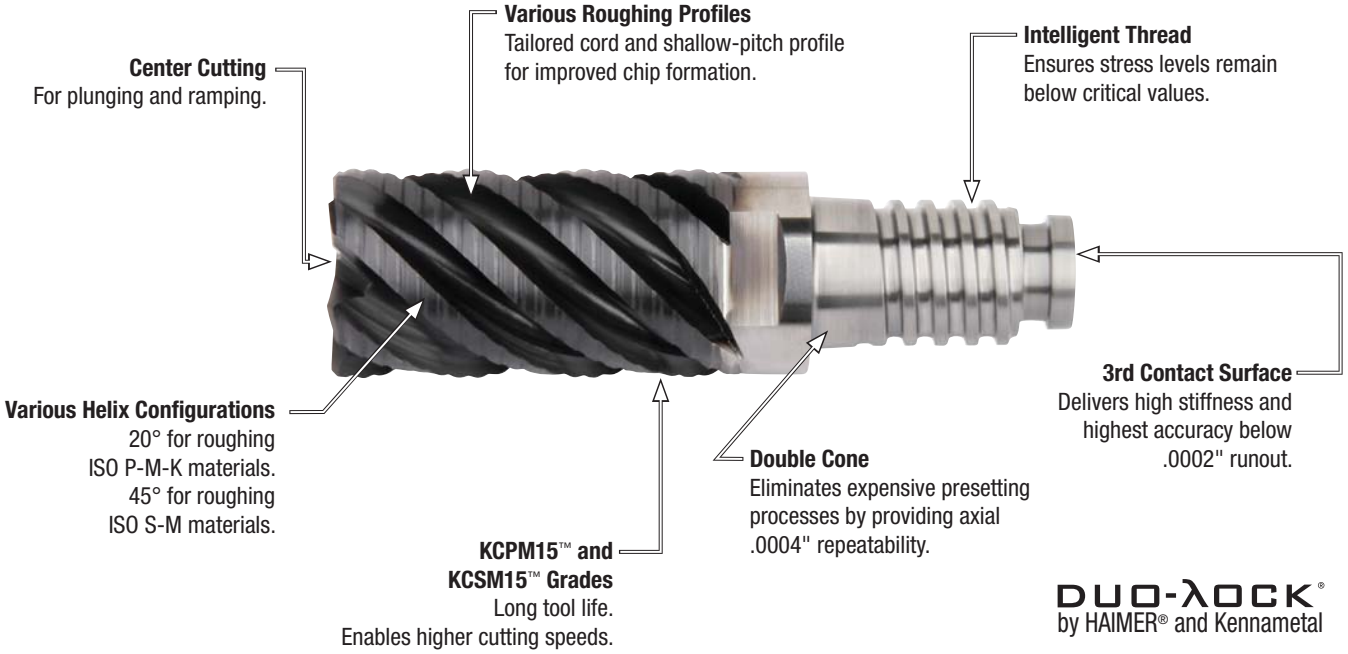
- Intermediate diameters are available between 3/8–1 1/4".

Extensive Standard Offering

- Diameter ranges 3/8–1".
- Necked, corner radii, and chamfered tips offered.
- Integral adapters 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.

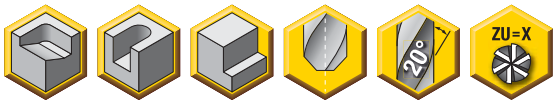
For high metal removal rates and low power consumption.

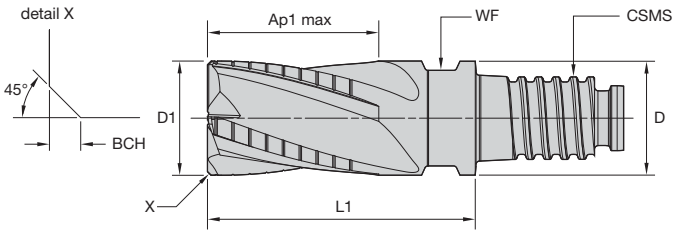




DUO-LOCK®
by HAIMER® and Kennametal

- Center cutting.
- Cord profile reduces machine power consumption.
- Standard items listed. Additional styles and coatings made-to-order.



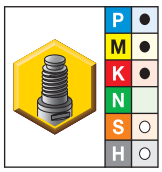




End Mill Tolerances

D1	tolerance d11
13/32–11/16"	-0.002/-0.0063"
23/32–1-3/16"	-0.026/ -0.0077"

RQDB • Inch

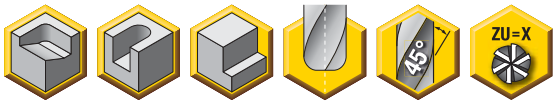


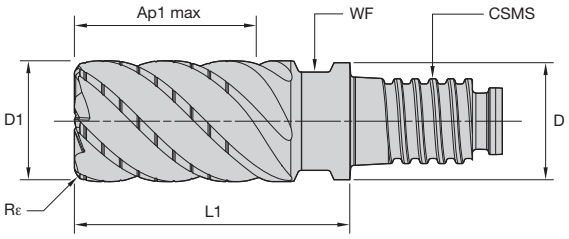
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	BCH	Z U
RQDB0375Y4CV	3/8	.359	9/16	.843	DL10	.315	.020	4
RQDB0500Y4CV	1/2	.480	3/4	1.126	DL12	.374	.020	4
RQDB0625Y4CV	5/8	.605	15/16	1.406	DL16	.512	.020	4
RQDB0750Y4CV	3/4	.730	1 1/8	1.689	DL20	.630	.020	4
RQDB1000Y5CV	1	.961	1 1/2	2.252	DL25	.827	.020	5

NOTE: For application data, please see page O37.

- Center cutting.
- Shallow-pitch profile reduces machine power consumption.
- Standard items listed. Additional styles and coatings made-to-order.



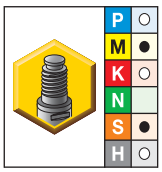




End Mill Tolerances

D1	tolerance d11
13/32–11/16"	-0.002/-0.0063"
23/32–1-3/16"	-0.026/ -0.0077"

RKDF • Inch

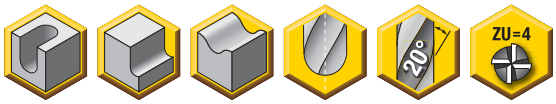


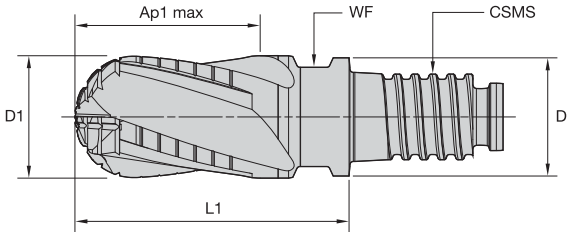
● first choice
○ alternate choice

KCSM15	D1	D	Ap1 max	L1	CSMS system size	WF	Rε	Z U
RKDF0375Y4CQA	3/8	.359	9/16	.843	DL10	.315	.015	4
RKDF0500Y4CQB	1/2	.480	3/4	1.126	DL12	.374	.030	4
RKDF0625Y4CQB	5/8	.605	15/16	1.406	DL16	.512	.030	4
RKDF0750Y6CQB	3/4	.730	1 1/8	1.689	DL20	.630	.030	6
RKDF1000Y6CQB	1	.961	1 1/2	2.252	DL25	.827	.030	6

NOTE: For application data, please see page O38.

- Center cutting.
- Cord profile reduces machine power consumption.
- Standard items listed. Additional styles and coatings made-to-order.



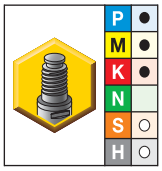




End Mill Tolerances

D1	tolerance d11
13/32–11/16"	-0.002/-0.0063"
23/32–1-3/16"	-0.026/ -0.0077"

RQBB • Inch



● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF
RQBB0375Y4CN	3/8	.359	9/16	.843	DL10	.315
RQBB0500Y4CN	1/2	.480	3/4	1.126	DL12	.374
RQBB0625Y4CN	5/8	.605	15/16	1.406	DL16	.512
RQBB0750Y4CN	3/4	.730	1 1/8	1.689	DL20	.630
RQBB1000Y4CN	1	.961	1 1/2	2.252	DL25	.827

NOTE: For application data, please see page O39.

RQDB • Inch



Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.					
		A		B	adapter reach									D1 — Diameter					
					KCPM15			KCPM15			KCPM15								
					Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.2500
P	0	1.5 x D	0.5 x D	1 x D	390	–	520	351	–	468	351	–	468	IPT	.0020	.0025	.0029	.0032	.0036
	1	1.5 x D	0.5 x D	1 x D	390	–	520	351	–	468	351	–	468	IPT	.0020	.0025	.0029	.0032	.0036
	2	1.5 x D	0.5 x D	1 x D	370	–	500	333	–	450	333	–	450	IPT	.0020	.0025	.0029	.0032	.0036
	3	1.5 x D	0.4 x D	0.75 x D	310	–	420	279	–	378	279	–	378	IPT	.0017	.0021	.0025	.0028	.0035
	4	1.5 x D	0.3 x D	0.3 x D	240	–	390	216	–	351	216	–	351	IPT	.0015	.0019	.0022	.0024	.0029
	5	1.5 x D	0.4 x D	0.75 x D	160	–	260	136	–	221	128	–	208	IPT	.0013	.0017	.0020	.0022	.0028
M	1	1.5 x D	0.4 x D	0.75 x D	240	–	300	192	–	240	168	–	210	IPT	.0017	.0021	.0025	.0028	.0035
	2	1.5 x D	0.4 x D	0.75 x D	160	–	210	128	–	168	112	–	147	IPT	.0013	.0017	.0020	.0022	.0028
	3	1.5 x D	0.4 x D	0.75 x D	160	–	180	128	–	144	112	–	126	IPT	.0011	.0014	.0016	.0018	.0021
K	1	1.5 x D	0.5 x D	1 x D	310	–	390	279	–	351	279	–	351	IPT	.0020	.0025	.0029	.0032	.0036
	2	1.5 x D	0.4 x D	1 x D	290	–	370	261	–	333	261	–	333	IPT	.0017	.0021	.0025	.0028	.0035
	3	1.5 x D	0.4 x D	1 x D	290	–	340	261	–	306	261	–	306	IPT	.0013	.0017	.0020	.0022	.0028
S	1	1.5 x D	0.4 x D	0.75 x D	130	–	240	104	–	192	78	–	144	IPT	.0017	.0021	.0025	.0028	.0035
	3	1.5 x D	0.4 x D	0.75 x D	70	–	100	56	–	80	42	–	60	IPT	.0009	.0011	.0013	.0015	.0019
H	1	1.5 x D	0.3 x D	0.3 x D	210	–	370	168	–	296	126	–	222	IPT	.0015	.0019	.0022	.0024	.0029

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.

RKDF • Inch

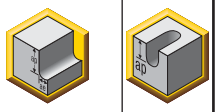




Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.					
		A		B	adapter reach									D1 — Diameter					
					KCSM15			KCSM15			KCSM15								
					Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.000
P	3	1.0 x D	0.5 x D	0.75 x D	390	–	520	351	–	468	351	–	468	IPT	.0019	.0025	.0029	.0033	.0033
	4	1.0 x D	0.3 x D	0.75 x D	300	–	490	270	–	441	270	–	441	IPT	.0017	.0022	.0026	.0029	.0028
	5	1.0 x D	0.4 x D	0.75 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0016	.0020	.0023	.0026	.0026
	6	1.0 x D	0.3 x D	0.3 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0013	.0016	.0019	.0021	.0020
M	1	1.0 x D	0.4 x D	0.75 x D	300	–	380	240	–	304	210	–	266	IPT	.0019	.0025	.0029	.0033	.0033
	2	1.0 x D	0.4 x D	0.75 x D	200	–	260	160	–	208	140	–	182	IPT	.0016	.0020	.0023	.0026	.0026
	3	1.0 x D	0.4 x D	0.75 x D	200	–	230	160	–	184	140	–	161	IPT	.0013	.0016	.0019	.0021	.0020
K	1	1.0 x D	0.5 x D	1 x D	390	–	490	351	–	441	351	–	441	IPT	.0023	.0029	.0034	.0037	.0035
	2	1.0 x D	0.5 x D	1 x D	360	–	460	324	–	414	324	–	414	IPT	.0019	.0025	.0029	.0033	.0033
	3	1.0 x D	0.5 x D	1 x D	360	–	430	324	–	387	324	–	387	IPT	.0016	.0020	.0023	.0026	.0026
S	1	1.0 x D	0.3 x D	0.75 x D	160	–	300	128	–	240	96	–	180	IPT	.0019	.0025	.0029	.0033	.0033
	2	1.0 x D	0.3 x D	0.75 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0018
	3	1.0 x D	0.3 x D	0.75 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0018
	4	1.0 x D	0.4 x D	0.75 x D	160	–	200	128	–	160	96	–	120	IPT	.0014	.0018	.0021	.0024	.0024
H	1	1.0 x D	0.3 x D	0.3 x D	260	–	460	208	–	368	156	–	276	IPT	.0017	.0022	.0026	.0029	.0028
	2	1.0 x D	0.2 x D	0.2 x D	230	–	390	184	–	312	138	–	234	IPT	.0013	.0016	.0019	.0021	.0020
	3	1.0 x D	0.2 x D	0.2 x D	200	–	300	160	–	240	120	–	180	IPT	.0010	.0013	.0015	.0018	.0018

NOTE: Lower value of cuting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cuting 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 • Inch





Material Group		Side Milling (A) and Slotting (B)			short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.					
		A		B	adapter reach									D1 — Diameter					
					KCPM15			KCPM15			KCPM15								
					Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min		max	min		max	min		max	dec.	.3750	.5000	.6250	.7500	1.000
P	0	1.5 x D	0.5 x D	1 x D	490	–	660	441	–	594	441	–	594	IPT	.0023	.0029	.0034	.0037	.0042
	1	1.5 x D	0.5 x D	1 x D	490	–	660	441	–	594	441	–	594	IPT	.0023	.0029	.0034	.0037	.0042
	2	1.5 x D	0.5 x D	1 x D	460	–	620	414	–	558	414	–	558	IPT	.0023	.0029	.0034	.0037	.0042
	3	1.5 x D	0.4 x D	0.75 x D	390	–	520	351	–	468	351	–	468	IPT	.0019	.0025	.0029	.0033	.0038
	4	1.5 x D	0.3 x D	0.3 x D	300	–	490	270	–	441	270	–	441	IPT	.0017	.0022	.0026	.0029	.0033
	5	1.5 x D	0.4 x D	0.75 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0016	.0020	.0023	.0026	.0031
	6	1.5 x D	0.3 x D	0.3 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0013	.0016	.0019	.0021	.0024
M	1	1.5 x D	0.4 x D	0.75 x D	300	–	380	240	–	304	210	–	266	IPT	.0019	.0025	.0029	.0033	.0038
	2	1.5 x D	0.4 x D	0.75 x D	200	–	260	160	–	208	140	–	182	IPT	.0016	.0020	.0023	.0026	.0031
	3	1.5 x D	0.4 x D	0.75 x D	200	–	230	160	–	184	140	–	161	IPT	.0013	.0016	.0019	.0021	.0024
K	1	1.5 x D	0.5 x D	1 x D	390	–	490	351	–	441	351	–	441	IPT	.0023	.0029	.0034	.0037	.0042
	2	1.5 x D	0.4 x D	1 x D	360	–	460	324	–	414	324	–	414	IPT	.0019	.0025	.0029	.0033	.0038
	3	1.5 x D	0.4 x D	1 x D	360	–	430	324	–	387	324	–	387	IPT	.0016	.0020	.0023	.0026	.0031
S	1	1.5 x D	0.4 x D	0.75 x D	160	–	300	128	–	240	96	–	180	IPT	.0019	.0025	.0029	.0033	.0038
	2	1.5 x D	0.3 x D	0.3 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0021
	3	1.5 x D	0.3 x D	0.3 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0013	.0015	.0018	.0021
	4	1.5 x D	0.3 x D	0.75 x D	160	–	200	128	–	160	96	–	120	IPT	.0014	.0018	.0021	.0024	.0028
H	1	1.5 x D	0.3 x D	0.3 x D	260	–	460	208	–	368	156	–	276	IPT	.0017	.0022	.0026	.0029	.0033
	2	1.5 x D	0.2 x D	0.2 x D	230	–	390	184	–	312	138	–	234	IPT	.0013	.0016	.0019	.0021	.0024
	3	1.5 x D	0.2 x D	0.2 x D	200	–	300	160	–	240	120	–	180	IPT	.0010	.0013	.0015	.0018	.0021

NOTE: Lower value of cuting speed is used for high stock removal applications or for higher hardness (machinability) within group.
Higher value of cuting 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.

Customization

- Intermediate diameters are available from 3/8–1".

Extensive Standard Offering

- Diameter ranges 3/8–1 1/4".
- Necked and corner radii tips available.
- Integral adapters 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 .0002" runout.

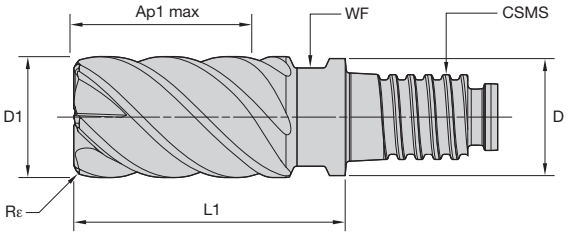
W-Shaped Flute Design with FSDE
Wider flute space for optimized chip evacuation.

KC643M™ Grade
Unmatched fine finishing and tool life.

Double Cone
Eliminates expensive presetting processes by providing axial .0004" repeatability.

- Center cutting.
- Standard items listed. Additional styles and coatings made-to-order.



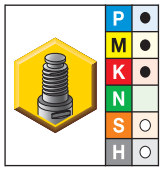




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"

FMDF • Inch



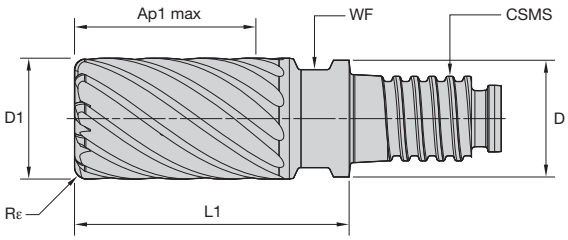
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	Rε
FMDF0375Y6CQA	3/8	.359	9/16	.843	DL10	.315	.015
FMDF0500Y6CQB	1/2	.480	3/4	1.126	DL12	.374	.030
FMDF0625Y6CQB	5/8	.605	15/16	1.406	DL16	.512	.030
FMDF0750Y6CQB	3/4	.730	1 1/8	1.689	DL20	.630	.030
FMDF1000Y6CQB	1	.961	1 1/2	2.252	DL25	.827	.030

NOTE: For application data, please see page O44.

- Non-center cutting.
- Optimized geometry for titanium machining.
- Unequal flute spacing minimizes chatter for smoother machining.
- Standard items listed. Additional styles and coatings made-to-order.



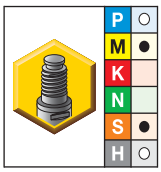




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"

FSDE • Inch



● first choice
○ alternate choice

KC643M	D1	D	Ap1 max	L1	CSMS system size	WF	Rε	Z U
FSDE0375Y9CQA	3/8	.359	9/16	.843	DL10	.315	.015	9
FSDE0375Y9CQB	3/8	.359	9/16	.843	DL10	.315	.030	9
FSDE0375Y9CQC	3/8	.359	9/16	.843	DL10	.315	.060	9
FSDE0375Y9CQD	3/8	.359	9/16	.843	DL10	.315	.090	9
FSDE0500Y9CQA	1/2	.480	3/4	1.126	DL12	.374	.015	9
FSDE0500Y9CQB	1/2	.480	3/4	1.126	DL12	.374	.030	9
FSDE0500Y9CQC	1/2	.480	3/4	1.126	DL12	.374	.060	9
FSDE0500Y9CQD	1/2	.480	3/4	1.126	DL12	.374	.090	9
FSDE0500Y9CQE	1/2	.480	3/4	1.126	DL12	.374	.120	9
FSDE0625Y11CQA	5/8	.605	15/16	1.406	DL16	.512	.015	11
FSDE0625Y11CQB	5/8	.605	15/16	1.406	DL16	.512	.030	11
FSDE0625Y11CQC	5/8	.605	15/16	1.406	DL16	.512	.060	11
FSDE0625Y11CQD	5/8	.605	15/16	1.406	DL16	.512	.090	11
FSDE0625Y11CQE	5/8	.605	15/16	1.406	DL16	.512	.120	11
FSDE0750Y15CQB	3/4	.730	1 1/8	1.689	DL20	.630	.030	15
FSDE0750Y15CQC	3/4	.730	1 1/8	1.689	DL20	.630	.060	15
FSDE0750Y15CQD	3/4	.730	1 1/8	1.689	DL20	.630	.090	15
FSDE0750Y15CQE	3/4	.730	1 1/8	1.689	DL20	.630	.120	15
FSDE1000Y19CQB	1	.961	1 1/2	2.252	DL25	.827	.030	19
FSDE1000Y19CQC	1	.961	1 1/2	2.252	DL25	.827	.060	19
FSDE1000Y19CQD	1	.961	1 1/2	2.252	DL25	.827	.090	19
FSDE1000Y19CQE	1	.961	1 1/2	2.252	DL25	.827	.120	19
FSDE1000Y19CQF	1	.961	1 1/2	2.252	DL25	.827	.250	19

NOTE: For application data, please see page O45.

FMDF • Inch



Material Group		Side Milling (A)		short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A).					
		A		adapter reach									D1 — Diameter					
				KCPM15			KCPM15			KCPM15								
				Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1
		ap	ae	min		max	min		max	min		max	dec.	.375	.500	.625	.750	1.000
P	0	1.5 x D	0.1 x D	490	–	660	441	–	594	441	–	594	IPT	.0027	.0034	.0039	.0044	.0049
	1	1.5 x D	0.1 x D	490	–	660	441	–	594	441	–	594	IPT	.0027	.0034	.0039	.0044	.0049
	2	1.5 x D	0.1 x D	460	–	620	414	–	558	414	–	558	IPT	.0027	.0034	.0039	.0044	.0049
	3	1.5 x D	0.1 x D	390	–	520	351	–	468	351	–	468	IPT	.0023	.0029	.0034	.0039	.0045
	4	1.5 x D	0.1 x D	300	–	490	270	–	441	270	–	441	IPT	.0020	.0026	.0030	.0034	.0039
	5	1.5 x D	0.1 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0018	.0023	.0027	.0031	.0036
	6	1.5 x D	0.1 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0015	.0019	.0022	.0025	.0028
M	1	1.5 x D	0.1 x D	300	–	380	240	–	304	210	–	266	IPT	.0023	.0029	.0034	.0039	.0045
	2	1.5 x D	0.1 x D	200	–	260	160	–	208	140	–	182	IPT	.0018	.0023	.0027	.0031	.0036
	3	1.5 x D	0.1 x D	200	–	230	160	–	184	140	–	161	IPT	.0015	.0019	.0022	.0025	.0028
K	1	1.5 x D	0.1 x D	390	–	490	351	–	441	351	–	441	IPT	.0027	.0034	.0039	.0044	.0049
	2	1.5 x D	0.1 x D	360	–	460	324	–	414	324	–	414	IPT	.0023	.0029	.0034	.0039	.0045
	3	1.5 x D	0.1 x D	360	–	430	324	–	387	324	–	387	IPT	.0018	.0023	.0027	.0031	.0036
S	1	1.5 x D	0.1 x D	160	–	300	128	–	240	96	–	180	IPT	.0023	.0029	.0034	.0039	.0045
	2	1.5 x D	0.1 x D	80	–	130	64	–	104	48	–	78	IPT	.0012	.0015	.0018	.0021	.0024
	3	1.5 x D	0.1 x D	80	–	130	64	–	104	48	–	78	IPT	.0012	.0015	.0018	.0021	.0024
	4	1.5 x D	0.15 x D	160	–	200	128	–	160	96	–	120	IPT	.0017	.0021	.0025	.0028	.0033
H	1	1.5 x D	0.1 x D	260	–	460	208	–	368	156	–	276	IPT	.0020	.0026	.0030	.0034	.0039
	2	1.5 x D	0.1 x D	230	–	390	184	–	312	138	–	234	IPT	.0015	.0019	.0022	.0025	.0028

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.

FSDE • Inch



Material Group		Side Milling (A)		short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A).					
		A		adapter reach									D1 — Diameter					
				KC643M			KC643M			KC643M								
				Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8	3/4	1
		ap	ae	min		max	min		max	min		max	dec.	.375	.500	.625	.750	1.000
P	4	Ap max	0.008–0.012"	445	–	1628	401	–	1465	401	–	1465	IPT	.0045	.0053	.0058	.0061	.0066
	5	Ap max	0.008–0.012"	295	–	1078	251	–	916	236	–	862	IPT	.0040	.0048	.0052	.0056	.0061
M	1	Ap max	0.008–0.012"	445	–	1243	356	–	994	312	–	870	IPT	.0050	.0060	.0066	.0070	.0077
	2	Ap max	0.008–0.012"	295	–	869	236	–	695	207	–	608	IPT	.0040	.0048	.0052	.0056	.0061
	3	Ap max	0.008–0.012"	295	–	759	236	–	607	207	–	531	IPT	.0033	.0040	.0043	.0045	.0048
S	1	Ap max	0.008–0.012"	245	–	979	196	–	783	147	–	587	IPT	.0050	.0060	.0066	.0070	.0077
	2	Ap max	0.008–0.012"	125	–	429	100	–	343	75	–	257	IPT	.0026	.0032	.0035	.0037	.0041
	3	Ap max	0.008–0.012"	125	–	429	100	–	343	75	–	257	IPT	.0026	.0032	.0035	.0037	.0041
	4	Ap max	0.008–0.012"	245	–	649	196	–	519	147	–	389	IPT	.0037	.0044	.0048	.0051	.0056
H	1	Ap max	0.008–0.012"	395	–	1518	316	–	1214	237	–	911	IPT	.0045	.0053	.0058	.0061	.0066
	2	Ap max	0.008–0.012"	345	–	1298	276	–	1038	207	–	779	IPT	.0033	.0040	.0043	.0045	.0048

NOTE: For better surface, finish reduce feed per tooth.
For side milling with Ap bigger 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.

Customization

- Intermediate diameters are available between 3/8–1 1/4".
- Various angles and inverse radii possible.

Extensive Standard Offering

- Diameter ranges 3/8–5/8".
- Integral adapters 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 .0002" runout.

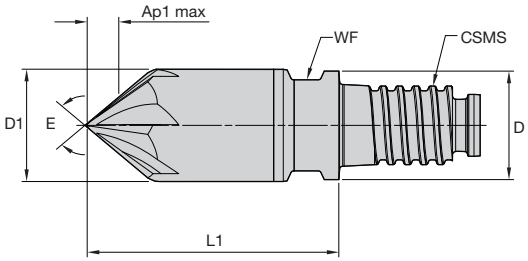
KCPM15™ Grade
Longest tool life.

Double Cone
Eliminates expensive presetting processes by providing axial .0004" repeatability.

DUO-LOCK®
by HAIMER® and Kennametal

- Non-center cutting.
- Standard items listed. Additional styles and coatings made-to-order.



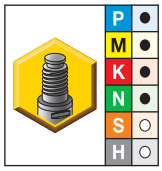




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"

XADA • Inch



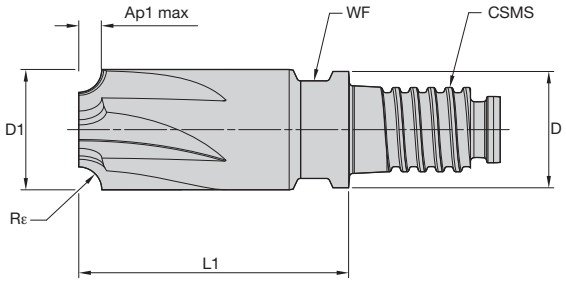
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	E	Z U
XADA0375Y4CU60	3/8	.359	.075	.847	DL10	.315	60	4
XADA0375Y4CU45	3/8	.359	.178	.847	DL10	.315	90	4
XADA0500Y5CU60	1/2	.480	.100	1.126	DL12	.374	60	5
XADA0500Y5CU45	1/2	.480	.100	1.130	DL12	.374	90	5
XADA0625Y6CU45	5/8	.605	.125	1.402	DL16	.512	90	6
XADA0625Y6CU60	5/8	.605	.125	1.406	DL16	.512	60	6

NOTE: For application data, please see page O50.

- Non-center cutting.
- Standard items listed. Additional styles and coatings made-to-order.



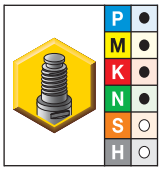




End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"

XRDA • Inch

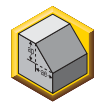


● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	Rε	Z U
XRDA0375Y4CUC	3/8	.359	.060	.843	DL10	.315	.060	4
XRDA0375Y4CUE	3/8	.359	.120	.852	DL10	.315	.120	4
XRDA0500Y5CUB	1/2	.480	.030	1.126	DL12	.374	.030	5
XRDA0500Y5CUC	1/2	.480	.060	1.131	DL12	.374	.060	5
XRDA0500Y5CUE	1/2	.480	.120	1.136	DL12	.374	.120	5
XRDA0625Y6CUC	5/8	.605	.060	1.406	DL16	.512	.060	6
XRDA0625Y6CUE	5/8	.605	.120	1.406	DL16	.512	.120	6

NOTE: For application data, please see page O51.

XADA • Inch





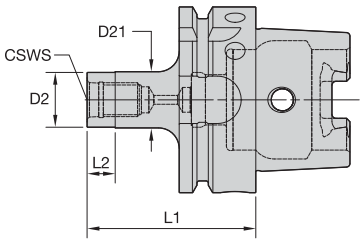
Material Group		Chamfering		short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A).			
		A		adapter reach									D1 — Diameter			
				KCPM15			KCPM15			KCPM15						
				Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8
		ap	ae	min		max	min		max	min		max	dec.	.375	.500	.625
P	0	0.35 x D	0.35 x D	490	–	660	441	–	594	441	–	594	IPT	.0022	.0027	.0032
	1	0.35 x D	0.35 x D	490	–	660	441	–	594	441	–	594	IPT	.0022	.0027	.0032
	2	0.35 x D	0.35 x D	460	–	620	414	–	558	414	–	558	IPT	.0022	.0027	.0032
	3	0.35 x D	0.35 x D	390	–	520	351	–	468	351	–	468	IPT	.0018	.0023	.0027
	4	0.35 x D	0.35 x D	300	–	490	270	–	441	270	–	441	IPT	.0016	.0021	.0024
	5	0.35 x D	0.35 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0015	.0018	.0022
	6	0.35 x D	0.35 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0012	.0015	.0018
M	1	0.35 x D	0.35 x D	300	–	380	240	–	304	210	–	266	IPT	.0018	.0023	.0027
	2	0.35 x D	0.35 x D	200	–	260	160	–	208	140	–	182	IPT	.0015	.0018	.0022
	3	0.35 x D	0.35 x D	200	–	230	160	–	184	140	–	161	IPT	.0012	.0015	.0018
K	1	0.35 x D	0.35 x D	390	–	490	351	–	441	351	–	441	IPT	.0022	.0027	.0032
	2	0.35 x D	0.35 x D	360	–	460	324	–	414	324	–	414	IPT	.0018	.0023	.0027
	3	0.35 x D	0.35 x D	360	–	430	324	–	387	324	–	387	IPT	.0015	.0018	.0022
N	1	0.35 x D	0.35 x D	1640	–	6560	1312	–	5248	984	–	3936	IPT	.0030	.0040	.0050
	2	0.35 x D	0.35 x D	1640	–	4920	1312	–	3936	984	–	2952	IPT	.0024	.0032	.0040
	3	0.35 x D	0.35 x D	1640	–	4920	1312	–	3936	984	–	2952	IPT	.0021	.0028	.0035
	4	0.35 x D	0.35 x D	1310	–	2460	1048	–	1968	786	–	1476	IPT	.0021	.0028	.0035
	5	0.35 x D	0.35 x D	820	–	3280	656	–	2624	492	–	1968	IPT	.0027	.0036	.0045
	6	0.35 x D	0.35 x D	330	–	2460	264	–	1968	198	–	1476	IPT	.0030	.0040	.0050
	7	0.35 x D	0.35 x D	330	–	2460	264	–	1968	198	–	1476	IPT	.0021	.0028	.0035
S	1	0.35 x D	0.35 x D	160	–	300	128	–	240	96	–	180	IPT	.0018	.0023	.0027
	2	0.35 x D	0.35 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0012	.0015
	3	0.35 x D	0.35 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0012	.0015
	4	0.35 x D	0.35 x D	160	–	200	128	–	160	96	–	120	IPT	.0013	.0017	.0020
H	1	0.35 x D	0.35 x D	260	–	460	208	–	368	156	–	276	IPT	.0016	.0021	.0024

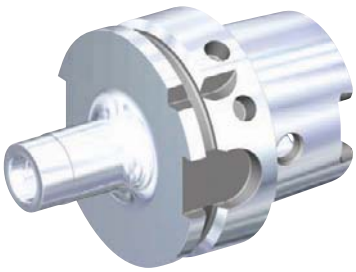
XRDA • Inch



Material Group		Corner Rounding		short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A).			
		A		adapter reach									D1 — Diameter			
				KCPM15			KCPM15			KCPM15						
				Cutting Speed — vc SFM			Cutting Speed — vc SFM			Cutting Speed — vc SFM			frac.	3/8	1/2	5/8
		ap	ae	min		max	min		max	min		max	dec.	.375	.500	.625
P	0	0.35 x D	0.35 x D	490	–	660	441	–	594	441	–	594	IPT	.0022	.0027	.0032
	1	0.35 x D	0.35 x D	490	–	660	441	–	594	441	–	594	IPT	.0022	.0027	.0032
	2	0.35 x D	0.35 x D	460	–	620	414	–	558	414	–	558	IPT	.0022	.0027	.0032
	3	0.35 x D	0.35 x D	390	–	520	351	–	468	351	–	468	IPT	.0018	.0023	.0027
	4	0.35 x D	0.35 x D	300	–	490	270	–	441	270	–	441	IPT	.0016	.0021	.0024
	5	0.35 x D	0.35 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0015	.0018	.0022
	6	0.35 x D	0.35 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0012	.0015	.0018
M	1	0.35 x D	0.35 x D	300	–	380	240	–	304	210	–	266	IPT	.0018	.0023	.0027
	2	0.35 x D	0.35 x D	200	–	260	160	–	208	140	–	182	IPT	.0015	.0018	.0022
	3	0.35 x D	0.35 x D	200	–	230	160	–	184	140	–	161	IPT	.0012	.0015	.0018
K	1	0.35 x D	0.35 x D	390	–	490	351	–	441	351	–	441	IPT	.0022	.0027	.0032
	2	0.35 x D	0.35 x D	360	–	460	324	–	414	324	–	414	IPT	.0018	.0023	.0027
	3	0.35 x D	0.35 x D	360	–	430	324	–	387	324	–	387	IPT	.0015	.0018	.0022
N	1	0.35 x D	0.35 x D	1640	–	6560	1312	–	5248	984	–	3936	IPT	.0030	.0040	.0050
	2	0.35 x D	0.35 x D	1640	–	4920	1312	–	3936	984	–	2952	IPT	.0024	.0032	.0040
	3	0.35 x D	0.35 x D	1640	–	4920	1312	–	3936	984	–	2952	IPT	.0021	.0028	.0035
	4	0.35 x D	0.35 x D	1310	–	2460	1048	–	1968	786	–	1476	IPT	.0021	.0028	.0035
	5	0.35 x D	0.35 x D	820	–	3280	656	–	2624	492	–	1968	IPT	.0027	.0036	.0045
	6	0.35 x D	0.35 x D	330	–	2460	264	–	1968	198	–	1476	IPT	.0030	.0040	.0050
	7	0.35 x D	0.35 x D	330	–	2460	264	–	1968	198	–	1476	IPT	.0021	.0028	.0035
S	1	0.35 x D	0.35 x D	160	–	300	128	–	240	96	–	180	IPT	.0018	.0023	.0027
	2	0.35 x D	0.35 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0012	.0015
	3	0.35 x D	0.35 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0012	.0015
	4	0.35 x D	0.35 x D	160	–	200	128	–	160	96	–	120	IPT	.0013	.0017	.0020
H	1	0.35 x D	0.35 x D	260	–	460	208	–	368	156	–	276	IPT	.0016	.0021	.0024





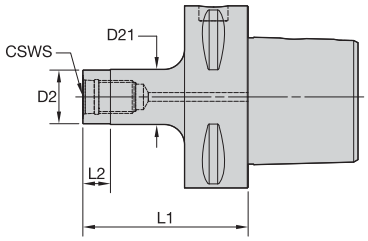


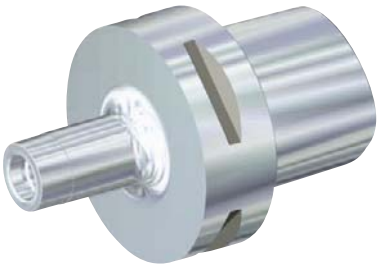
DL HSK Form A Inch

order number	catalog number	CSWS system size	D2	D21	L1	L2	ft. lbs.
6136895	**HSK63ADL10200**	DL10	.36	.38	2.00	.19	18.40
6136896	**HSK63ADL12225**	DL12	.48	.50	2.25	.25	21.10
6136897	**HSK63ADL16225**	DL16	.61	.63	2.25	.31	44.20
6136898	**HSK63ADL20225**	DL20	.73	.75	2.25	.37	59.00
6136899	**HSK63ADL25250**	DL25	.96	1.00	2.50	.49	73.80
6136900	**HSK63ADL32288**	DL32	1.21	1.25	2.88	.61	98.90

PSC63 Duo-Lock™ Integrated



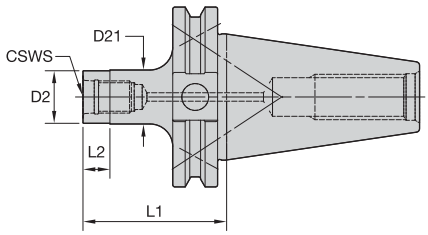




DL PSC63 Inch

order number	catalog number	CSWS system size	D2	D21	L1	L2	lbs
6136931	**PSC63DL10200**	DL10	.36	.37	2.00	.19	1.69
6136932	**PSC63DL12200**	DL12	.48	.50	2.00	.25	1.70
6136933	**PSC63DL16225**	DL16	.61	.63	2.25	.31	1.73
6136934	**PSC63DL20225**	DL20	.73	.75	2.25	.37	1.75
6136935	**PSC63DL25238**	DL25	.96	1.00	2.38	.49	1.84
6136936	**PSC63DL32275**	DL32	1.21	1.25	2.75	.61	2.02





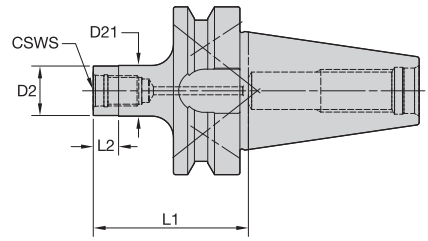


DL CV40 Inch

order number	catalog number	CSWS system size	D2	D21	L1	L2	lbs
6136937	CV40BDL10162	DL10	.36	.38	1.62	.19	1.77
6136938	CV40BDL12162	DL12	.48	.50	1.62	.25	1.78
6136939	CV40BDL16200	DL16	.61	.63	2.00	.31	1.82
6136940	CV40BDL20200	DL20	.73	.75	2.00	.37	1.84
6136941	CV40BDL25225	DL25	.96	1.00	2.25	.49	1.94
6136942	CV40BDL32250	DL32	1.21	1.25	2.50	.61	2.07

BT40 Duo-Lock™ Integrated

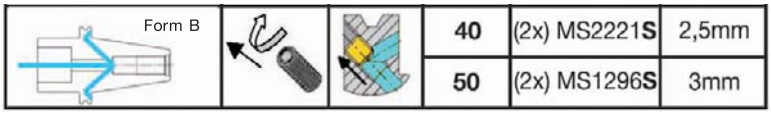




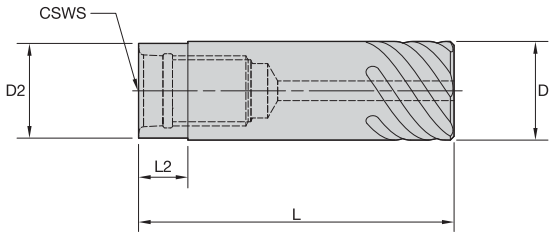


DL BT40 Inch

order number	catalog number	CSWS system size	D2	D21	L1	L2	lbs
6136943	BT40BDL10200	DL10	.36	.38	2.00	.19	2.14
6136944	BT40BDL12200	DL12	.48	.50	2.00	.25	2.15
6136945	BT40BDL16225	DL16	.61	.63	2.25	.31	2.19
6136946	BT40BDL20225	DL20	.73	.75	2.25	.37	2.19
6136947	BT40BDL25238	DL25	.96	1.00	2.38	.49	2.26
6136948	BT40BDL32275	DL32	1.21	1.25	2.75	.61	2.41







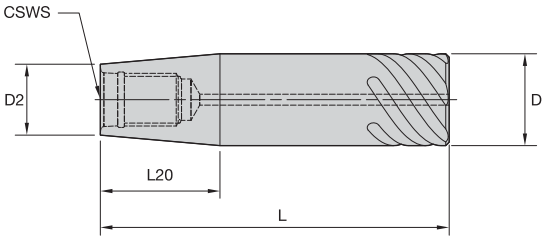


DL SS SL Cylindrical Inch

order number	catalog number	CSWS system size	D	D2	L	L2	ft. lbs.
6136800	SS038SLDL100225	DL10	.38	.36	2.25	.19	18.40
6136868	SS050SLDL120250	DL12	.50	.48	2.50	.25	22.10
6136874	SS062SLDL160275	DL16	.63	.61	2.75	.33	44.20
6136880	SS075SLDL200300	DL20	.75	.73	3.00	.39	59.00
6136884	SS100SLDL250350	DL25	1.00	.96	3.50	.52	73.80
6136888	SS125SLDL320400	DL32	1.25	1.21	4.00	.64	95.90

NOTE: Cylindrical shanks not recommended for full slotting.



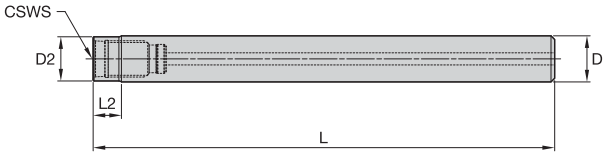




DL SS SL Conical Inch

order number	catalog number	CSWS system size	D	D2	L	L20	lbs
6136862	SS050SLDL100250	DL10	.50	.36	2.50	.80	.11
6136864	SS062SLDL100350	DL10	.63	.36	3.50	1.52	.24
6136866	SS075SLDL100450	DL10	.75	.36	4.50	2.23	.42
6136870	SS062SLDL120325	DL12	.63	.48	3.25	.82	.24
6136872	SS075SLDL120425	DL12	.75	.48	4.25	1.53	.45
6136876	SS075SLDL160325	DL16	.75	.61	3.25	.82	.34
6136878	SS100SLDL160450	DL16	1.00	.61	4.50	2.25	.78
6136882	SS100SLDL200375	DL20	1.00	.73	3.75	1.53	.67
6136886	SS125SLDL250425	DL25	1.25	.96	4.25	1.64	1.19
6136890	SS150SLDL320550	DL32	1.50	1.21	5.50	1.64	2.29
6136892	SS200SLDL320750	DL32	2.00	1.21	7.50	4.50	4.92





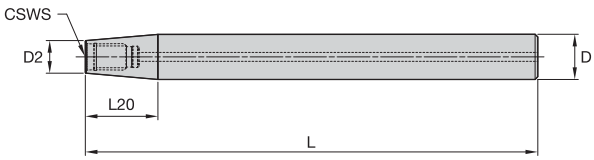


DL SS Cylindrical Cut Off to Modify Length Inch

order number	catalog number	CSWS system size	D	D2	L	L2	ft. lbs.
6136861	SS038DL100375	DL10	.38	.36	3.75	.19	18.40
6136869	SS050DL120500	DL12	.50	.48	5.00	.25	22.10
6136875	SS062DL160625	DL16	.63	.61	6.25	.31	44.20
6136881	SS075DL200750	DL20	.75	.73	7.50	.38	59.00
6136885	SS100DL251000	DL25	1.00	.96	10.00	.50	73.80
6136889	SS125DL321000	DL32	1.25	1.21	10.00	.63	95.90

NOTE: Standard catalog cutting data does not apply. Consult tooling application expert before use.







DL SS Conical Cut Off to Modify Length Inch

order number	catalog number	CSWS system size	D	D2	L	L20	lbs
6136863	SS050DL100500	DL10	.50	.36	5.00	.80	.25
6136865	SS062DL100625	DL10	.63	.36	6.25	1.52	.47
6136867	SS075DL100750	DL10	.75	.36	7.50	2.23	.79
6136871	SS062DL120625	DL12	.63	.48	6.25	.82	.50
6136873	SS075DL120750	DL12	.75	.48	7.50	1.53	.85
6136877	SS075DL160750	DL16	.75	.61	7.50	.82	.86
6136879	SS100DL161000	DL16	1.00	.61	10.00	2.25	1.99
6136883	SS100DL201000	DL20	1.00	.73	10.00	1.53	2.04
6136887	SS125DL251000	DL25	1.25	.96	10.00	1.64	3.14
6136891	SS150DL321000	DL32	1.50	1.21	10.00	1.64	4.51
6136893	SS200DL321000	DL32	2.00	1.21	10.00	4.50	7.18

NOTE: Standard catalog cutting data does not apply. Consult tooling application expert before use.



Torque Wrench

order number	catalog 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

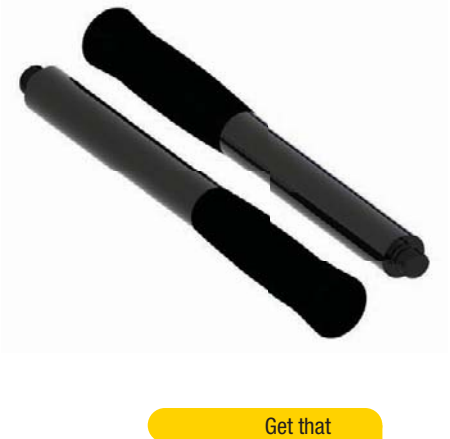
1 Basic Duo-Lock™ Wrench



2 Insert



3 Extension Handle



Order this

Get that

order number	catalog 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™ adapter in a mounting block with a clamping chuck sufficient to enable torque transmission.



3 Screw the Duo-Lock™ cutting tip into adapter by hand.

Attention: Use of protective gloves is mandatory!



4 A gap of approx. 0.06–0.12" 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	Torque ft. lbs.
DL 10	20	15
DL 12	30	22
DL 16	60	44
DL 20	80	59
DL 25	100	74
DL 32	130	96



Solid End Milling •
High-Performance Solid Carbide End Mills

High-Performance Tool Selector and Grades P2–P11

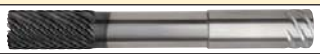
High-Performance Capability End Mills P12–P86

High-Performance Solid Carbide Roughing End Mills P88–P104

High-Performance Solid Carbide Finishing End Mills P106–P112

High-Performance Material Specific End Mills P114–P163

High-Performance Application Specific End Mills P164–P171

beyond	*Beyond™ grade		series	D1 diameter (inch)	length of cut	flute Z	helix	internal coolant
HARVI™ I*			HPHV	1/8–1 1/4	1.8–2 x D1	ZU=4	35°	
HARVI I*			UBDE/UADE	1/4–1	1.25 x D	ZU=4	35°	
HARVI I*			HPRSHV	1/2–1	1–1.2 x D1	ZU=4	35°	
HARVI I*			HPHVBN	1/8–1	1.5–4 x D1	ZU=4	35°	
HARVI I			HPHVT	1/2–1	1.25–1.8 x D1	ZU=4	35°	
CXE			CXE	1/8–1	2 x D	ZU=4	35° VP	
CXER			CXER	1/8–1	2 x D	ZU=4	35° VP	
HARVI II*			UCDE	3/16–1	1.75–3.3 x D1	ZU=5	35°	
HARVI II*			UCDE	1/4–1	1.75–2 x D1	ZU=5	35°	
HARVI II			UDDE	1/2–1	1.75–2.5 x D1	ZU=5	35°	
HARVI II Long			UGDE	1/4–1	3 x D	ZU=5	45°	
HARVI II Long			UGDE	1/4–1	5 x D	ZU=5	45°	
HARVI III			UJDE	3/8–1 1/4	1.75–2 x D	ZU=6	35°	
HARVI III			UJDE	3/8–1	1.75–2.25 x D	ZU=6	35°	
HARVI III Ball Nose			UJBE	3/8–1	1.5–2 x D	ZU=6	35°	
HARVI III Ball Nose			UJBE	3/8–1	1.5 x D1	ZU=6	35°	
HARVI™ III Aerospace Expansion			UJDE	1/2–1.5	1.3–5.3 x D	ZU=6	35°	
HARVI III Aerospace Expansion			UJBE	1/2–1.5	1.3–5.3 x D	ZU=6	35°	
HARVI III Taper Ball Nose			UJBE	1/8–7/16	5–6 x D	ZU=6	35°	
HP Rougher			HPRSS	1/4–3/4	2–3 x D1	ZU=3	35°	
HP Rougher			MDRHEC	1/4–1	1–2.5 x D1	ZU=X	40°	
HP Rougher			HPRST	1/4–1	1.5–2.5 x D1	ZU=X	45°	
RSM II Short			FSDE	3/8–1	2 x D	ZU=X	35°	
RSM II with neck			FSDE	1/4–1	2 x D1	ZU=X	30°	
HP Finisher			HPFSS	1/8–3/4	2–4 x D1	ZU=3	45°	
HP Finisher			HPFSS	1/8–3/8	2–3.25 x D1	ZU=5	45°	
HP Finisher			HPFT	1/8–3/4	2–4 x D1	ZU=6	45°	
Aluminum MaxiMet™			ABDF	3/16–1	2 x D1	ZU=2	45°	
Aluminum MaxiMet			ABDE	3/16–1	1.2–2 x D1	ZU=3	35°	
Aluminum MaxiMet			ABDF	1/4–1	1–4 x D1	ZU=2	45°	
Aluminum MaxiMet			ABDE	1/4–1	1.25–4 x D1	ZU=3	35°	
Aluminum			AADF	1/8–1	1–4 x D1	ZU=2	45°	
Aluminum			AADE	1/8–1	1.25–4 x D1	ZU=3	45°	
Aluminum			SFRHEC	1/4–1	2.25–3 x D1	ZU=3	50°	

							shank	center cutting	neck	P	M	K	N	C	S	H							product page(s)	cutting data page(s)
			✓	✓	✓		✓	✓		●	●	●			○	○	✓	✓	✓	✓		✓	P16–P20	P25
				✓	✓		✓	✓	✓	●	●	●			●	○	✓	✓	✓	✓		✓	P21	P25
			✓	✓			✓	✓		●	●	●					✓	✓	✓				P22	P26
						✓	✓	✓		●	●	●			○	○	✓	✓			✓		P23	P26
			✓	✓			✓	✓		●					●	○	✓	✓	✓	✓		✓	P24	P27
					✓		✓	✓	✓	○	●				○		✓	✓	✓	✓		✓	P84	P86
					✓		✓	✓	✓	○	●				○		✓	✓	✓	✓		✓	P85	P86
			✓		✓		✓			●	●	●			○	○	✓	✓	✓			✓	P30–P31	P34
			✓		✓		✓		✓	●	●	●			●	○	✓	✓	✓			✓	P32	P35
			✓		✓		✓			●					●		✓	✓	✓			✓	P33	P35
			✓		✓		✓			●	●	○			●	○	✓					✓	P38	P40
			✓		✓		✓			●	●	○			●	○	✓					✓	P39	P41
			✓		✓		✓	✓		○	●				●	○	✓		✓			✓	P44–P45	P47
					✓		✓	✓	✓	○	●				●	○	✓		✓			✓	P46	P48
						✓	✓	✓		○	●				●	○	✓				✓	✓	P52	P56
						✓	✓	✓	✓	○	●				●	○	✓				✓	✓	P53	P56
					✓		✓	✓	✓	○	●				●	○	✓		✓			✓	P60–P65	P70
							✓	✓		○	●				●	○	✓				✓	✓	P66–P67	P71
✓							✓	✓		●	●				●	○	✓				✓	✓	P74	P80
					✓		✓	✓		●	●	●				○	✓	✓	✓				P90	P93
				✓			✓	✓		●	●	●			○	○	✓	✓	✓				P91	P94
					✓		✓	✓		○	●	○			●	●	✓	✓	✓				P92	P95
					✓		✓			○	●				●	○	✓						P98	P99
					✓		✓			○	●				●	○	✓						P100	P101
					✓		✓	✓		●	●	●			○		✓	✓	✓			✓	P108	P111
			✓				✓	✓		●	●	○			●	○	✓		✓			✓	P109	P111
			✓				✓	✓		●	●	●			●	○	✓					✓	P110	P112
			✓		✓		✓	✓					●				✓	✓	✓	✓			P116	P122
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			✓		✓		✓	✓	✓				●				✓	✓	✓				P118–P119	P123
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			✓		✓		✓	✓					●				✓	✓	✓	✓			P126–P127	P132
			✓		✓		✓	✓					●				✓	✓	✓				P128–P130	P132
				✓			✓	✓					●				✓	✓	✓				P131	P132

● first choice
○ alternate choice

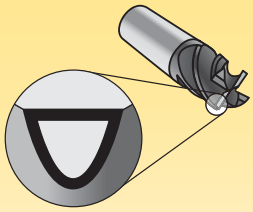
(continued)

(Solid Carbide End Mills — continued)

beyond	*Beyond™ grade		series	D1 diameter (inch)	length of cut	flute Z	helix	internal coolant
CFRP			CCNC	1/4–1/2	3 x D1	ZU=X	45°	
CFRP			CDDC	1/4–1/2	3 x D1	ZU=6	35°	
CFRP			CBDB	1/4–1/2	3 x D1	ZU=12	15°	
KenFeed™			KMDA	1/4–3/4	0.5 x D1	ZU=6	30°	
KenFeed			KHDA	1/4–3/4	0.3 x D1	ZU=6	30°	
Hard Steels			HPFDM	1/4–1	1.5–3.5 x D1	ZU=X	50°	
Hard Steels			HPRDM	3/16–1/2	1 x D1	ZU=X	45°	
Hard Steels Ball Nose			HPBNDM	1/8–3/4	1 x D1	ZU=4	15°	
Ceramic Rougher			EADE	3/16–1/2	0,75 x D	ZU=4	40°	
Ceramic Rougher			EADE	3/16–1/2	0,75 x D	ZU=6	40°	
GOmill™			UEDE	5/64–1/2	1.25 x D1	ZU=3	35°	
GOmill			UEDE	5/32–1/2	1.25 x D1	ZU=4	35°	
GOmill			UEBD	5/64–1/2	1.25 x D1	ZU=2	30°	
GOmill			UEBD	5/64–1/2	1.25 x D1	ZU=3	35°	

							shank	center cutting	neck	P	M	K	N	C	S	H							product page(s)	cutting data page(s)
				✓										●			✓		✓					P136	P139
				✓										●			✓	✓	✓					P137	P139
				✓										●			✓	✓	✓					P138	P139
		✓							✓	●						○			✓		✓			P142	P144
		✓							✓							●			✓		✓			P143	P144
			✓					✓		●						●	✓	✓	✓					P148	P151
					✓			✓	✓	●	○	○			○	●	✓	✓	✓					P149	P151
						✓		✓	✓	●						●	✓	✓			✓			P150	P152
					✓									●			✓	✓	✓					P156	P158
					✓									●			✓	✓	✓					P157	P158
			✓					✓		●	●	●			○	○	✓	✓	✓					P166	P170
				✓				✓		●	●	●			●	○	✓	✓	✓	✓				P167	P170
						✓		✓		●	○	●			○	○	✓	✓						P168	P171
						✓		✓		●	○	●			○	○	✓	✓						P169	P171

● first choice
○ alternate choice



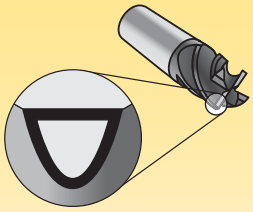
Coatings provide high-speed capability and are engineered for roughing to finishing.

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 optimized 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 characterized by a high hardness and wear resistance. This grade is suitable for cutting hard materials (up to 65HRC).	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 optimized 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 characterized 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

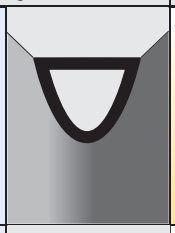
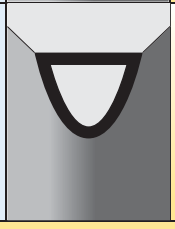
Kennametal is pleased to announce the KCPM15™ and KCSM15™ grades — the first Beyond grades for solid carbide end mills. KCPM15 and KCSM15 grades feature an improved high-performance carbide substrate with proprietary aluminum titanium nitride (AlTiN) PVD coating.

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

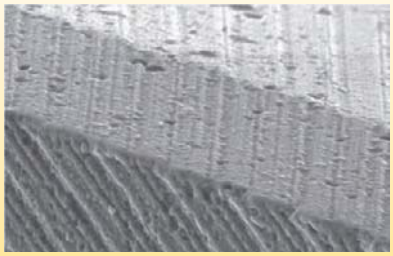
Coating		Grade Description	
KCPM15		Coated carbide grade with thick PVD coating and optimized chemistry and process for increased wear resistance. Outstanding protection in milling stainless steel to mitigate crater, DOCN (depth-of-cut notching), and flank wear. Excellent performance up to 52 HRC.	P M K
KCSM15		Coated carbide grade with thick PVD coating and optimized 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

Conventional End Mill Cutting Edge

Conventional





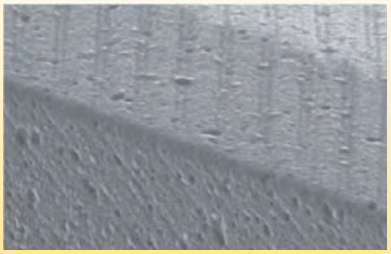


KCPM15™/KCSM15™ End Mill Cutting Edge

KCPM15/KCSM15 grade

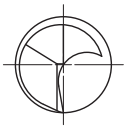
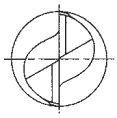
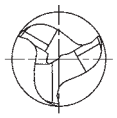
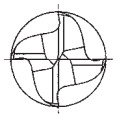
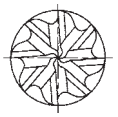
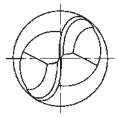
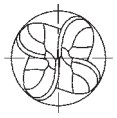
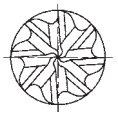






View: 1st and 2nd relief.

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 adapter size (DV40, DV50, HSK63, etc.).
7. See Tool Reference Guides on pages P2–P5.

Recommended Adapters per End Mill Platform

SCEM Platform	Recommended Adapters	
	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® Adapter
RSM II	Shrink Fit	Shrink Fit
High-Performance Finishers	HydroForce	Shrink Fit
MaxiMet™/Aluminum Tools	HydroForce	Shrink Fit
Hard Material End Mills/KenFeed™	HydroForce	Shrink Fit
GOmill™	Shrink Fit	Weldon Adapter

Select Adapter per Technical Data/Characteristics

Technical data/characteristics	Toolholders				
	HydroForce high torque	Shrink Fit	Milling chuck	ER collet chuck	Weldon adapter
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	★★★★★	★★★★★	★★★	★★★	★

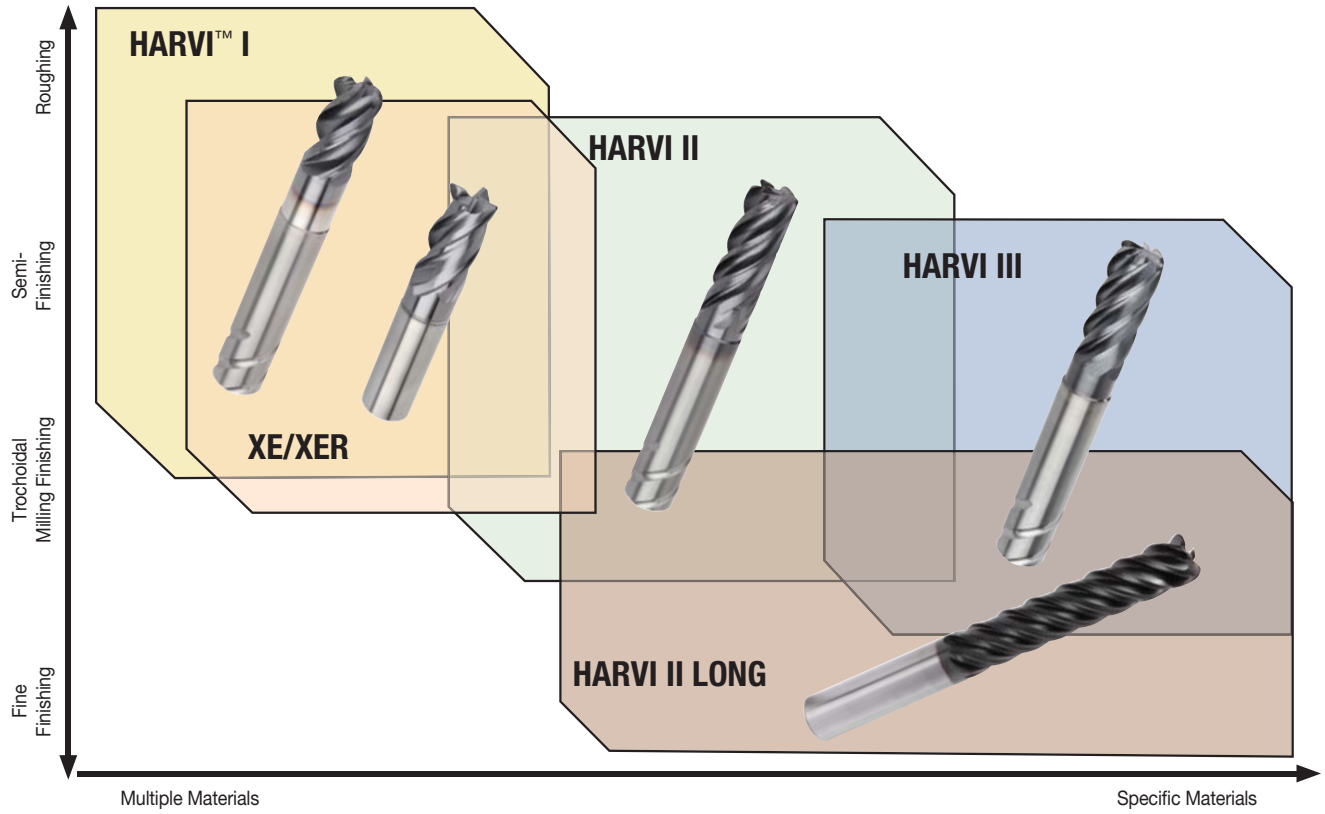
[1] Radial runout may affect tool life.
[2] Radial rigidity for Weldon holder is low at a direction perpendicular to the screw.
[3] Accepts different shank diameters through the use of reduction sleeves or due to collapse range.
[4] Collet chucks and milling chucks may require the use of a torque or special wrench; Shrink Fit adapter 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 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.
- Center 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).

Customization

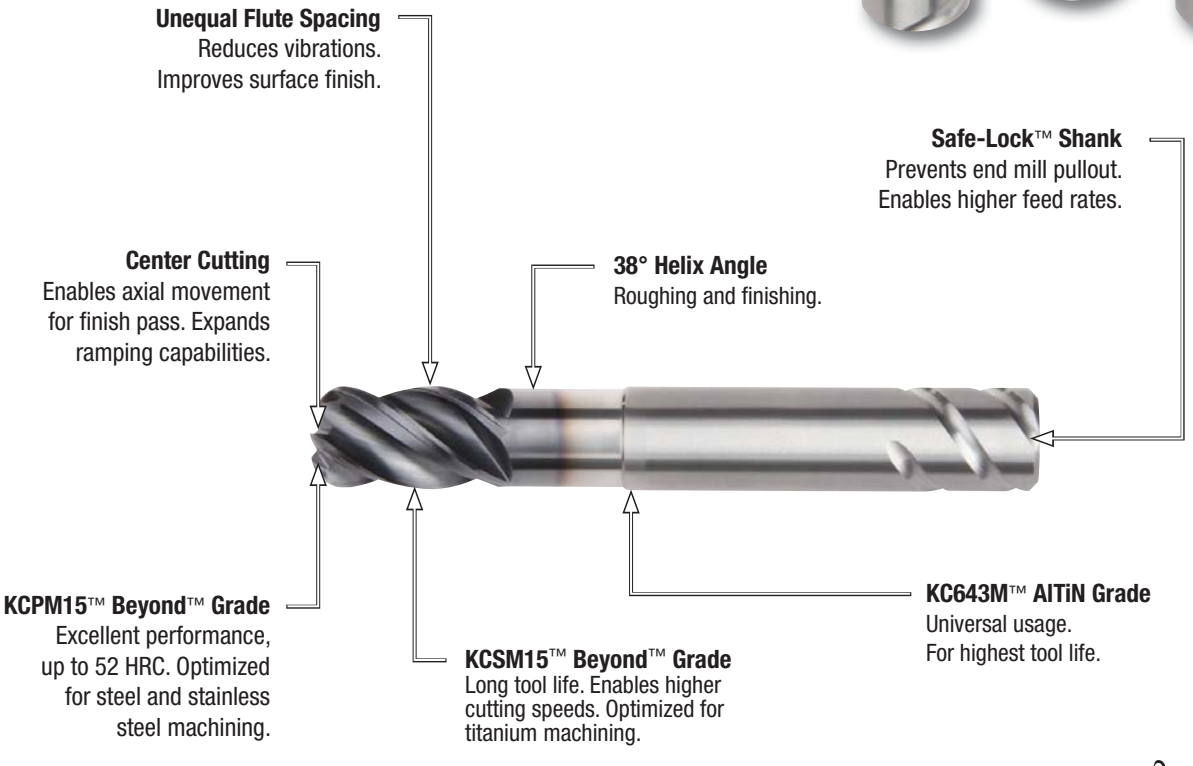
- Intermediate diameters available.
- Expanded length of tool and increased length of cut are possible.
- Chip divider geometry reduces power consumption and improves chip formation in difficult-to-cut materials.
- Internal coolant axial and radial available.
- Various shanks and non-standard coatings available.
- Multiple steps possible.

Extensive Standard Offering

- Diameter range 1/8–1-1/4".
- Necked, corner radii, chamfer, and square-end offering.
- Extended-reach length.
- Ball nose with extended length of cut.

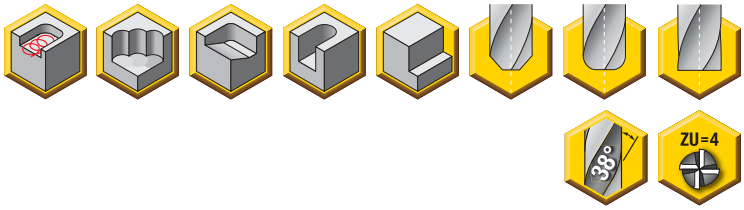
Designed for roughing and finishing with one tool in almost all materials.



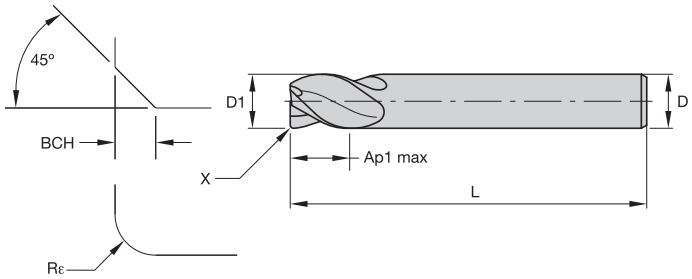


SAFE-λOCK®
by HAIMER®

- Kennametal standard dimensions.
- Center cutting.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.





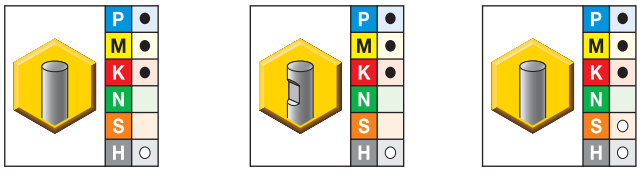


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1-3/16"	0/.00051"

beyond

HPHV • UADE • 4 Flute • Inch

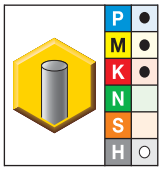


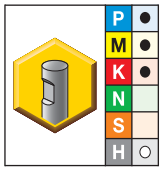
● first choice
○ alternate choice

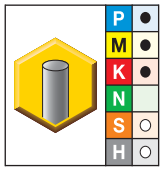
KCPM15	KCPM15	KC643M	D1	D	Ap1 max	L	Rε	BCH
HPHV125S4025CH	–	–	1/8	1/8	1/4	1 1/2	–	.015
HPHV125S4025	–	–	1/8	1/8	1/4	1 1/2	–	–
HPHV125S4025LR015	–	–	1/8	1/8	1/4	2 1/2	.015	–
HPHV125S4050R015	–	–	1/8	1/8	1/2	2	.015	–
HPHV125S4050CH	–	–	1/8	1/8	1/2	2	–	.015
HPHV125S4050	–	–	1/8	1/8	1/2	2	–	–
HPHV125S4050L	–	–	1/8	1/8	1/2	2 1/2	–	–
HPHV188S4031CH	–	–	3/16	3/16	5/16	1 1/2	–	.015
HPHV188S4031	–	–	3/16	3/16	5/16	1 1/2	–	–
HPHV188S4031LR015	–	–	3/16	3/16	5/16	2 1/2	.015	–
HPHV188S4031L	–	–	3/16	3/16	5/16	2 1/2	–	–
HPHV188S4063R015	–	–	3/16	3/16	5/8	2 1/4	.015	–
HPHV188S4063R030	–	–	3/16	3/16	5/8	2 1/4	.030	–
HPHV188S4063CH	–	–	3/16	3/16	5/8	2 1/4	–	.015
HPHV188S4063	–	–	3/16	3/16	5/8	2 1/4	–	–
HPHV188S4063LR015	–	–	3/16	3/16	5/8	2 1/2	.015	–
HPHV188S4063LR030	–	–	3/16	3/16	5/8	2 1/2	.030	–
HPHV188S4063L	–	–	3/16	3/16	5/8	2 1/2	–	–
HPHV250S4038R030	–	–	1/4	1/4	3/8	2	.030	–
HPHV250S4038CH	–	–	1/4	1/4	3/8	2	–	.015
HPHV250S4038	–	–	1/4	1/4	3/8	2	–	–
HPHV250S4038LR015	–	–	1/4	1/4	3/8	2 1/2	.015	–
HPHV250S4050R015	–	–	1/4	1/4	1/2	2 1/2	.015	–
HPHV250S4050R030	–	–	1/4	1/4	1/2	2 1/2	.030	–
HPHV250S4050R060	–	–	1/4	1/4	1/2	2 1/2	.060	–
HPHV250S4050	–	–	1/4	1/4	1/2	2 1/2	–	–
HPHV250S4075R015	–	UADE250J4ARA	1/4	1/4	3/4	2 1/2	.015	–
HPHV250S4075R030	–	–	1/4	1/4	3/4	2 1/2	.030	–

(continued)

(HPHV • UADE • 4 Flute • Inch — continued)





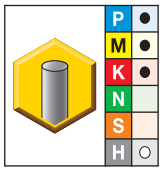


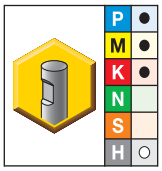
● first choice
○ alternate choice

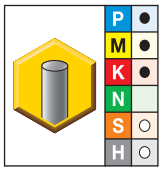
KCPM15	KCPM15	KC643M	D1	D	Ap1 max	L	Rε	BCH
HPHV250S4075R060	–	UADE250J4ARC	1/4	1/4	3/4	2 1/2	.060	–
HPHV250S4075CH	–	–	1/4	1/4	3/4	2 1/2	–	.015
HPHV250S4075	–	–	1/4	1/4	3/4	2 1/2	–	–
HPHV250S4100R015	–	–	1/4	1/4	1	3	.015	–
HPHV250S4100	–	–	1/4	1/4	1	3	–	–
HPHV250S4125R030	–	–	1/4	1/4	1 1/4	3 1/4	.030	–
HPHV250S4125CH	–	–	1/4	1/4	1 1/4	3 1/4	–	.015
HPHV250S4125	–	–	1/4	1/4	1 1/4	3 1/4	–	–
HPHV250S4175R015	–	–	1/4	1/4	1 3/4	4	.015	–
HPHV250S4175R030	–	–	1/4	1/4	1 3/4	4	.030	–
HPHV312S4050R030	–	–	5/16	5/16	1/2	2	.030	–
HPHV312S4050CH	–	–	5/16	5/16	1/2	2	–	.015
HPHV312S4050	–	–	5/16	5/16	1/2	2	–	–
HPHV312S4050LR015	–	–	5/16	5/16	1/2	2 1/2	.015	–
HPHV312S4050L	–	–	5/16	5/16	1/2	2 1/2	–	–
HPHV312S4075R015	–	–	5/16	5/16	3/4	2 1/2	.015	–
HPHV312S4075R030	–	–	5/16	5/16	3/4	2 1/2	.030	–
HPHV312S4075R060	–	–	5/16	5/16	3/4	2 1/2	.060	–
HPHV312S4075CH	–	–	5/16	5/16	3/4	2 1/2	–	.015
HPHV312S4075	–	–	5/16	5/16	3/4	2 1/2	–	–
HPHV312S4125R030	–	–	5/16	5/16	1 1/4	3 1/4	.030	–
HPHV375S4050R030	–	–	3/8	3/8	1/2	2	.030	–
HPHV375S4050CH	–	–	3/8	3/8	1/2	2	–	.020
HPHV375S4050	–	–	3/8	3/8	1/2	2	–	–
HPHV375S4050LR015	–	–	3/8	3/8	1/2	2 1/2	.015	–
HPHV375S4050LR030	–	–	3/8	3/8	1/2	2 1/2	.030	–
HPHV375S4050L	–	–	3/8	3/8	1/2	2 1/2	–	–
HPHV375S4088R015	–	–	3/8	3/8	7/8	2 1/2	.015	–
HPHV375S4088R030	–	–	3/8	3/8	7/8	2 1/2	.030	–
HPHV375S4088R060	–	–	3/8	3/8	7/8	2 1/2	.060	–
HPHV375S4088R090	–	–	3/8	3/8	7/8	2 1/2	.090	–
HPHV375S4088CH	–	–	3/8	3/8	7/8	2 1/2	–	.020
HPHV375S4088	–	–	3/8	3/8	7/8	2 1/2	–	–
HPHV375S4088LR015	–	–	3/8	3/8	7/8	3	.015	–
HPHV375S4088LR030	–	–	3/8	3/8	7/8	3	.030	–
HPHV375S4088LR090	–	–	3/8	3/8	7/8	3	.090	–
HPHV375S4088L	–	–	3/8	3/8	7/8	3	–	–
HPHV375S4100R015	–	–	3/8	3/8	1	3	.015	–
HPHV375S4100R030	–	–	3/8	3/8	1	3	.030	–
HPHV375S4100R060	–	–	3/8	3/8	1	3	.060	–
HPHV375S4100	–	–	3/8	3/8	1	3	–	–
HPHV375S4125R015	–	–	3/8	3/8	1 1/4	3	.015	–
HPHV375S4125R030	–	–	3/8	3/8	1 1/4	3	.030	–
HPHV375S4125R060	–	–	3/8	3/8	1 1/4	3	.060	–
HPHV375S4125	–	–	3/8	3/8	1 1/4	3	–	–
HPHV375S4150R030	–	–	3/8	3/8	1 1/2	4	.030	–
HPHV375S4150R060	–	–	3/8	3/8	1 1/2	4	.060	–
HPHV375S4150	–	–	3/8	3/8	1 1/2	4	–	–
HPHV375S4250R030	–	–	3/8	3/8	2 1/2	4	.030	–
HPHV375S4250R060	–	–	3/8	3/8	2 1/2	4	.060	–
–	–	UADE375J4ARA	3/8	3/8	1/2	2	.015	–
–	–	UADE375J4ARB	3/8	3/8	1/2	2	.030	–

(continued)

(HPHV • UADE • 4 Flute • Inch — continued)





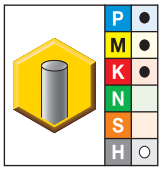


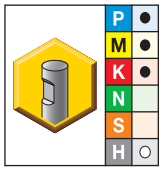
● first choice
○ alternate choice

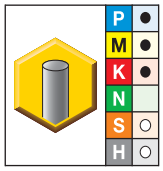
KCPM15	KCPM15	KC643M	D1	D	Ap1 max	L	Rε	BCH
–	–	UADE375J4ARC	3/8	3/8	1/2	2	.060	–
–	–	UADE375J4BRA	3/8	3/8	7/8	2 1/2	.015	–
–	–	UADE375J4BRB	3/8	3/8	7/8	2 1/2	.030	–
HPHV438S4063CH	–	–	7/16	7/16	5/8	2 1/2	–	.020
HPHV438S4088CH	–	–	7/16	7/16	7/8	2 1/2	–	.020
HPHV438S4113R015	–	–	7/16	7/16	1 1/8	3 1/2	.015	–
–	HPHV500S4063R030	–	1/2	1/2	5/8	2 1/2	.030	–
–	HPHV500S4063R060	–	1/2	1/2	5/8	2 1/2	.060	–
–	HPHV500S4063CH	–	1/2	1/2	5/8	2 1/2	–	.020
–	HPHV500S4063	–	1/2	1/2	5/8	2 1/2	–	–
–	HPHV500S4063LR015	–	1/2	1/2	5/8	3	.015	–
–	HPHV500S4063LR030	–	1/2	1/2	5/8	3	.030	–
–	HPHV500S4063LR060	–	1/2	1/2	5/8	3	.060	–
–	HPHV500S4063L	–	1/2	1/2	5/8	3	–	–
–	–	UADE500J4ARA	1/2	1/2	5/8	2 1/2	.015	–
–	–	UADE500J4ARB	1/2	1/2	5/8	2 1/2	.030	–
–	–	UADE500J4ARC	1/2	1/2	5/8	2 1/2	.060	–
–	–	UADE500J4ARE	1/2	1/2	5/8	2 1/2	.120	–
–	HPHV500S4100R030	–	1/2	1/2	1	3	.030	–
–	HPHV500S4100R060	–	1/2	1/2	1	3	.060	–
–	HPHV500S4100CH	–	1/2	1/2	1	3	–	.020
–	HPHV500S4100	–	1/2	1/2	1	3	–	–
–	HPHV500S4125R015	UADE500J4BRA	1/2	1/2	1 1/4	3	.015	–
–	HPHV500S4125R030	UADE500J4BRB	1/2	1/2	1 1/4	3	.030	–
–	HPHV500S4125R060	UADE500J4BRC	1/2	1/2	1 1/4	3	.060	–
–	HPHV500S4125R090	UADE500J4BRD	1/2	1/2	1 1/4	3	.090	–
–	HPHV500S4125R120	UADE500J4BRE	1/2	1/2	1 1/4	3	.120	–
–	HPHV500S4125CH	–	1/2	1/2	1 1/4	3	–	.020
–	HPHV500S4125	–	1/2	1/2	1 1/4	3	–	–
–	–	UADE500J4CRA	1/2	1/2	1 1/2	4	.015	–
–	HPHV500S4150R030	UADE500J4CRB	1/2	1/2	1 1/2	4	.030	–
–	HPHV500S4150R060	UADE500J4CRC	1/2	1/2	1 1/2	4	.060	–
–	–	UADE500J4CRD	1/2	1/2	1 1/2	4	.090	–
–	–	UADE500J4CRE	1/2	1/2	1 1/2	4	.120	–
–	HPHV500S4150CH	–	1/2	1/2	1 1/2	4	–	.020
–	HPHV500S4150	–	1/2	1/2	1 1/2	4	–	–
–	HPHV500S4163R030	–	1/2	1/2	1 5/8	4	.030	–
–	HPHV500S4163R060	–	1/2	1/2	1 5/8	4	.060	–
–	HPHV500S4163R120	–	1/2	1/2	1 5/8	4	.120	–
–	HPHV500S4163	–	1/2	1/2	1 5/8	4	–	–
–	HPHV500S4200R030	–	1/2	1/2	2	4	.030	–
–	HPHV500S4200CH	–	1/2	1/2	2	4	–	.020
–	HPHV500S4200	–	1/2	1/2	2	4	–	–
–	HPHV500S4250R030	–	1/2	1/2	2 1/2	4 1/2	.030	–
–	HPHV500S4300R030	–	1/2	1/2	3	5	.030	–
–	HPHV500S4300R060	–	1/2	1/2	3	5	.060	–
–	HPHV625S4075R060	–	5/8	5/8	3/4	3	.060	–
–	HPHV625S4075CH	–	5/8	5/8	3/4	3	–	.020
–	HPHV625S4075	–	5/8	5/8	3/4	3	–	–
–	HPHV625S4075LR015	–	5/8	5/8	3/4	3 1/2	.015	–
–	HPHV625S4075LR030	–	5/8	5/8	3/4	3 1/2	.030	–
–	HPHV625S4075LR060	–	5/8	5/8	3/4	3 1/2	.060	–

(continued)

(HPHV • UADE • 4 Flute • Inch — continued)





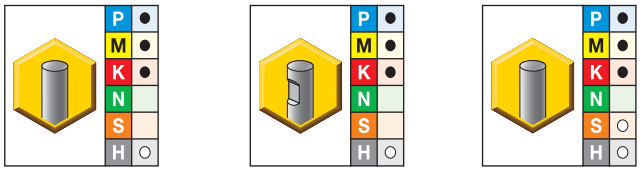


● first choice
○ alternate choice

KCPM15	KCPM15	KC643M	D1	D	Ap1 max	L	Rε	BCH
–	HPHV625S4075L	–	5/8	5/8	3/4	3 1/2	–	–
–	HPHV625S4125R030	–	5/8	5/8	1 1/4	3 1/2	.030	–
–	HPHV625S4125R060	–	5/8	5/8	1 1/4	3 1/2	.060	–
–	HPHV625S4125R090	–	5/8	5/8	1 1/4	3 1/2	.090	–
–	HPHV625S4125CH	–	5/8	5/8	1 1/4	3 1/2	–	.020
–	HPHV625S4125	–	5/8	5/8	1 1/4	3 1/2	–	–
–	HPHV625S4163R030	–	5/8	5/8	1 5/8	3 1/2	.030	–
–	HPHV625S4163R060	–	5/8	5/8	1 5/8	3 1/2	.060	–
–	HPHV625S4163R120	–	5/8	5/8	1 5/8	3 1/2	.120	–
–	HPHV625S4163	–	5/8	5/8	1 5/8	3 1/2	–	–
–	HPHV625S4213R030	–	5/8	5/8	2 1/8	4	.030	–
–	HPHV625S4213R120	–	5/8	5/8	2 1/8	4	.120	–
–	HPHV625S4213	–	5/8	5/8	2 1/8	4	–	–
–	HPHV625S4225R060	–	5/8	5/8	2 1/4	5	.060	–
–	–	UADE625J4ARB	5/8	5/8	3/4	3	.030	–
–	–	UADE625J4ARC	5/8	5/8	3/4	3	.060	–
–	HPHV750S4088CH	–	3/4	3/4	7/8	3 1/2	–	.020
–	HPHV750S4088	–	3/4	3/4	7/8	3 1/2	–	–
–	HPHV750S4088LR030	–	3/4	3/4	7/8	4	.030	–
–	HPHV750S4088L	–	3/4	3/4	7/8	4	–	–
–	–	UADE750J4ARB	3/4	3/4	7/8	3 1/2	.030	–
–	–	UADE750J4ARE	3/4	3/4	7/8	3 1/2	.120	–
–	HPHV750S4150R015	UADE750J4BRA	3/4	3/4	1 1/2	4	.015	–
–	HPHV750S4150R030	UADE750J4BRB	3/4	3/4	1 1/2	4	.030	–
–	HPHV750S4150R060	UADE750J4BRC	3/4	3/4	1 1/2	4	.060	–
–	HPHV750S4150R090	–	3/4	3/4	1 1/2	4	.090	–
–	HPHV750S4150R120	UADE750J4BRE	3/4	3/4	1 1/2	4	.120	–
–	HPHV750S4150CH	–	3/4	3/4	1 1/2	4	–	.020
–	HPHV750S4150	–	3/4	3/4	1 1/2	4	–	–
–	HPHV750S4163R030	–	3/4	3/4	1 5/8	4	.030	–
–	HPHV750S4163R060	–	3/4	3/4	1 5/8	4	.060	–
–	HPHV750S4163R120	–	3/4	3/4	1 5/8	4	.120	–
–	HPHV750S4163CH	–	3/4	3/4	1 5/8	4	–	.020
–	HPHV750S4225R030	–	3/4	3/4	2 1/4	5	.030	–
–	HPHV750S4225R060	–	3/4	3/4	2 1/4	5	.060	–
–	HPHV750S4225CH	–	3/4	3/4	2 1/4	5	–	.020
–	HPHV750S4225	–	3/4	3/4	2 1/4	5	–	–
–	HPHV750S4300CH	–	3/4	3/4	3	6	–	.020
–	HPHV750S4300	–	3/4	3/4	3	6	–	–
–	HPHV750S4400R030	–	3/4	3/4	4	6 1/4	.030	–
–	HPHV750S4400R060	–	3/4	3/4	4	6 1/4	.060	–
–	–	UADE1000J4ARA	1	1	1 1/2	4	.015	–
–	HPHV1000S4150R030	UADE1000J4ARB	1	1	1 1/2	4	.030	–
–	–	UADE1000J4ARC	1	1	1 1/2	4	.060	–
–	–	UADE1000J4ARD	1	1	1 1/2	4	.090	–
–	HPHV1000S4150R120	–	1	1	1 1/2	4	.120	–
–	HPHV1000S4150R250	UADE1000J4ARF	1	1	1 1/2	4	.250	–
–	HPHV1000S4150	–	1	1	1 1/2	4	–	–
–	HPHV1000S4150CH	–	1	1	1 1/2	4	–	.020
–	HPHV1000S4200R030	–	1	1	2	4	.030	–
–	HPHV1000S4200R060	–	1	1	2	4	.060	–
–	HPHV1000S4200R120	–	1	1	2	4	.120	–

(continued)

(HPHV • UADE • 4 Flute • Inch — continued)

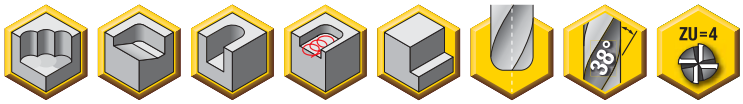


● first choice
○ alternate choice

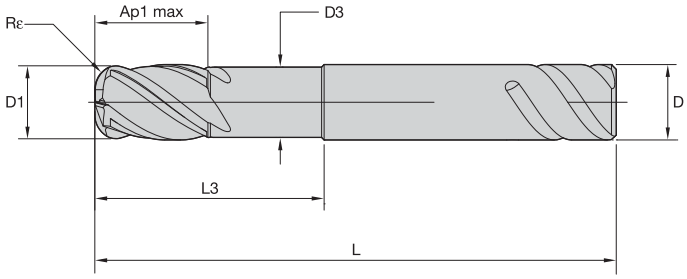
KCPM15	KCPM15	KC643M	D1	D	Ap1 max	L	Rε	BCH
–	**HPHV1000S4200**	–	1	1	2	4	–	–
–	**HPHV1000S4225R030**	–	1	1	2 1/4	5	.030	–
–	**HPHV1000S4225R060**	–	1	1	2 1/4	5	.060	–
–	**HPHV1000S4225CH**	–	1	1	2 1/4	5	–	.020
–	**HPHV1000S4225**	–	1	1	2 1/4	5	–	–
–	**HPHV1000S4263R030**	–	1	1	2 5/8	5	.030	–
–	**HPHV1000S4263CH**	–	1	1	2 5/8	5	–	.020
–	**HPHV1000S4263**	–	1	1	2 5/8	5	–	–
–	**HPHV1000S4300R030**	–	1	1	3	6	.030	–
–	**HPHV1000S4300R060**	–	1	1	3	6	.060	–
–	**HPHV1000S4300CH**	–	1	1	3	6	–	.020
–	**HPHV1000S4400R030**	–	1	1	4	7	.030	–
–	**HPHV1000S4400R060**	–	1	1	4	7	.060	–
–	**HPHV1000S4400CH**	–	1	1	4	7	–	.020
–	**HPHV1250S4225R030**	–	1 1/4	1 1/4	2 1/4	5	.030	–
–	**HPHV1250S4225CH**	–	1 1/4	1 1/4	2 1/4	5	–	.020

NOTE: For application data, see page P25.

- Kennametal standard dimensions.
- Center cutting.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.





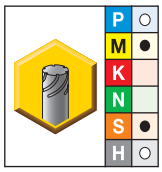


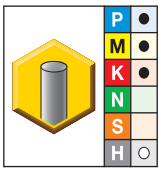
End Mill Tolerances

D1	tolerance	D	tolerance h6 +/-
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1-3/16"	+0/-.00051"

beyond

UADE • UBDE • 4 Flute with Neck • Inch





● first choice
○ alternate choice

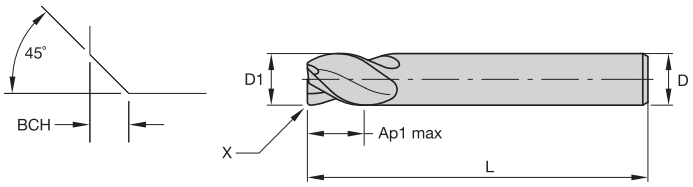
KCSM15	KCPM15	D1	D	D3	Ap1 max	L3	L	Rε
–	UADE0250J4AQA	1/4	1/4	.235	3/8	1 1/4	4	.015
–	UADE0250J4AQB	1/4	1/4	.235	3/8	1 1/4	4	.030
–	UADE0375J4AQA	3/8	3/8	.345	1/2	2	4	.015
–	UADE0375J4AQB	3/8	3/8	.345	1/2	2	4	.030
UBDE0500N4AQA *	–	1/2	3/4	.470	5/8	2 1/4	4	.015
–	UADE0500J4AQB	1/2	1/2	.470	5/8	2 1/4	4	.030
UBDE0500N4AQB *	–	1/2	3/4	.470	5/8	2 1/4	4	.030
UBDE0625N4AQB *	UADE0625J4AQB	5/8	5/8	.587	3/4	2 1/4	4	.030
UBDE0625N4AQC *	–	5/8	5/8	.587	3/4	2 1/4	4	.060
UBDE0750N4AQB *	UADE0750J4AQB	3/4	3/4	.700	1	2 1/4	4 1/2	.030
UBDE0750N4AQC *	–	3/4	3/4	.700	1	2 1/4	4 1/2	.060
UBDE0750N4AQD *	–	3/4	3/4	.700	1	2 1/4	4 1/2	.090
UBDE0750N4AQE *	–	3/4	3/4	.700	1	2 1/4	4 1/2	.120
UBDE0750N4BQB *	UADE0750J4BQB	3/4	3/4	.700	1	3 1/4	5 1/2	.030
UBDE0750N4BQC *	–	3/4	3/4	.700	1	3 1/4	5 1/2	.060
UBDE0750N4BQD *	–	3/4	3/4	.700	1	3 1/4	5 1/2	.090
UBDE0750N4BQE *	–	3/4	3/4	.700	1	3 1/4	5 1/2	.120
UBDE1000N4BQB *	UADE1000J4BQB *	1	1	.939	1 1/8	3 1/4	5 1/2	.030
UBDE1000N4BQC *	–	1	1	.939	1 1/8	3 1/4	5 1/2	.060
UBDE1000N4BQE *	–	1	1	.939	1 1/8	3 1/4	5 1/2	.120

NOTE: For application data, see page P25.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standard dimensions.
- Center cutting.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.





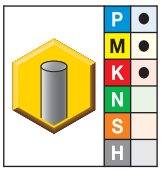


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1-3/16"	+0/-.00051"

beyond

HPRSHV • 4 Flute with Extended Reach • Inch



● first choice
○ alternate choice

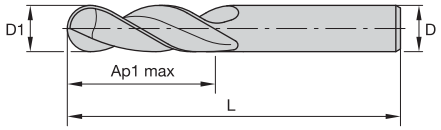
KCPM15	D1	D	Ap1 max	L	BCH
HPRSHV500S4600CH	1/2	1/2	5/8	6	.020
HPRSHV500S4600	1/2	1/2	5/8	6	—
HPRSHV625S4600CH	5/8	5/8	3/4	6	.020
HPRSHV625S4600	5/8	5/8	3/4	6	—
HPRSHV750S4500CH	3/4	3/4	1	5	.020
HPRSHV750S4600CH	3/4	3/4	1	6	.020
HPRSHV750S4600	3/4	3/4	1	6	—
HPRSHV1000S4700CH	1	1	1 1/8	7	.020

NOTE: For application data, see page P26.

- Kennametal standard dimensions.
- Center cutting.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.





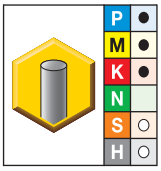


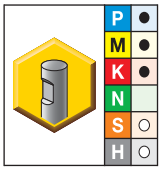
End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

beyond

HPHVBN • 4 Flute with Extended Length-of-Cut • Ball Nose • Inch



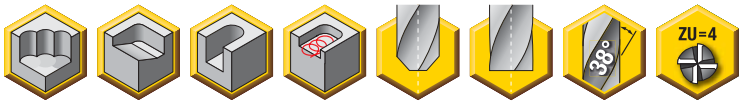


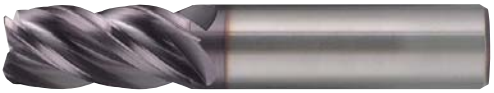
● first choice
○ alternate choice

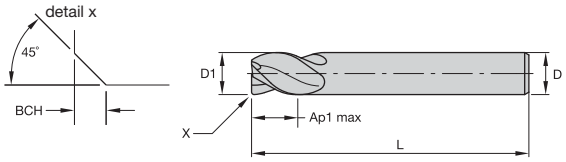
KCPM15	KCPM15	D1	D	Ap1 max	L
HPHVBN125S4050	–	1/8	1/8	1/2	2
HPHVBN188S4063	–	3/16	3/16	5/8	2 1/4
HPHVBN250S4075	–	1/4	1/4	3/4	2 1/2
HPHVBN312S4075	–	5/16	5/16	3/4	2 1/2
HPHVBN375S4088	–	3/8	3/8	7/8	2 1/2
HPHVBN438S4088	–	7/16	7/16	7/8	2 1/2
–	**HPHVBN500S4100**	1/2	1/2	1	3
–	**HPHVBN500S4125**	1/2	1/2	1 1/4	3
–	**HPHVBN625S4125**	5/8	5/8	1 1/4	3 1/2
–	**HPHVBN750S4150**	3/4	3/4	1 1/2	4
–	**HPHVBN1000S4150**	1	1	1 1/2	4

NOTE: For application data, see page P26.

- Kennametal standard dimensions.
- Center cutting.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.
- Optimized geometry for titanium machining.



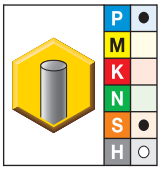




End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

HPHVT • 4 Flute • Inch

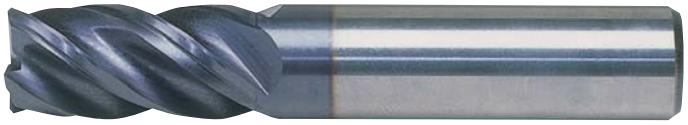


● first choice
○ alternate choice

KC643M	D1	D	Ap1 max	L	BCH
HPHVT500S4063CH	1/2	1/2	5/8	2 1/2	.020
HPHVT500S4063	1/2	1/2	5/8	2 1/2	—
HPHVT500S4125CH	1/2	1/2	1 1/4	3	.020
HPHVT500S4125	1/2	1/2	1 1/4	3	—
HPHVT625S4075CH	5/8	5/8	3/4	3	.020
HPHVT625S4075	5/8	5/8	3/4	3	—
HPHVT625S4125CH	5/8	5/8	1 1/4	3 1/2	.020
HPHVT625S4125	5/8	5/8	1 1/4	3 1/2	—
HPHVT750S4088CH	3/4	3/4	7/8	3 1/2	.020
HPHVT750S4088	3/4	3/4	7/8	3 1/2	—
HPHVT750S4150CH	3/4	3/4	1 1/2	4	.020
HPHVT750S4150	3/4	3/4	1 1/2	4	—
HPHVT1000S4150CH *	1	1	1 1/2	4	.020
HPHVT1000S4150 *	1	1	1 1/2	4	—

NOTE: For application data, see page P27.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

HARVI I • HPHV • UADE • Unequal Flute Spacing



Material Group		Side Milling (A) and Slotting (B)			KC643M		KCPM15		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.												
		A		B	Cutting Speed — vc SFM					D1 — Diameter											
									frac.	1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	1 1/4
		ap	ae	ap	min	max	min	max	dec.	.125	.188	.250	.313	.375	.438	.500	.625	.750	1.000	1.250
P	0	Ap max	0.5 x D	1 x D	490	660	490	660	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	.0049	.0049
	1	Ap max	0.5 x D	1 x D	490	660	490	660	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	.0049	.0049
	2	Ap max	0.5 x D	1 x D	460	620	460	620	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	.0049	.0049
	3	Ap max	0.5 x D	1 x D	390	520	390	520	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045	.0048
	4	Ap max	0.5 x D	0.75 x D	300	490	300	490	IPT	.0007	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034	.0039	.0040
	5	Ap max	0.5 x D	1 x D	200	330	200	330	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036	.0039
	6	Ap max	0.5 x D	0.75 x D	160	250	160	250	IPT	.0005	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025	.0028	.0029
M	1	Ap max	0.5 x D	1 x D	300	380	300	380	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045	.0048
	2	Ap max	0.5 x D	1 x D	200	260	200	260	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036	.0039
	3	Ap max	0.5 x D	1 x D	200	230	200	230	IPT	.0005	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025	.0028	.0029
K	1	Ap max	0.5 x D	1 x D	390	490	390	490	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	.0049	.0049
	2	Ap max	0.5 x D	1 x D	360	460	360	460	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045	.0048
	3	Ap max	0.5 x D	1 x D	360	430	360	430	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036	.0039
S	1	Ap max	0.3 x D	0.3 x D	160	300	–	–	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045	.0048
	2	Ap max	0.3 x D	0.3 x D	80	130	–	–	IPT	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021	.0024	.0026
	3	Ap max	0.3 x D	0.3 x D	80	130	–	–	IPT	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021	.0024	.0026
	4	Ap max	0.5 x D	1 x D	160	200	–	–	IPT	.0005	.0008	.0011	.0014	.0017	.0019	.0021	.0025	.0028	.0033	.0036
H	1	Ap max	0.5 x D	0.75 x D	260	460	260	460	IPT	.0007	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034	.0039	.0040

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 centers, please adjust parameters accordingly on >1/2" diameter.
For tools 2 x D <LOC (Ap1 max) =<3 x D Ae = 0.25 x D, for tools with LOC (Ap1 max) longer than 3 x D, Ae = 0, Ae = 0.1 x D and no slot.

HARVI I • UADE • UBDE • Unequal Flute Spacing • With Neck



Material Group		Side Milling (A) and Slotting (B)			KCSM15		KCPM15		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.						
		A		B	Cutting Speed — vc SFM					D1 — Diameter					
									frac.	1/4	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	max	max	dec.	.2500	.3750	.5000	.6250	.7500	1.0000
P	0	0.75 x D	0.5 x D	0.75 x D	490	660	490	660	IPT	.0018	.0027	.0034	.0039	.0044	.0049
	1	0.75 x D	0.5 x D	0.75 x D	490	660	490	660	IPT	.0018	.0027	.0034	.0039	.0044	.0049
	2	0.75 x D	0.5 x D	0.75 x D	460	620	460	620	IPT	.0018	.0027	.0034	.0039	.0044	.0049
	3	0.75 x D	0.5 x D	0.75 x D	390	520	390	520	IPT	.0015	.0023	.0029	.0034	.0039	.0045
	4	0.75 x D	0.5 x D	0.5 x D	300	490	300	490	IPT	.0014	.0020	.0026	.0030	.0034	.0039
	5	0.75 x D	0.5 x D	0.75 x D	200	330	200	330	IPT	.0012	.0018	.0023	.0027	.0031	.0036
	6	0.75 x D	0.5 x D	0.5 x D	160	250	160	250	IPT	.0010	.0015	.0019	.0022	.0025	.0028
M	1	0.75 x D	0.5 x D	0.75 x D	300	380	300	380	IPT	.0015	.0023	.0029	.0034	.0039	.0045
	2	0.75 x D	0.5 x D	0.75 x D	200	260	200	260	IPT	.0012	.0018	.0023	.0027	.0031	.0036
	3	0.75 x D	0.5 x D	0.75 x D	200	230	200	230	IPT	.0010	.0015	.0019	.0022	.0025	.0028
K	1	0.75 x D	0.5 x D	0.75 x D	–	–	390	490	IPT	.0018	.0027	.0034	.0039	.0044	.0049
	2	0.75 x D	0.5 x D	0.75 x D	–	–	360	460	IPT	.0015	.0023	.0029	.0034	.0039	.0045
	3	0.75 x D	0.5 x D	0.75 x D	–	–	360	430	IPT	.0012	.0018	.0023	.0027	.0031	.0036
S	1	0.75 x D	0.3 x D	0.3 x D	160	300	–	–	IPT	.0015	.0023	.0029	.0034	.0039	.0045
	2	0.75 x D	0.3 x D	0.3 x D	80	130	–	–	IPT	.0008	.0012	.0015	.0018	.0021	.0024
	3	0.75 x D	0.3 x D	0.3 x D	80	130	–	–	IPT	.0008	.0012	.0015	.0018	.0021	.0024
	4	0.75 x D	0.5 x D	0.75 x D	160	200	–	–	IPT	.0011	.0017	.0021	.0025	.0028	.0033
H	1	0.75 x D	0.5 x D	0.5 x D	260	460	260	460	IPT	.0014	.0020	.0026	.0030	.0034	.0039

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 centers, please adjust parameters accordingly on >1/2" diameter.
Side milling applications — for longest reach (L3) tools, reduce ae by 30%.
Slot milling applications — for longest reach (L3) tools, redulce ap by 30%.

HARVI I • HPRSHV • Unequal Flute Spacing • Extended Reach

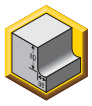




Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KCPM15 Cutting Speed — vc SFM min	max	frac. / dec.	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. D1 — Diameter 1/2 .500	5/8 .625	3/4 .750	1 1.000
P	1	0.75 x D	0.5 x D	0.75 x D	500	650	IPT	.0035	.0039	.0043	.0050
	2	0.75 x D	0.5 x D	0.75 x D	450	625	IPT	.0035	.0039	.0043	.0050
	3	0.75 x D	0.5 x D	0.75 x D	400	525	IPT	.0029	.0034	.0038	.0046
	4	0.75 x D	0.5 x D	0.5 x D	300	475	IPT	.0026	.0030	.0033	.0039
	5	1.5 x D	0.5 x D	0.75 x D	200	325	IPT	.0023	.0027	.0030	.0036
	6	0.75 x D	0.5 x D	0.5 x D	150	225	IPT	.0019	.0022	.0024	.0028
M	1	0.75 x D	0.5 x D	0.75 x D	260	330	IPT	.0029	.0034	.0038	.0046
	2	0.75 x D	0.5 x D	0.75 x D	200	260	IPT	.0023	.0027	.0030	.0036
	3	0.75 x D	0.5 x D	0.75 x D	200	260	IPT	.0019	.0022	.0024	.0028
K	1	0.75 x D	0.5 x D	0.75 x D	390	520	IPT	.0035	.0039	.0043	.0050
	2	0.75 x D	0.5 x D	0.75 x D	360	460	IPT	.0029	.0034	.0038	.0046
	3	0.75 x D	0.5 x D	0.75 x D	330	430	IPT	.0023	.0027	.0030	.0036

NOTE: Those guidelines may require variations to achieve optimum results.
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%.

HARVI I • HPHVBN • 4 Flute with Extended Length-of-Cut • Ball Nose





Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KCPM15 Cutting Speed — vc SFM min	max	frac. / dec.	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. D1 — Diameter 1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	7/16 .438	1/2 .500	5/8 .625	3/4 .750	1 1.000
P	0	1.25 x D	0.5 x D	1 x D	490	660	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	.0049
	1	1.25 x D	0.5 x D	1 x D	490	660	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	.0049
	2	1.25 x D	0.5 x D	1 x D	460	620	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	.0049
	3	1.25 x D	0.5 x D	1 x D	390	520	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045
	4	1.25 x D	0.5 x D	0.75 x D	300	490	IPT	.0007	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034	.0039
	5	1.25 x D	0.5 x D	1 x D	200	330	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036
	6	1.25 x D	0.5 x D	0.75 x D	160	250	IPT	.0005	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025	.0028
M	1	1.25 x D	0.5 x D	1 x D	300	380	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045
	2	1.25 x D	0.5 x D	1 x D	200	260	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036
	3	1.25 x D	0.5 x D	1 x D	200	230	IPT	.0005	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025	.0028
K	1	1.25 x D	0.5 x D	1 x D	390	490	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	.0049
	2	1.25 x D	0.5 x D	1 x D	360	460	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045
	3	1.25 x D	0.5 x D	1 x D	360	430	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036
S	1	1 x D	0.3 x D	0.3 x D	160	300	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045
	2	1 x D	0.3 x D	0.3 x D	80	130	IPT	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021	.0024
	3	1.25 x D	0.3 x D	0.3 x D	80	130	IPT	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021	.0024
	4	1.25 x D	0.5 x D	1 x D	160	200	IPT	.0005	.0008	.0011	.0014	.0017	.0019	.0021	.0025	.0028	.0033
H	1	1.25 x D	0.5 x D	0.75 x D	260	460	IPT	.0007	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034	.0039

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

HARVI I • HPHVT • Unequal Flute Spacing





Material Group		Side Milling (A) and Slotting (B)			KC643M		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.				
		A		B	Cutting Speed — vc SFM			D1 — Diameter			
							frac.	1/2	5/8	3/4	1
		ap	ae	ap	min	max	dec.	.500	.625	.750	1.000
P	5	1.5 x D	0.5 x D	1 x D	200	330	IPT	.0023	.0027	.0031	.0036
	6	1.5 x D	0.5 x D	0.75 x D	160	250	IPT	.0019	.0022	.0025	.0028
S	1	1.5 x D	0.3 x D	0.3 x D	160	300	IPT	.0029	.0034	.0039	.0045
	2	1.5 x D	0.3 x D	0.3 x D	80	130	IPT	.0015	.0018	.0021	.0024
	3	1.5 x D	0.3 x D	0.3 x D	80	130	IPT	.0015	.0018	.0021	.0024
	4	1.5 x D	0.5 x D	1 x D	160	200	IPT	.0021	.0025	.0028	.0033
H	1	1.5 x D	0.5 x D	0.75 x D	260	460	IPT	.0026	.0030	.0034	.0039

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

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.

- 1 x D slotting in titanium and stainless steels with five unequally spaced flutes.
- Roughing and finishing with one tool.
- KCPM15™ 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.
- Universal KC643M™ grade suitable for cutting steel, cast iron, stainless steel (wet), and titanium (wet).

Customization

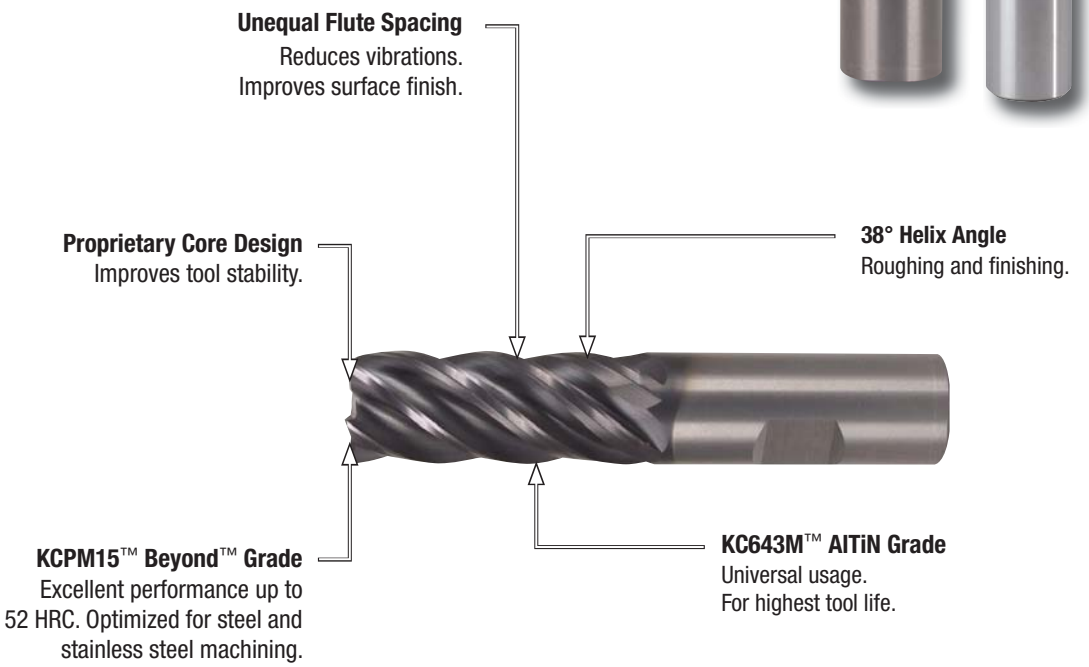
- Intermediate diameters available.
- Expanded length of tool and increased length of cut possible.
- Chip divider geometry reduces power consumption and improves chip formation in difficult-to-cut materials.
- Ball-nose version available.
- Internal coolant axial and radial available.
- Various shanks, including Safe-Lock™ by Haimer, and non-standard coatings available.
- Multiple steps possible.

Extensive Standard Offering

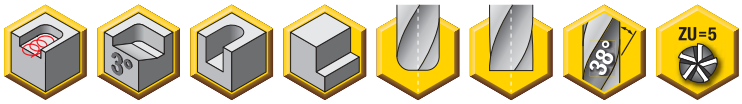
- Diameter range 3/16–1".
- Necked, corner radii, and square-end offering.

High-feed roughing and finishing with one tool at highest length of cut.

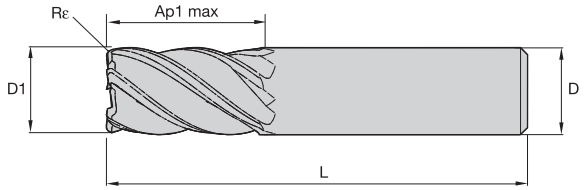




- Kennametal standard dimensions.
- Non-center cutting.
- Ramping up to 3°.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.
- Five-flute geometry enables slotting up to 1 x D.





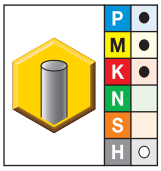


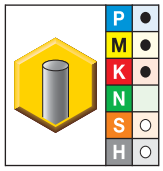
End Mill Tolerances

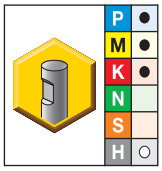
D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

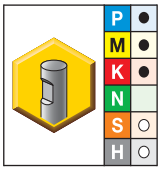
beyond

UCDE • 5 Flute • Inch







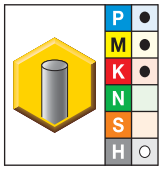


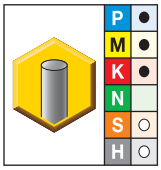
● first choice
○ alternate choice

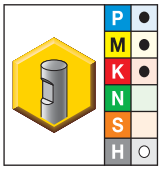
KCPM15	KC643M	KCPM15	KC643M	D1	D	Ap1 max	L	Rε
UCDE188J5BRA	UCDE188J5BRA	–	–	3/16	3/16	5/8	2 1/4	.015
UCDE188J5BRB	UCDE188J5BRB	–	–	3/16	3/16	5/8	2 1/4	.030
UCDE188J5BS	UCDE188J5BS	–	–	3/16	3/16	5/8	2 1/4	–
–	UCDE219J5BS	–	–	7/32	1/4	5/8	2 1/2	–
UCDE250J5BRA	UCDE250J5BRA	–	–	1/4	1/4	3/4	2 1/2	.015
UCDE250J5BRB	UCDE250J5BRB	–	–	1/4	1/4	3/4	2 1/2	.030
UCDE250J5BS	UCDE250J5BS	–	–	1/4	1/4	3/4	2 1/2	–
–	UCDE281J5BS	–	–	9/32	5/16	3/4	2 1/2	–
UCDE312J5BRA	UCDE312J5BRA	–	–	5/16	5/16	3/4	2 1/2	.015
UCDE312J5BRB	UCDE312J5BRB	–	–	5/16	5/16	3/4	2 1/2	.030
UCDE312J5BS	UCDE312J5BS	–	–	5/16	5/16	3/4	2 1/2	–
–	UCDE344J5BS	–	–	11/32	3/8	1	2 1/2	–
UCDE375J5BRA	UCDE375J5BRA	–	–	3/8	3/8	7/8	2 1/2	.015
UCDE375J5BRB	UCDE375J5BRB	–	–	3/8	3/8	7/8	2 1/2	.030
UCDE375J5BS	UCDE375J5BS	–	–	3/8	3/8	7/8	2 1/2	–
–	UCDE375J5CRA	–	–	3/8	3/8	1	3	.015
–	UCDE375J5CRB	–	–	3/8	3/8	1	3	.030
–	UCDE438J5BS	–	–	7/16	7/16	1	2 1/2	–
UCDE500J5BRA	UCDE500J5BRA	UCDE500K5BRA	UCDE500K5BRA	1/2	1/2	1 1/4	3	.015
UCDE500J5BRB	UCDE500J5BRB	UCDE500K5BRB	UCDE500K5BRB	1/2	1/2	1 1/4	3	.030
–	UCDE500J5BRD	–	–	1/2	1/2	1 1/4	3	.060
UCDE500J5BRF	UCDE500J5BRF	UCDE500K5BRF	UCDE500K5BRF	1/2	1/2	1 1/4	3	.120
UCDE500J5BS	UCDE500J5BS	UCDE500K5BS	UCDE500K5BS	1/2	1/2	1 1/4	3	–
–	UCDE562J5BRA	–	–	9/16	5/8	1 1/4	3 1/2	.015
–	UCDE562J5BRB	–	–	9/16	5/8	1 1/4	3 1/2	.030
–	UCDE562J5BS	–	–	9/16	5/8	1 1/4	3 1/2	–
–	UCDE625J5BRA	–	–	5/8	5/8	1 1/4	3 1/2	.015
UCDE625J5BRB	UCDE625J5BRB	UCDE625K5BRB	UCDE625K5BRB	5/8	5/8	1 1/4	3 1/2	.030
–	UCDE625J5BRD	–	–	5/8	5/8	1 1/4	3 1/2	.060
UCDE625J5BS	UCDE625J5BS	UCDE625K5BS	UCDE625K5BS	5/8	5/8	1 1/4	3 1/2	–
–	UCDE750J5BRA	–	–	3/4	3/4	1 1/2	4	.015
UCDE750J5BRB	UCDE750J5BRB	UCDE750K5BRB	UCDE750K5BRB	3/4	3/4	1 1/2	4	.030

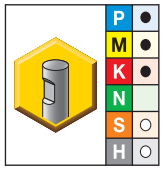
(continued)

(UCDE • 5 Flute • Inch — continued)







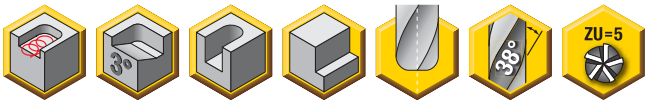


● first choice
○ alternate choice

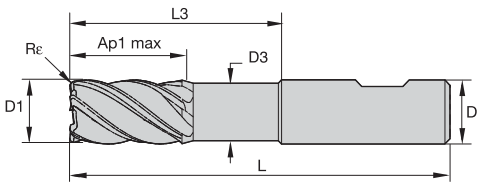
KCPM15	KC643M	KCPM15	KC643M	D1	D	Ap1 max	L	Rε
UCDE750J5BRD	UCDE750J5BRD	—	—	3/4	3/4	1 1/2	4	.060
UCDE750J5BRE	UCDE750J5BRE *	—	—	3/4	3/4	1 1/2	4	.090
UCDE750J5BRF	UCDE750J5BRF	—	UCDE750K5BRF	3/4	3/4	1 1/2	4	.120
UCDE750J5BS	UCDE750J5BS	UCDE750K5BS	UCDE750K5BS	3/4	3/4	1 1/2	4	—
—	UCDE750J5CRB	—	—	3/4	3/4	1 5/8	4	.030
—	UCDE750J5CRD	—	—	3/4	3/4	1 5/8	4	.060
—	UCDE750J5CRF	—	—	3/4	3/4	1 5/8	4	.120
—	UCDE750J5CS	—	—	3/4	3/4	1 5/8	4	—
—	UCDE1000J5BRA	—	—	1	1	1 3/4	4 1/2	.015
UCDE1000J5BRB	UCDE1000J5BRB	UCDE1000K5BRB	UCDE1000K5BRB	1	1	1 3/4	4 1/2	.030
UCDE1000J5BRD	UCDE1000J5BRD *	—	—	1	1	1 3/4	4 1/2	.060
UCDE1000J5BRE *	UCDE1000J5BRE *	—	—	1	1	1 3/4	4 1/2	.090
UCDE1000J5BRF	UCDE1000J5BRF	UCDE1000K5BRF *	UCDE1000K5BRF *	1	1	1 3/4	4 1/2	.120
UCDE1000J5BS	UCDE1000J5BS *	UCDE1000K5BS	UCDE1000K5BS	1	1	1 3/4	4 1/2	—

NOTE: For application data, see page P34.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standard dimensions.
- Non-center cutting.
- Ramping up to 3°.
- Unequal flute spacing minimizes 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.





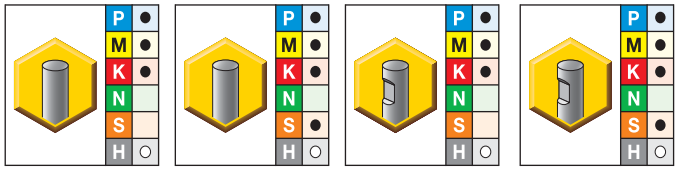


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

beyond

UCDE • 5 Flute with Neck • Inch

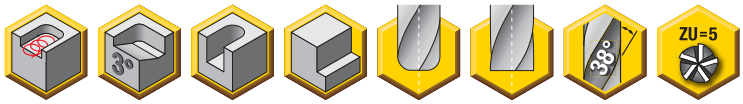


● first choice
○ alternate choice

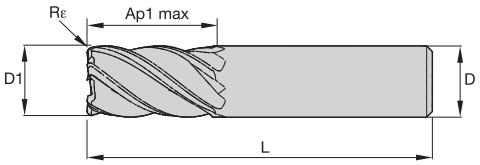
KCPM15	KC643M	KCPM15	KC643M	D1	D	D3	Ap1 max	L3	L	Rε
UCDE250J5ARA	**UCDE250J5ARA**	**–**	**–**	1/4	1/4	.235	1/2	1 1/4	4	.015
UCDE375J5ARA	**UCDE375J5ARA**	**–**	**–**	3/8	3/8	.353	7/8	1 7/8	4	.015
–	**–**	**UCDE500K5ARB**	**UCDE500K5ARB**	1/2	1/2	.472	1 1/4	2 1/4	4	.030
–	**–**	**UCDE625K5ARB**	**UCDE625K5ARB**	5/8	5/8	.590	1 1/4	2 1/4	4	.030
–	**–**	**UCDE750K5ARB**	**UCDE750K5ARB**	3/4	3/4	.704	1 1/2	3 1/4	5 1/2	.030
–	**–**	**UCDE1000K5ARB**	**UCDE1000K5ARB**	1	1	.940	1 3/4	3 1/4	5 1/2	.030

NOTE: For application data, see page P35.

- Kennametal standard dimensions.
- Non-center cutting.
- Ramping up to 3°.
- Unequal flute spacing minimzes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.
- Optimized geometry for titanium machining.
- Five-flute geometry enables slotting up to 1 x D.



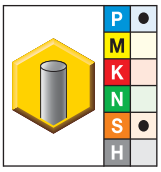


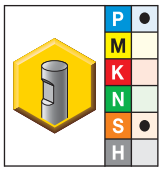


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

UDDE • 5 Flute • Inch





● first choice
○ alternate choice

KC643M	KC643M	D1	D	Ap1 max	L3	L	Rε
UDDE500J5BRA	–	1/2	1/2	1 1/4	1 1/4	3	.015
UDDE500J5BRB	–	1/2	1/2	1 1/4	1 1/4	3	.030
UDDE500J5BRF	–	1/2	1/2	1 1/4	1 1/4	3	.120
UDDE500J5BS	–	1/2	1/2	1 1/4	1 1/4	3	–
–	**UDDE500K5BRA**	1/2	1/2	1 1/4	1 1/2	3	.015
–	**UDDE500K5BRB**	1/2	1/2	1 1/4	1 1/2	3	.030
–	**UDDE500K5BRF**	1/2	1/2	1 1/4	1 1/2	3	.120
–	**UDDE500K5BS**	1/2	1/2	1 1/4	1 1/2	3	–
UDDE625J5BRB	–	5/8	5/8	1 1/4	1 1/4	3 1/2	.030
UDDE625J5BS	–	5/8	5/8	1 1/4	1 1/4	3 1/2	–
–	**UDDE625K5BRB**	5/8	5/8	1 1/4	1 1/2	3 1/2	.030
–	**UDDE625K5BS**	5/8	5/8	1 1/4	1 1/2	3 1/2	–
UDDE750J5BRB	–	3/4	3/4	1 1/2	1 1/4	4	.030
UDDE750J5BRF	–	3/4	3/4	1 1/2	1 1/4	4	.120
UDDE750J5BS	–	3/4	3/4	1 1/2	1 1/4	4	–
–	**UDDE750K5BRB**	3/4	3/4	1 1/2	1 3/4	4	.030
–	**UDDE750K5BRF**	3/4	3/4	1 1/2	1 3/4	4	.120
–	**UDDE750K5BS**	3/4	3/4	1 1/2	1 3/4	4	–
UDDE1000J5BRB	–	1	1	1 3/4	1 1/4	4 1/2	.030
UDDE1000J5BRF *	–	1	1	1 3/4	1 1/4	4 1/2	.120
UDDE1000J5BS	–	1	1	1 3/4	1 1/4	4 1/2	–
–	**UDDE1000K5BRB**	1	1	1 3/4	1 3/4	4 1/2	.030
–	**UDDE1000K5BRF**	1	1	1 3/4	1 3/4	4 1/2	.120
–	**UDDE1000K5BS**	1	1	1 3/4	1 3/4	4 1/2	–

NOTE: For application data, see page P35.
*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 (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.						
		A		B	Cutting Speed — vc SFM					D1 — Diameter					
									frac.	1/4	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	min	max	dec.	.250	.375	.500	.625	.750	1.000
P	0	1.5 x D	0.5 x D	1 x D	490	660	490	660	IPT	.0018	.0027	.0034	.0039	.0044	.0049
	1	1.5 x D	0.5 x D	1 x D	490	660	490	660	IPT	.0018	.0027	.0034	.0039	.0044	.0049
	2	1.5 x D	0.5 x D	1 x D	460	620	460	620	IPT	.0018	.0027	.0034	.0039	.0044	.0049
	3	1.5 x D	0.5 x D	1 x D	390	520	390	520	IPT	.0015	.0023	.0029	.0034	.0039	.0045
	4	1.5 x D	0.5 x D	0.75 x D	300	490	300	490	IPT	.0014	.0020	.0026	.0030	.0034	.0039
	5	1.5 x D	0.5 x D	1 x D	200	330	200	330	IPT	.0012	.0018	.0023	.0027	.0031	.0036
	6	1.5 x D	0.5 x D	0.75 x D	160	250	160	250	IPT	.0010	.0015	.0019	.0022	.0025	.0028
M	1	1.5 x D	0.5 x D	1 x D	300	380	300	380	IPT	.0015	.0023	.0029	.0034	.0039	.0045
	2	1.5 x D	0.5 x D	1 x D	200	260	200	260	IPT	.0012	.0018	.0023	.0027	.0031	.0036
	3	1.5 x D	0.5 x D	1 x D	200	230	200	230	IPT	.0010	.0015	.0019	.0022	.0025	.0028
K	1	1.5 x D	0.5 x D	1 x D	390	490	390	490	IPT	.0018	.0027	.0034	.0039	.0044	.0049
	2	1.5 x D	0.5 x D	1 x D	360	460	360	460	IPT	.0015	.0023	.0029	.0034	.0039	.0045
	3	1.5 x D	0.5 x D	1 x D	360	430	360	430	IPT	.0012	.0018	.0023	.0027	.0031	.0036
S	1	1.5 x D	0.3 x D	0.3 x D	160	300	–	–	IPT	.0015	.0023	.0029	.0034	.0039	.0045
	2	1.5 x D	0.3 x D	0.3 x D	80	130	–	–	IPT	.0008	.0012	.0015	.0018	.0021	.0024
	3	1.5 x D	0.3 x D	0.3 x D	80	130	–	–	IPT	.0008	.0012	.0015	.0018	.0021	.0024
	4	1.5 x D	0.5 x D	1 x D	160	200	–	–	IPT	.0011	.0017	.0021	.0025	.0028	.0033
H	1	1.5 x D	0.5 x D	0.75 x D	260	460	260	460	IPT	.0014	.0020	.0026	.0030	.0034	.0039

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

HARVI II • UCDE • Unequal Flute Spacing • With Neck



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC643M Cutting Speed — vc SFM min	KC643M max	KCPM15 max	KCPM15 max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. frac.	D1 — Diameter 1/4	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	max	max	dec.	.2500	.3750	.5000	.6250	.7500	1.0000
P	0	0.75 x D	0.5 x D	0.75 x D	490	660	490	660	IPT	.0018	.0027	.0034	.0039	.0044	.0049
	1	0.75 x D	0.5 x D	0.75 x D	490	660	490	660	IPT	.0018	.0027	.0034	.0039	.0044	.0049
	2	0.75 x D	0.5 x D	0.75 x D	460	620	460	620	IPT	.0018	.0027	.0034	.0039	.0044	.0049
	3	0.75 x D	0.5 x D	0.75 x D	390	520	390	520	IPT	.0015	.0023	.0029	.0034	.0039	.0045
	4	0.75 x D	0.5 x D	0.5 x D	300	490	300	490	IPT	.0014	.0020	.0026	.0030	.0034	.0039
	5	0.75 x D	0.5 x D	0.75 x D	200	330	200	330	IPT	.0012	.0018	.0023	.0027	.0031	.0036
	6	0.75 x D	0.5 x D	0.5 x D	160	250	160	250	IPT	.0010	.0015	.0019	.0022	.0025	.0028
M	1	0.75 x D	0.5 x D	0.75 x D	300	380	300	380	IPT	.0015	.0023	.0029	.0034	.0039	.0045
	2	0.75 x D	0.5 x D	0.75 x D	200	260	200	260	IPT	.0012	.0018	.0023	.0027	.0031	.0036
	3	0.75 x D	0.5 x D	0.75 x D	200	230	200	230	IPT	.0010	.0015	.0019	.0022	.0025	.0028
K	1	0.75 x D	0.5 x D	0.75 x D	390	490	390	490	IPT	.0018	.0027	.0034	.0039	.0044	.0049
	2	0.75 x D	0.5 x D	0.75 x D	360	460	360	460	IPT	.0015	.0023	.0029	.0034	.0039	.0045
	3	0.75 x D	0.5 x D	0.75 x D	360	430	360	430	IPT	.0012	.0018	.0023	.0027	.0031	.0036
S	1	0.75 x D	0.3 x D	0.3 x D	160	300	–	–	IPT	.0015	.0023	.0029	.0034	.0039	.0045
	2	0.75 x D	0.3 x D	0.3 x D	80	130	–	–	IPT	.0008	.0012	.0015	.0018	.0021	.0024
	3	0.75 x D	0.3 x D	0.3 x D	80	130	–	–	IPT	.0008	.0012	.0015	.0018	.0021	.0024
	4	0.75 x D	0.5 x D	0.75 x D	160	200	–	–	IPT	.0011	.0017	.0021	.0025	.0028	.0033
H	1	0.75 x D	0.5 x D	0.5 x D	260	460	260	460	IPT	.0014	.0020	.0026	.0030	.0034	.0039

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 centers, please adjust parameters accordingly on >1/2" diameter.
Side milling applications — for longest reach (L3) tools, reduce ae by 30%.
Slot milling applications — for longest reach (L3) tools, redulce ap by 30%.

HARVI II • UDDE • Unequal Flute Spacing



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC643M Cutting Speed — vc SFM min	KC643M max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. frac.	D1 — Diameter 1/2	5/8	3/4	1
		ap	ae	ap	min	max	dec.	.500	.625	.750	1.000
P	5	1.25 x D	0.5 x D	1 x D	200	325	IPT	.0023	.0027	.0003	.0036
	6	1.25 x D	0.5 x D	0.75 x D	150	225	IPT	.0019	.0022	.0024	.0028
S	2	1.0 x D	0.3 x D	0.3 x D	70	130	IPT	.0016	.0018	.0020	.0025
	3	1.25 x D	0.5 x D	1 x D	160	260	IPT	.0023	.0027	.0030	.0036
	4	1.25 x D	0.5 x D	1 x D	150	210	IPT	.0022	.0025	.0028	.0033

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

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.

- 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).

Customization

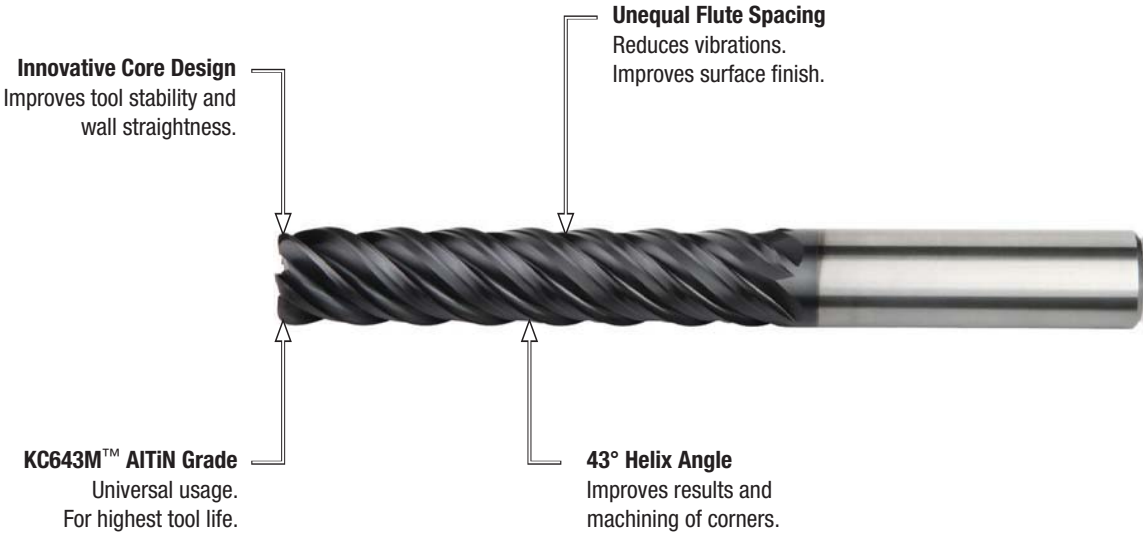
- Intermediate diameters available.
- Chip divider geometry available for reduced power consumption and improved chip formation in difficult-to-cut materials.
- Internal coolant axial, as well as radial, available.
- Various shank options, including Safe-Lock™ by Haimer, and non-standard coatings available.

Extensive Standard Offering

- Diameter range 1/4–1".
- Various corner radii in stock.

3 x D and 5 x D lengths of cut without reduced feed rates when machining corners.

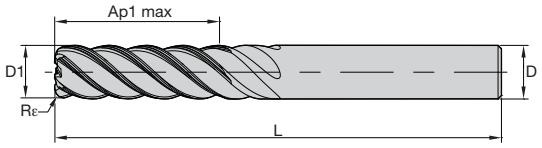




- Kennametal standard dimensions.
- Non-center cutting.
- Unequal flute spacing minimizes chatter for smoother machining.
- For finishing and semi-finishing applications.
- Optimized geometry for machining corners at deep cavities.



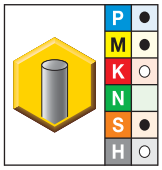




End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

HARVI II • UGDE • 3 x D Lengths of Cut



● first choice
○ alternate choice

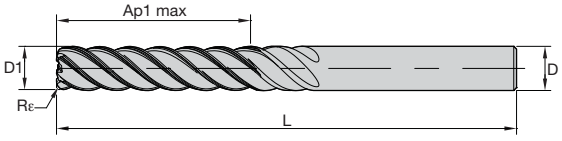
KC643M	D1	D	Ap1 max	L	Rε
UGDE0250J5ARA	1/4	1/4	3/4	2 1/2	.015
UGDE0250J5ARB	1/4	1/4	3/4	2 1/2	.030
UGDE0250J5AE	1/4	1/4	3/4	2 1/2	—
UGDE0312J5ARA	5/16	5/16	15/16	3	.015
UGDE0312J5ARB *	5/16	5/16	15/16	3	.030
UGDE0312J5AE	5/16	5/16	15/16	3	—
UGDE0375J5ARA	3/8	3/8	1 1/8	4	.015
UGDE0375J5ARB	3/8	3/8	1 1/8	4	.030
UGDE0375J5ARC	3/8	3/8	1 1/8	4	.060
UGDE0375J5AE	3/8	3/8	1 1/8	4	—
UGDE0500J5ARA	1/2	1/2	1 1/2	4	.015
UGDE0500J5ARB	1/2	1/2	1 1/2	4	.030
UGDE0500J5ARC	1/2	1/2	1 1/2	4	.060
UGDE0500J5AE	1/2	1/2	1 1/2	4	—
UGDE0625J5ARA	5/8	5/8	1 7/8	5	.015
UGDE0625J5ARB	5/8	5/8	1 7/8	5	.030
UGDE0625J5ARC	5/8	5/8	1 7/8	5	.060
UGDE0625J5ARD	5/8	5/8	1 7/8	5	.120
UGDE0625J5AE	5/8	5/8	1 7/8	5	—
UGDE0750J5ARA	3/4	3/4	2 1/4	5	.015
UGDE0750J5ARB	3/4	3/4	2 1/4	5	.030
UGDE0750J5ARC	3/4	3/4	2 1/4	5	.060
UGDE0750J5ARD	3/4	3/4	2 1/4	5	.120
UGDE0750J5AE	3/4	3/4	2 1/4	5	—
UGDE1000J5ARA	1	1	3	6	.015
UGDE1000J5ARB	1	1	3	6	.030
UGDE1000J5ARC	1	1	3	6	.060
UGDE1000J5ARD	1	1	3	6	.120
UGDE1000J5AE	1	1	3	6	—

NOTE: For application data, see page P40.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standard dimensions.
- Non-center cutting.
- Unequal flute spacing minimizes chatter for smoother machining.
- For finishing and semi-finishing applications.
- Optimized geometry for machining corners at deep cavities.



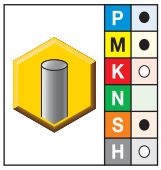




End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

HARVI II • UGDE • 5 x D Lengths of Cut



● first choice
○ alternate choice

KC643M	D1	D	Ap1 max	L	Rε
UGDE0250J5BRA	1/4	1/4	1 1/4	3	.015
UGDE0250J5BRB	1/4	1/4	1 1/4	3	.030
UGDE0250J5BE	1/4	1/4	1 1/4	3	—
UGDE0312J5BRA	5/16	5/16	1 1/4	3 1/2	.015
UGDE0312J5BRB	5/16	5/16	1 1/4	3 1/2	.030
UGDE0312J5BE	5/16	5/16	1 1/4	3 1/2	—
UGDE0375J5BRA	3/8	3/8	1 7/8	4	.015
UGDE0375J5BRB	3/8	3/8	1 7/8	4	.030
UGDE0375J5BRC	3/8	3/8	1 7/8	4	.060
UGDE0375J5BE	3/8	3/8	1 7/8	4	—
UGDE0500J5BRA	1/2	1/2	2 1/2	5	.015
UGDE0500J5BRB	1/2	1/2	2 1/2	5	.030
UGDE0500J5BRC	1/2	1/2	2 1/2	5	.060
UGDE0500J5BE	1/2	1/2	2 1/2	5	—
UGDE0625J5BRA	5/8	5/8	3 1/8	6	.015
UGDE0625J5BRB	5/8	5/8	3 1/8	6	.030
UGDE0625J5BRC	5/8	5/8	3 1/8	6	.060
UGDE0625J5BRD	5/8	5/8	3 1/8	6	.120
UGDE0625J5BE	5/8	5/8	3 1/8	6	—
UGDE0750J5BRA	3/4	3/4	3 3/4	7	.015
UGDE0750J5BRB	3/4	3/4	3 3/4	7	.030
UGDE0750J5BRC	3/4	3/4	3 3/4	7	.060
UGDE0750J5BRD	3/4	3/4	3 3/4	7	.120
UGDE0750J5BE	3/4	3/4	3 3/4	7	—
UGDE1000J5BRA	1	1	5	7 1/2	.015
UGDE1000J5BRB	1	1	5	7 1/2	.030
UGDE1000J5BRC	1	1	5	7 1/2	.060
UGDE1000J5BRD	1	1	5	7 1/2	.120
UGDE1000J5BE	1	1	5	7 1/2	—

NOTE: For application data, see page P41.

HARVI II • UGDE • Unequal Flute Spacing • 3 x D Lengths of Cut



Side Milling (A)



Material Group		A		KC643M		Recommended feed per tooth (IPT = inch/th) for side milling (A).						
				Cutting Speed — vc SFM			D1 — Diameter					
						frac.	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	min	max	dec.	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
P	0	Ap max	0.05 x D	980	1310	IPT	.0022	.0028	.0033	.0041	.0047	.0053	.0059
	1	Ap max	0.05 x D	980	1310	IPT	.0022	.0028	.0033	.0041	.0047	.0053	.0059
	2	Ap max	0.05 x D	920	1250	IPT	.0022	.0028	.0033	.0041	.0047	.0053	.0059
	3	Ap max	0.05 x D	790	1050	IPT	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	4	Ap max	0.05 x D	590	980	IPT	.0017	.0021	.0025	.0031	.0036	.0040	.0046
	5	Ap max	0.05 x D	390	660	IPT	.0015	.0019	.0022	.0028	.0033	.0037	.0043
	6	Ap max	0.05 x D	330	490	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0034
M	1	Ap max	0.05 x D	590	750	IPT	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	2	Ap max	0.05 x D	390	520	IPT	.0015	.0019	.0022	.0028	.0033	.0037	.0043
	3	Ap max	0.05 x D	390	460	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0034
K	1	Ap max	0.05 x D	790	980	IPT	.0022	.0028	.0033	.0041	.0047	.0053	.0059
	2	Ap max	0.05 x D	720	920	IPT	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	3	Ap max	0.05 x D	720	850	IPT	.0015	.0019	.0022	.0028	.0033	.0037	.0043
S	1	Ap max	0.05 x D	330	590	IPT	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	2	Ap max	0.05 x D	160	260	IPT	.0010	.0012	.0015	.0018	.0022	.0025	.0029
	3	Ap max	0.05 x D	160	260	IPT	.0010	.0012	.0015	.0018	.0022	.0025	.0029
	4	Ap max	0.05 x D	330	390	IPT	.0013	.0017	.0020	.0026	.0030	.0034	.0040
H	1	Ap max	0.05 x D	520	920	IPT	.0017	.0021	.0025	.0031	.0036	.0040	.0046
	2	Ap max	0.05 x D	460	790	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0034

* For the above cutting data, do not exceed an overall ae of .031".

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 centers, please adjust parameters accordingly on >1/2" diameter.

HARVI II • UGDE • Unequal Flute Spacing • 5 x D Lengths of Cut



Material Group		Side Milling (A)		KC643M		Recommended feed per tooth (IPT = inch/th) for side milling (A).							
		A		Cutting Speed — vc SFM			D1 — Diameter						
						frac.	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	min	max	dec.	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
P	0	Ap max	0.05 x D	980	1310	IPT	.0022	.0028	.0033	.0041	.0047	.0053	.0059
	1	Ap max	0.05 x D	980	1310	IPT	.0022	.0028	.0033	.0041	.0047	.0053	.0059
	2	Ap max	0.05 x D	920	1250	IPT	.0022	.0028	.0033	.0041	.0047	.0053	.0059
	3	Ap max	0.05 x D	790	1050	IPT	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	4	Ap max	0.05 x D	590	980	IPT	.0017	.0021	.0025	.0031	.0036	.0040	.0046
	5	Ap max	0.05 x D	390	660	IPT	.0015	.0019	.0022	.0028	.0033	.0037	.0043
	6	Ap max	0.05 x D	330	490	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0034
M	1	Ap max	0.05 x D	590	750	IPT	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	2	Ap max	0.05 x D	390	520	IPT	.0015	.0019	.0022	.0028	.0033	.0037	.0043
	3	Ap max	0.05 x D	390	460	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0034
K	1	Ap max	0.05 x D	790	980	IPT	.0022	.0028	.0033	.0041	.0047	.0053	.0059
	2	Ap max	0.05 x D	720	920	IPT	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	3	Ap max	0.05 x D	720	850	IPT	.0015	.0019	.0022	.0028	.0033	.0037	.0043
S	1	Ap max	0.05 x D	330	590	IPT	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	2	Ap max	0.05 x D	160	260	IPT	.0010	.0012	.0015	.0018	.0022	.0025	.0029
	3	Ap max	0.05 x D	160	260	IPT	.0010	.0012	.0015	.0018	.0022	.0025	.0029
	4	Ap max	0.05 x D	330	390	IPT	.0013	.0017	.0020	.0026	.0030	.0034	.0040
H	1	Ap max	0.05 x D	520	920	IPT	.0017	.0021	.0025	.0031	.0036	.0040	.0046
	2	Ap max	0.05 x D	460	790	IPT	.0012	.0016	.0018	.0023	.0027	.0030	.0034

* For the above cutting data, do not exceed an overall ae of .031".

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 centers, please adjust parameters accordingly on >1/2" diameter.

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.
- Center 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.

Customization

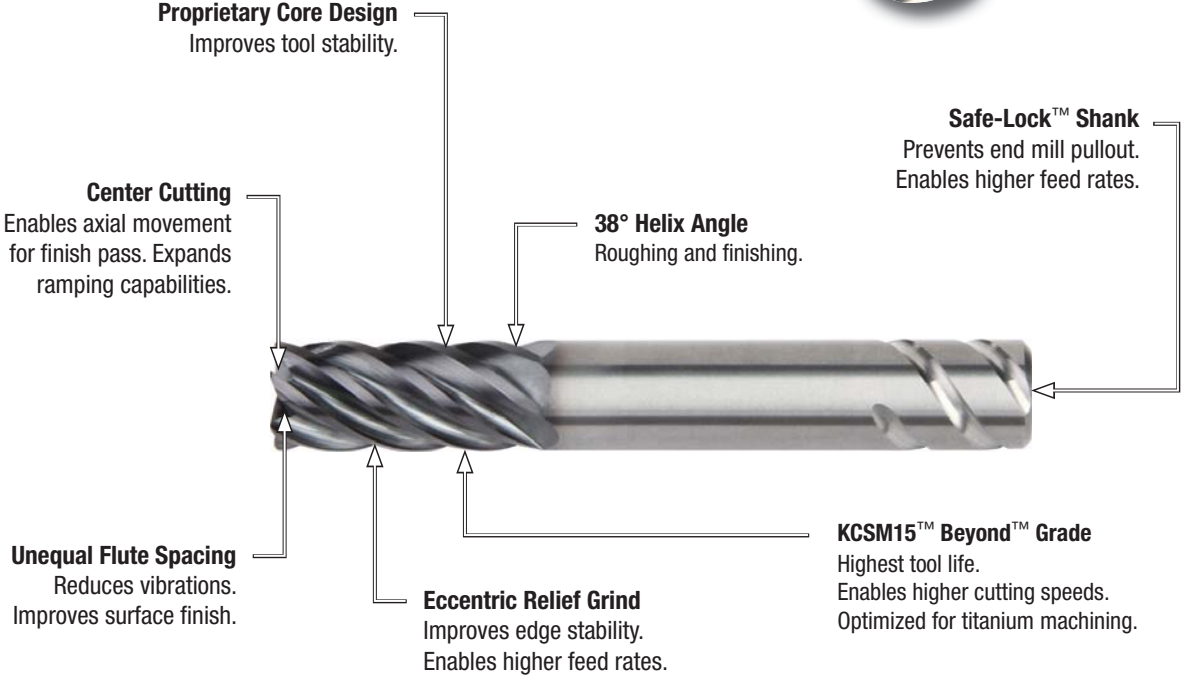
- Engineered solutions, including ball nose versions, are available upon request.

Extensive Standard Offering

- Diameter ranges 3/8–1-1/4".
- 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.



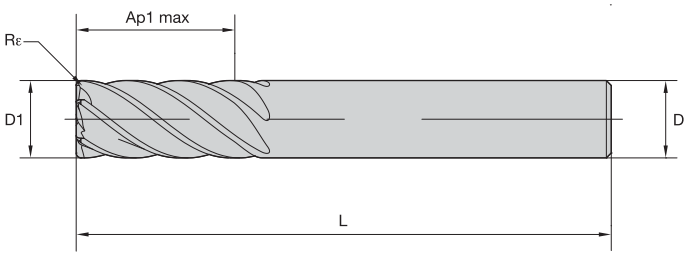


SAFE-λOCK®
by HAIMER®

- Kennametal standard dimensions.
- Center cutting.
- Optimized geometry for titanium machining.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.





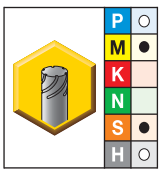


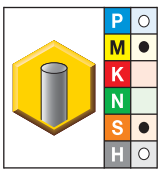
End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1-3/16"	0/.00051"

beyond

UJDE • 6 Flute with Eccentric Relief Grind • Inch



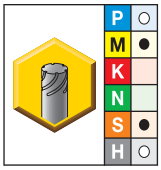


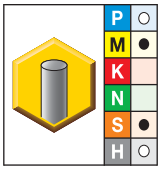
● first choice
○ alternate choice

KCSM15	KCSM15	D1	D	Ap1 max	L	Rε
–	UJDE375J6CRA	3/8	3/8	1	3	.015
–	UJDE375J6CRB	3/8	3/8	1	3	.030
–	UJDE375J6CRC	3/8	3/8	1	3	.060
–	UJDE375J6CS	3/8	3/8	1	3	–
–	UJDE0500J6ARB	1/2	1/2	1	3	.030
–	UJDE0500J6ARC	1/2	1/2	1	3	.060
UJDE500N6BRA	UJDE500J6BRA	1/2	1/2	1 1/4	3	.015
UJDE500N6BRB	UJDE500J6BRB	1/2	1/2	1 1/4	3	.030
UJDE500N6BRC	UJDE500J6BRC	1/2	1/2	1 1/4	3	.060
UJDE500N6BRE	UJDE500J6BRE	1/2	1/2	1 1/4	3	.120
UJDE500N6BS	UJDE500J6BS	1/2	1/2	1 1/4	3	–
–	UJDE0500J6CRB	1/2	1/2	2	4	.030
–	UJDE0500J6CRE	1/2	1/2	2	4	.120
–	UJDE0625J6ARA	5/8	5/8	1	3 1/2	.015
UJDE625N6BRB	UJDE625J6BRB	5/8	5/8	1 1/4	3 1/2	.030
UJDE625N6BRC	UJDE625J6BRC	5/8	5/8	1 1/4	3 1/2	.060
UJDE625N6BS	UJDE625J6BS	5/8	5/8	1 1/4	3 1/2	–
–	UJDE0625J6CRB	5/8	5/8	1 5/8	3 1/2	.030
–	UJDE0625J6CRC	5/8	5/8	1 5/8	3 1/2	.060
–	UJDE0625J6CRD	5/8	5/8	1 5/8	3 1/2	.090
–	UJDE0625J6CRE	5/8	5/8	1 5/8	3 1/2	.120
–	UJDE0750J6ARB	3/4	3/4	1	3	.030
UJDE750N6BRB	UJDE750J6BRB	3/4	3/4	1 1/2	4	.030
UJDE750N6BRC	UJDE750J6BRC	3/4	3/4	1 1/2	4	.060
UJDE750N6BRD	UJDE750J6BRD	3/4	3/4	1 1/2	4	.090
UJDE750N6BRE	UJDE750J6BRE	3/4	3/4	1 1/2	4	.120
–	UJDE0750J6BRH	3/4	3/4	1 1/2	4	.190
UJDE750N6BS	UJDE750J6BS	3/4	3/4	1 1/2	4	–

(continued)

(UJDE • 6 Flute with Eccentric Relief Grind • Inch — continued)





● first choice
○ alternate choice

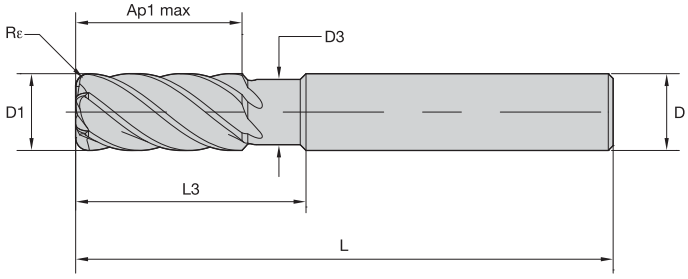
KCSM15	KCSM15	D1	D	Ap1 max	L	Rε
UJDE750N6CRB	UJDE750J6CRB	3/4	3/4	1 5/8	4	.030
UJDE750N6CRC	UJDE750J6CRC	3/4	3/4	1 5/8	4	.060
UJDE750N6CRD	UJDE750J6CRD	3/4	3/4	1 5/8	4	.090
UJDE750N6CRE	UJDE750J6CRE	3/4	3/4	1 5/8	4	.120
UJDE750N6CS	UJDE750J6CS	3/4	3/4	1 5/8	4	—
—	UJDE1000J6ARB	1	1	1 1/2	4	.030
—	UJDE1000J6ARC	1	1	1 1/2	4	.060
—	UJDE1000J6ARE *	1	1	1 1/2	4	.120
—	UJDE1000J6AS	1	1	1 1/2	4	—
UJDE1000N6BRB	—	1	1	1 3/4	4 1/2	.030
UJDE1000N6BRC	UJDE1000J6BRC	1	1	1 3/4	4 1/2	.060
UJDE1000N6BRE	UJDE1000J6BRE	1	1	1 3/4	4 1/2	.120
UJDE1000N6BRF	UJDE1000J6BRF	1	1	1 3/4	4 1/2	.250
UJDE1000N6BS	UJDE1000J6BS	1	1	1 3/4	4 1/2	—
—	UJDE1000J6CRB	1	1	2	4 1/2	.030
—	UJDE1000J6CRC	1	1	2	4 1/2	.060
—	UJDE1000J6CRD	1	1	2	4 1/2	.090
—	UJDE1000J6CRE	1	1	2	4 1/2	.120
—	UJDE1000J6CRH	1	1	2	4 1/2	.190
—	UJDE1000J6CRF	1	1	2	4 1/2	.250
—	UJDE1000J6CS	1	1	2	4 1/2	—
—	UJDE1000J6DRB	1	1	2	5	.030
—	UJDE1000J6DS	1	1	2 1/4	5	—
UJDE1250N6BRB	UJDE1250J6BRB	1 1/4	1 1/4	2 1/4	5	.030
UJDE1250N6BRE	—	1 1/4	1 1/4	2 1/4	5	.120
UJDE1250N6BS	—	1 1/4	1 1/4	2 1/4	5	—

NOTE: For application data, see page P47.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standard dimensions.
- Center cutting.
- Optimized geometry for titanium machining.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.





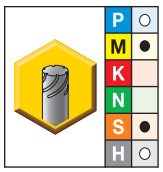


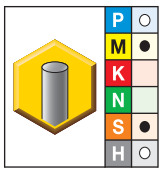
End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1-3/16"	0/.00051"

beyond

UJDE • 6 Flute with Eccentric Relief Grind and Neck • Inch



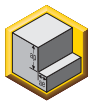


● first choice
○ alternate choice

KCSM15	KCSM15	D1	D	D3	Ap1 max	L3	L	Rε
–	**UJDE0375J6BQE**	3/8	3/8	.353	7/8	1 1/4	3	.120
–	**UJDE375J6BQA**	3/8	3/8	.353	7/8	1 7/8	4	.015
–	**UJDE0500J6DQB**	1/2	1/2	.470	3/4	2 1/4	6	.030
UJDE500N6BQB	–	1/2	1/2	.470	1 1/4	2 1/4	4	.030
UJDE625N6BQB	–	5/8	5/8	.588	1 1/4	2 1/4	4	.030
–	**UJDE0625J6DQB**	5/8	5/8	.588	1 1/4	2 1/4	6	.030
UJDE750N6BQB	–	3/4	3/4	.705	1 1/2	3 1/4	5 1/2	.030
UJDE1000N6BQB	–	1	1	.940	1 3/4	3 1/4	5 1/2	.030

NOTE: For application data, see page P48.

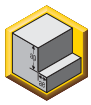
HARVI III • UJDE • Unequal Flute Spacing • Roughing





Material Group		Side Milling (A)		KCSM15		Recommended feed per tooth (IPT = inch/th) for side milling (A).						
		A		Cutting Speed — vc SFM			D1 — Diameter					
						frac.	3/8	1/2	5/8	3/4	1	1 1/4
		ap	ae	min	max	dec.	.3750	.5000	.6250	.7500	1.0000	1.2500
P	4	Ap max	0.4 x D	300	490	IPT	.0020	.0026	.0030	.0034	.0039	.0040
	5	Ap max	0.4 x D	200	330	IPT	.0018	.0023	.0027	.0031	.0036	.0039
M	1	Ap max	0.4 x D	300	380	IPT	.0023	.0029	.0034	.0039	.0045	.0048
	2	Ap max	0.4 x D	200	260	IPT	.0018	.0023	.0027	.0031	.0036	.0039
	3	Ap max	0.4 x D	200	230	IPT	.0015	.0019	.0022	.0025	.0028	.0029
S	1	Ap max	0.4 x D	160	300	IPT	.0023	.0029	.0034	.0039	.0045	.0048
	2	Ap max	0.4 x D	80	130	IPT	.0012	.0015	.0018	.0021	.0024	.0026
	3	Ap max	0.4 x D	80	130	IPT	.0012	.0015	.0018	.0021	.0024	.0026
	4	Ap max	0.4 x D	160	200	IPT	.0017	.0021	.0025	.0028	.0033	.0036
H	1	Ap max	0.4 x D	260	460	IPT	.0020	.0026	.0030	.0034	.0039	.0040

HARVI III • UJDE • Unequal Flute Spacing • Finishing





Material Group		Side Milling (A)		KCSM15		Recommended feed per tooth (IPT = inch/th) for side milling (A).						
		A		Cutting Speed — vc SFM			D1 — Diameter					
						frac.	3/8	1/2	5/8	3/4	1	1 1/4
		ap	ae	min	max	dec.	.3750	.5000	.6250	.7500	1.0000	1.2500
P	4	Ap max	0.06 x D	560	940	IPT	.0025	.0031	.0036	.0040	.0046	.0048
	5	Ap max	0.06 x D	370	620	IPT	.0022	.0028	.0033	.0037	.0043	.0047
M	1	Ap max	0.06 x D	560	720	IPT	.0027	.0035	.0041	.0046	.0054	.0058
	2	Ap max	0.06 x D	370	500	IPT	.0022	.0028	.0033	.0037	.0043	.0047
	3	Ap max	0.06 x D	370	440	IPT	.0018	.0023	.0027	.0030	.0034	.0035
S	1	Ap max	0.06 x D	310	560	IPT	.0027	.0035	.0041	.0046	.0054	.0058
	2	Ap max	0.06 x D	160	250	IPT	.0015	.0018	.0022	.0025	.0029	.0032
	3	Ap max	0.06 x D	160	250	IPT	.0015	.0018	.0022	.0025	.0029	.0032
	4	Ap max	0.06 x D	310	370	IPT	.0020	.0026	.0030	.0034	.0040	.0043
H	1	Ap max	0.06 x D	500	870	IPT	.0025	.0031	.0036	.0040	.0046	.0048

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 centers, please adjust parameters accordingly on >1/2" diameter.

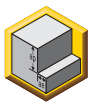
HARVI III • UJDE • Unequal Flute Spacing • Roughing • With Neck





Material Group		Side Milling (A)		KCSM15		Recommended feed per tooth (IPT = inch/th) for side milling (A).					
		A		Cutting Speed — vc SFM			D1 — Diameter				
						frac.	3/8	1/2	5/8	3/4	1
		ap	ae	min	max	dec.	.3750	.5000	.6250	.7500	1.0000
P	4	Ap1 max	0.4 x D	300	490	IPT	.0020	.0026	.0030	.0033	.0039
	5	Ap1 max	0.4 x D	200	330	IPT	.0018	.0023	.0027	.0030	.0036
M	1	Ap1 max	0.4 x D	300	380	IPT	.0023	.0029	.0034	.0038	.0046
	2	Ap1 max	0.4 x D	200	260	IPT	.0018	.0023	.0027	.0030	.0036
	3	Ap1 max	0.4 x D	200	230	IPT	.0015	.0019	.0022	.0024	.0028
S	1	Ap1 max	0.4 x D	160	300	IPT	.0023	.0029	.0034	.0038	.0046
	2	Ap1 max	0.4 x D	160	300	IPT	.0023	.0029	.0034	.0038	.0046
	3	Ap1 max	0.4 x D	80	130	IPT	.0012	.0016	.0018	.0020	.0025
	4	Ap1 max	0.4 x D	160	260	IPT	.0017	.0022	.0025	.0028	.0033
H	1	Ap1 max	0.4 x D	260	460	IPT	.0020	.0026	.0030	.0033	.0039

HARVI III • UJDE • Unequal Flute Spacing • Finishing • With Neck





Material Group		Side Milling (A)		KCSM15		Recommended feed per tooth (IPT = inch/th) for side milling (A).					
		A		Cutting Speed — vc SFM			D1 — Diameter				
						frac.	3/8	1/2	5/8	3/4	1
		ap	ae	min	max	dec.	.3750	.5000	.6250	.7500	1.0000
P	4	Ap1 max	0.06 x D	560	940	IPT	.0024	.0031	.0036	.0040	.0047
	5	Ap1 max	0.06 x D	370	620	IPT	.0022	.0028	.0033	.0036	.0044
M	1	Ap1 max	0.06 x D	560	720	IPT	.0027	.0035	.0041	.0045	.0055
	2	Ap1 max	0.06 x D	370	500	IPT	.0022	.0028	.0033	.0036	.0044
	3	Ap1 max	0.06 x D	370	440	IPT	.0018	.0023	.0027	.0029	.0034
S	1	Ap1 max	0.06 x D	310	560	IPT	.0027	.0035	.0041	.0045	.0055
	2	Ap1 max	0.06 x D	310	560	IPT	.0027	.0035	.0041	.0045	.0055
	3	Ap1 max	0.06 x D	160	250	IPT	.0014	.0019	.0022	.0024	.0029
	4	Ap1 max	0.06 x D	310	500	IPT	.0020	.0026	.0030	.0033	.0040
H	1	Ap1 max	0.06 x D	500	870	IPT	.0024	.0031	.0036	.0040	.0047

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 centers, please adjust parameters accordingly on >1/2" diameter.

EADE Solid Ceramic End Mill



- Roughing nickel-based high-temperature alloys.
- Highest productivity and longest tool life.
- Outstanding reduction of machining time.
- Less tool changes due to higher tool life.
- Benefit from throw-away type of tooling.
- Minimum cutting speed of 1300 SFM (400 m/min).

Offering

- 4-flute necked tools for slotting.
- 6-flute version for face and side milling.

KYS40

- Cutting speeds up to 3300 SFM (1000 m/min) increases Metal Removal Rates (MRR).

beyond™

Visit **kennametal.com** or contact your local Authorized Kennametal Distributor.

KENNAMETAL®

kennametal.com

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 increases 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.
- 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 at roughing and finishing operations.

Tailored Grade

- KCSM15 Beyond grade for exceptional tool life in titanium and stainless steels.

Extensive Standard Offering

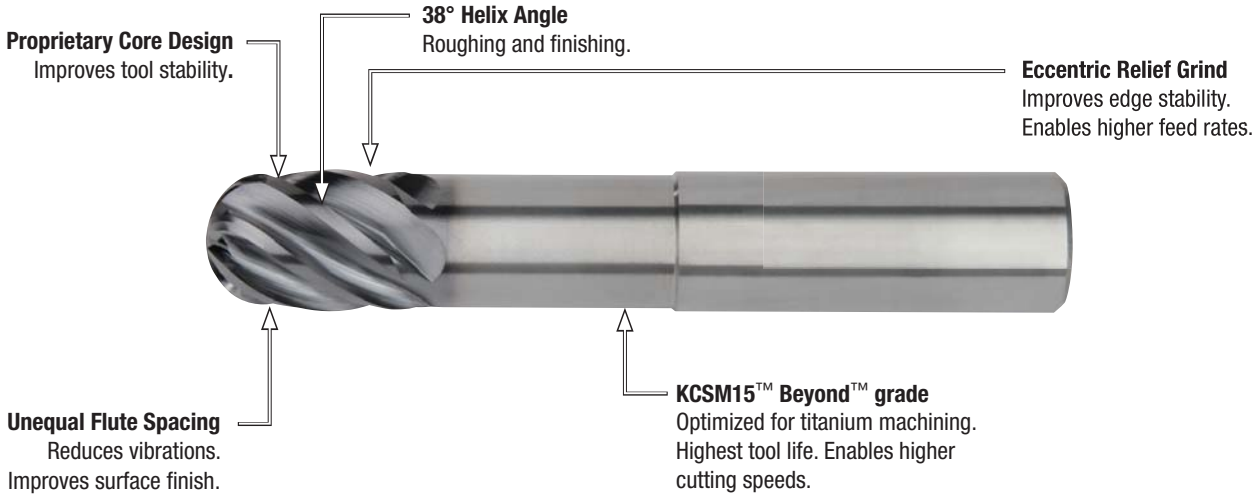
- Diameter ranges 3/8–1".
- Necked, round shank offering in two length variations.

Customization

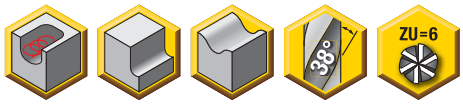
- Engineered solutions, including shank and non-standard length versions, are available upon request.

3D profiling at highest productivity in titanium and stainless steels.

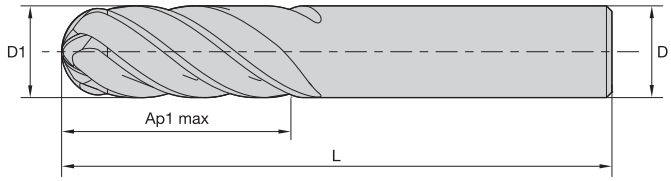




- Kennametal standard dimensions.
- Center cutting.
- Optimized geometry for titanium machining.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.



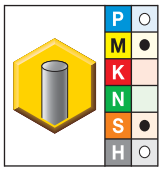




End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1-3/16"	0/.00051"

UJBE • 6-Flute Ball Nose with Eccentric Relief Grind • Inch



● first choice
○ alternate choice

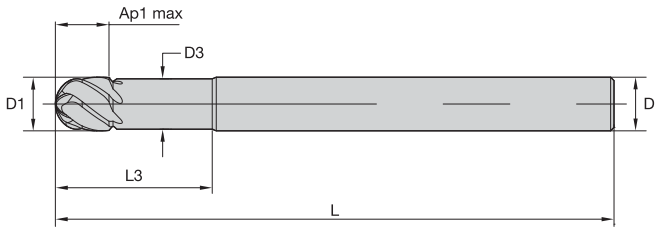
KCSM15	D1	D	Ap1 max	L
UJBE0375J6B	3/8	3/8	7/8	2 1/2
UJBE0500J6B	1/2	1/2	1	3
UJBE0500J6C	1/2	1/2	1 1/4	3
UJBE0625J6B	5/8	5/8	1 1/4	3 1/2
UJBE0750J6B	3/4	3/4	1 1/2	4
UJBE1000J6B	1	1	1 1/2	4

NOTE: For application data, see page P56.

- Kennametal standard dimensions.
- Center cutting.
- Optimized geometry for titanium machining.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.



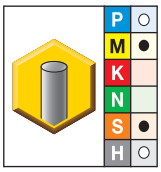




End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1-3/16"	0/.00051"

UJBE • 6-Flute Ball Nose with Eccentric Relief Grind and Neck • Inch



● first choice
○ alternate choice

KCSM15	D1	D	D3	Ap1 max	L3	L
UJBE0375J6AL	3/8	3/8	.35	1/2	2.00	6
UJBE0500J6AL	1/2	1/2	.47	5/8	2.25	6
UJBE0625J6AL	5/8	5/8	.59	3/4	2.25	6
UJBE0750J6AL	3/4	3/4	.71	1	2.25	6
UJBE1000J6AL	1	1	.94	1 1/4	3.25	6

NOTE: For application data, see page P56.



HARVI III Ball Nose with Eccentric Relief

CHALLENGE

- Finish profile machining of keel for weapon attachment.
- Vertical machining center.
- Titanium Alloy Beta (R56400).
- External emulsion.

SOLUTION

- HARVI III ball nose Ø .5" with eccentric relief in KCSM15™.
- Six effective teeth.

CUTTING DATA

- vc 300 SFM
- fz .0018 IPT
- ap 1.2"
- ae .025"

RESULT

- Significantly increased tool life.
- Reduced machining time from 210 minutes to 90 minutes.
- Surface finish 90 RMS.

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 .787" (20mm) with eccentric relief in KCSM15.
- Six effective teeth.

CUTTING DATA

- vc 400 SFM
- fz .003 IPT
- ap 1.7"
- ae .1"

RESULT

- Tool completed seven workpieces compared to five workpieces with existing tooling.
- Surface finish 120 RMS.

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 stich profile neck to flanged blend.
- Lathe with driven tooling.
- 4340 low-alloy steel.
- External emulsion.

SOLUTION

- HARVI III ball nose Ø .5" with eccentric relief in KCSM15™.
- Six effective teeth.

CUTTING DATA

- vc 350 SFM
- fz .0025 IPT
- ap .05"
- ae .05"

RESULT

- Increase in cutting speed from 150 SFM to 350 SFM.
- 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 Rate (MRR).

HARVI III Ball Nose with Eccentric Relief

CHALLENGE

- Finish interior walls and blend filet radius.
- Horizontal machining center.
- 4340 low-alloy steel.
- External emulsion.

SOLUTION

- HARVI III ball nose Ø .5" with eccentric relief in KCSM15.
- Six effective teeth.

CUTTING DATA

- vc 350 SFM
- fz .0025 IPT
- ap .553"
- ae .05"

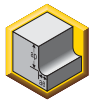
RESULT

- Tool completed six workpieces compared to two workpieces with existing solution.
- Surface finish 63 RMS.

BENEFIT

- Reduced machining time from 25 minutes to 10 minutes.
- Improved surface finish from 90 RMS to 63 RMS 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

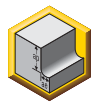




Material Group		Side Milling (A)		KCSM15			Recommended feed per tooth (IPT = inch/th) for side milling (A).				
		A		Cutting Speed — vc SFM				D1 — Diameter			
							frac.	3/8	1/2	5/8	3/4	1
		ap	ae	min		max	inch	.3750	.5000	.6250	.7500	1.0000
P	0	Ap max	0.4 x D	490	–	660	IPT	.0027	.0034	.0039	.0044	.0049
	1	Ap max	0.4 x D	490	–	660	IPT	.0027	.0034	.0039	.0044	.0049
	2	Ap max	0.4 x D	460	–	620	IPT	.0027	.0034	.0039	.0044	.0049
	3	Ap max	0.4 x D	390	–	520	IPT	.0023	.0029	.0034	.0039	.0045
	4	Ap max	0.4 x D	300	–	490	IPT	.0020	.0026	.0030	.0034	.0039
	5	Ap max	0.4 x D	200	–	330	IPT	.0018	.0023	.0027	.0031	.0036
	4	Ap max	0.4 x D	160	–	250	IPT	.0015	.0019	.0022	.0025	.0028
M	1	Ap max	0.4 x D	300	–	380	IPT	.0023	.0029	.0034	.0039	.0045
	2	Ap max	0.4 x D	200	–	260	IPT	.0018	.0023	.0027	.0031	.0036
	3	Ap max	0.4 x D	200	–	230	IPT	.0015	.0019	.0022	.0025	.0028
S	1	Ap max	0.4 x D	160	–	300	IPT	.0023	.0029	.0034	.0039	.0045
	2	Ap max	0.4 x D	80	–	130	IPT	.0012	.0015	.0018	.0021	.0024
	3	Ap max	0.4 x D	80	–	130	IPT	.0012	.0015	.0018	.0021	.0024
	4	Ap max	0.4 x D	160	–	200	IPT	.0017	.0021	.0025	.0028	.0033
H	1	Ap max	0.4 x D	260	–	460	IPT	.0020	.0026	.0030	.0034	.0039

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 centers, please adjust parameters accordingly on >1/2" diameter.

HARVI III • UJBE • Ball Nose • Unequal Flute Spacing • Finishing





Material Group		Side Milling (A)		KCSM15			Recommended feed per tooth (IPT = inch/th) for side milling (A).				
		A		Cutting Speed — vc SFM				D1 — Diameter			
							frac.	3/8	1/2	5/8	3/4	1
		ap	ae	min		max	in	.3750	.5000	.6250	.7500	1.0000
P	0	Ap max	0.06 x D	940	–	1250	IPT	.0033	.0041	.0047	.0053	.0059
	1	Ap max	0.06 x D	940	–	1250	IPT	.0033	.0041	.0047	.0053	.0059
	2	Ap max	0.06 x D	870	–	1180	IPT	.0033	.0041	.0047	.0053	.0059
	3	Ap max	0.06 x D	750	–	1000	IPT	.0027	.0035	.0041	.0046	.0054
	4	Ap max	0.06 x D	560	–	940	IPT	.0025	.0031	.0036	.0040	.0046
	5	Ap max	0.06 x D	370	–	620	IPT	.0022	.0028	.0033	.0037	.0043
	6	Ap max	0.06 x D	310	–	470	IPT	.0018	.0023	.0027	.0030	.0034
M	1	Ap max	0.06 x D	560	–	720	IPT	.0027	.0035	.0041	.0046	.0054
	2	Ap max	0.06 x D	370	–	500	IPT	.0022	.0028	.0033	.0037	.0043
	3	Ap max	0.06 x D	370	–	440	IPT	.0018	.0023	.0027	.0030	.0034
S	1	Ap max	0.06 x D	310	–	560	IPT	.0027	.0035	.0041	.0046	.0054
	2	Ap max	0.06 x D	160	–	250	IPT	.0015	.0018	.0022	.0025	.0029
	3	Ap max	0.06 x D	160	–	250	IPT	.0015	.0018	.0022	.0025	.0029
	4	Ap max	0.06 x D	310	–	370	IPT	.0020	.0026	.0030	.0034	.0040
H	1	Ap max	0.06 x D	500	–	870	IPT	.0025	.0031	.0036	.0040	.0046

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 centers, please adjust parameters accordingly on >1/2" diameter.

Superior Finishing

MaxiMet™

Designed to significantly reduce machining time in aluminum! The innovative geometry designs include a wiper facet for superior surface finish on aluminum 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 Authorized Kennametal Distributor.

KENNAMETAL®

kennametal.com

HARVI™ III

High-Performance Solid Carbide End Mills

Primary Application

This new HARVI III version is tailored to address traditional machining techniques, as well as high-velocity machining techniques with one tool design. This allows for the highest level of flexibility, fully utilizing the tool capabilities. This is designed specifically for high-performance profiling, semi-finishing, and finishing of titanium. The HARVI III provides maximum metal removal rates and achieves supreme surfaces. The standard offering comprises various length versions for each diameter to satisfy the need for maximum stability, as well as highest reach lengths in ball nose and square end designs.

- 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 the highest tool stability in roughing and finishing operations.
- Center cutting design for higher flexibility, as well as radial and axial finishing pass after roughing operation.
- Tailored rank angles allow for high performance in both traditional and high-velocity machining techniques.

Tailored Grades

- KCSM15™ Beyond™ grade for exceptional tool life in titanium and stainless steels.

Customization

- Engineered solutions, including ball nose versions, are available upon request.

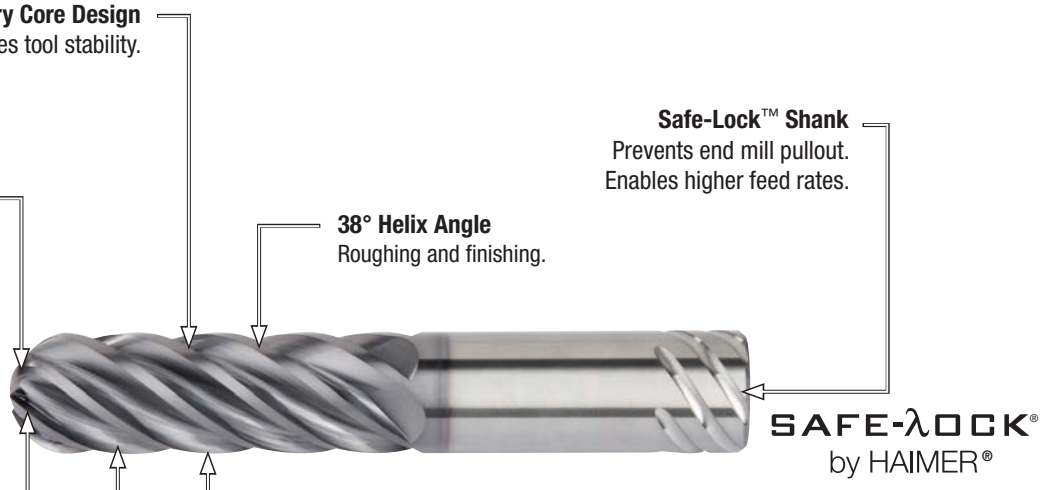
Extensive Standard Offering

- Off-the-shelf standard diameter range 1/2–1".
- 1 1/2" diameter items are made-to-order.
- Ball nose and corner radii tooling in various length.
- Round shank and Safe-Lock™ shank available.

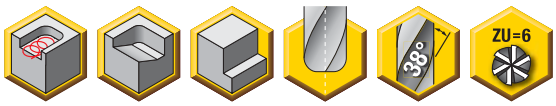
The new HARVI™ III by Kennametal.

"The HARVI III line boasts a portfolio of 300+ tools that have met the expectations set forth in the Industry Challenge — Increased tool life, High MRR, Reduced Tool Changes, and Decreasing overall tooling cost."

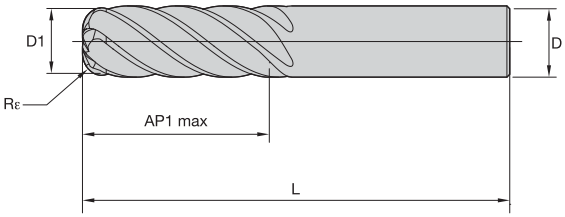




- Kennametal standard dimensions.
- Center cutting.
- Optimized geometry for titanium machining.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.





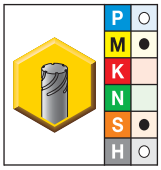


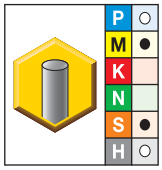
End Mill Tolerances

D1	tolerance	D	tolerance
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1-3/16"	0/.00051"

beyond

HARVI III • UJDE • Unequal Flute Spacing • With Eccentric Relief Grind



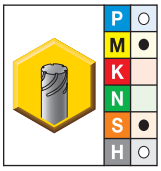


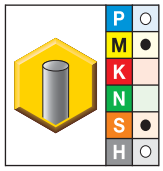
● first choice
○ alternate choice

KCSM15	KCSM15	D1	D	Ap1 max	L	Rε
–	UJDE0500J6ABB	1/2	1/2	1	3	.030
–	UJDE0500J6ABC	1/2	1/2	1	3	.060
–	UJDE0500J6ABD	1/2	1/2	1	3	.090
–	UJDE0500J6ABE	1/2	1/2	1	3	.120
–	UJDE0500J6ABH	1/2	1/2	1	3	.190
–	UJDE0500J6ZBB	1/2	1/2	1 1/2	3 1/2	.030
–	UJDE0500J6ZBC	1/2	1/2	1 1/2	3 1/2	.060
–	UJDE0500J6ZBD	1/2	1/2	1 1/2	3 1/2	.090
–	UJDE0500J6ZBE	1/2	1/2	1 1/2	3 1/2	.120
–	UJDE0500J6ZBH	1/2	1/2	1 1/2	3 1/2	.190
–	UJDE0500J6CBB	1/2	1/2	2	4	.030
–	UJDE0500J6CBC	1/2	1/2	2	4	.060
–	UJDE0500J6CBD	1/2	1/2	2	4	.090
–	UJDE0500J6CBE	1/2	1/2	2	4	.120
–	UJDE0500J6CBH	1/2	1/2	2	4	.190
–	UJDE0500J6DBB	1/2	1/2	2 1/2	4 1/2	.030
–	UJDE0500J6DBC	1/2	1/2	2 1/2	4 1/2	.060
–	UJDE0500J6DBD	1/2	1/2	2 1/2	4 1/2	.090
–	UJDE0500J6DBE	1/2	1/2	2 1/2	4 1/2	.120
–	UJDE0500J6DBH	1/2	1/2	2 1/2	4 1/2	.190
–	UJDE0750J6ABB	3/4	3/4	1	3 1/2	.030
–	UJDE0750J6ABC	3/4	3/4	1	3 1/2	.060
–	UJDE0750J6ABD	3/4	3/4	1	3 1/2	.090
–	UJDE0750J6ABE	3/4	3/4	1	3 1/2	.120
–	UJDE0750J6ABH	3/4	3/4	1	3 1/2	.190
–	UJDE0750J6ABF	3/4	3/4	1	3 1/2	.250
–	UJDE0750J6ZBB	3/4	3/4	2	4 1/2	.030
–	UJDE0750J6ZBC	3/4	3/4	2	4 1/2	.060
–	UJDE0750J6ZBD	3/4	3/4	2	4 1/2	.090
–	UJDE0750J6ZBE	3/4	3/4	2	4 1/2	.120
–	UJDE0750J6ZBH	3/4	3/4	2	4 1/2	.190
–	UJDE0750J6ZBF	3/4	3/4	2	4 1/2	.250

(continued)

(HARVI III • UJDE • Unequal Flute Spacing • With Eccentric Relief Grind — continued)



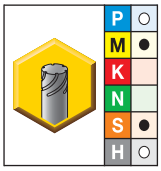


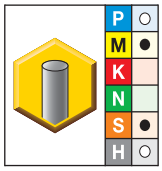
● first choice
○ alternate choice

KCSM15	KCSM15	D1	D	Ap1 max	L	Rε
–	UJDE0750J6DBB	3/4	3/4	3	5 1/2	.030
–	UJDE0750J6DBC	3/4	3/4	3	5 1/2	.060
–	UJDE0750J6DBD	3/4	3/4	3	5 1/2	.090
–	UJDE0750J6DBE	3/4	3/4	3	5 1/2	.120
–	UJDE0750J6DBH	3/4	3/4	3	5 1/2	.190
–	UJDE0750J6DBF	3/4	3/4	3	5 1/2	.250
–	UJDE0750J6EBB	3/4	3/4	4	6 1/2	.030
–	UJDE0750J6EBC	3/4	3/4	4	6 1/2	.060
–	UJDE0750J6EBD	3/4	3/4	4	6 1/2	.090
–	UJDE0750J6EBE	3/4	3/4	4	6 1/2	.120
–	UJDE0750J6EBH	3/4	3/4	4	6 1/2	.190
–	UJDE0750J6EBF	3/4	3/4	4	6 1/2	.250
UJDE1000N6XBB	–	1	1	1	4	.030
UJDE1000N6XBC	–	1	1	1	4	.060
UJDE1000N6XBD	–	1	1	1	4	.090
UJDE1000N6XBE	–	1	1	1	4	.120
UJDE1000N6XBH	–	1	1	1	4	.190
UJDE1000N6XBF	–	1	1	1	4	.250
UJDE1000N6XBK	–	1	1	1	4	.375
UJDE1000N6ABB	–	1	1	1 1/2	4 1/2	.030
UJDE1000N6ABC	–	1	1	1 1/2	4 1/2	.060
UJDE1000N6ABD	–	1	1	1 1/2	4 1/2	.090
UJDE1000N6ABE	–	1	1	1 1/2	4 1/2	.120
UJDE1000N6ABH	–	1	1	1 1/2	4 1/2	.190
UJDE1000N6ABF	–	1	1	1 1/2	4 1/2	.250
UJDE1000N6ABK	–	1	1	1 1/2	4 1/2	.375
UJDE1000N6CBB	–	1	1	2	5	.030
UJDE1000N6CBC	–	1	1	2	5	.060
UJDE1000N6CBD	–	1	1	2	5	.090
UJDE1000N6CBE	–	1	1	2	5	.120
UJDE1000N6CBH	–	1	1	2	5	.190
UJDE1000N6CBF	–	1	1	2	5	.250
UJDE1000N6CBK	–	1	1	2	5	.375
UJDE1000N6ZBB	–	1	1	2 1/2	5 1/2	.030
UJDE1000N6ZBC	–	1	1	2 1/2	5 1/2	.060
UJDE1000N6ZBD	–	1	1	2 1/2	5 1/2	.090
UJDE1000N6ZBE	–	1	1	2 1/2	5 1/2	.120
UJDE1000N6ZBH	–	1	1	2 1/2	5 1/2	.190
UJDE1000N6ZBF	–	1	1	2 1/2	5 1/2	.250
UJDE1000N6ZBK	–	1	1	2 1/2	5 1/2	.375
UJDE1000N6FBB	–	1	1	3	6	.030
UJDE1000N6FBC	–	1	1	3	6	.060
UJDE1000N6FBD	–	1	1	3	6	.090
UJDE1000N6FBE	–	1	1	3	6	.120
UJDE1000N6FBH	–	1	1	3	6	.190
UJDE1000N6FBF	–	1	1	3	6	.250
UJDE1000N6FBK	–	1	1	3	6	.375
UJDE1000N6GBB	–	1	1	3 1/2	6 1/2	.030
UJDE1000N6GBC	–	1	1	3 1/2	6 1/2	.060
UJDE1000N6GBD	–	1	1	3 1/2	6 1/2	.090
UJDE1000N6GBE	–	1	1	3 1/2	6 1/2	.120
UJDE1000N6GBH	–	1	1	3 1/2	6 1/2	.190

(continued)

(HARVI III • UJDE • Unequal Flute Spacing • With Eccentric Relief Grind — continued)



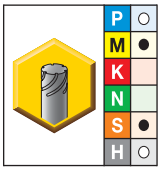


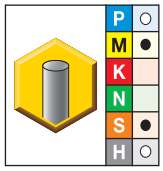
● first choice
○ alternate choice

KCSM15	KCSM15	D1	D	Ap1 max	L	Rε
UJDE1000N6GBF	–	1	1	3 1/2	6 1/2	.250
UJDE1000N6GBK	–	1	1	3 1/2	6 1/2	.375
UJDE1000N6DBB	–	1	1	4	7	.030
UJDE1000N6DBC	–	1	1	4	7	.060
UJDE1000N6DBD	–	1	1	4	7	.090
UJDE1000N6DBE	–	1	1	4	7	.120
UJDE1000N6DBH	–	1	1	4	7	.190
UJDE1000N6DBF	–	1	1	4	7	.250
UJDE1000N6DBK	–	1	1	4	7	.375
UJDE1000N6HBB	–	1	1	4 1/2	7 1/2	.030
UJDE1000N6HBC	–	1	1	4 1/2	7 1/2	.060
UJDE1000N6HBD	–	1	1	4 1/2	7 1/2	.090
UJDE1000N6HBE	–	1	1	4 1/2	7 1/2	.120
UJDE1000N6HBH	–	1	1	4 1/2	7 1/2	.190
UJDE1000N6HBF	–	1	1	4 1/2	7 1/2	.250
UJDE1000N6HBK	–	1	1	4 1/2	7 1/2	.375
UJDE1000N6EBB	–	1	1	5	8	.030
UJDE1000N6EBC	–	1	1	5	8	.060
UJDE1000N6EBD	–	1	1	5	8	.090
UJDE1000N6EBE	–	1	1	5	8	.120
UJDE1000N6EBH	–	1	1	5	8	.190
UJDE1000N6EBF	–	1	1	5	8	.250
UJDE1000N6EBK	–	1	1	5	8	.375
UJDE1250N6ABB	–	1 1/4	1 1/4	2	5	.030
UJDE1250N6ABC	–	1 1/4	1 1/4	2	5	.060
UJDE1250N6ABD	–	1 1/4	1 1/4	2	5	.090
UJDE1250N6ABE	–	1 1/4	1 1/4	2	5	.120
UJDE1250N6ABH	–	1 1/4	1 1/4	2	5	.190
UJDE1250N6ABF	–	1 1/4	1 1/4	2	5	.250
UJDE1250N6ABJ	–	1 1/4	1 1/4	2	5	.375
UJDE1250N6ABK	–	1 1/4	1 1/4	2	5	.500
UJDE1250N6XBB	–	1 1/4	1 1/4	2 1/2	5 1/2	.030
UJDE1250N6XBC	–	1 1/4	1 1/4	2 1/2	5 1/2	.060
UJDE1250N6XBD	–	1 1/4	1 1/4	2 1/2	5 1/2	.090
UJDE1250N6XBE	–	1 1/4	1 1/4	2 1/2	5 1/2	.120
UJDE1250N6XBH	–	1 1/4	1 1/4	2 1/2	5 1/2	.190
UJDE1250N6XBF	–	1 1/4	1 1/4	2 1/2	5 1/2	.250
UJDE1250N6XBJ	–	1 1/4	1 1/4	2 1/2	5 1/2	.375
UJDE1250N6XBK	–	1 1/4	1 1/4	2 1/2	5 1/2	.500
UJDE1250N6ZBB	–	1 1/4	1 1/4	3	6	.030
UJDE1250N6ZBC	–	1 1/4	1 1/4	3	6	.060
UJDE1250N6ZBD	–	1 1/4	1 1/4	3	6	.090
UJDE1250N6ZBE	–	1 1/4	1 1/4	3	6	.120
UJDE1250N6ZBH	–	1 1/4	1 1/4	3	6	.190
UJDE1250N6ZBF	–	1 1/4	1 1/4	3	6	.250
UJDE1250N6ZBJ	–	1 1/4	1 1/4	3	6	.375
UJDE1250N6ZBK	–	1 1/4	1 1/4	3	6	.500
UJDE1250N6CBB	–	1 1/4	1 1/4	3 1/2	6 1/2	.030
UJDE1250N6CBC	–	1 1/4	1 1/4	3 1/2	6 1/2	.060
UJDE1250N6CBD	–	1 1/4	1 1/4	3 1/2	6 1/2	.090
UJDE1250N6CBE	–	1 1/4	1 1/4	3 1/2	6 1/2	.120
UJDE1250N6CBH	–	1 1/4	1 1/4	3 1/2	6 1/2	.190

(continued)

(HARVI III • UJDE • Unequal Flute Spacing • With Eccentric Relief Grind — continued)



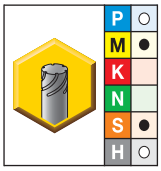


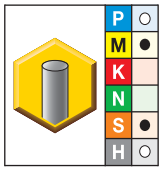
● first choice
○ alternate choice

KCSM15	KCSM15	D1	D	Ap1 max	L	Rε
UJDE1250N6CBF	–	1 1/4	1 1/4	3 1/2	6 1/2	.250
UJDE1250N6CBJ	–	1 1/4	1 1/4	3 1/2	6 1/2	.375
UJDE1250N6CBK	–	1 1/4	1 1/4	3 1/2	6 1/2	.500
UJDE1250N6FBB	–	1 1/4	1 1/4	4	7	.030
UJDE1250N6FBC	–	1 1/4	1 1/4	4	7	.060
UJDE1250N6FBD	–	1 1/4	1 1/4	4	7	.090
UJDE1250N6FBE	–	1 1/4	1 1/4	4	7	.120
UJDE1250N6FBH	–	1 1/4	1 1/4	4	7	.190
UJDE1250N6FBF	–	1 1/4	1 1/4	4	7	.250
UJDE1250N6FBJ	–	1 1/4	1 1/4	4	7	.375
UJDE1250N6FBK	–	1 1/4	1 1/4	4	7	.500
UJDE1250N6GBB	–	1 1/4	1 1/4	4 1/2	7 1/2	.030
UJDE1250N6GBC	–	1 1/4	1 1/4	4 1/2	7 1/2	.060
UJDE1250N6GBD	–	1 1/4	1 1/4	4 1/2	7 1/2	.090
UJDE1250N6GBE	–	1 1/4	1 1/4	4 1/2	7 1/2	.120
UJDE1250N6GBH	–	1 1/4	1 1/4	4 1/2	7 1/2	.190
UJDE1250N6GBF	–	1 1/4	1 1/4	4 1/2	7 1/2	.250
UJDE1250N6GBJ	–	1 1/4	1 1/4	4 1/2	7 1/2	.375
UJDE1250N6GBK	–	1 1/4	1 1/4	4 1/2	7 1/2	.500
UJDE1250N6DBB	–	1 1/4	1 1/4	5	8	.030
UJDE1250N6DBC	–	1 1/4	1 1/4	5	8	.060
UJDE1250N6DBD	–	1 1/4	1 1/4	5	8	.090
UJDE1250N6DBE	–	1 1/4	1 1/4	5	8	.120
UJDE1250N6DBH	–	1 1/4	1 1/4	5	8	.190
UJDE1250N6DBF	–	1 1/4	1 1/4	5	8	.250
UJDE1250N6DBJ	–	1 1/4	1 1/4	5	8	.375
UJDE1250N6DBK	–	1 1/4	1 1/4	5	8	.500
UJDE1250N6HBB	–	1 1/4	1 1/4	5 1/2	8 1/2	.030
UJDE1250N6HBC	–	1 1/4	1 1/4	5 1/2	8 1/2	.060
UJDE1250N6HBD	–	1 1/4	1 1/4	5 1/2	8 1/2	.090
UJDE1250N6HBE	–	1 1/4	1 1/4	5 1/2	8 1/2	.120
UJDE1250N6HBH	–	1 1/4	1 1/4	5 1/2	8 1/2	.190
UJDE1250N6HBF	–	1 1/4	1 1/4	5 1/2	8 1/2	.250
UJDE1250N6HBJ	–	1 1/4	1 1/4	5 1/2	8 1/2	.375
UJDE1250N6HBK	–	1 1/4	1 1/4	5 1/2	8 1/2	.500
UJDE1250N6JBB	–	1 1/4	1 1/4	6	9	.030
UJDE1250N6JBC	–	1 1/4	1 1/4	6	9	.060
UJDE1250N6JBD	–	1 1/4	1 1/4	6	9	.090
UJDE1250N6JBE	–	1 1/4	1 1/4	6	9	.120
UJDE1250N6JBH	–	1 1/4	1 1/4	6	9	.190
UJDE1250N6JBF	–	1 1/4	1 1/4	6	9	.250
UJDE1250N6JBJ	–	1 1/4	1 1/4	6	9	.375
UJDE1250N6JBK	–	1 1/4	1 1/4	6	9	.500
UJDE1250N6EBB	–	1 1/4	1 1/4	6 1/2	9 1/2	.030
UJDE1250N6EBC	–	1 1/4	1 1/4	6 1/2	9 1/2	.060
UJDE1250N6EBD	–	1 1/4	1 1/4	6 1/2	9 1/2	.090
UJDE1250N6EBE	–	1 1/4	1 1/4	6 1/2	9 1/2	.120
UJDE1250N6EBH	–	1 1/4	1 1/4	6 1/2	9 1/2	.190
UJDE1250N6EBF	–	1 1/4	1 1/4	6 1/2	9 1/2	.250
UJDE1250N6EBJ	–	1 1/4	1 1/4	6 1/2	9 1/2	.375
UJDE1250N6EBK	–	1 1/4	1 1/4	6 1/2	9 1/2	.500
UJDE1500N6XBB *	–	1 1/2	1 1/2	2	6	.030

(continued)

(HARVI III • UJDE • Unequal Flute Spacing • With Eccentric Relief Grind — continued)



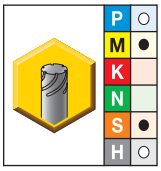


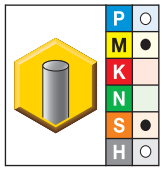
● first choice
○ alternate choice

KCSM15	KCSM15	D1	D	Ap1 max	L	Rε
UJDE1500N6XBC *	–	1 1/2	1 1/2	2	6	.060
UJDE1500N6XBD *	–	1 1/2	1 1/2	2	6	.090
UJDE1500N6XBE *	–	1 1/2	1 1/2	2	6	.120
UJDE1500N6XBH *	–	1 1/2	1 1/2	2	6	.190
UJDE1500N6XBF *	–	1 1/2	1 1/2	2	6	.250
UJDE1500N6XBJ *	–	1 1/2	1 1/2	2	6	.375
UJDE1500N6XBK *	–	1 1/2	1 1/2	2	6	.500
UJDE1500N6XBL *	–	1 1/2	1 1/2	2	6	.625
UJDE1500N6ABB *	–	1 1/2	1 1/2	2 1/2	6 1/2	.030
UJDE1500N6ABC *	–	1 1/2	1 1/2	2 1/2	6 1/2	.060
UJDE1500N6ABD *	–	1 1/2	1 1/2	2 1/2	6 1/2	.090
UJDE1500N6ABE *	–	1 1/2	1 1/2	2 1/2	6 1/2	.120
UJDE1500N6ABH *	–	1 1/2	1 1/2	2 1/2	6 1/2	.190
UJDE1500N6ABF *	–	1 1/2	1 1/2	2 1/2	6 1/2	.250
UJDE1500N6ABJ *	–	1 1/2	1 1/2	2 1/2	6 1/2	.375
UJDE1500N6ABK *	–	1 1/2	1 1/2	2 1/2	6 1/2	.500
UJDE1500N6ABL *	–	1 1/2	1 1/2	2 1/2	6 1/2	.625
UJDE1500N6BBB *	–	1 1/2	1 1/2	3	7	.030
UJDE1500N6BBC *	–	1 1/2	1 1/2	3	7	.060
UJDE1500N6BBD *	–	1 1/2	1 1/2	3	7	.090
UJDE1500N6BBE *	–	1 1/2	1 1/2	3	7	.120
UJDE1500N6BBH *	–	1 1/2	1 1/2	3	7	.190
UJDE1500N6BBF *	–	1 1/2	1 1/2	3	7	.250
UJDE1500N6BBJ *	–	1 1/2	1 1/2	3	7	.375
UJDE1500N6BBK *	–	1 1/2	1 1/2	3	7	.500
UJDE1500N6BBL *	–	1 1/2	1 1/2	3	7	.625
UJDE1500N6ZBB *	–	1 1/2	1 1/2	3 1/2	7 1/2	.030
UJDE1500N6ZBC *	–	1 1/2	1 1/2	3 1/2	7 1/2	.060
UJDE1500N6ZBD *	–	1 1/2	1 1/2	3 1/2	7 1/2	.090
UJDE1500N6ZBE *	–	1 1/2	1 1/2	3 1/2	7 1/2	.120
UJDE1500N6ZBH *	–	1 1/2	1 1/2	3 1/2	7 1/2	.190
UJDE1500N6ZBF *	–	1 1/2	1 1/2	3 1/2	7 1/2	.250
UJDE1500N6ZBJ *	–	1 1/2	1 1/2	3 1/2	7 1/2	.375
UJDE1500N6ZBK *	–	1 1/2	1 1/2	3 1/2	7 1/2	.500
UJDE1500N6ZBL *	–	1 1/2	1 1/2	3 1/2	7 1/2	.625
UJDE1500N6CBB *	–	1 1/2	1 1/2	4	8	.030
UJDE1500N6CBC *	–	1 1/2	1 1/2	4	8	.060
UJDE1500N6CBD *	–	1 1/2	1 1/2	4	8	.090
UJDE1500N6CBE *	–	1 1/2	1 1/2	4	8	.120
UJDE1500N6CBH *	–	1 1/2	1 1/2	4	8	.190
UJDE1500N6CBF *	–	1 1/2	1 1/2	4	8	.250
UJDE1500N6CBJ *	–	1 1/2	1 1/2	4	8	.375
UJDE1500N6CBK *	–	1 1/2	1 1/2	4	8	.500
UJDE1500N6CBL *	–	1 1/2	1 1/2	4	8	.625
UJDE1500N6FBB *	–	1 1/2	1 1/2	4 1/2	8 1/2	.030
UJDE1500N6FBC *	–	1 1/2	1 1/2	4 1/2	8 1/2	.060
UJDE1500N6FBD *	–	1 1/2	1 1/2	4 1/2	8 1/2	.090
UJDE1500N6FBE *	–	1 1/2	1 1/2	4 1/2	8 1/2	.120
UJDE1500N6FBH *	–	1 1/2	1 1/2	4 1/2	8 1/2	.190
UJDE1500N6FBF *	–	1 1/2	1 1/2	4 1/2	8 1/2	.250
UJDE1500N6FBJ *	–	1 1/2	1 1/2	4 1/2	8 1/2	.375
UJDE1500N6FBK *	–	1 1/2	1 1/2	4 1/2	8 1/2	.500

(continued)

(HARVI III • UJDE • Unequal Flute Spacing • With Eccentric Relief Grind — continued)





● first choice
○ alternate choice

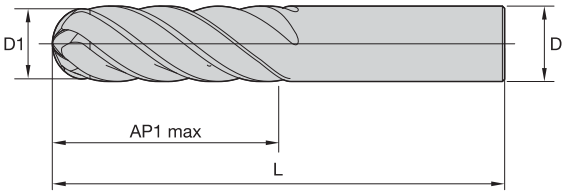
KCSM15	KCSM15	D1	D	Ap1 max	L	Rε
UJDE1500N6FBL *	–	1 1/2	1 1/2	4 1/2	8 1/2	.625
UJDE1500N6GBB *	–	1 1/2	1 1/2	5	9	.030
UJDE1500N6GBC *	–	1 1/2	1 1/2	5	9	.060
UJDE1500N6GBD *	–	1 1/2	1 1/2	5	9	.090
UJDE1500N6GBE *	–	1 1/2	1 1/2	5	9	.120
UJDE1500N6GBH *	–	1 1/2	1 1/2	5	9	.190
UJDE1500N6GBF *	–	1 1/2	1 1/2	5	9	.250
UJDE1500N6GBJ *	–	1 1/2	1 1/2	5	9	.375
UJDE1500N6GBK *	–	1 1/2	1 1/2	5	9	.500
UJDE1500N6GBL *	–	1 1/2	1 1/2	5	9	.625
UJDE1500N6DBB *	–	1 1/2	1 1/2	5 1/2	9 1/2	.030
UJDE1500N6DBC *	–	1 1/2	1 1/2	5 1/2	9 1/2	.060
UJDE1500N6DBD *	–	1 1/2	1 1/2	5 1/2	9 1/2	.090
UJDE1500N6DBE *	–	1 1/2	1 1/2	5 1/2	9 1/2	.120
UJDE1500N6DBH *	–	1 1/2	1 1/2	5 1/2	9 1/2	.190
UJDE1500N6DBF *	–	1 1/2	1 1/2	5 1/2	9 1/2	.250
UJDE1500N6DBJ *	–	1 1/2	1 1/2	5 1/2	9 1/2	.375
UJDE1500N6DBK *	–	1 1/2	1 1/2	5 1/2	9 1/2	.500
UJDE1500N6DBL *	–	1 1/2	1 1/2	5 1/2	9 1/2	.625
UJDE1500N6HBB *	–	1 1/2	1 1/2	6	10	.030
UJDE1500N6HBC *	–	1 1/2	1 1/2	6	10	.060
UJDE1500N6HBD *	–	1 1/2	1 1/2	6	10	.090
UJDE1500N6HBE *	–	1 1/2	1 1/2	6	10	.120
UJDE1500N6HBH *	–	1 1/2	1 1/2	6	10	.190
UJDE1500N6HBF *	–	1 1/2	1 1/2	6	10	.250
UJDE1500N6HBJ *	–	1 1/2	1 1/2	6	10	.375
UJDE1500N6HBK *	–	1 1/2	1 1/2	6	10	.500
UJDE1500N6HBL *	–	1 1/2	1 1/2	6	10	.625

NOTE: For application data, see page P70.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standard dimensions.
- Center cutting.
- Optimized geometry for titanium machining.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations requiring fewer setups.





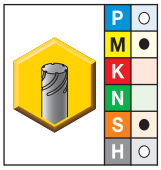


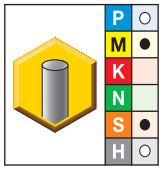
End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1-3/16"	0/.00051"

beyond

HARVI III Ball Nose • UJBE • Unequal Flute Spacing • With Eccentric Relief Grind



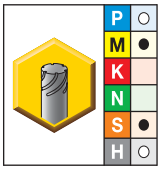


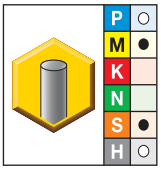
● first choice
○ alternate choice

KCSM15	KCSM15	D1	D	Ap1 max	L
–	UJBE0500J6BB	1/2	1/2	1	3
–	UJBE0500J6ZB	1/2	1/2	1 1/2	3 1/2
–	UJBE0500J6CB	1/2	1/2	2	4
–	UJBE0500J6DB	1/2	1/2	2 1/2	4 1/2
–	UJBE0750J6AB	3/4	3/4	1	3 1/2
–	UJBE0750J6ZB	3/4	3/4	2	4 1/2
–	UJBE0750J6DB	3/4	3/4	3	5 1/2
–	UJBE0750J6EB	3/4	3/4	4	6 1/2
UJBE1000N6XB	–	1	1	1	4
UJBE1000N6AB	–	1	1	1 1/2	4 1/2
UJBE1000N6CB	–	1	1	2	5
UJBE1000N6ZB	–	1	1	2 1/2	5 1/2
UJBE1000N6FB	–	1	1	3	6
UJBE1000N6GB	–	1	1	3 1/2	6 1/2
UJBE1000N6DB	–	1	1	4	7
UJBE1000N6HB	–	1	1	4 1/2	7 1/2
UJBE1000N6EB	–	1	1	5	8
UJBE1250N6AB	–	1 1/4	1 1/4	2	5
UJBE1250N6XB	–	1 1/4	1 1/4	2 1/2	5 1/2
UJBE1250N6ZB	–	1 1/4	1 1/4	3	6
UJBE1250N6CB	–	1 1/4	1 1/4	3 1/2	6 1/2
UJBE1250N6FB	–	1 1/4	1 1/4	4	7
UJBE1250N6GB	–	1 1/4	1 1/4	4 1/2	7 1/2
UJBE1250N6DB	–	1 1/4	1 1/4	5	8
UJBE1250N6HB	–	1 1/4	1 1/4	5 1/2	8 1/2
UJBE1250N6JB	–	1 1/4	1 1/4	6	9
UJBE1250N6EB	–	1 1/4	1 1/4	6 1/2	9 1/2
UJBE1500N6XB *	–	1 1/2	1 1/2	2	6

(continued)

(HARVI III Ball Nose • UJBE • Unequal Flute Spacing • With Eccentric Relief Grind — continued)





● first choice
○ alternate choice

KCSM15	KCSM15	D1	D	Ap1 max	L
UJBE1500N6AB *	–	1 1/2	1 1/2	2 1/2	6 1/2
UJBE1500N6BB *	–	1 1/2	1 1/2	3	7
UJBE1500N6ZB *	–	1 1/2	1 1/2	3 1/2	7 1/2
UJBE1500N6CB *	–	1 1/2	1 1/2	4	8
UJBE1500N6FB *	–	1 1/2	1 1/2	4 1/2	8 1/2
UJBE1500N6GB *	–	1 1/2	1 1/2	5	9
UJBE1500N6DB *	–	1 1/2	1 1/2	5 1/2	9 1/2
UJBE1500N6HB *	–	1 1/2	1 1/2	6	10

NOTE: For application data, see page P71.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.



HARVI III Aerospace Expansion

CHALLENGE

- Industry challenge II.
- Traditional approach.
- Ti6AL4V.
- External emulsion.

SOLUTION

- HARVI III Ø 1.250" (31.75mm) — Safe-Lock™ shank.
- SK50 Type B coolant shrink fit.
- Corner Radius R = 0.090" (2.28mm).

CUTTING DATA

- V_c 250 SFM (76 m/min).
- F_z .0074" (0,187mm).
- A_p 2.000" (50.8mm).
- A_e .100" (2,54mm).

RESULT

- After one hour of cut time, less than .001" (0,025mm) wear.
- Surface finish of 23 µ in Ra (0,6 µm Ra).

BENEFIT

- Increased tool life.
- High MRR.
- Reduced tool changes.
- Decrease overall tooling cost.



HARVI III Aerospace Expansion

CHALLENGE

- Industry challenge II.
- High-Velocity Approach.
- Ti6AL4V.
- External emulsion.

SOLUTION

- HARVI III Ø 1.250" (31.75mm) — Safe-Lock™ shank.
- SK50 Type B coolant shrink fit.
- Corner Radius R = 0.090" (2.28mm).

CUTTING DATA

- V_c 500 SFM (152 m/min).
- F_z .0095" (0,24mm).
- A_p 2.000" (50.8mm).
- A_e .020" (0,508mm).

RESULT

- After one hour of cut time, less than .0014" (0,035mm) wear.
- Surface finish of 27.5 µ in Ra (0,7 µm Ra).

BENEFIT

- Increased tool life.
- High MRR.
- Reduced tool changes.
- Decrease overall tooling cost.



HARVI III Aerospace Expansion

CHALLENGE

- Seat track.
- Ti6AL4V.
- External emulsion.
- Test vs. regular HARVI III.

SOLUTION

- HARVI III Ø .750" (19.05mm) — cylindrical shank
- HydroForce™ with reducer sleeve
- Corner Radius R = 0.120" (3.05mm)

CUTTING DATA

- V_c 40 m/min (130 SFM).
- F_z Varies.
- A_p From .050" (1,27mm) to 1.500" (38.1mm).
- A_e From .050" (1,27mm) to full slot.

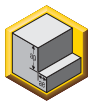
RESULT

- Tool life increased from 45min up to 5h.

BENEFIT

- Increased tool life.
- Reduced tool changes.
- Decrease overall tooling cost.

HARVI III™ • UJDE • Unequal Flute Spacing





Material Group		Side Milling (A)		KCSM15			Recommended feed per tooth (IPT = inch/th) for side milling (A).						
		A		Cutting Speed — vc SFM			D1 — Diameter						
							frac.	1/2	5/8	3/4	1	1 1/4	1 1/2
		ap	ae	min		max	dec.	.5000	.6250	.7500	1.0000	1.2500	1.5000
P	4	Ap max	0.4 x D	300	–	490	IPT	.0026	.0030	.0033	.0039	.0043	.0046
	5	Ap max	0.4 x D	200	–	330	IPT	.0023	.0027	.0030	.0036	.0041	.0045
M	1	Ap max	0.4 x D	300	–	380	IPT	.0029	.0034	.0038	.0046	.0051	.0056
	2	Ap max	0.4 x D	200	–	260	IPT	.0023	.0027	.0030	.0036	.0041	.0045
	3	Ap max	0.4 x D	200	–	230	IPT	.0019	.0022	.0024	.0028	.0031	.0033
S	1	Ap max	0.4 x D	160	–	300	IPT	.0029	.0034	.0038	.0046	.0051	.0056
	2	Ap max	0.4 x D	160	–	300	IPT	.0029	.0034	.0038	.0046	.0051	.0056
	3	Ap max	0.4 x D	80	–	130	IPT	.0016	.0018	.0020	.0025	.0028	.0031
	4	Ap max	0.4 x D	150	–	200	IPT	.0022	.0025	.0028	.0033	.0037	.0041
H	1	Ap max	0.4 x D	260	–	460	IPT	.0026	.0030	.0033	.0039	.0043	.0046

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 centers, please adjust parameters accordingly.

Adjustment factor table for feed and speed calculation

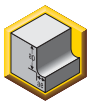
	Ae/D	0.50%	1.00%	1.60%	2.00%	4.00%	5.00%	8.00%	10.00%	20.00%	30.00%
Speed factor	Kv	2.9	2.85	2.8	2	1.5	1.45	1.4	1.35	1.25	1.2
Feed factor	KFz	2.8	2.6	2.5	2.4	2.3	2.2	2	1.7	1.25	1.02

To calculate application specific cutting data, please use above KV coefficient for adaptation of cutting speed and KFz for feed respectively.
Vc new = Vc * Kv
Fz new = IPT * KFz

Calculation example:
Application: D = 1 inch; S4 material group; Ae 0,02 inch
Cutting data recommendation: 150 SFM; fz = 0.0033 IPT
Adjustment coefficients: Ae = 0,02 = inch equals 2,00%; Kv = 2; KFz = 2.4

Final cutting data recommendation:
Vc new = 150 SFM * 2 = 300 SFM
Fz new = .0033 IPT * 2.4 = .0079 IPT

HARVI™ III • UJBE • Ball Nose • Unequal Flute Spacing





Material Group		Side Milling (A)		KCSM15			Recommended feed per tooth (IPT = inch/th) for side milling (A).						
		A		Cutting Speed — vc SFM			D1 — Diameter						
							frac.	1/2	5/8	3/4	1	1 1/4	1 1/2
		ap	ae	min		max	dec.	.5000	.6250	.7500	1.0000	1.2500	1.5000
P	4	Ap max	0.4 x D	300	–	490	IPT	.0026	.0030	.0033	.0039	.0043	.0046
	5	Ap max	0.4 x D	200	–	330	IPT	.0023	.0027	.0030	.0036	.0041	.0045
M	1	Ap max	0.4 x D	300	–	380	IPT	.0029	.0034	.0038	.0046	.0051	.0056
	2	Ap max	0.4 x D	200	–	260	IPT	.0023	.0027	.0030	.0036	.0041	.0045
	3	Ap max	0.4 x D	200	–	230	IPT	.0019	.0022	.0024	.0028	.0031	.0033
S	1	Ap max	0.4 x D	160	–	300	IPT	.0029	.0034	.0038	.0046	.0051	.0056
	2	Ap max	0.4 x D	160	–	300	IPT	.0029	.0034	.0038	.0046	.0051	.0056
	3	Ap max	0.4 x D	80	–	130	IPT	.0016	.0018	.0020	.0025	.0028	.0031
	4	Ap max	0.4 x D	150	–	200	IPT	.0022	.0025	.0028	.0033	.0037	.0041
H	1	Ap max	0.4 x D	260	–	460	IPT	.0026	.0030	.0033	.0039	.0043	.0046

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 centers, please adjust parameters accordingly.

Adjustment factor table for feed and speed calculation

	Ae/D	0.50%	1.00%	1.60%	2.00%	4.00%	5.00%	8.00%	10.00%	20.00%	30.00%
Speed factor	Kv	2.9	2.85	2.8	2	1.5	1.45	1.4	1.35	1.25	1.2
Feed factor	KFz	2.8	2.6	2.5	2.4	2.3	2.2	2	1.7	1.25	1.02

To calculate application specific cutting data, please use above KV coefficient for adaptation of cutting speed and KFz for feed respectively.
Vc new = Vc * Kv
Fz new = IPT * KFz

Calculation example:
Application: D = 1 inch; S4 material group; Ae 0,02 inch
Cutting data recommendation: 150 SFM; fz = 0.0033 IPT
Adjustment coefficients: Ae = 0,02 = inch equals 2,00%; Kv = 2; KFz = 2.4

Final cutting data recommendation:
Vc new = 150 SFM * 2 = 300 SFM
Fz new = .0033 IPT * 2.4 = .0079 IPT

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 minimize 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.

Customization

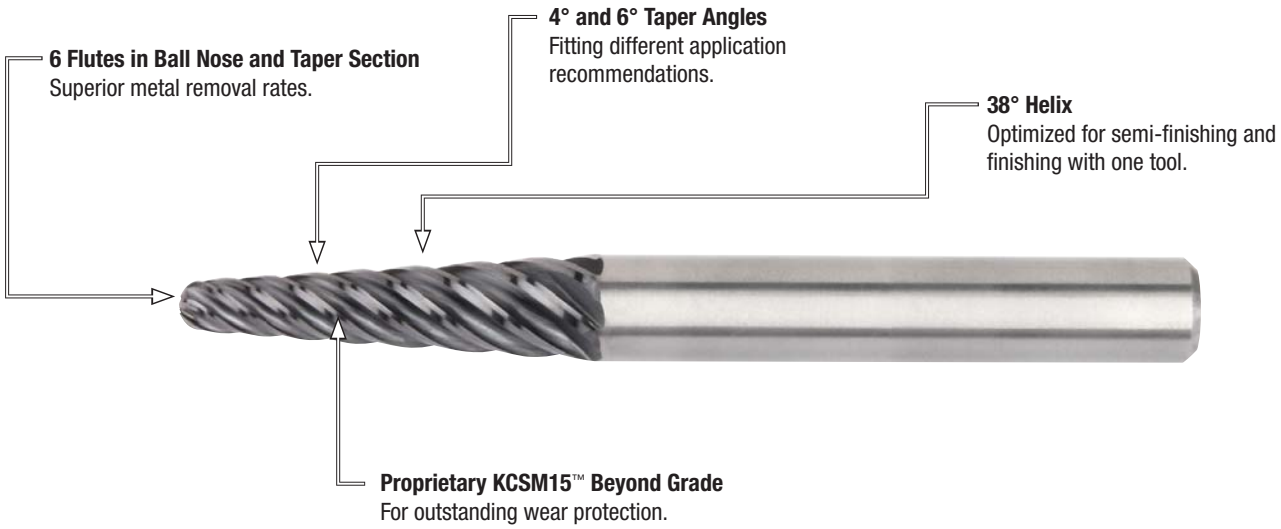
- Intermediate diameters available.
- Expanded length of tool and increased length of cut are possible.

Standard Offerings

- Diameter ranges 1/8–7/16".

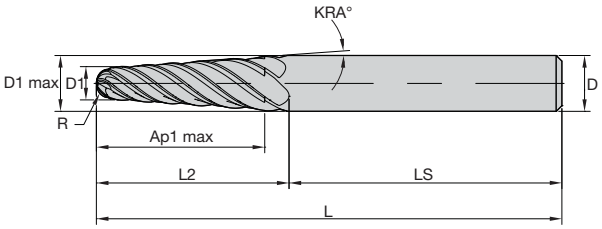
Designed for 5-axis machining in steel, stainless steel, nickel-based alloys, and titanium.





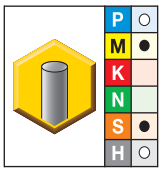
- Center cutting.
- 6 flutes for highest material removal rates.
- Unequal flute spacing minimizes chatter for smoother machining.
- 2 taper angle versions for optimized stability in long-reach operations.
- Single tool for both semi-finishing and finishing operations requiring fewer setups.
- Optimized geometry for stainless, nickel-based-alloys, and titanium machining.







UJBE • 6-Flute Taper Ball Nose • Unequal Flute Spacing



● first choice
○ alternate choice

KCSM15	D1	D	Ap1 max	L	L2	LS	R	KRA
UJBE0125J6CP	1/8	5/16	1.188	3	1.401	1.599	.063	4
UJBE0125J6BP	1/8	3/8	1.000	3 1/2	1.249	2.252	.063	6
UJBE0188J6BP	3/16	3/8	1.188	3 1/2	1.431	2.069	.094	4
UJBE0188J6CP	3/16	1/2	1.250	4	1.576	2.425	.094	6
UJBE0250J6CP	1/4	1/2	1.563	4	1.908	2.092	.125	4
UJBE0250J6BP	1/4	5/8	1.500	5	1.902	3.098	.125	6
UJBE0312J6BP	5/16	5/8	1.250	5	1.635	3.365	.156	6
UJBE0312J6CP	5/16	5/8	2.000	5	2.385	2.615	.156	4
UJBE0375J6BP	3/8	5/8	1.000	5	1.367	3.633	.188	6
UJBE0375J6CP	3/8	5/8	1.563	5	1.969	3.032	.188	4
UJBE0438J6BP	7/16	5/8	.750	5	1.099	3.901	.219	6
UJBE0438J6CP	7/16	5/8	1.188	5	1.552	3.448	.219	4

NOTE: For application data, see page P80.

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 Authorized Kennametal Distributor.

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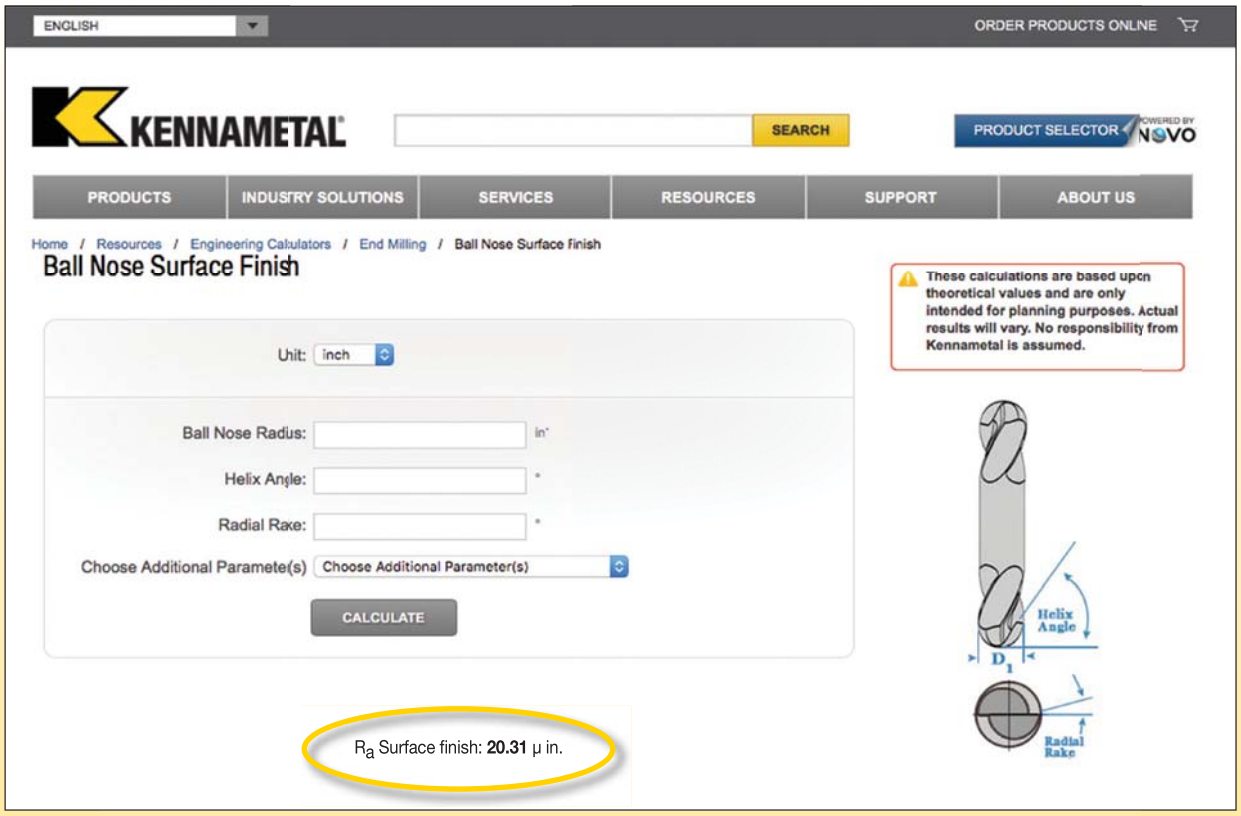
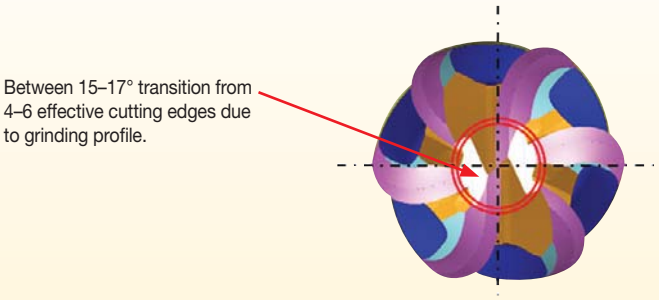
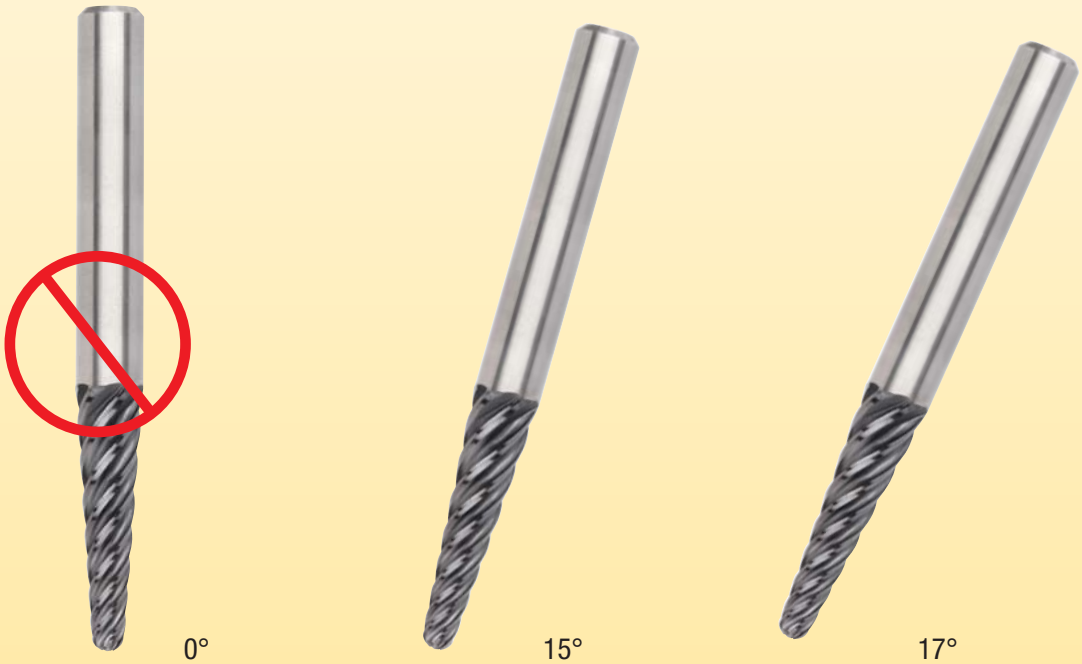


Use 5–10° for radial rake angle.

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 center of the HARVI III taper ball nose end mill.
Therefore, certain machining angles will result in different numbers of effective cutting edges.





0°
Avoid (center cutting speed = 0)

15°
<15° z = 2 effective cutting edges

17°
>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 0.315".

CUTTING DATA

- vc 328 SFM
- fz .0020 IPT
- ap .0787"
- ae .0236"

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 0.394".

CUTTING DATA

- vc 853 SFM
- fz .0024 IPT
- ap .0236"
- ae .0118"

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

- HARVI III taper ball nose UJBE, 6° taper angle, and KCSM15™.
- Ø 0.157" with 8 effective cutting edges.

CUTTING DATA

- vc 459 SFM
- fz .0006 IPT
- ap .0197"
- ae .0138"

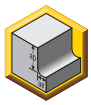
RESULT

- Substantial increase in Metal Removal Rates (MRR).

BENEFIT

- Improved surface quality.
- Regrindable tool to reduce tool cost.

HARVI III • UJBE • Ball Nose • Unequal Flute Spacing • Roughing

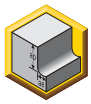




Material Group		Side Milling (A)		KCSM15			Recommended feed per tooth (IPT = inch/th) for side milling (A).								
		A		Cutting Speed — vc SFM				D1 — Diameter							
							frac.	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	min		max	dec.	.1250	.1875	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
P	0	Ap max	0.4 x D	490	–	660	IPT	.0009	.0014	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	1	Ap max	0.4 x D	490	–	660	IPT	.0009	.0014	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	2	Ap max	0.4 x D	460	–	620	IPT	.0009	.0014	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	3	Ap max	0.4 x D	390	–	520	IPT	.0008	.0011	.0015	.0019	.0023	.0029	.0034	.0039	.0045
	4	Ap max	0.4 x D	300	–	490	IPT	.0007	.0010	.0014	.0017	.0020	.0026	.0030	.0034	.0039
	5	Ap max	0.4 x D	200	–	330	IPT	.0006	.0009	.0012	.0015	.0018	.0023	.0027	.0031	.0036
	6	Ap max	0.4 x D	160	–	250	IPT	.0005	.0008	.0010	.0013	.0015	.0019	.0022	.0025	.0028
M	1	Ap max	0.4 x D	300	–	380	IPT	.0008	.0011	.0015	.0019	.0023	.0029	.0034	.0039	.0045
	2	Ap max	0.4 x D	200	–	260	IPT	.0006	.0009	.0012	.0015	.0018	.0023	.0027	.0031	.0036
	3	Ap max	0.4 x D	200	–	230	IPT	.0005	.0008	.0010	.0013	.0015	.0019	.0022	.0025	.0028
S	1	Ap max	0.4 x D	160	–	300	IPT	.0008	.0011	.0015	.0019	.0023	.0029	.0034	.0039	.0045
	2	Ap max	0.4 x D	80	–	130	IPT	.0004	.0006	.0008	.0010	.0012	.0015	.0018	.0021	.0024
	3	Ap max	0.4 x D	80	–	130	IPT	.0004	.0006	.0008	.0010	.0012	.0015	.0018	.0021	.0024
	4	Ap max	0.4 x D	160	–	200	IPT	.0006	.0008	.0011	.0014	.0017	.0021	.0025	.0028	.0033
H	1	Ap max	0.4 x D	260	–	460	IPT	.0007	.0010	.0014	.0017	.0020	.0026	.0030	.0034	.0039

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 centers, please adjust parameters accordingly on >1/2" diameter.

HARVI™ III • UJBE • Ball Nose • Unequal Flute Spacing • Finishing





Material Group		Side Milling (A)		KCSM15			Recommended feed per tooth (IPT = inch/th) for side milling (A).								
		A		Cutting Speed — vc SFM				D1 — Diameter							
							frac.	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	min		max	dec.	.1250	.1875	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
P	0	Ap max	.06 x D	940	–	1250	IPT	.0011	.0016	.0022	.0027	.0033	.0041	.0047	.0053	.0059
	1	Ap max	.06 x D	940	–	1250	IPT	.0011	.0016	.0022	.0027	.0033	.0041	.0047	.0053	.0059
	2	Ap max	.06 x D	870	–	1180	IPT	.0011	.0016	.0022	.0027	.0033	.0041	.0047	.0053	.0059
	3	Ap max	.06 x D	750	–	1000	IPT	.0009	.0014	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	4	Ap max	.06 x D	560	–	940	IPT	.0008	.0012	.0016	.0020	.0025	.0031	.0036	.0040	.0046
	5	Ap max	.06 x D	370	–	620	IPT	.0007	.0011	.0015	.0018	.0022	.0028	.0033	.0037	.0043
	6	Ap max	.06 x D	310	–	470	IPT	.0006	.0009	.0012	.0015	.0018	.0023	.0027	.0030	.0034
M	1	Ap max	.06 x D	560	–	720	IPT	.0009	.0014	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	2	Ap max	.06 x D	370	–	500	IPT	.0007	.0011	.0015	.0018	.0022	.0028	.0033	.0037	.0043
	3	Ap max	.06 x D	370	–	440	IPT	.0006	.0009	.0012	.0015	.0018	.0023	.0027	.0030	.0034
S	1	Ap max	.06 x D	310	–	560	IPT	.0009	.0014	.0018	.0023	.0027	.0035	.0041	.0046	.0054
	2	Ap max	.06 x D	160	–	250	IPT	.0005	.0007	.0010	.0012	.0015	.0018	.0022	.0025	.0029
	3	Ap max	.06 x D	160	–	250	IPT	.0005	.0007	.0010	.0012	.0015	.0018	.0022	.0025	.0029
	4	Ap max	.06 x D	310	–	370	IPT	.0007	.0010	.0013	.0017	.0020	.0026	.0030	.0034	.0040
H	1	Ap max	.06 x D	500	–	870	IPT	.0008	.0012	.0016	.0020	.0025	.0031	.0036	.0040	.0046

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 centers, please adjust parameters accordingly on >1/2" diameter.

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 .0230" per tooth on a 3/4" tool.
- Machine hardened materials at 2–3x the metal removal rate of competitive end mills.
- Wide range of cutting diameters: down to 1/4" for small and medium pocket work.
- Innovative new geometry maximizes metal removal rates.
- High metal removal rates lower manufacturing costs.



Visit **kennametal.com** or contact your local Authorized Kennametal Distributor.

KENNAMETAL®

kennametal.com

CXE/CXER

High-Performance Solid Carbide End Mills

Primary Application

CXE and CXER radius end mills are specially developed and manufactured for stainless steel, titanium, and high-temperature alloys that are typically found in aerospace, defense, medical, oil, and gas industries.

- Roughing and finishing with one tool.
- Highest Metal Removal Rates (MRR) optimize 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.
- Center cutting for helical operations and pocketing.
- Front-end design and unequal helix for optimized chip control.

Tailored Grades

- SP4060 grade with tough and wear-resistant substrate, advanced nano-composite PVD coating for highest tool life.

Customization

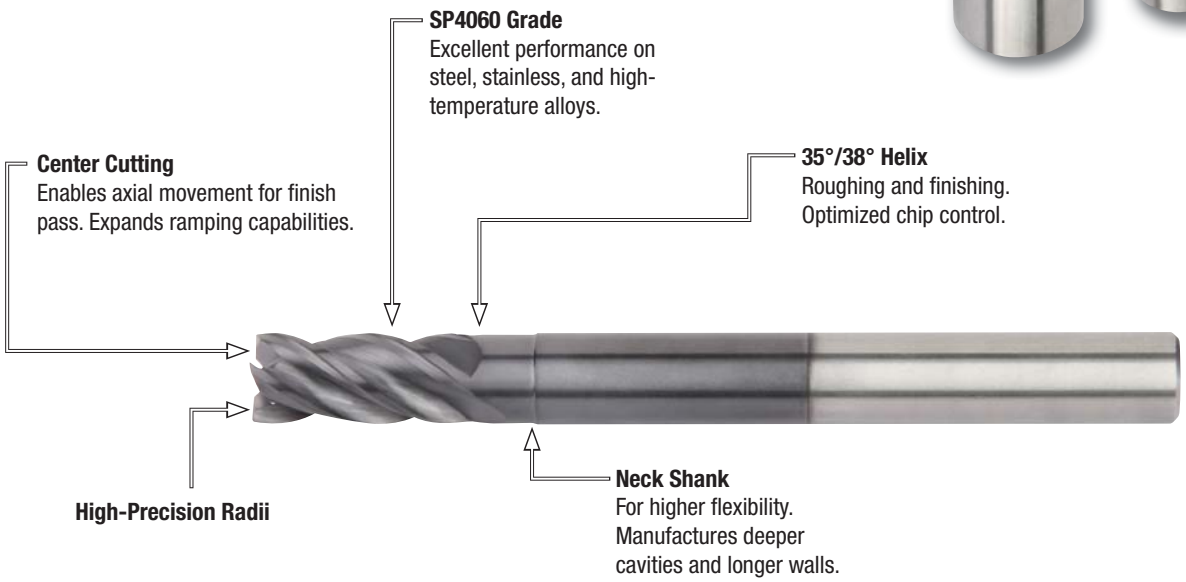
- Intermediate diameters available.
- Expanded length of tool and increased length of cut are possible.

Standard Offering

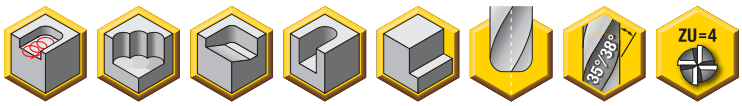
- Diameter range 1/8–1".

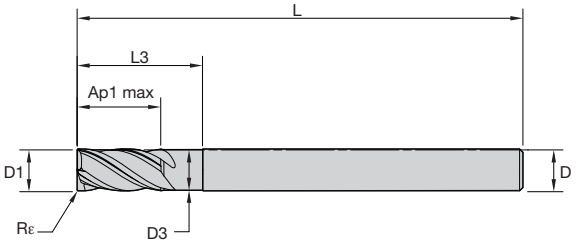
Designed for roughing and finishing with the highest Metal Removal Rates (MRR) in demanding materials.





- Asymmetrical flute spacing and variable helix configuration minimizes chatter and harmonics for smoother machining.
- Center cutting.
- Single tool for both roughing and finishing operations requiring fewer setups.
- Standard items listed. Additional styles and coatings made-to-order.



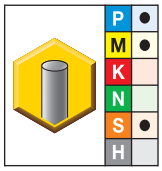




End Mill Tolerances

D1	tolerance
All	+.000/- .002"

CXE • 4 Flute • Inch

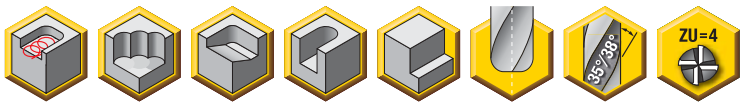


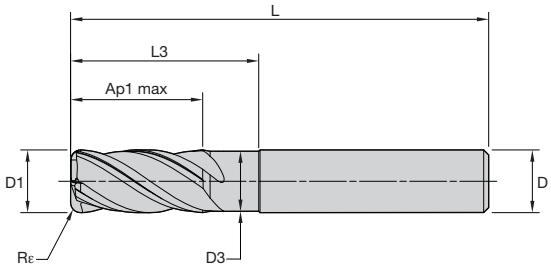
● first choice
○ alternate choice

SP4060	D1	D	D3	Ap1 max	L	L3	Rε
CXE0125MTN4-C	1/8	1/4	—	1/4	2 1/2	—	.010
CXE0187MTN4-C	3/16	1/4	—	3/8	3	—	.010
CXE0250MN4-C	1/4	1/4	.240	1/2	3	3/4	.010
CXE0375MN4-C	3/8	3/8	.365	3/4	4	1 1/8	.010
CXE0500MN4-C	1/2	1/2	.490	1	4	1 1/2	.010
CXE0750MN4-C	3/4	3/4	.740	1 1/2	5	2 1/4	.010

NOTE: For application data, see page P86.

- Asymmetrical flute spacing and variable helix configuration minimizes chatter and harmonics for smoother machining.
- Center cutting.
- Single tool for both roughing and finishing operations requiring fewer setups.
- Standard items listed. Additional styles and coatings made-to-order.



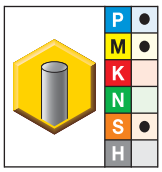




End Mill Tolerances

D1	tolerance
All	+.000/- .002"

CXER • 4 Flute • Inch

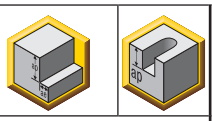


● first choice
○ alternate choice

SP4060	D1	D	Ap1 max	L	L3	Rε
CXER0125NTN4-C	1/8	.250	.275	2 1/2	—	.010
CXER0125NTN4-F *	1/8	.250	.290	2 1/2	—	.030
CXER0250NN4-C	1/4	.250	.540	2 1/2	.750	.010
CXER0250NN4-E	1/4	.250	.550	2 1/2	.750	.020
CXER0375NN4-C	3/8	.375	.825	2 1/2	1.125	.010
CXER0375NN4-E	3/8	.375	.825	2 1/2	1.125	.020
CXER0469NTN4-E *	15/32	.500	1.031	3	—	.020
CXER0500NN4-C	1/2	.500	1.100	3	1.500	.010
CXER0500NN4-F *	1/2	.500	1.100	3	1.500	.030
CXER0500NN4-J	1/2	.500	1.100	3	1.500	.060
CXER0500NN4-K	1/2	.500	1.100	3	1.500	.090
CXER0500NN4-L	1/2	.500	1.100	3	1.500	.120
CXER0625NN4-C	5/8	.625	1.375	3 1/2	1.875	.010
CXER0625NN4-J *	5/8	.625	1.375	3 1/2	1.875	.060
CXER0750NN4-C	3/4	.750	1.650	4	2.250	.010
CXER0750NN4-F	3/4	.750	1.650	4	2.250	.030
CXER0750NN4-K	3/4	.750	1.650	4	2.250	.090
CXER0750NN4-L	3/4	.750	1.650	4	2.250	.120
CXER1000NN4-C *	1	1.000	2.200	5	3.000	.010
CXER1000NN4-F	1	1.000	2.200	5	3.000	.030
CXER1000NN4-L *	1	1.000	2.200	5	3.000	.120

NOTE: For application data, see page P86.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

CXE/CXER • Asymmetrical Flute Spacing



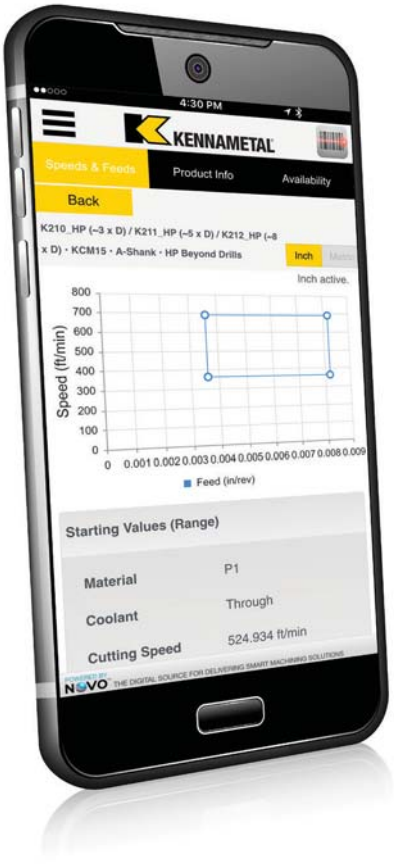


Material Group		Side Milling (A) and Slotting (B)			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.												
		A		B	SP4060 Cutting Speed — vc SFM			D1 — Diameter									
								frac.	1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1
		ap	ae	ap	min		max	dec.	.125	.188	.250	.313	.375	.438	.500	.625	.750	1.000
P	3	1.5 x D	0.5 x D	1 x D	390	–	520	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045
	4	1.5 x D	0.5 x D	0.75 x D	300	–	490	IPT	.0007	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034	.0039
	5	1.5 x D	0.5 x D	1 x D	200	–	330	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036
	6	1.5 x D	0.5 x D	0.75 x D	160	–	250	IPT	.0005	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025	.0028
M	1	1.5 x D	0.5 x D	1 x D	300	–	380	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045
	2	1.5 x D	0.5 x D	1 x D	200	–	260	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036
	3	1.5 x D	0.5 x D	1 x D	200	–	230	IPT	.0005	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025	.0028
S	1	1.5 x D	0.5 x D	1 x D	160	–	300	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045
	2	1.5 x D	0.5 x D	1 x D	80	–	130	IPT	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021	.0024
	3	1.5 x D	0.5 x D	1 x D	80	–	130	IPT	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021	.0024
	4	1.5 x D	0.5 x D	1 x D	160	–	200	IPT	.0005	.0008	.0011	.0014	.0017	.0019	.0021	.0025	.0028	.0033

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 centers, please adjust parameters accordingly on >1/2" diameter.

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 catalog 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.

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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.
- Center 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.

Tailored Grades

- From proprietary KCPM15™ Beyond™ grade for outstanding wear to uncoated tools suitable for a variety of workpiece materials.
- Universal KC643M™ grade suitable for cutting steel, stainless, and titanium.

Customization

- 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.
- Internal coolant for improved chip evacuation and extended tool life.

Extensive Standard Offering

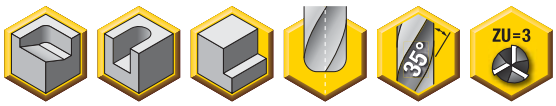
- Diameter range 1/4–1".
- Weldon® shank for maximum torque transmission.

Highest metal removal rates — even on unstable machines or workpiece clamping.

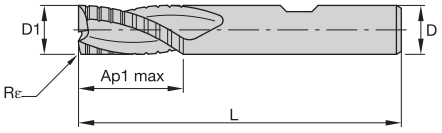




- Kennametal standard dimensions.
- Center cutting.
- Chipbreaker profile.





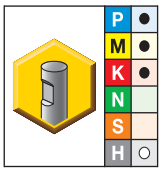


End Mill Tolerances

D1	d11	D	tolerance h6
<1/8"	-.0008/-.0031"	<1/8"	+0/-.00024"
1/8–7/32"	-.0012/-.0041"	1/8–7/32"	+0/-.00031"
1/4–3/8"	-.0016/-.0051"	1/4–3/8"	+0/-.00035"
13/32–11/16"	-.002/-.0063"	13/32–11/16"	+0/-.00043"
23/32–1-3/16"	-.0026/-.0077"	23/32–1-3/16"	+0/-.00051"

beyond

HPRSS

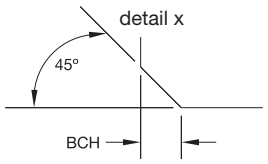


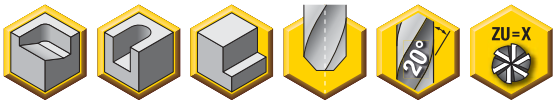
● first choice
○ alternate choice

KCPM15	D1	D	Ap1 max	L	Rε
HPRSS250S3075	1/4	1/4	3/4	2 1/2	.020
HPRSS375S3100	3/8	3/8	1	2 1/2	.020
HPRSS500S3125	1/2	1/2	1 1/4	3	.030
HPRSS625S3163	5/8	5/8	1 5/8	3 1/2	.030
HPRSS750S3163	3/4	3/4	1 5/8	4	.030

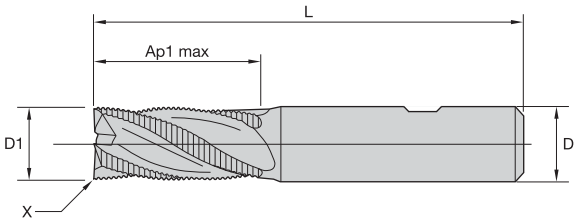
NOTE: For application data, see page P93.

- Kennametal standard dimensions.
- Center cutting.
- Cord profile.







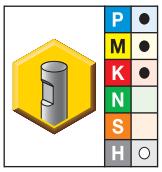


End Mill Tolerances

D1	d11	D	tolerance h6
<1/8"	-.0008/-.0031"	<1/8"	+0/-.00024"
1/8–7/32"	-.0012/-.0041"	1/8–7/32"	+0/-.00031"
1/4–3/8"	-.0016/-.0051"	1/4–3/8"	+0/-.00035"
13/32–11/16"	-.002/-.0063"	13/32–11/16"	+0/-.00043"
23/32–1-3/16"	-.0026/-.0077"	23/32–1-3/16"	+0/-.00051"

beyond

MDRHEC • Rougher • Beyond™

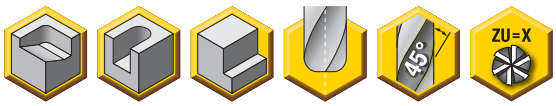


● first choice
○ alternate choice

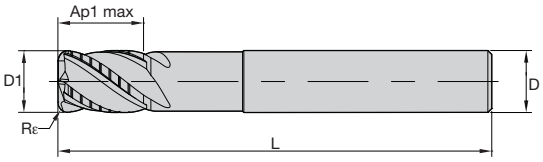
KCPM15	D1	D	Ap1 max	L	BCH	Z U
MDRHEC250S3025	1/4	1/4	3/8	2	.012	3
MDRHEC250S3075	1/4	1/4	3/4	2 1/2	.012	3
MDRHEC250S4025	1/4	1/4	3/8	2	.012	3
MDRHEC250S4075	1/4	1/4	3/4	2 1/2	.012	3
MDRHEC312S4081	5/16	5/16	13/16	2 1/2	.012	4
MDRHEC375S4038	3/8	3/8	1/2	2	.020	4
MDRHEC375S4088	3/8	3/8	7/8	2 1/2	.020	4
MDRHEC500S4050	1/2	1/2	5/8	2 1/2	.020	4
MDRHEC500S4100	1/2	1/2	1	3	.020	4
MDRHEC625S4063	5/8	5/8	3/4	3	.020	4
MDRHEC625S4125	5/8	5/8	1 1/4	3 1/2	.020	4
MDRHEC750S4075	3/4	3/4	7/8	3 1/2	.020	4
MDRHEC750S4150	3/4	3/4	1 1/2	4	.020	4
MDRHEC100S5150	1	1	1 1/2	4	.020	5

NOTE: For application data, see page P94.

- Kennametal standard dimensions.
- Center cutting.
- Shallow-pitch profile.



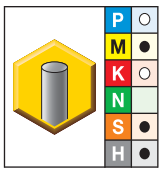


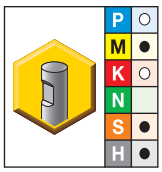


End Mill Tolerances

D1	d11	D	tolerance h6
<1/8"	-.0008/-.0031"	<1/8"	+0/-.00024"
1/8–7/32"	-.0012/-.0041"	1/8–7/32"	+0/-.00031"
1/4–3/8"	-.001/-.0051"	1/4–3/8"	+0/-.00035"
13/32–11/16"	-.002/-.0063"	13/32–11/16"	+0/-.00043"
23/32–1 3/16"	-.0026/-.0077"	23/32–1 3/16"	+0/-.00051"

HPRST





● first choice
○ alternate choice

KC643M	KC643M	D1	D	Ap1 max	L	Rε	Z U
HPRST250S4038	**–**	1/4	1/4	3/8	2	.030	3
HPRST250S4075	**–**	1/4	1/4	3/4	2 1/2	.030	4
HPRST375S4050	**–**	3/8	3/8	1/2	2	.030	4
HPRST375S4088	**–**	3/8	3/8	7/8	2 1/2	.030	4
–	**HPRST500S4063**	1/2	1/2	5/8	2 1/2	.040	4
–	**HPRST500S4125**	1/2	1/2	1 1/4	3	.040	4
–	**HPRST625S4075**	5/8	5/8	3/4	3	.040	4
–	**HPRST625S4125**	5/8	5/8	1 1/4	3 1/2	.040	4
–	**HPRST625S6125**	5/8	5/8	1 1/4	3 1/2	.040	6
–	**HPRST750S4088**	3/4	3/4	7/8	3 1/2	.050	4
–	**HPRST750S4150**	3/4	3/4	1 1/2	4	.050	4
–	**HPRST750S6150**	3/4	3/4	1 1/2	4	.050	6
–	**HPRST1000S4150**	1	1	1 1/2	4	.050	4
–	**HPRST1000S6150**	1	1	1 1/2	4	.050	6

NOTE: For application data, see page P95.

HPRSS



Material Group		Side Milling (A) and Slotting (B)			KCPM15		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.						
		A		B	Cutting Speed — vc SFM			D1 — Diameter					
							frac.	1/4	5/16	3/8	1/2	5/8	3/4
		ap	ae	ap	min	max	dec.	.250	.313	.375	.500	.625	.750
P	1	1 x D	0.5 x D	0.75 x D	500	650	fz	.0018	.0023	.0027	.0035	.0039	.0043
	2	1 x D	0.5 x D	0.75 x D	450	625	fz	.0018	.0023	.0027	.0035	.0039	.0043
	3	1 x D	0.5 x D	0.75 x D	400	525	fz	.0015	.0020	.0023	.0029	.0034	.0038
	4	1 x D	0.4 x D	0.3 x D	350	475	fz	.0014	.0018	.0020	.0026	.0030	.0033
	5	1 x D	0.5 x D	0.75 x D	200	325	fz	.0012	.0016	.0018	.0023	.0027	.0030
	6	1 x D	0.4 x D	0.3 x D	150	225	fz	.0010	.0013	.0015	.0019	.0022	.0024
M	1	1 x D	0.5 x D	0.75 x D	250	325	fz	.0015	.0020	.0023	.0029	.0034	.0038
	2	1 x D	0.5 x D	0.75 x D	190	260	fz	.0012	.0016	.0018	.0023	.0027	.0030
	3	1 x D	0.5 x D	0.75 x D	200	260	fz	.0010	.0013	.0015	.0019	.0022	.0024
K	1	1 x D	0.5 x D	0.75 x D	400	525	fz	.0018	.0023	.0027	.0035	.0039	.0043
	2	1 x D	0.5 x D	0.75 x D	360	460	fz	.0015	.0020	.0023	.0029	.0034	.0038
	3	1 x D	0.5 x D	0.75 x D	330	430	fz	.0012	.0016	.0018	.0023	.0027	.0030
H	1	1 x D	0.4 x D	0.3 x D	300	450	fz	.0014	.0018	.0020	.0026	.0030	.0033

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

MDRHEC

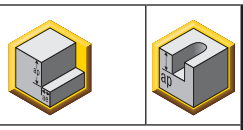




Material Group		Side Milling (A) and Slotting (B)			KCPM15		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.							
		A		B	Cutting Speed — vc SFM			D1 — Diameter						
							frac.	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	dec.	.250	.313	.375	.500	.625	.750	1.000
P	0	1.0 x D	0.5 x D	0.5 x D	490	660	IPT	.0016	.0020	.0023	.0029	.0034	.0037	.0042
	1	1.0 x D	0.5 x D	0.5 x D	490	660	IPT	.0016	.0020	.0023	.0029	.0034	.0037	.0042
	2	1.0 x D	0.4 x D	0.5 x D	460	620	IPT	.0016	.0020	.0023	.0029	.0034	.0037	.0042
	3	1.0 x D	0.4 x D	0.5 x D	390	520	IPT	.0013	.0017	.0019	.0025	.0029	.0033	.0038
	4	1.0 x D	0.3 x D	0.4 x D	300	490	IPT	.0012	.0015	.0017	.0022	.0026	.0029	.0033
	5	1.0 x D	0.4 x D	0.5 x D	200	330	IPT	.0010	.0013	.0016	.0020	.0023	.0026	.0031
M	1	1.0 x D	0.4 x D	0.5 x D	300	380	IPT	.0013	.0017	.0019	.0025	.0029	.0033	.0038
	2	1.0 x D	0.4 x D	0.5 x D	200	260	IPT	.0010	.0013	.0016	.0020	.0023	.0026	.0031
	3	1.0 x D	0.4 x D	0.5 x D	200	230	IPT	.0009	.0011	.0013	.0016	.0019	.0021	.0024
K	1	1.0 x D	0.5 x D	0.5 x D	390	490	IPT	.0016	.0020	.0023	.0029	.0034	.0037	.0042
	2	1.0 x D	0.4 x D	0.5 x D	360	460	IPT	.0013	.0017	.0019	.0025	.0029	.0033	.0038
	3	1.0 x D	0.4 x D	0.5 x D	360	430	IPT	.0010	.0013	.0016	.0020	.0023	.0026	.0031
S	1	1.0 x D	0.4 x D	0.5 x D	–	–	IPT	.0013	.0017	.0019	.0025	.0029	.0033	.0038
	2	1.0 x D	0.4 x D	0.5 x D	–	–	IPT	.0007	.0009	.0010	.0013	.0015	.0018	.0021
H	1	1.0 x D	0.3 x D	0.4 x D	260	460	IPT	.0012	.0015	.0017	.0022	.0026	.0029	.0033

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

HPRST





Material Group		Side Milling (A) and Slotting (B)			KC643M		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.							
		A		B	Cutting Speed — vc SFM			D1 — Diameter						
							frac.	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	dec.	.250	.313	.378	.500	.625	.750	1.000
P	3	1.0 x D	0.5 x D	0.75 x D	390	520	IPT	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	1.0 x D	0.3 x D	0.75 x D	300	490	IPT	.0014	.0017	.0020	.0026	.0030	.0034	.0039
	5	1.0 x D	0.5 x D	0.75 x D	200	330	IPT	.0012	.0016	.0018	.0023	.0027	.0031	.0036
	6	1.0 x D	0.3 x D	0.3 x D	160	250	IPT	.0010	.0013	.0015	.0019	.0022	.0025	.0028
M	1	1.0 x D	0.5 x D	0.75 x D	300	380	IPT	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	1.0 x D	0.5 x D	0.75 x D	200	260	IPT	.0012	.0016	.0018	.0023	.0027	.0031	.0036
	3	1.0 x D	0.5 x D	0.75 x D	200	230	IPT	.0010	.0013	.0015	.0019	.0022	.0025	.0028
K	1	1.0 x D	0.5 x D	1 x D	390	490	IPT	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	2	1.0 x D	0.5 x D	1 x D	360	460	IPT	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	3	1.0 x D	0.5 x D	1 x D	360	430	IPT	.0012	.0016	.0018	.0023	.0027	.0031	.0036
S	1	1.0 x D	0.3 x D	0.75 x D	160	300	IPT	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	1.0 x D	0.3 x D	0.75 x D	80	130	IPT	.0008	.0010	.0012	.0015	.0018	.0021	.0024
	3	1.0 x D	0.3 x D	0.75 x D	80	130	IPT	.0008	.0010	.0012	.0015	.0018	.0021	.0024
	4	1.0 x D	0.4 x D	0.75 x D	160	200	IPT	.0011	.0014	.0017	.0021	.0025	.0028	.0033
H	1	1.0 x D	0.3 x D	0.3 x D	260	460	IPT	.0014	.0017	.0020	.0026	.0030	.0034	.0039
	2	1.0 x D	0.2 x D	0.2 x D	230	390	IPT	.0010	.0013	.0015	.0019	.0022	.0025	.0028
	3	1.0 x D	0.2 x D	0.2 x D	200	300	IPT	.0008	.0010	.0012	.0015	.0018	.0021	.0024

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

RSM II

Multi-Flute End Mills

Primary Application

RSM II offers the highest productivity in machining aerospace structural components in titanium and titanium alloys. The RSM II is 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.

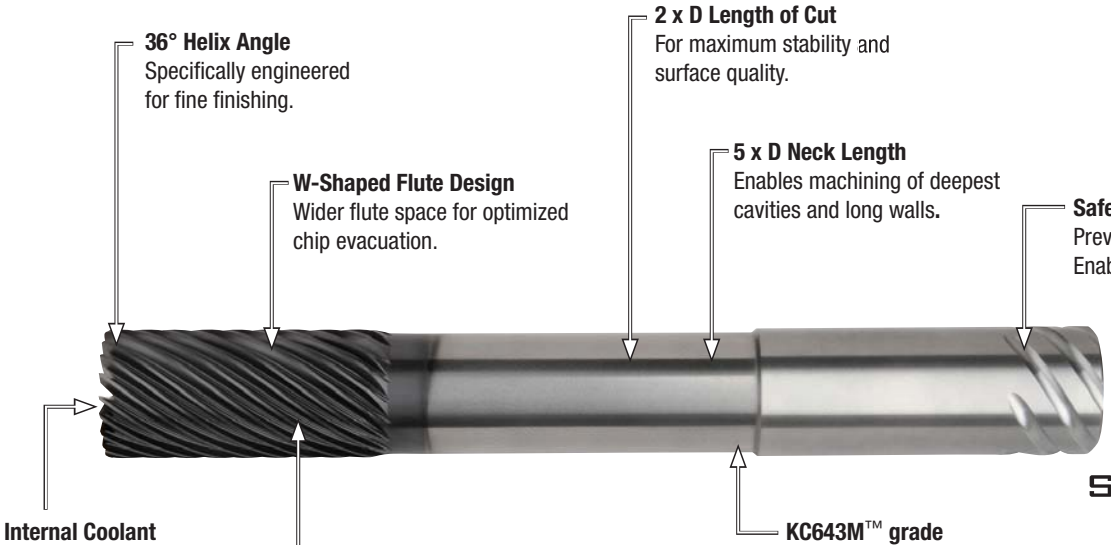
Customization

- 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 optimized 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 optimized chip evacuation.

2 x D Length of Cut
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.

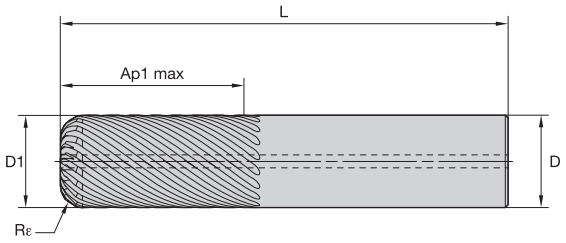
Eccentric Relief Grind
Improves edge stability and enables higher feed rates.

KC643M™ grade
Unmatched fine finishing and tool life results.

K600™ Uncoated Grade
Addresses critical-to-fly applications for uncoated tools.

- Kennametal standard dimensions.
- Non-center cutting.
- Optimized geometry for titanium machining.
- Unequal flute spacing minimizes chatter for smoother machining.



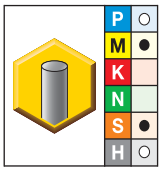




End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
< 1/8"	+0/-.002	< 1/8"	0/.00024
1/8–7/32"	+0/-.002	1/8–7/32"	0/.00031
1/4–3/8"	+0/-.002	1/4–3/8"	0/.00035
13/32–11/16"	+0/-.002	13/32–11/16"	0/.00043
23/32–1-3/16"	+0/-.002	23/32–1-3/16"	0/.00051

FSDE.. • Multi-Flute • Short • Inch



● first choice
○ alternate choice

KC643M	D1	D	Ap1 max	L	Rε	Z U
FSDE0375J9BCA	3/8	3/8	3/4	2	.015	9
FSDE0375J9BCB	3/8	3/8	3/4	2	.030	9
FSDE0500J9BCA	1/2	1/2	1	2 1/2	.015	9
FSDE0500J9BCB	1/2	1/2	1	2 1/2	.030	9
FSDE0500J9BCC	1/2	1/2	1	2 1/2	.060	9
FSDE0625JBBCB	5/8	5/8	1 1/4	3	.030	11
FSDE0750JFBCA	3/4	3/4	1 1/2	3 1/2	.015	15
FSDE0750JFBCB	3/4	3/4	1 1/2	3 1/2	.030	15
FSDE0750JFBCC	3/4	3/4	1 1/2	3 1/2	.060	15
FSDE0750JFBCE	3/4	3/4	1 1/2	3 1/2	.120	15
FSDE1000JJBCA	1	1	2	4	.015	19
FSDE1000JJBCB	1	1	2	4	.030	19
FSDE1000JJBCC	1	1	2	4	.060	19
FSDE1000JJBCE	1	1	2	4	.120	19

NOTE: For application data, please see page P99.

FSDE.. • Multi-Flute • Short • Inch • Roughing



Material Group		Side Milling (A) A ap	ae	KC643M Cutting Speed — vc SFM min		max	Recommended feed per tooth (IPT = inch/th) for side milling (A). D1 — Diameter in	1/4 .2500	3/8 .3750	1/2 .5000	5/8 .6250	3/4 .7500	1 1.0000
P	4	Ap max	0.03–0.045	440	–	740	IPT	.0032	.0034	.0040	.0043	.0049	.0058
	5	Ap max	0.03–0.045	300	–	490	IPT	.0028	.0030	.0036	.0039	.0045	.0054
M	1	Ap max	0.03–0.045	440	–	570	IPT	.0035	.0038	.0045	.0049	.0056	.0068
	2	Ap max	0.03–0.045	300	–	390	IPT	.0028	.0030	.0036	.0039	.0045	.0054
	3	Ap max	0.03–0.045	300	–	340	IPT	.0024	.0025	.0030	.0032	.0036	.0042
S	1	Ap max	0.03–0.045	250	–	440	IPT	.0035	.0038	.0045	.0049	.0056	.0068
	2	Ap max	0.03–0.045	120	–	200	IPT	.0019	.0020	.0024	.0026	.0030	.0036
	3	Ap max	0.03–0.045	120	–	200	IPT	.0019	.0020	.0024	.0026	.0030	.0036
	4	Ap max	0.03–0.045	250	–	300	IPT	.0025	.0028	.0033	.0036	.0041	.0050
H	1	Ap max	0.03–0.045	390	–	690	IPT	.0032	.0034	.0040	.0043	.0049	.0058
	2	Ap max	0.03–0.045	340	–	590	IPT	.0024	.0025	.0030	.0032	.0036	.0042

NOTE: For better surface finish, reduce feed per tooth.

FSDE.. • Multi-Flute • Highest Surface Quality • Finishing

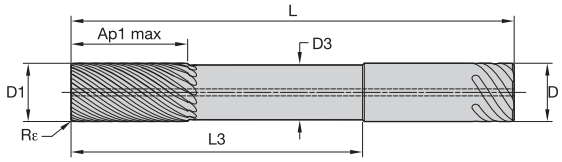


Material Group		Side Milling (A) A ap	ae	KC643M Cutting Speed — vc SFM min		max	Recommended feed per tooth (IPT = inch/th) for side milling (A). frac. dec.	D1 — Diameter 1/4 .2500	3/8 .3750	1/2 .5000	5/8 .6250	3/4 .7500	1 1.0000
P	4	Ap max	.008–.012	445	–	1628	IPT	.0042	.0045	.0053	.0058	.0061	.0066
	5	Ap max	.008–.012	295	–	1078	IPT	.0038	.0040	.0048	.0052	.0056	.0061
M	1	Ap max	.008–.012	445	–	1243	IPT	.0047	.0050	.0060	.0066	.0070	.0077
	2	Ap max	.008–.012	295	–	869	IPT	.0038	.0040	.0048	.0052	.0056	.0061
	3	Ap max	.008–.012	295	–	759	IPT	.0032	.0033	.0040	.0043	.0045	.0048
S	1	Ap max	.008–.012	245	–	979	IPT	.0047	.0050	.0060	.0066	.0070	.0077
	2	Ap max	.008–.012	125	–	429	IPT	.0025	.0026	.0032	.0035	.0037	.0041
	3	Ap max	.008–.012	125	–	429	IPT	.0025	.0026	.0032	.0035	.0037	.0041
	4	Ap max	.008–.012	245	–	649	IPT	.0033	.0037	.0044	.0048	.0051	.0056
H	1	Ap max	.008–.012	395	–	1518	IPT	.0042	.0045	.0053	.0058	.0061	.0066
	2	Ap max	.008–.012	345	–	1298	IPT	.0032	.0033	.0040	.0043	.0045	.0048

NOTE: For better surface finish, reduce feed per tooth.

- Kennametal standard dimensions.
- Non-center cutting.
- Optimized geometry for titanium machining.
- Unequal flute spacing minimizes chatter for smoother machining.
- Reach optimized for machining deep cavities.



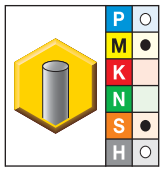


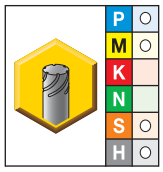


End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
< 1/8"	+0/-.002	< 1/8"	0/.00024
1/8–7/32"	+0/-.002	1/8–7/32"	0/.00031
1/4–3/8"	+0/-.002	1/4–3/8"	0/.00035
13/32–11/16"	+0/-.002	13/32–11/16"	0/.00043
23/32–1-3/16"	+0/-.002	23/32–1-3/16"	0/.00051

FSDE.. • Multi-Flute with Neck • Inch





● first choice
○ alternate choice

KC643M	KC643M	D1	D	D3	Ap1 max	L3	L	Rε	Z U
FSDE0250J7DYA	–	1/4	1/4	.235	1/2	1.250	3	.015	7
FSDE0375J9DYA	–	3/8	3/8	.353	3/4	1.875	4	.015	9
FSDE0375J9DYB	–	3/8	3/8	.353	3/4	1.875	4	.030	9
–	**FSDE0500N9DYA**	1/2	1/2	.470	1	2.500	5	.015	9
–	**FSDE0500N9DYB**	1/2	1/2	.470	1	2.500	5	.030	9
–	**FSDE0500N9DYC**	1/2	1/2	.470	1	2.500	5	.060	9
–	**FSDE0625NBDYB**	5/8	5/8	.588	1 1/4	3.125	5 1/4	.030	11
–	**FSDE0750NFDYA**	3/4	3/4	.705	1 1/2	3.750	6	.015	15
–	**FSDE0750NFDYB**	3/4	3/4	.705	1 1/2	3.750	6	.030	15
–	**FSDE0750NFDYC**	3/4	3/4	.705	1 1/2	3.750	6	.060	15
–	**FSDE0750NFDYE**	3/4	3/4	.705	1 1/2	3.750	6	.120	15
–	**FSDE1000NJDYA**	1	1	.940	2	5.000	7 1/2	.015	19
–	**FSDE1000NJDYB**	1	1	.940	2	5.000	7 1/2	.030	19
–	**FSDE1000NJDYC**	1	1	.940	2	5.000	7 1/2	.060	19
–	**FSDE1000NJDYE**	1	1	.940	2	5.000	7 1/2	.120	19

NOTE: For application data, please see page P101.

FSDE.. • Multi-Flute with Neck • Inch



Material Group		Side Milling (A)		KC643M			Recommended feed per tooth (IPT = inch/th) for side milling (A).						
		A		Cutting Speed — vc SFM			D1 — Diameter						
		ap	ae	min		max	frac.	1/4	3/8	1/2	5/8	3/4	1
							dec.	.2500	.3750	.5000	.6250	.7500	1.0000
P	4	Ap max	0.008–0.012	445	–	1628	IPT	.0042	.0045	.0053	.0058	.0061	.0066
	5	Ap max	0.008–0.012	295	–	1078	IPT	.0038	.0040	.0048	.0052	.0056	.0061
M	1	Ap max	0.008–0.012	445	–	1243	IPT	.0047	.0050	.0060	.0066	.0070	.0077
	2	Ap max	0.008–0.012	295	–	869	IPT	.0038	.0040	.0048	.0052	.0056	.0061
	3	Ap max	0.008–0.012	295	–	759	IPT	.0032	.0033	.0040	.0043	.0045	.0048
S	1	Ap max	0.008–0.012	245	–	979	IPT	.0047	.0050	.0060	.0066	.0070	.0077
	2	Ap max	0.008–0.012	125	–	429	IPT	.0025	.0026	.0032	.0035	.0037	.0041
	3	Ap max	0.008–0.012	125	–	429	IPT	.0025	.0026	.0032	.0035	.0037	.0041
	4	Ap max	0.008–0.012	245	–	649	IPT	.0033	.0037	.0044	.0048	.0051	.0056
H	1	Ap max	0.008–0.012	395	–	1518	IPT	.0042	.0045	.0053	.0058	.0061	.0066
	2	Ap max	0.008–0.012	345	–	1298	IPT	.0032	.0033	.0040	.0043	.0045	.0048

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 centers, please adjust parameters accordingly on >1/2" diameter.



FSDE 15-Flute End Mill

CHALLENGE

- Finishing contour milling on aerospace part with interrupted cut.
- Depth of cut: 1.575" (40mm).
- Titanium alloy R56400.
- External emulsion.

SOLUTION

- RSM II multi-flute cutter with KC643M™.
- Ø .787" (20mm) with 15 effective cutting edges and .158" (4mm) radius.

CUTTING DATA

- vc 230 SFM
- fz .0030 IPT
- ap 1.569"
- ae .001"

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: 1.535" (39mm).
- Titanium alloy.
- External emulsion.

SOLUTION

- RSM II multi-flute cutter with KC643M.
- Ø .625" (15.875mm) with 11 effective cutting edges and .003" (0.762mm) radius.

CUTTING DATA

- vc 425 SFM
- fz .0021 IPT
- ap 1.55"
- ae .001"

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: .787" (20mm).
- Titanium alloy 6Al4V.
- External emulsion.

SOLUTION

- RSM II multi-flute cutter with KC643M™.
- Ø .787" (20mm) with 15 effective cutting edges and .158" (4mm) corner radius.

CUTTING DATA

- vc 492 SFM
- fz .0020 IPT
- ap .784"
- ae .0024"

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: .787" (20mm).
- Titanium alloy 6Al4V.
- External emulsion.

SOLUTION

- RSM II multi-flute cutter with KC643M.
- Ø .984" (25mm) with 19 effective cutting edges and .039" (1mm) corner radius.

CUTTING DATA

- vc 492 SFM
- fz .0020 IPT
- ap .784"
- ae .0024"

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 0.0393" (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-center 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 0.0393" (1mm). • RSM ll 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.

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 optimization. Hardware support. Tooling selection. Troubleshooting.
BEST-IN-CLASS SUPPORT TOOLS AND TECHNOLOGY	Materials database. Application calculators. Tooling performance experts.



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France	French	080 5540 367	eu.techsupport@kennametal.com
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Israel	English	1809 449889	na.techsupport@kennametal.com
Italy	Italian	800 916561	eu.techsupport@kennametal.com
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Korea (South)	English	+82 2 2100 6100	ap-kmt.techsupport@kennametal.com
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Mexico	Spanish	1800 253 0758	na.techsupport@kennametal.com
Netherlands	English	0800 0201 130	eu.techsupport@kennametal.com
New Zealand	English	0800 450 941	ap-kmt.techsupport@kennametal.com
Norway	English	800 10080	na.techsupport@kennametal.com
Poland	Polish	0080 04411887	eu.techsupport@kennametal.com
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Russia (cell phone)	Russian	+7 8005556394	eu.techsupport@kennametal.com
Singapore	English	1800 6221031	ap-kmt.techsupport@kennametal.com
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UK	English	0800 032 8339	na.techsupport@kennametal.com
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USA	English	800 835 3668	na.techsupport@kennametal.com

Numbers shown only serve the originating country listed.

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 6 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.



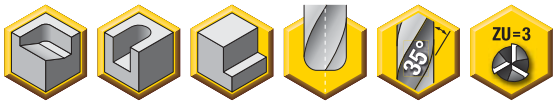
Customization

- Intermediate diameters available.
- Expanded length of tool and increased length of cut are possible.
- Different radii available.

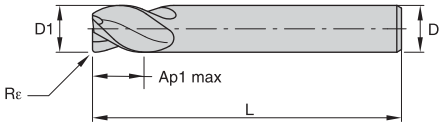
Standard Offering

- Diameter range 1/8–1".

- Center cutting.



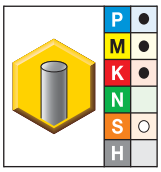


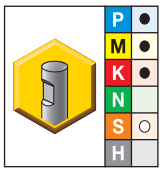


End Mill Tolerances

D1	tolerance	D	tolerance h6 +/-
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

HPFSS 3 Flute • Soft Steels and Stainless Steels



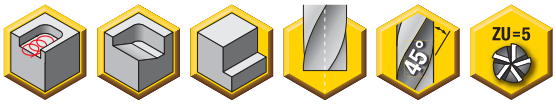


● first choice
○ alternate choice

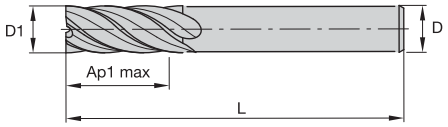
KC635M	KC635M	D1	D	Ap1 max	L	Rε
HPFSS125S3025	–	1/8	1/8	1/4	1 1/2	.010
HPFSS188S3031	–	3/16	3/16	5/16	2	.010
HPFSS250S3038	–	1/4	1/4	3/8	2	.020
HPFSS250S3050	–	1/4	1/4	1/2	2	.020
HPFSS312S3081	–	5/16	5/16	13/16	2 1/2	.020
HPFSS375S3050	–	3/8	3/8	1/2	2	.020
HPFSS375S3088	–	3/8	3/8	7/8	2 1/2	.020
–	**HPFSS500S3063**	1/2	1/2	5/8	2 1/2	.030
–	**HPFSS500S3125**	1/2	1/2	1 1/4	3	.030

NOTE: For application data, see page P111.

- Kennametal standard dimensions.
- Center cutting.





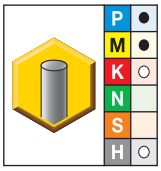


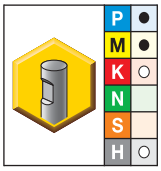
End Mill Tolerances

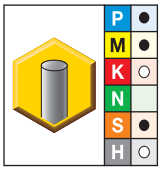
D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

beyond

HPFSS 5 Flute • Steel, Stainless Steels, and Titanium







● first choice
○ alternate choice

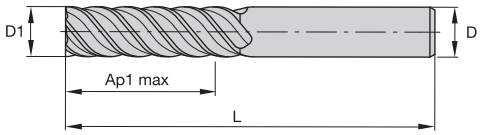
KCPM15	KCPM15	KC635M	D1	D	Ap1 max	L
–	–	HPFSS125S5025	1/8	1/8	1/4	1 1/2
–	–	HPFSS156S5056	5/32	3/16	9/16	2
–	–	HPFSS188S5031	3/16	3/16	5/16	2
HPFSS188S5056	–	–	3/16	3/16	9/16	2
HPFSS250S5038	–	–	1/4	1/4	3/8	2
HPFSS250S5075	–	–	1/4	1/4	3/4	2 1/2
HPFSS250S5125	–	–	1/4	1/4	1 1/4	4
HPFSS375S5050	–	–	3/8	3/8	1/2	2
HPFSS375S5088	–	–	3/8	3/8	7/8	2 1/2
HPFSS375S5150	–	–	3/8	3/8	1 1/2	4
–	HPFSS500S5063	–	1/2	1/2	5/8	2 1/2
–	HPFSS500S5125	–	1/2	1/2	1 1/4	3
–	HPFSS500S5200	–	1/2	1/2	2	4
–	HPFSS625S5075	–	5/8	5/8	3/4	3
–	HPFSS625S5163	–	5/8	5/8	1 5/8	4
–	HPFSS750S5088	–	3/4	3/4	7/8	3
–	HPFSS750S5163	–	3/4	3/4	1 5/8	4
–	HPFSS750S5325	–	3/4	3/4	3 1/4	5
–	HPFSS1000S5200	–	1	1	2	4
–	HPFSS1000S5325	–	1	1	3 1/4	6

NOTE: For application data, see page P111.

- Kennametal standard dimensions.
- Center cutting.



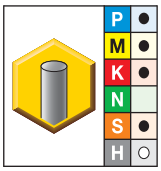




End Mill Tolerances

D1	tolerance	D	tolerance h6 +/-
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

HPFT • Stainless Steels and High-Temp Alloys



● first choice
○ alternate choice

KC635M	D1	D	Ap1 max	L	Z U
HPFT250S6038	1/4	1/4	3/8	2	6
HPFT250S6075	1/4	1/4	3/4	2 1/2	6
HPFT312S6081	5/16	5/16	13/16	2 1/2	6
HPFT375S6088	3/8	3/8	7/8	2 1/2	6
HPFT375S6113	3/8	3/8	1 1/8	3	6
HPFT500S6063	1/2	1/2	5/8	2 1/2	6
HPFT500S6100	1/2	1/2	1	3	6
HPFT500S6200	1/2	1/2	2	4 1/2	6
HPFT625S6125	5/8	5/8	1 1/4	3 1/2	6
HPFT750S6150	3/4	3/4	1 1/2	4	6
HPFT750S6225	3/4	3/4	2 1/4	5	6
HPFT750S6300	3/4	3/4	3	5 1/4	6
HPFT750S6400	3/4	3/4	4	6 1/4	6
HPFT1000S6150	1	1	1 1/2	4	6
HPFT1000S6225	1	1	2 1/4	5	6
HPFT1000S6400	1	1	4	6 1/2	6

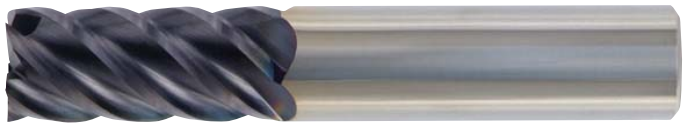
NOTE: For application data, see page P112.

HPFSS 3 Flute • With Radius • Soft Steels and Stainless Steels



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC635M Cutting Speed — vc SFM min	max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. frac.	D1 — Diameter 1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4
							dec.	.125	.188	.250	.313	.375	.438	.500	.625	.750
P	0	1.5 x D	0.3 x D	0.5 x D	490	660	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044
	1	1.5 x D	0.3 x D	0.5 x D	490	660	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044
	2	1.5 x D	0.3 x D	0.5 x D	460	620	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044
	3	1.5 x D	0.3 x D	0.5 x D	390	520	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039
	4	1.5 x D	0.3 x D	0.3 x D	300	490	IPT	.0007	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034
	5	1.5 x D	0.3 x D	0.5 x D	200	330	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031
	6	1.5 x D	0.3 x D	0.3 x D	160	250	IPT	.0005	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025
M	1	1.5 x D	0.3 x D	0.5 x D	300	380	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039
	2	1.5 x D	0.3 x D	0.5 x D	200	260	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031
	3	1.5 x D	0.3 x D	0.5 x D	200	230	IPT	.0005	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025
K	1	1.5 x D	0.3 x D	0.5 x D	390	490	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044
	2	1.5 x D	0.3 x D	0.5 x D	360	460	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039
	3	1.5 x D	0.3 x D	0.5 x D	360	430	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031
S	1	1.5 x D	0.3 x D	0.3 x D	160	300	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039
	2	1.5 x D	0.3 x D	0.3 x D	80	130	IPT	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021
	3	1.5 x D	0.3 x D	0.3 x D	80	130	IPT	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021
	4	1.5 x D	0.3 x D	0.5 x D	160	200	IPT	.0005	.0008	.0011	.0014	.0017	.0019	.0021	.0025	.0028

HPFSS 5 Flute • Steel, Stainless Steels, and Titanium



Material Group		Side Milling (A) A ap	A ae	KC635M Cutting Speed — vc SFM min	max	KCPM15 Cutting Speed — vc SFM min	max	Recommended feed per tooth (IPT = inch/th) for side milling (A). frac.	D1 — Diameter 1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1
								dec.	.125	.188	.250	.313	.375	.438	.500	.625	.750	1.000
P	0	1.5 x D	0.2 x D	490	660	490	660	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	.0049
	1	1.5 x D	0.2 x D	490	660	490	660	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	.0049
	2	1.5 x D	0.2 x D	460	620	460	620	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	.0049
	3	1.5 x D	0.2 x D	390	520	390	520	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045
	4	1.5 x D	0.2 x D	300	490	300	490	IPT	.0007	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034	.0039
	5	1.5 x D	0.2 x D	200	330	200	330	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036
	6	1.5 x D	0.2 x D	160	250	160	250	IPT	.0005	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025	.0028
M	1	1.5 x D	0.2 x D	300	380	300	380	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045
	2	1.5 x D	0.2 x D	200	260	200	260	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036
	3	1.5 x D	0.2 x D	200	230	200	230	IPT	.0005	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025	.0028
K	1	1.5 x D	0.2 x D	390	490	390	490	IPT	.0009	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044	.0049
	2	1.5 x D	0.2 x D	360	460	360	460	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045
	3	1.5 x D	0.2 x D	360	430	360	430	IPT	.0006	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031	.0036
S	1	1.5 x D	0.2 x D	160	300	–	–	IPT	.0007	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039	.0045
	2	1.5 x D	0.2 x D	80	130	–	–	IPT	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021	.0024
	3	1.5 x D	0.2 x D	80	130	–	–	IPT	.0004	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021	.0024
	4	1.5 x D	0.2 x D	160	200	–	–	IPT	.0005	.0008	.0011	.0014	.0017	.0019	.0021	.0025	.0028	.0033
H	1	1.5 x D	0.2 x D	260	460	260	460	IPT	.0007	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034	.0039

NOTE: These 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 centers, please adjust parameters accordingly on > 1/2" diameter.

HPFT • Stainless Steels and High-Temp Alloys





Material Group		Side Milling (A)		KC635M		Recommended feed per tooth (IPT = inch/th) for side milling (A).								
		A		Cutting Speed — vc SFM			D1 — Diameter							
						frac.	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4
		ap	ae	min	max	dec.	.188	.250	.313	.375	.438	.500	.625	.750
P	0	1.5 x D	0.05 x D	490	660	IPT	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044
	1	1.5 x D	0.05 x D	490	660	IPT	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044
	2	1.5 x D	0.05 x D	460	620	IPT	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044
	3	1.5 x D	0.05 x D	390	520	IPT	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039
	4	1.5 x D	0.05 x D	300	490	IPT	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034
	5	1.5 x D	0.05 x D	200	330	IPT	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031
	6	1.5 x D	0.04 x D	160	250	IPT	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025
M	1	1.5 x D	0.05 x D	300	380	IPT	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039
	2	1.5 x D	0.05 x D	200	260	IPT	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031
	3	1.5 x D	0.05 x D	200	230	IPT	.0008	.0010	.0013	.0015	.0017	.0019	.0022	.0025
K	1	1.5 x D	0.05 x D	390	490	IPT	.0013	.0018	.0023	.0027	.0031	.0034	.0039	.0044
	2	1.5 x D	0.05 x D	360	460	IPT	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039
	3	1.5 x D	0.05 x D	360	430	IPT	.0009	.0012	.0016	.0018	.0021	.0023	.0027	.0031
S	1	1.5 x D	0.04 x D	160	300	IPT	.0011	.0015	.0020	.0023	.0026	.0029	.0034	.0039
	2	1.5 x D	0.04 x D	80	130	IPT	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021
	3	1.5 x D	0.04 x D	80	130	IPT	.0006	.0008	.0010	.0012	.0014	.0015	.0018	.0021
	4	1.5 x D	0.05 x D	160	200	IPT	.0008	.0011	.0014	.0017	.0019	.0021	.0025	.0028
H	1	1.5 x D	0.04 x D	260	460	IPT	.0010	.0014	.0017	.0020	.0023	.0026	.0030	.0034

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
These guidelines may require variations to achieve optimum results.

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.
- Aluminum 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 adapters.
- Proprietary HARVI geometries enable roughing and finishing with one tool.

Visit **kennametal.com** or contact your local Authorized Kennametal Distributor.

KENNAMETAL®

kennametal.com

MaxiMet™

Primary Application

The MaxiMet system provides extraordinary metal removal rates and combines roughing and finishing operations with any aluminum 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 aluminum and other non-ferrous materials.

Customization

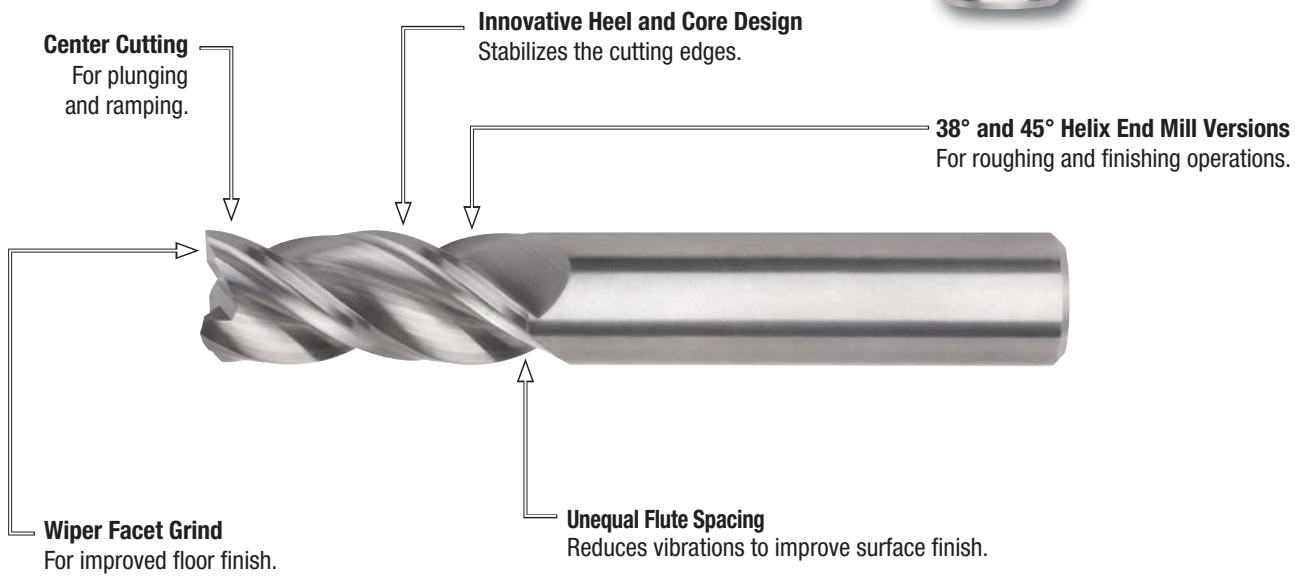
- Intermediate diameters available.
- Custom solutions available for machining titanium and other high-temperature alloys.
- Internal coolant axial and radial available.
- Various shank options and non-standard coatings available.

Extensive Standard Offering

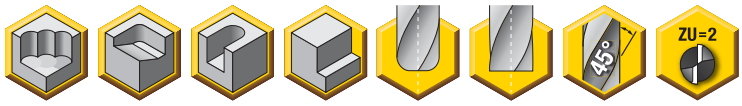
- Diameter ranges 3/16–1".
- Extended neck for long-reach applications and radii and sharp corner configurations.

Solid carbide end mills for high metal removal rates and superior surface finishes in aluminum.

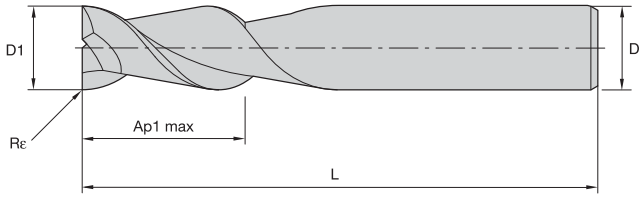




- Kennametal standards dimensions.
- Center cutting.
- Effective in thin wall applications.
- Wiper facet, special end gash, and flute geometry provide better surface finishes.
- Unique geometry delivers maximum metal removal rates.



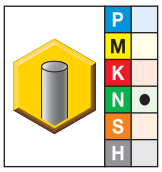




End Mill Tolerances

D1	tolerance h6	D	tolerance h6
<1/8"	+0/-.002"	<1/8"	+0/-.00024"
1/8–7/32"	+0/-.002"	1/8–7/32"	+0/-.00031"
1/4–3/8"	+0/-.00035"	1/4–3/8"	+0/-.00035"
13/32–11/16"	+0/-.00043"	13/32–11/16"	+0/-.00043"
23/32–1 3/16"	+0/-.00051"	23/32–1 3/16"	+0/-.00051"

ABDF • Wiper Facet



● first choice
○ alternate choice

K600	D1	D	Ap1 max	L	Rε
ABDF0188J2ARA	3/16	3/16	3/8	2	.015
ABDF0188J2AS	3/16	3/16	3/8	2	—
ABDF0250J2ARA	1/4	1/4	1/2	2 1/2	.015
ABDF0250J2ARB	1/4	1/4	1/2	2 1/2	.030
ABDF0250J2AS	1/4	1/4	1/2	2 1/2	—
ABDF0312J2ARA	5/16	5/16	5/8	2 1/2	.015
ABDF0312J2ARB	5/16	5/16	5/8	2 1/2	.030
ABDF0312J2AS	5/16	5/16	5/8	2 1/2	—
ABDF0375J2ARB	3/8	3/8	3/4	2 1/2	.030
ABDF0375J2AS	3/8	3/8	3/4	2 1/2	—
ABDF0500J2ARB	1/2	1/2	1 1/4	3	.030
ABDF0500J2ARC	1/2	1/2	1 1/4	3	.060
ABDF0500J2ARE	1/2	1/2	1 1/4	3	.120
ABDF0500J2AS	1/2	1/2	1 1/4	3	—
ABDF0625J2AS	5/8	5/8	1 1/4	3 1/2	—
ABDF0625J2BRB	5/8	5/8	1 5/8	3 1/2	.030
ABDF0625J2BRC	5/8	5/8	1 5/8	3 1/2	.060
ABDF0625J2BRE *	5/8	5/8	1 5/8	3 1/2	.120
ABDF0625J2BS	5/8	5/8	1 5/8	3 1/2	—
ABDF0750J2ARB *	3/4	3/4	1 1/2	4	.030
ABDF0750J2ARC	3/4	3/4	1 1/2	4	.060
ABDF0750J2ARE	3/4	3/4	1 1/2	4	.120
ABDF0750J2AS	3/4	3/4	1 1/2	4	—
ABDF0750J2BRB	3/4	3/4	1 5/8	4	.030
ABDF0750J2BRC	3/4	3/4	1 5/8	4	.060
ABDF0750J2BS	3/4	3/4	1 5/8	4	—
ABDF1000J2ARB *	1	1	1 1/2	4	.030
ABDF1000J2ARC	1	1	1 1/2	4	.060
ABDF1000J2ARE *	1	1	1 1/2	4	.120
ABDF1000J2AS *	1	1	1 1/2	4	—
ABDF1000J2BRB *	1	1	2	5	.030
ABDF1000J2BRC	1	1	2	5	.060
ABDF1000J2BS	1	1	2	5	—

NOTE: For application data, see page P122.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standards dimensions.
- Center cutting.
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- Wiper facet, special end gash, and flute geometry provide better surface finishes.
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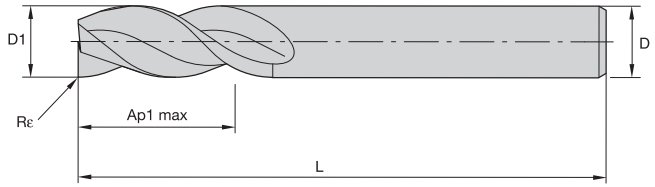
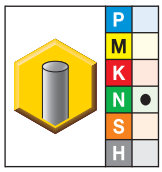


End Mill Tolerances

D1	tolerance h6	D	tolerance h6
<1/8"	+0/-.002"	<1/8"	+0/-.00024"
1/8–7/32"	+0/-.002"	1/8–7/32"	+0/-.00031"
1/4–3/8"	+0/-.00035"	1/4–3/8"	+0/-.00035"
13/32–11/16"	+0/-.00043"	13/32–11/16"	+0/-.00043"
23/32–1 3/16"	+0/-.00051"	23/32–1 3/16"	+0/-.00051"

ABDE • Wiper Facet



● first choice
○ alternate choice

K600	D1	D	Ap1 max	L	Rε
ABDE0188J3ARA	3/16	3/16	7/32	2	.015
ABDE0188J3AS	3/16	3/16	7/32	2	–
ABDE0250J3ARB	1/4	1/4	1/2	2 1/2	.030
ABDE0250J3AS	1/4	1/4	1/2	2 1/2	–
ABDE0312J3ARB	5/16	5/16	5/8	2 1/2	.030
ABDE0312J3AS	5/16	5/16	5/8	2 1/2	–
ABDE0375J3ARB	3/8	3/8	3/4	2 1/2	.030
ABDE0375J3AS	3/8	3/8	3/4	2 1/2	–
ABDE0500J3ARB	1/2	1/2	1 1/4	3	.030
ABDE0500J3ARC	1/2	1/2	1 1/4	3	.060
ABDE0500J3ARE	1/2	1/2	1 1/4	3	.120
ABDE0500J3AS	1/2	1/2	1 1/4	3	–
ABDE0625J3AS	5/8	5/8	1 1/4	3 1/2	–
ABDE0625J3BRB	5/8	5/8	1 5/8	3 1/2	.030
ABDE0625J3BS	5/8	5/8	1 5/8	3 1/2	–
ABDE0750J3ARB	3/4	3/4	1 1/2	4	.030
ABDE0750J3ARC	3/4	3/4	1 1/2	4	.060
ABDE0750J3ARE	3/4	3/4	1 1/2	4	.120
ABDE0750J3AS	3/4	3/4	1 1/2	4	–
ABDE0750J3BRB	3/4	3/4	1 5/8	4	.030
ABDE0750J3BRC	3/4	3/4	1 5/8	4	.060
ABDE0750J3BRE	3/4	3/4	1 5/8	4	.120
ABDE0750J3BS	3/4	3/4	1 5/8	4	–
ABDE1000J3ARB	1	1	1 1/2	4	.030
ABDE1000J3ARC	1	1	1 1/2	4	.060
ABDE1000J3ARE	1	1	1 1/2	4	.120
ABDE1000J3AS	1	1	1 1/2	4	–
ABDE1000J3BRB	1	1	2	5	.030
ABDE1000J3BRC	1	1	2	5	.060
ABDE1000J3BRE	1	1	2	5	.120
ABDE1000J3BS	1	1	2	5	–

NOTE: For application data, see page P122.

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- Center cutting.
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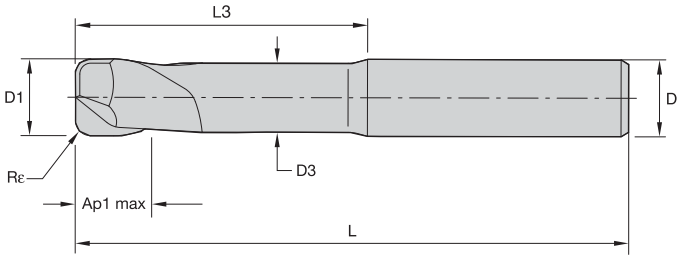
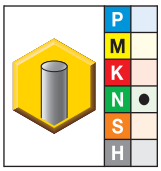


End Mill Tolerances

D1	tolerance h6	D	tolerance h6
<1/8"	+0/-.002"	<1/8"	+0/-.00024"
1/8–7/32"	+0/-.002"	1/8–7/32"	+0/-.00031"
1/4–3/8"	+0/-.00035"	1/4–3/8"	+0/-.00035"
13/32–11/16"	+0/-.00043"	13/32–11/16"	+0/-.00043"
23/32–1 3/16"	+0/-.00051"	23/32–1 3/16"	+0/-.00051"

ABDF • Wiper Facet • Extended Neck

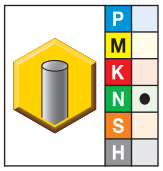


● first choice
○ alternate choice

K600	D1	D	D3	Ap1 max	L3	L	Rε
ABDF0250J2AQB *	1/4	1/4	.235	3/8	3/4	4	.030
ABDF0250J2BQB	1/4	1/4	.235	3/8	1 1/8	4	.030
ABDF0250J2BQ	1/4	1/4	.235	3/8	1 1/8	4	—
ABDF0250J2CQB	1/4	1/4	.235	3/8	2 1/8	4	.030
ABDF0250J2CQ	1/4	1/4	.235	3/8	2 1/8	4	—
ABDF0312J2AQB	5/16	5/16	.294	7/16	1 1/8	4	.030
ABDF0375J2AQB	3/8	3/8	.352	1/2	1 1/8	4	.030
ABDF0375J2AQ	3/8	3/8	.352	1/2	1 1/8	4	—
ABDF0375J2BQB	3/8	3/8	.352	1/2	2 1/8	4	.030
ABDF0375J2BQ	3/8	3/8	.352	1/2	2 1/8	4	—
ABDF0500J2AQB	1/2	1/2	.469	5/8	1 3/8	4	.030
ABDF0500J2AQE	1/2	1/2	.469	5/8	1 3/8	4	.120
ABDF0500J2AQ	1/2	1/2	.469	5/8	1 3/8	4	—
ABDF0500J2BQB	1/2	1/2	.469	5/8	2 1/4	4	.030
ABDF0500J2BQC	1/2	1/2	.469	5/8	2 1/4	4	.060
ABDF0500J2BQD	1/2	1/2	.469	5/8	2 1/4	4	.090
ABDF0500J2BQE	1/2	1/2	.469	5/8	2 1/4	4	.120
ABDF0500J2BQ	1/2	1/2	.469	5/8	2 1/4	4	—
ABDF0500J2CQB	1/2	1/2	.469	5/8	3 3/8	6	.030
ABDF0500J2CQC	1/2	1/2	.469	5/8	3 3/8	6	.060
ABDF0500J2CQD *	1/2	1/2	.469	5/8	3 3/8	6	.090
ABDF0500J2CQE	1/2	1/2	.469	5/8	3 3/8	6	.120
ABDF0500J2CQ	1/2	1/2	.469	5/8	3 3/8	6	—
ABDF0625J2AQ	5/8	5/8	.587	3/4	1 5/8	4	—
ABDF0625J2BQB	5/8	5/8	.587	3/4	3 3/8	6	.030
ABDF0625J2BQE *	5/8	5/8	.587	3/4	3 3/8	6	.120
ABDF0625J2BQ	5/8	5/8	.587	3/4	3 3/8	6	—
ABDF0750J2AQB *	3/4	3/4	.705	1	1 5/8	4	.030
ABDF0750J2AQE	3/4	3/4	.705	1	1 5/8	4	.120
ABDF0750J2AQ *	3/4	3/4	.705	1	1 5/8	4	—
ABDF0750J2BQB	3/4	3/4	.705	1	2 1/2	6	.030
ABDF0750J2BQC	3/4	3/4	.705	1	2 1/2	6	.060

(continued)

(ABDF • Wiper Facet • Extended Neck — continued)



● first choice
○ alternate choice

K600	D1	D	D3	Ap1 max	L3	L	Rε
ABDF0750J2BQD *	3/4	3/4	.705	1	2 1/2	6	.090
ABDF0750J2BQE	3/4	3/4	.705	1	2 1/2	6	.120
ABDF0750J2BQ	3/4	3/4	.705	1	2 1/2	6	–
ABDF0750J2CQB	3/4	3/4	.705	1	3 3/8	6	.030
ABDF0750J2CQ	3/4	3/4	.705	1	3 3/8	6	–
ABDF1000J2AQB *	1	1	.940	1 1/4	2 3/8	5	.030
ABDF1000J2AQE	1	1	.940	1 1/4	2 3/8	5	.120
ABDF1000J2AQ *	1	1	.940	1 1/4	2 3/8	5	–
ABDF1000J2BQB	1	1	.940	1 1/4	3 3/8	7	.030
ABDF1000J2BQE *	1	1	.940	1 1/4	3 3/8	7	.120
ABDF1000J2BQ *	1	1	.940	1 1/4	3 3/8	7	–
ABDF1000J2CQB *	1	1	.940	1 1/4	4 3/8	7	.030
ABDF1000J2CQ *	1	1	.940	1 1/4	4 3/8	7	–

NOTE: For application data, see page P123.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

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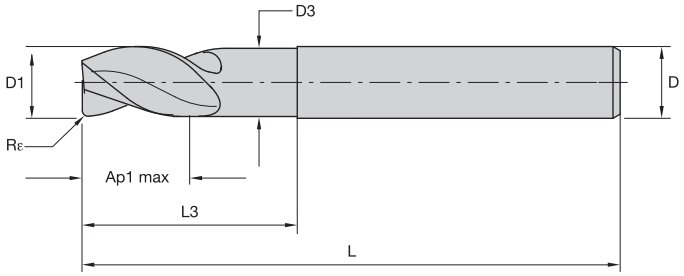
- Wiper facet, special end gash, and flute geometry provide better surface finishes.
- Unique geometry delivers maximum metal removal rates.



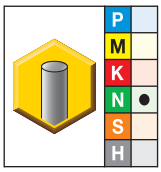




End Mill Tolerances

D1	tolerance h6	D	tolerance h6
<1/8"	+0/-.002"	<1/8"	+0/-.00024"
1/8–7/32"	+0/-.002"	1/8–7/32"	+0/-.00031"
1/4–3/8"	+0/-.00035"	1/4–3/8"	+0/-.00035"
13/32–11/16"	+0/-.00043"	13/32–11/16"	+0/-.00043"
23/32–1 3/16"	+0/-.00051"	23/32–1 3/16"	+0/-.00051"

ABDE • Wiper Facet • Extended Neck

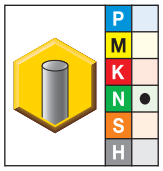


● first choice
○ alternate choice

K600	D1	D	D3	Ap1 max	L3	L	Rε
ABDE0250J3AQB	1/4	1/4	.234	3/8	3/4	4	.030
ABDE0250J3AQ	1/4	1/4	.234	3/8	3/4	4	–
ABDE0250J3BQB	1/4	1/4	.234	3/8	1 1/8	4	.030
ABDE0250J3BQ	1/4	1/4	.234	3/8	1 1/8	4	–
ABDE0250J3CQB	1/4	1/4	.234	3/8	2 1/8	4	.030
ABDE0250J3CQ	1/4	1/4	.234	3/8	2 1/8	4	–
ABDE0312J3AQB	5/16	5/16	.293	7/16	1 1/8	4	.030
ABDE0375J3AQB	3/8	3/8	.351	1/2	1 1/8	4	.030
ABDE0375J3AQ	3/8	3/8	.351	1/2	1 1/8	4	–
ABDE0375J3BQB	3/8	3/8	.351	1/2	2 1/8	4	.030
ABDE0375J3BQ	3/8	3/8	.351	1/2	2 1/8	4	–
ABDE0500J3AQB	1/2	1/2	.469	5/8	1 3/8	4	.030
ABDE0500J3AQE	1/2	1/2	.469	5/8	1 3/8	4	.120
ABDE0500J3AQ	1/2	1/2	.469	5/8	1 3/8	4	–
ABDE0500J3BQB	1/2	1/2	.469	5/8	2 1/4	4	.030
ABDE0500J3BQC	1/2	1/2	.469	5/8	2 1/4	4	.060
ABDE0500J3BQD	1/2	1/2	.469	5/8	2 1/4	4	.090
ABDE0500J3BQE	1/2	1/2	.469	5/8	2 1/4	4	.120
ABDE0500J3BQ	1/2	1/2	.469	5/8	2 1/4	4	–
ABDE0500J3CQB	1/2	1/2	.469	5/8	3 3/8	6	.030
ABDE0500J3CQC	1/2	1/2	.469	5/8	3 3/8	6	.060
ABDE0500J3CQD *	1/2	1/2	.469	5/8	3 3/8	6	.090
ABDE0500J3CQE	1/2	1/2	.469	5/8	3 3/8	6	.120
ABDE0500J3CQ	1/2	1/2	.469	5/8	3 3/8	6	–
ABDE0625J3AQB	5/8	5/8	.585	3/4	1 5/8	4	.030
ABDE0625J3AQ	5/8	5/8	.585	3/4	1 5/8	4	–
ABDE0625J3BQB	5/8	5/8	.585	3/4	3 3/8	6	.030
ABDE0625J3BQE	5/8	5/8	.585	3/4	3 3/8	6	.120
ABDE0625J3BQ	5/8	5/8	.585	3/4	3 3/8	6	–
ABDE0750J3AQB	3/4	3/4	.705	1	1 5/8	4	.030
ABDE0750J3AQE *	3/4	3/4	.705	1	1 5/8	4	.120
ABDE0750J3AQ	3/4	3/4	.705	1	1 5/8	4	–

(continued)

(ABDE • Wiper Facet • Extended Neck — continued)

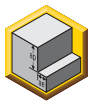


● first choice
○ alternate choice

K600	D1	D	D3	Ap1 max	L3	L	Rε
ABDE0750J3BQB	3/4	3/4	.705	1	2 1/2	6	.030
ABDE0750J3BQC	3/4	3/4	.705	1	2 1/2	6	.060
ABDE0750J3BQD	3/4	3/4	.705	1	2 1/2	6	.090
ABDE0750J3BQE	3/4	3/4	.705	1	2 1/2	6	.120
ABDE0750J3BQ	3/4	3/4	.705	1	2 1/2	6	—
ABDE0750J3CQB	3/4	3/4	.705	1	3 3/8	6	.030
ABDE0750J3CQ	3/4	3/4	.705	1	3 3/8	6	—
ABDE1000J3AQB	1	1	.940	1 1/4	2 3/8	5	.030
ABDE1000J3AQE *	1	1	.940	1 1/4	2 3/8	5	.120
ABDE1000J3AQ	1	1	.940	1 1/4	2 3/8	5	—
ABDE1000J3BQB	1	1	.940	1 1/4	3 3/8	7	.030
ABDE1000J3BQE	1	1	.940	1 1/4	3 3/8	7	.120
ABDE1000J3BQ	1	1	.940	1 1/4	3 3/8	7	—
ABDE1000J3CQB *	1	1	.940	1 1/4	4 3/8	7	.030
ABDE1000J3CQ	1	1	.940	1 1/4	4 3/8	7	—

NOTE: For application data, see page P123.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

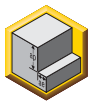
ABDF...





Material Group		Side Milling (A) and Slotting (B)			K600		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.							
		A		B	Cutting Speed — vc SFM			D1 — Diameter						
							frac.	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	dec.	.1875	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
N	1	1.5 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090
	2	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0014	.0018	.0023	.0027	.0036	.0045	.0054	.0072
	3	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	4	1.5 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	5	1.5 x D	0.5 x D	1.0 x D	820	3280	IPT	.0015	.0020	.0025	.0030	.0041	.0051	.0061	.0081

ABDE...

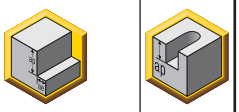




Material Group		Side Milling (A) and Slotting (B)			K600		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.							
		A		B	Cutting Speed — vc SFM			D1 — Diameter						
							frac.	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	dec.	.1875	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
N	1	1.5 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090
	2	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0014	.0018	.0023	.0027	.0036	.0045	.0054	.0072
	3	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	4	1.5 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	5	1.5 x D	0.5 x D	1.0 x D	820	3280	IPT	.0015	.0020	.0025	.0030	.0041	.0051	.0061	.0081

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.
For cutting aluminum with high silicon, coating is recommended.
Ap for spindle with ceramic bearings, multiply by 0.5.
For better surface finish, reduce feed per tooth.
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%.

ABDF... with Neck





Material Group		Side Milling (A) and Slotting (B)			K600		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.						
		A		B	Cutting Speed — vc SFM			D1 — Diameter					
							frac.	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	dec.	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
N	1	1 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	1 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	3	1 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0018	.0022	.0026	.0035	.0044	.0053	.0070
	4	1 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0018	.0022	.0026	.0035	.0044	.0053	.0070
	5	1 x D	0.5 x D	1.0 x D	820	3280	IPT	.0023	.0028	.0034	.0045	.0056	.0068	.0090

ABDE... with Neck





Material Group		Side Milling (A) and Slotting (B)			K600		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.						
		A		B	Cutting Speed — vc SFM			D1 — Diameter					
							frac.	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	dec.	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
N	1	1 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	1 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	3	1 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0018	.0022	.0026	.0035	.0044	.0053	.0070
	4	1 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0018	.0022	.0026	.0035	.0044	.0053	.0070
	5	1 x D	0.5 x D	1.0 x D	820	3280	IPT	.0023	.0028	.0034	.0045	.0056	.0068	.0090

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.
For cutting aluminum with high silicon, coating is recommended.
Ap for spindle with ceramic bearings, multiply by 0.5.
For better surface finish, reduce feed per tooth.
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%.

High-Performance Aluminum Solid Carbide End Mills

Primary Application

High-performance aluminum end mills from Kennametal provide the highest Metal Removal Rates (MRR) and high-quality surfaces while reducing machining time. The center-cutting design enables plunging, slotting, and profiling applications in any type of aluminum 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

- Double rake flute form for improved chip formation and evacuation.
- 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 aluminum and other non-ferrous materials.

Customization

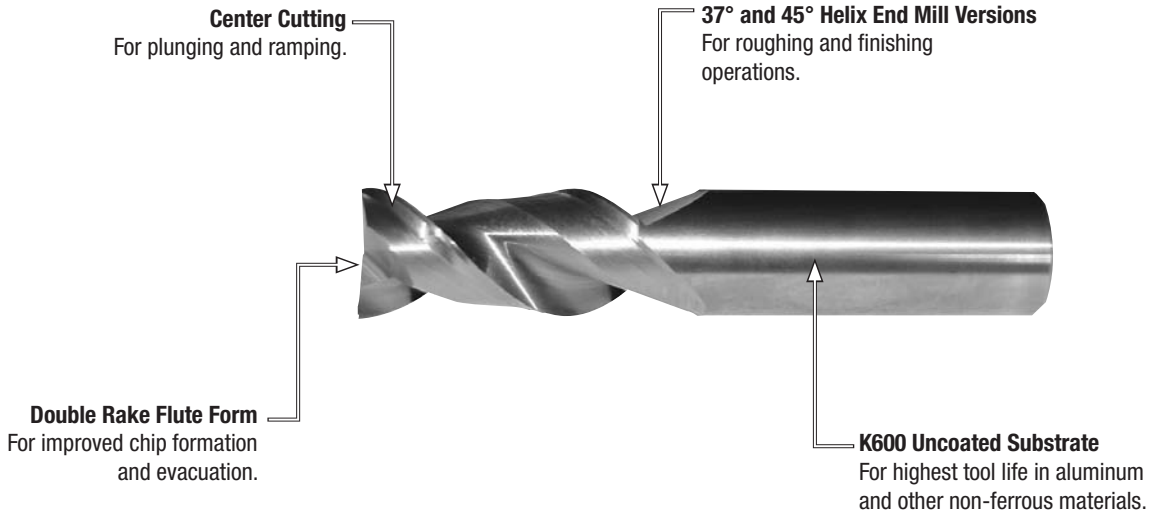
- Intermediate diameters available.
- Expanded length of tool and increased length of cut are possible.
- Internal coolant axial and radial available.
- Various shank options and non-standard coatings available.
- TiB_2 grade KC651M available as custom solution.

Extensive Standard Offering

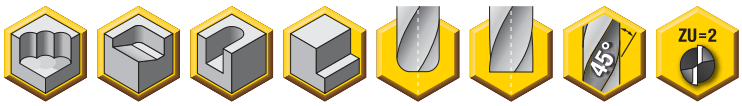
- Diameter ranges 1/8–1".
- Extended neck for long-reach applications as well as radii and sharp corner configurations.

Extended neck for long-reach applications as well as radii and sharp corner configurations.

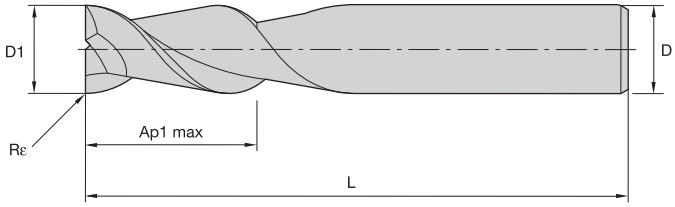




- Double-rake flute form.
- Center cutting.



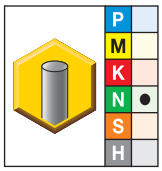




End Mill Tolerances

D1	tolerance h6	D	tolerance h6
<1/8"	+0/-.002"	<1/8"	+0/-.00024"
1/8–7/32"	+0/-.002"	1/8–7/32"	+0/-.00031"
1/4–3/8"	+0/-.00035"	1/4–3/8"	+0/-.00035"
13/32–11/16"	+0/-.00043"	13/32–11/16"	+0/-.00043"
23/32–1 3/16"	+0/-.00051"	23/32–1 3/16"	+0/-.00051"

AADF • Double-Rake Flute Form

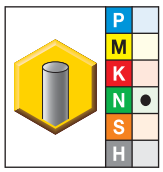


● first choice
○ alternate choice

K600	D1	D	Ap1 max	L	Rε
AADF0125J2A	1/8	1/8	1/4	2	–
AADF0125J2B	1/8	1/8	1/2	2	–
AADF0188J2A	3/16	3/16	5/16	2	–
AADF0188J2D	3/16	3/16	9/16	2 1/2	–
AADF0188J2B	3/16	3/16	5/8	2	–
AADF0250J2A	1/4	1/4	3/8	2	–
AADF0250J2E	1/4	1/4	5/8	2 1/2	–
AADF0250J2BRA	1/4	1/4	3/4	2 1/2	.015
AADF0250J2BRB	1/4	1/4	3/4	2 1/2	.030
AADF0250J2B	1/4	1/4	3/4	2 1/2	–
AADF0250J2FRB	1/4	1/4	1	3	.030
AADF0250J2F	1/4	1/4	1	3	–
AADF250J2I	1/4	1/4	1 1/8	3	–
AADF0250J2C	1/4	1/4	1 1/4	3 1/4	–
AADF0250J2G	1/4	1/4	1 3/4	4	–
AADF0375J2B	3/8	3/8	7/8	2 1/2	–
AADF0375J2DRA	3/8	3/8	1	3	.015
AADF0375J2DRB	3/8	3/8	1	3	.030
AADF0375J2D	3/8	3/8	1	3	–
AADF375J2H	3/8	3/8	1 1/8	3	–
AADF0375J2E	3/8	3/8	1 1/4	3 1/2	–
AADF0375J2CRB	3/8	3/8	1 1/2	4	.030
AADF0375J2CRC	3/8	3/8	1 1/2	4	.060
AADF0375J2C	3/8	3/8	1 1/2	4	–
AADF375J2G	3/8	3/8	1 3/4	4	–
AADF0500J2A	1/2	1/2	5/8	2 1/2	–
AADF0500J2E	1/2	1/2	5/8	3	–
AADF0500J2FRB	1/2	1/2	1	3	.030

(continued)

(AADF • Double-Rake Flute Form — continued)



● first choice
○ alternate choice

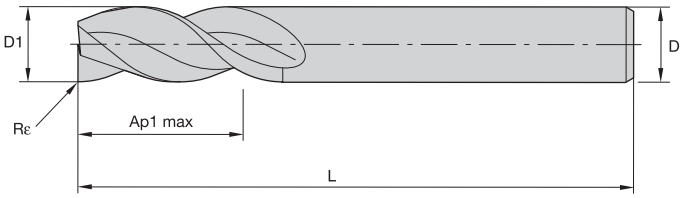
K600	D1	D	Ap1 max	L	Rε
AADF0500J2F	1/2	1/2	1	3	—
AADF500J2F	1/2	1/2	1	3	—
AADF0500J2BRA	1/2	1/2	1 1/4	3	.015
AADF0500J2BRB	1/2	1/2	1 1/4	3	.030
AADF0500J2B	1/2	1/2	1 1/4	3	—
AADF500J2B	1/2	1/2	1 1/4	3	—
AADF0500J2GRA	1/2	1/2	1 5/8	4	.015
AADF0500J2GRB	1/2	1/2	1 5/8	4	.030
AADF0500J2GRC	1/2	1/2	1 5/8	4	.060
AADF0500J2G	1/2	1/2	1 5/8	4	—
AADF0500J2CRA	1/2	1/2	2	4	.015
AADF0500J2CRB	1/2	1/2	2	4	.030
AADF0500J2CRC	1/2	1/2	2	4	.060
AADF0500J2C	1/2	1/2	2	4	—
AADF0500J2D	1/2	1/2	2	5	—
AADF0625J2BRB	5/8	5/8	2 1/4	5	.030
AADF0625J2FRB	5/8	5/8	2 1/2	5	.030
AADF0625J2GRB	5/8	5/8	3 1/4	6	.030
AADF0750J2F	3/4	3/4	1	4	—
AADF0750J2BRB	3/4	3/4	1 1/2	4	.030
AADF0750J2B	3/4	3/4	1 1/2	4	—
AADF0750J2CRA	3/4	3/4	2 1/4	5	.015
AADF0750J2CRB	3/4	3/4	2 1/4	5	.030
AADF0750J2C	3/4	3/4	2 1/4	5	—
AADF0750J2GRA	3/4	3/4	3 1/4	6	.015
AADF1000J2A	1	1	1 1/2	4	—
AADF1000J2D	1	1	2	5	—
AADF1000J2BRB	1	1	2 1/4	5	.030
AADF1000J2C	1	1	3	5	—

NOTE: For application data, see page P132.

- Double-rake flute form.
- Center cutting.



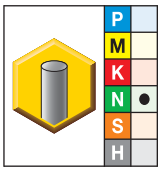




End Mill Tolerances

D1	tolerance h6	D	tolerance h6
<1/8"	+0/-.002"	<1/8"	+0/-.00024"
1/8–7/32"	+0/-.002"	1/8–7/32"	+0/-.00031"
1/4–3/8"	+0/-.00035"	1/4–3/8"	+0/-.00035"
13/32–11/16"	+0/-.00043"	13/32–11/16"	+0/-.00043"
23/32–1 3/16"	+0/-.00051"	23/32–1 3/16"	+0/-.00051"

AADE • Double-Rake Flute Form

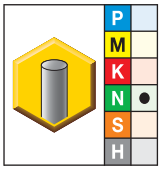


● first choice
○ alternate choice

K600	D1	D	Ap1 max	L	Rε
AADE125J3G	1/8	1/8	1/4	1 1/2	—
AADE125J3F	1/8	1/8	3/8	1 1/2	—
AADE0125J3D	1/8	1/8	1/2	3	—
AADE0125J3E	1/8	1/8	3/4	3	—
AADE0188J3C	3/16	3/16	5/16	3	—
AADE188J3F	3/16	3/16	9/16	2	—
AADE0188J3D	3/16	3/16	9/16	3	—
AADE0188J3E	3/16	3/16	3/4	3	—
AADE0250J3ARB	1/4	1/4	3/8	2	.030
AADE0250J3A	1/4	1/4	3/8	2	—
AADE0250J3D	1/4	1/4	1/2	2 1/2	—
AADE0250J3E	1/4	1/4	5/8	2 1/2	—
AADE0250J3BRA	1/4	1/4	3/4	2 1/2	.015
AADE0250J3BRB	1/4	1/4	3/4	2 1/2	.030
AADE0250J3B	1/4	1/4	3/4	2 1/2	—
AADE250J3B	1/4	1/4	3/4	2 1/2	—
AADE0250J3FRA	1/4	1/4	1	3	.015
AADE0250J3F	1/4	1/4	1	3	—
AADE250J3H	1/4	1/4	1 1/4	3	—
AADE0250J3CRA	1/4	1/4	1 1/4	3 1/4	.015
AADE0250J3CRB	1/4	1/4	1 1/4	3 1/4	.030
AADE0250J3C	1/4	1/4	1 1/4	3 1/4	—
AADE0250J3G	1/4	1/4	1 3/4	4	—
AADE0312J3A	5/16	5/16	13/16	2 1/2	—
AADE0312J3B	5/16	5/16	1	3	—
AADE0312J3DRB	5/16	5/16	1 1/4	3 1/4	.030
AADE0312J3D	5/16	5/16	1 1/4	3 1/4	—
AADE0375J3A	3/8	3/8	1/2	2	—
AADE0375J3F	3/8	3/8	1/2	3	—
AADE0375J3G	3/8	3/8	3/4	2 1/2	—
AADE0375J3BRB	3/8	3/8	7/8	2 1/2	.030
AADE0375J3BRC	3/8	3/8	7/8	2 1/2	.060

(continued)

(AADE • Double-Rake Flute Form — continued)

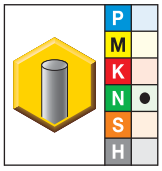


● first choice
○ alternate choice

K600	D1	D	Ap1 max	L	Rε
AADE0375J3B	3/8	3/8	7/8	2 1/2	–
AADE0375J3DRA	3/8	3/8	1	3	.015
AADE0375J3DRB	3/8	3/8	1	3	.030
AADE0375J3D	3/8	3/8	1	3	–
AADE375J3I	3/8	3/8	1 1/8	3	–
AADE0375J3ERA	3/8	3/8	1 1/4	3 1/2	.015
AADE0375J3ERB	3/8	3/8	1 1/4	3 1/2	.030
AADE0375J3ERC	3/8	3/8	1 1/4	3 1/2	.060
AADE0375J3E	3/8	3/8	1 1/4	3 1/2	–
AADE0375J3CRB	3/8	3/8	1 1/2	4	.030
AADE0375J3CRC	3/8	3/8	1 1/2	4	.060
AADE0375J3C	3/8	3/8	1 1/2	4	–
AADE0375J3H	3/8	3/8	2	4	–
AADE0375J3KRB	3/8	3/8	2 1/2	4	.030
AADE0375J3KRC	3/8	3/8	2 1/2	4	.060
AADE0375J3J	3/8	3/8	2 1/2	5	–
AADE438J3A	7/16	7/16	9/16	2 1/2	–
AADE0438J3A	7/16	7/16	7/8	2 1/2	–
AADE0500J3ARB	1/2	1/2	5/8	2 1/2	.030
AADE0500J3ARC	1/2	1/2	5/8	2 1/2	.060
AADE0500J3A	1/2	1/2	5/8	2 1/2	–
AADE0500J3FRA	1/2	1/2	1	3	.015
AADE0500J3FRB	1/2	1/2	1	3	.030
AADE0500J3FRC	1/2	1/2	1	3	.060
AADE0500J3F	1/2	1/2	1	3	–
AADE0500J3BRA	1/2	1/2	1 1/4	3	.015
AADE0500J3BRB	1/2	1/2	1 1/4	3	.030
AADE0500J3BRC	1/2	1/2	1 1/4	3	.060
AADE0500J3BRE	1/2	1/2	1 1/4	3	.120
AADE0500J3B	1/2	1/2	1 1/4	3	–
AADE0500J3KRB	1/2	1/2	1 1/2	4	.030
AADE0500J3KRC	1/2	1/2	1 1/2	4	.060
AADE0500J3K	1/2	1/2	1 1/2	4	–
AADE0500J3GRB	1/2	1/2	1 5/8	4	.030
AADE0500J3GRC	1/2	1/2	1 5/8	4	.060
AADE0500J3GRD	1/2	1/2	1 5/8	4	.090
AADE0500J3G	1/2	1/2	1 5/8	4	–
AADE0500J3CRA	1/2	1/2	2	4	.015
AADE0500J3CRB	1/2	1/2	2	4	.030
AADE0500J3CRC	1/2	1/2	2	4	.060
AADE0500J3C	1/2	1/2	2	4	–
AADE500J3H	1/2	1/2	2	4 1/2	–
AADE0500J3DRB	1/2	1/2	2 1/2	5	.030
AADE0500J3DRC	1/2	1/2	2 1/2	5	.060
AADE0500J3D	1/2	1/2	2 1/2	5	–
AADE0500J3LRB	1/2	1/2	3	5	.030
AADE0500J3LRC	1/2	1/2	3	5	.060
AADE0500J3L	1/2	1/2	3	5	–
AADE0500J3H	1/2	1/2	3 1/8	6	–
AADE625J3I	5/8	5/8	3/4	3	–
AADE0625J3A	5/8	5/8	1 1/4	3 1/2	–
AADE0625J3DRA	5/8	5/8	1 5/8	3 1/2	.015

(continued)

(AADE • Double-Rake Flute Form — continued)

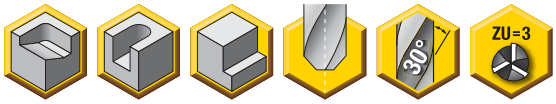


● first choice
○ alternate choice

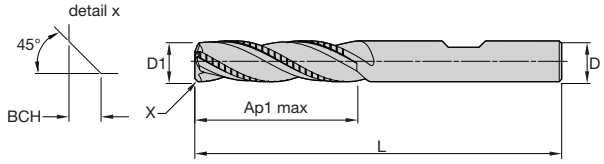
K600	D1	D	Ap1 max	L	Rε
AADE0625J3DRE	5/8	5/8	1 5/8	3 1/2	.120
AADE0625J3D	5/8	5/8	1 5/8	3 1/2	—
AADE0625J3E	5/8	5/8	2 1/8	4	—
AADE0625J3B	5/8	5/8	2 1/4	5	—
AADE0625J3FRE	5/8	5/8	2 1/2	5	.120
AADE0625J3F	5/8	5/8	2 1/2	5	—
AADE0625J3HRC	5/8	5/8	3	5 1/4	.060
AADE0625J3H	5/8	5/8	3	5 1/4	—
AADE0625J3G	5/8	5/8	3 1/4	6	—
AADE0750J3ARB	3/4	3/4	7/8	3	.030
AADE0750J3ARC	3/4	3/4	7/8	3	.060
AADE0750J3A	3/4	3/4	7/8	3	—
AADE750J3K	3/4	3/4	1	3	—
AADE0750J3F	3/4	3/4	1	4	—
AADE0750J3BRB	3/4	3/4	1 1/2	4	.030
AADE0750J3BRC	3/4	3/4	1 1/2	4	.060
AADE0750J3BRE	3/4	3/4	1 1/2	4	.120
AADE0750J3B	3/4	3/4	1 1/2	4	—
AADE0750J3HRB	3/4	3/4	1 5/8	4	.030
AADE0750J3HRD	3/4	3/4	1 5/8	4	.090
AADE0750J3H	3/4	3/4	1 5/8	4	—
AADE0750J3CRA	3/4	3/4	2 1/4	5	.015
AADE0750J3CRB	3/4	3/4	2 1/4	5	.030
AADE0750J3CRC	3/4	3/4	2 1/4	5	.060
AADE0750J3CRE	3/4	3/4	2 1/4	5	.120
AADE0750J3C	3/4	3/4	2 1/4	5	—
AADE0750J3DRB	3/4	3/4	3	5 1/4	.030
AADE0750J3DRC	3/4	3/4	3	5 1/4	.060
AADE0750J3D	3/4	3/4	3	5 1/4	—
AADE0750J3GRA	3/4	3/4	3 1/4	6	.015
AADE0750J3GRB	3/4	3/4	3 1/4	6	.030
AADE0750J3GRD	3/4	3/4	3 1/4	6	.090
AADE0750J3GRE	3/4	3/4	3 1/4	6	.120
AADE0750J3G	3/4	3/4	3 1/4	6	—
AADE0750J3K	3/4	3/4	4	6 1/4	—
AADE750J3J	3/4	3/4	4	6 1/2	—
AADE1000J3ARB	1	1	1 1/2	4	.030
AADE1000J3A	1	1	1 1/2	4	—
AADE1000J3K	1	1	2	4 1/2	—
AADE1000J3D	1	1	2	5	—
AADE1000J3BRC	1	1	2 1/4	5	.060
AADE1000J3B	1	1	2 1/4	5	—
AADE1000J3GRB	1	1	2 5/8	6	.030
AADE1000J3CRB	1	1	3	5 1/2	.030
AADE1000J3CRC	1	1	3	5 1/2	.060
AADE1000J3C	1	1	3	5 1/2	—
AADE1000J3ERA	1	1	3 1/4	6	.015
AADE1000J3ERB	1	1	3 1/4	6	.030
AADE1000J3ERE	1	1	3 1/4	6	.120
AADE1000J3E	1	1	3 1/4	6	—
AADE1000J3I	1	1	4	7	—
AADE1000J3HRA	1	1	4 1/8	7	.015
AADE1000J3H	1	1	4 1/8	7	—

NOTE: For application data, see page P132.

- Kennametal standard dimensions.
- Center cutting.
- Coarse pitch profile.



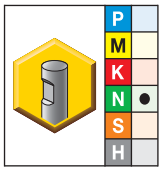


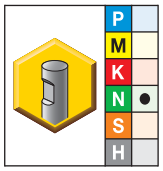


End Mill Tolerances

D1	d11	D	tolerance h6
<1/8"	-.0008/-.0031"	<1/8"	+0/-.00024"
1/8–7/32"	-.0012/-.0041"	1/8–7/32"	+0/-.00031"
1/4–3/8"	-.0016/-.0051"	1/4–3/8"	+0/-.00035"
13/32–11/16"	-.002/-.0063"	13/32–11/16"	+0/-.00043"
23/32–1-3/16"	-.0026/-.0077"	23/32–1-3/16"	+0/-.00051"

SFRHEC • Roughing Profile



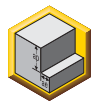


● first choice
○ alternate choice

K600	KC625M	D1	D	Ap1 max	L	BCH
SFRHEC250S3075	**–**	1/4	1/4	3/4	2 1/2	.024
–	**SFRHEC312S3075**	5/16	5/16	3/4	2 1/2	.024
SFRHEC375S3088	**SFRHEC375S3088**	3/8	3/8	7/8	2 1/2	.024
SFRHEC500S3100	**SFRHEC500S3100**	1/2	1/2	1	3	.039
SFRHEC500S3200	**SFRHEC500S3200**	1/2	1/2	2	4 1/2	.039
SFRHEC625S3225	**SFRHEC625S3225**	5/8	5/8	2 1/4	5	.039
SFRHEC750S3150	**SFRHEC750S3150**	3/4	3/4	1 1/2	4	.039
SFRHEC750S3225	**SFRHEC750S3225**	3/4	3/4	2 1/4	5	.039
–	**SFRHEC100S3150**	1	1	1 1/2	4	.039
SFRHEC100S3225	**SFRHEC100S3225**	1	1	2 1/4	5	.039

NOTE: For application data, see page P132.

AADF

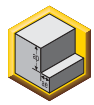




Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600 Cutting Speed — vc SFM min	max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. frac.	D1 — Diameter 1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
							dec.	.125	.188	.250	.313	.375	.500	.625	.750	1.000
N	1	1.5 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090
	2	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0009	.0014	.0018	.0023	.0027	.0036	.0045	.0054	.0072
	3	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	4	1.5 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	5	1.5 x D	0.5 x D	1.0 x D	820	3280	IPT	.0010	.0015	.0020	.0025	.0030	.0041	.0051	.0061	.0081

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

AADE





Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600 Cutting Speed — vc SFM min	max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. frac.	D1 — Diameter 1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
							dec.	0.125	0.188	0.250	0.313	0.375	0.500	0.625	0.750	1.000
N	1	1.5 x D	0.5 x D	1.0 x D	1640	6560	IPT	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090
	2	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0009	.0014	.0018	.0023	.0027	.0036	.0045	.0054	.0072
	3	1.5 x D	0.5 x D	1.0 x D	1640	4920	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	4	1.5 x D	0.5 x D	1.0 x D	1310	2460	IPT	.0008	.0012	.0016	.0020	.0024	.0032	.0039	.0047	.0063
	5	1.5 x D	0.5 x D	1.0 x D	820	3280	IPT	.0010	.0015	.0020	.0025	.0030	.0041	.0051	.0061	.0081

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

SFRHEC





Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	K600/KC625M Cutting Speed — vc SFM min	max	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. frac.	D1 — Diameter 1/4	3/8	1/2	5/8	3/4	1
							dec.	0.250	0.375	0.500	0.625	0.750	1.000
N	1	1.25 x D	0.5 x D	1 x D	1650	6500	fz	.0028	.0041	.0055	.0070	.0085	.0110
	2	1.25 x D	0.5 x D	1 x D	1650	5050	fz	.0025	.0037	.0050	.0060	.0075	.0010

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

NOVO KNOWS CAD/CAM

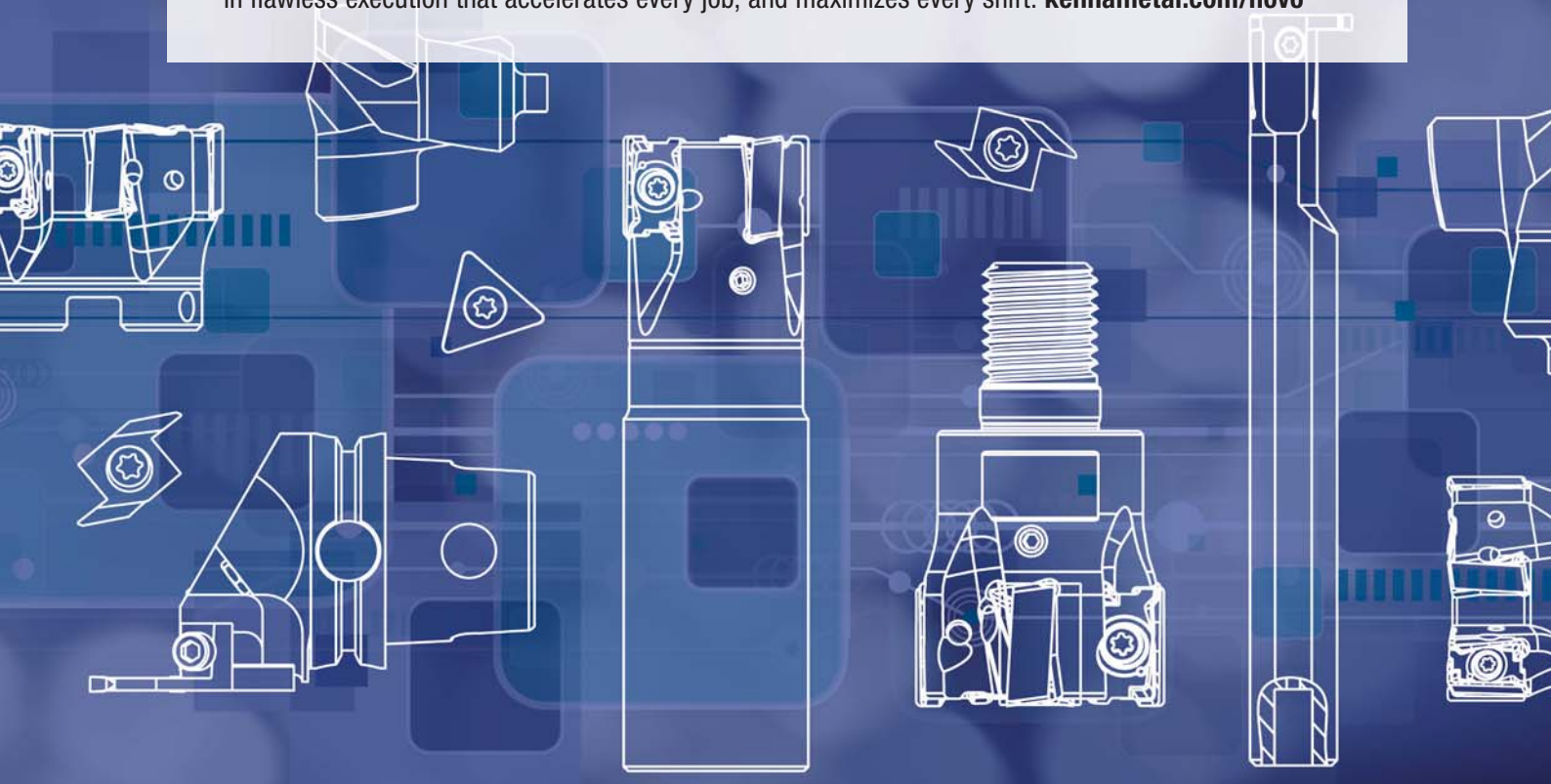
With the addition of NOVO™ applications to your team, your CAD/CAM capabilities become much more accurate, streamlined, and productive.

Before NOVO: The programmer would be in their CAD/CAM software, programming a part. Using the tedious method of finding a tool in a catalog, and then manually inputting the tooling information from the catalog 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 maximizes every shift. **kennametal.com/novo**



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-fiber 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 fiberglass and CFRP, and for slotting and profiling.

Tailored Grades

- KCN05 diamond coating uses a proprietary substrate to optimize coating adhesion and improve tool life.

Customization

- 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.
- K600 uncoated grade for fiberglass applications and as an economic alternative to KCN05 routers.

Extensive Standard Offering

- Diameters 1/4, 3/8, and 1/2".
- 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.



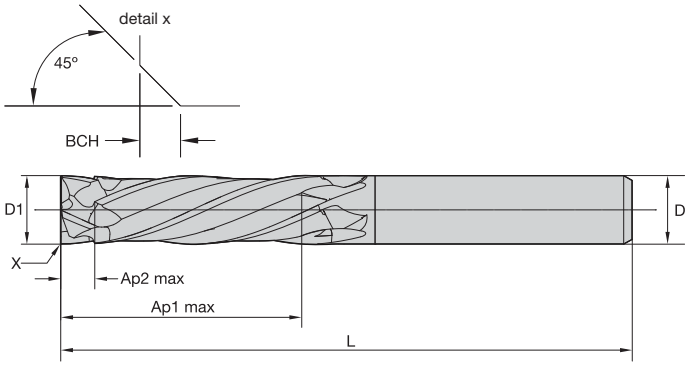
Highest Number of Cutting Edges
For excellent temperature control and highest metal removal rates.

Extended Length of Cut Version
Enables machining in different levels for multiplying tool life of same tool.

- Kennametal standard dimensions.
- Aerospace composites and fiberglass.
- Internal air coolant for ZU = 4.





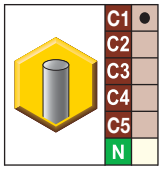


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .003"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

beyond

Compression-Style Router • CCNC • Inch



● first choice
○ alternate choice

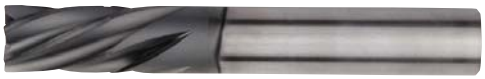
KCN05	D1	D	Ap1 max	Ap2 max	L	BCH	Z U
CCNC0250J3AH	1/4	1/4	3/4	0.1250	2 1/2	.005	3
CCNC0250J3BH	1/4	1/4	1 1/2	0.1250	4	.005	3
CCNC0375J4AH	3/8	3/8	3/4	0.1250	3 1/4	.005	4
CCNC0375J4BH	3/8	3/8	1 1/2	0.1250	4	.005	4
CCNC0500J4AH	1/2	1/2	3/4	0.1250	3 1/4	.005	4
CCNC0500J4BH	1/2	1/2	1 1/2	0.1250	4	.005	4

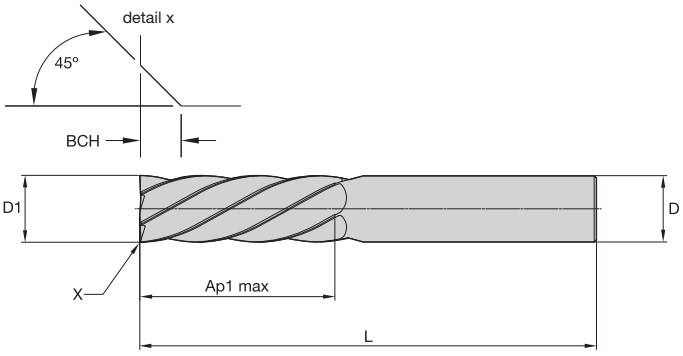
NOTE: For application data, see page P139.

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

- Kennametal standard dimensions.
- Aerospace composites and fiberglass.





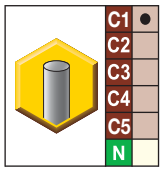


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .003"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

beyond

Down-Cut Router • CDDC • Inch



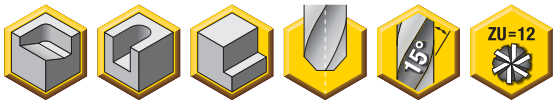
● first choice
○ alternate choice

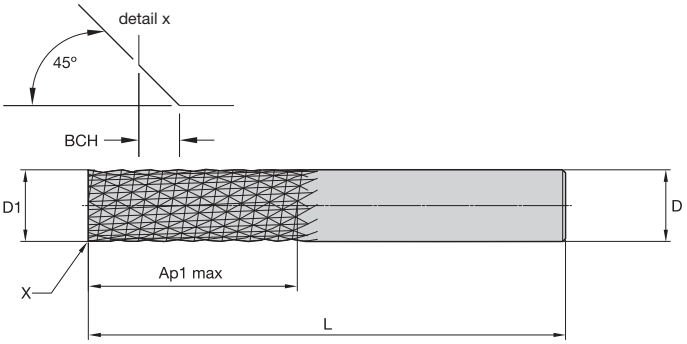
KCN05	D1	D	Ap1 max	L	BCH
CDDC0250J6AH	1/4	1/4	3/4	2 1/2	.010
CDDC0250J6BH	1/4	1/4	1 1/2	4	.010
CDDC0375J6AH	3/8	3/8	3/4	3 1/4	.010
CDDC0375J6BH	3/8	3/8	1 1/2	4	.010
CDDC0500J6AH	1/2	1/2	3/4	3 1/4	.010
CDDC0500J6BH	1/2	1/2	1 1/2	4	.010

NOTE: For application data, see page P139.

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

- Kennametal standard dimensions.
- Aerospace composites and fiberglass.

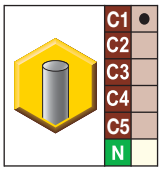






beyond

Bur-Style Router • CBDB • Inch



● first choice
○ alternate choice

KCN05	D1	D	Ap1 max	L	BCH
CBDB0250JXAS	1/4	1/4	3/4	2 1/2	.020
CBDB0250JXBS	1/4	1/4	1 1/2	4	.020
CBDB0375JXAS	3/8	3/8	3/4	3 1/4	.035
CBDB0375JXBS	3/8	3/8	1 1/2	4	.035
CBDB0500JXAS	1/2	1/2	3/4	3 1/4	.045
CBDB0500JXBS	1/2	1/2	1 1/2	4	.045

NOTE: For application data, see page P139.
12 RHS/RHC flutes. 10 LHS/RHC flutes, 6 end teeth.
For tolerance table, see page P137.

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

Additional point styles are available upon request:



End Mill End Cutting

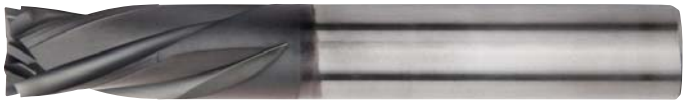


Drill-Point Cutting



Non-End Cutting

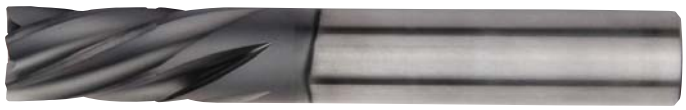
Compression-Style Router • CCNC • Inch



Material Group		Side Milling (A)		beyond KCN05			Feed per Tooth — fz information is for side milling (A).		
		A		Cutting Speed — vc SFM			D1 — Diameter		
		ap	ae	min	max	frac	1/4	3/8	1/2
C	1	Ap1 max	0.5 x D	330	500	fz	.0007	.0012	.0014

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 centers, please adjust parameters accordingly on >1/2" diameter.

Down-Cut Router • CDDC • Inch



Material Group		Side Milling (A)		beyond KCN05			Feed per Tooth — fz information is for side milling (A).		
		A		Cutting Speed — vc SFM			D1 — Diameter		
		ap	ae	min	max	frac	1/4	3/8	1/2
C	1	Ap1 max	1 x D	330	500	fz	.0018	.0030	.0036

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 centers, please adjust parameters accordingly on >1/2" diameter.

Burr-Style Router • CBDB • Inch



Material Group		Side Milling (A) and Slotting (B)			beyond KCN05		Feed per Revolution — Inch per revolution (IPR) information is for side milling (A). For Slotting (B), reduce IPR by 10%.			
		A		B	Cutting Speed — vc SFM			D1 — Diameter		
		ap	ae	ap	min	max	frac	1/4	3/8	1/2
C	1	Ap1 max	0.2 x D	1 x D	330	500	IPR	.0059	.0098	.0118

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 centers, please adjust parameters accordingly on >1/2" 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 maximize 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 maximizes 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 1/4".
- 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

- KC639M AlTiN-coated grade for longest tool life in hardened steels from 40 to 67 HRC.

Customization

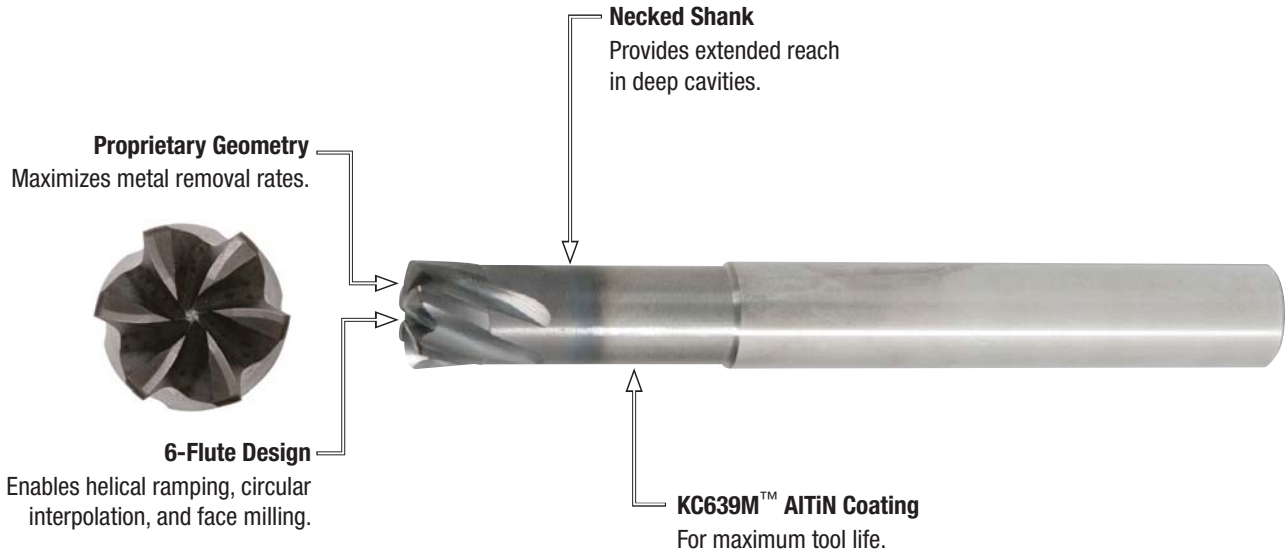
- Intermediate diameters available.
- Custom solutions available for machining titanium and other high-temperature alloys.
- Internal coolant axial and radial available.
- Various shank options and non-standard coatings available.

Extensive Standard Offering

- Diameter ranges 1/4–3/4".
- Extended neck for long-reach applications.

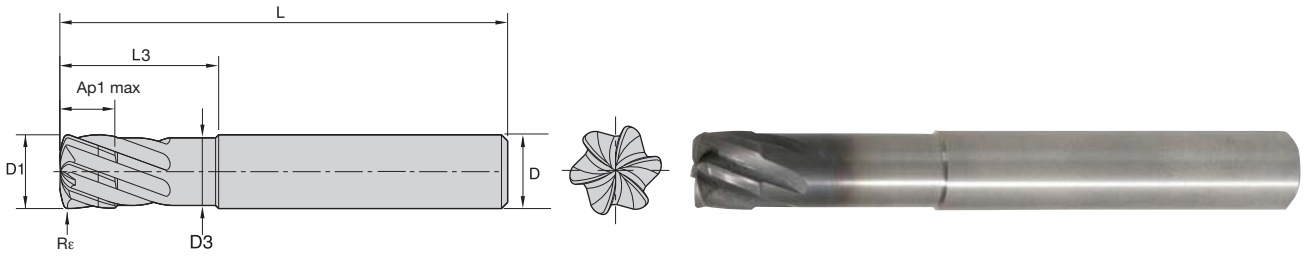
End mills for high-feed milling of medium and hard steels.



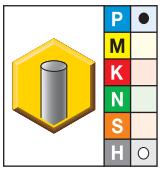


- Kennametal standard dimensions.
- Non-center cutting.
- High feed.





KenFeed • KMDA • <52 HRC • Medium Steels



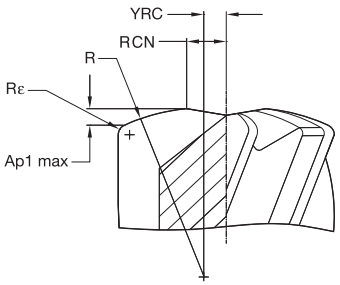
● first choice
○ alternate choice

KC639M	D1	D	D3	Ap1 max	L3	L	Rε
KMDA0250J6ANA	1/4	1/4	.211	.013	3/4	2 1/2	.016
KMDA0312J6ANA	5/16	5/16	.273	.017	1	3	.020
KMDA0375J6ANA	3/8	3/8	.336	.023	1 1/4	3 1/2	.023
KMDA0500J6ANA	1/2	1/2	.461	.027	1 1/2	4	.032
KMDA0625J6ANA	5/8	5/8	.586	.033	2	5	.040
KMDA0750J6ANA	3/4	3/4	.711	.040	2 1/2	5	.047

NOTE: For application data, see page P144.

End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"



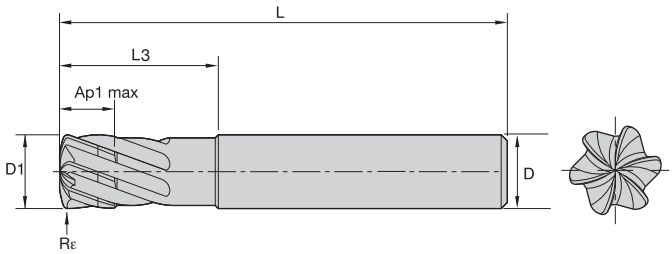
Programming Data

	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				
catalog number	D1	Ap1 max	R	Rε	YRC	RCN	smallest	largest	1°	2°	3°	4°	5°
KMDA0250J6ANA	1/4	0.0133	0.250	0.0160	0.0313	0.0525	0.355	0.500	0.762	0.381	0.254	0.190	0.152
KMDA0312J6ANA	5/16	0.0166	0.313	0.0200	0.0391	0.0656	0.444	0.625	0.953	0.476	0.317	0.238	0.190
KMDA0375J6ANA	3/8	0.0200	0.375	0.0235	0.0469	0.0788	0.533	0.750	1.143	0.572	0.381	0.285	0.228
KMDA0500J6ANA	1/2	0.0266	0.500	0.0320	0.0625	0.1050	0.710	1.000	1.525	0.762	0.508	0.381	0.304
KMDA0625J6ANA	5/8	0.0333	0.625	0.0400	0.0781	0.1313	0.888	1.250	1.906	0.953	0.635	0.476	0.380
KMDA0750J6ANA	3/4	0.0399	0.750	0.0470	0.0938	0.1575	1.065	1.500	2.287	1.143	0.762	0.571	0.456
							recommended % of programmed feed rate to use while ramping		100%	70%	50%	30%	10%

NOTE: YRC = distance from center line to the crown of the R radius.
RCN = distance from center line 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.

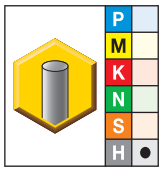
- Kennametal standard dimensions.
- Non-center cutting.
- High feed.







KHDA • Steels with Hardness • >52 HRC



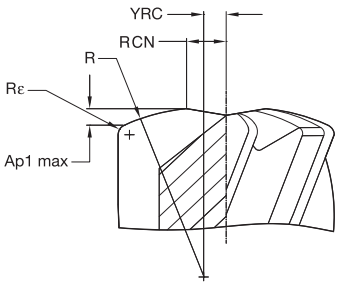
● first choice
○ alternate choice

KC639M	D1	D	Ap1 max	L3	L	Rε
KHDA0250J6ANA	1/4	1/4	.0082	.750	2 1/2	.016
KHDA0312J6ANA	5/16	5/16	.0103	1.000	3	.020
KHDA0375J6ANA	3/8	3/8	.0123	1.250	3 1/2	.020
KHDA0500J6ANA	1/2	1/2	.0164	1.500	4	.023
KHDA0625J6ANA	5/8	5/8	.0205	2.000	4 1/2	.032
KHDA0750J6ANA	3/4	3/4	.0250	2.500	5	.040

NOTE: For application data, see page P144.

End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"



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				
catalog number	D1	Ap1 max	R	Rε	YRC	RCN	smallest	largest	1°	2°	3°	4°	5°
KHDA0250J6ANA	1/4	0.0082	0.375	0.0160	0.0313	0.0550	0.360	0.500	0.470	0.235	0.157	0.117	0.094
KHDA0312J6ANA	5/16	0.0103	0.469	0.0200	0.0391	0.0688	0.450	0.625	0.588	0.294	0.196	0.147	0.117
KHDA0375J6ANA	3/8	0.0123	0.563	0.0240	0.0469	0.0825	0.540	0.750	0.706	0.353	0.235	0.176	0.141
KHDA0500J6ANA	1/2	0.0164	0.750	0.0320	0.0625	0.1100	0.720	1.000	0.941	0.470	0.313	0.235	0.188
KHDA0625J6ANA	5/8	0.0205	0.938	0.0400	0.0781	0.1375	0.900	1.250	1.176	0.588	0.392	0.294	0.235
KHDA0750J6ANA	3/4	0.0246	1.125	0.0470	0.0938	0.1650	1.080	1.500	1.411	0.705	0.470	0.352	0.282
							recommended % of programmed feed rate to use while ramping		100%	70%	50%	30%	10%

NOTE: YRC = distance from center line to the crown of the R radius.
RCN = distance from center line 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.

KMDA • Steels with Hardness <52 HRC





Material Group		3D Milling/Profiling		KC639M Cutting Speed — vc SFM		frac.	D1 — Diameter					
		ap	ae	min	max	dec.	1/4	5/16	3/8	1/2	5/8	3/4
							0.250	0.313	0.375	0.500	0.625	0.750
P	4	0.05 x D	0.55 x D	528	594	fz	.0130	.0160	.0190	.0250	.0260	.0280
H	1	0.05 x D	0.55 x D	462	528	fz	.0130	.0160	.0190	.0250	.0260	.0280
	2	0.05 x D	0.55 x D	330	396	fz	.0080	.0090	.0110	.0150	.0190	.0230

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

KHDA • Steels with Hardness >52 HRC





Material Group		3D Milling/Profiling		KC639M Cutting Speed — vc SFM		frac.	D1 — Diameter					
		ap	ae	min	max	dec.	1/4	5/16	3/8	1/2	5/8	3/4
							0.250	0.313	0.375	0.500	0.625	0.750
H	2	0.03 x D	0.55 x D	330	396	fz	.0080	.0090	.0110	.0150	.0190	.0230
	3	0.03 x D	0.55 x D	265	330	fz	.0080	.0090	.0110	.0150	.0190	.0230
	4	0.03 x D	0.55 x D	165	230	fz	.0060	.0080	.0090	.0130	.0160	.0190

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

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 Authorized 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™.

Customization

- Intermediate diameters available.
- Expanded length of tool and increased length of cut possible.
- Toroidal as well as undercutting end mills (Spherical Lollipop-Style).
- Various shank options and non-standard coatings available.
- TiAlN wear-resistant substrate grade KC637M and AlTiN grade KC643M available as custom solution.

Extensive Standard Offering

- Diameter ranges 1/8–1".
- Extended neck for long-reach applications and radii and sharp corner configurations.
- Roughing and ball nose finishing geometries.

Sophisticated coatings for maximum wear resistance.



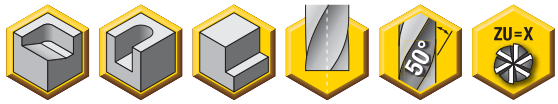
Parabolic Core Design
Proprietary technology stabilizes end mill to avoid deflection in longer length of cut.

Various Helix End Mill Versions
Dedicated application-specific design.

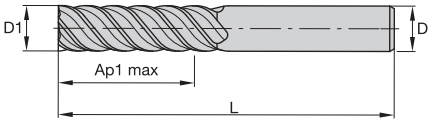


KC633M™ TiAlN-Coated Substrate
For longest tool life in challenging applications.

- Kennametal standard dimensions.
- Center cutting.



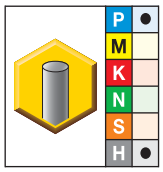




End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

HPFDM • Medium and Hardened Steels

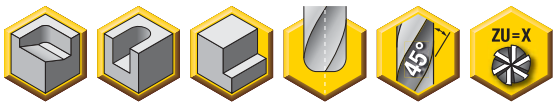


● first choice
○ alternate choice

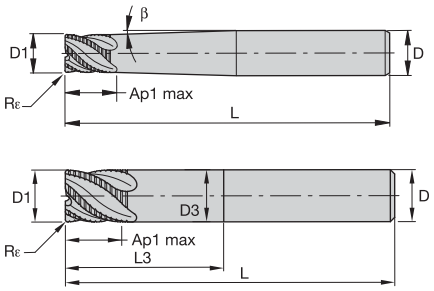
KC633M	D1	D	Ap1 max	L	Z U
HPFDM250S4038	1/4	1/4	3/8	3	4
HPFDM250S4063	1/4	1/4	5/8	3	4
HPFDM250S4088	1/4	1/4	7/8	3	4
HPFDM312S4050	5/16	5/16	1/2	4	4
HPFDM312S4075	5/16	5/16	3/4	4	4
HPFDM312S4113	5/16	5/16	1 1/8	4	4
HPFDM375S4056	3/8	3/8	9/16	4	4
HPFDM375S5094	3/8	3/8	15/16	4	5
HPFDM375S5131	3/8	3/8	1 5/16	4	5
HPFDM500S4075	1/2	1/2	3/4	5	4
HPFDM500S6125	1/2	1/2	1 1/4	5	6
HPFDM500S6175	1/2	1/2	1 3/4	5	6
HPFDM625S4094	5/8	5/8	15/16	5	4
HPFDM625S6156	5/8	5/8	1 9/16	5	6
HPFDM625S6219 *	5/8	5/8	2 3/16	5	6
HPFDM750S4113	3/4	3/4	1 1/8	6	4
HPFDM750S6188	3/4	3/4	1 7/8	6	6
HPFDM750S6263	3/4	3/4	2 5/8	6	6
HPFDM1000S5150	1	1	1 1/2	6	5
HPFDM1000S6250	1	1	2 1/2	6	6
HPFDM1000S6350	1	1	3 1/2	6	6

NOTE: For application data, see page P151.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standard dimensions.
- Center cutting.
- Shallow-pitch profile.



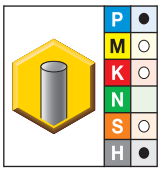




End Mill Tolerances

D1	d11	D	tolerance h6
<1/8"	-.0008/-.0031"	<1/8"	+0/-.00024"
1/8–7/32"	-.0012/-.0041"	1/8–7/32"	+0/-.00031"
1/4–3/8"	-.0016/-.0051"	1/4–3/8"	+0/-.00035"
13/32–11/16"	-.002/-.0063"	13/32–11/16"	+0/-.00043"
23/32–1-3/16"	-.0026/-.0077"	23/32–1-3/16"	+0/-.00051"

HPRDM • Rougher for Medium and Hardened Steels



● first choice
○ alternate choice

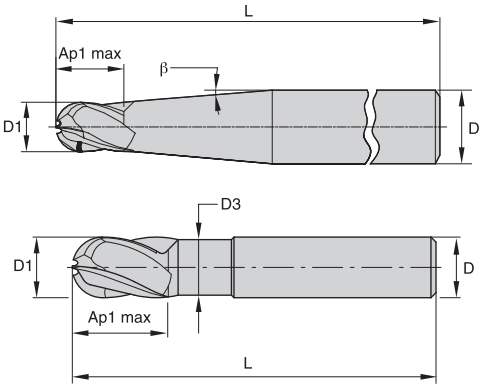
KC633M	D1	D	Ap1 max	L	Rε	β	Z U
HPRDM188S3019	3/16	1/4	3/16	3	.030	2.5	3
HPRDM250S4025	1/4	3/8	1/4	4	.030	2.5	4
HPRDM312S4031	5/16	3/8	5/16	4	.030	2.5	4
HPRDM375S4038	3/8	1/2	3/8	5	.030	2.5	4
HPRDM500S4050	1/2	5/8	1/2	5	.040	2.5	4

NOTE: For application data, see page P151.

- Kennametal standard dimensions.
- Center cutting.





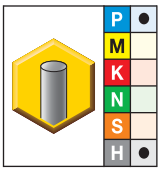


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

HPBNDM • Medium and Hardened Steels

● first choice
○ alternate choice



KC633M	D1	D	D3	Ap1 max	L3	L	β
HPBNDM125S4013	1/8	1/4	—	1/8	1.56	3	2.5
HPBNDM188S4019	3/16	1/4	—	3/16	.90	3	2.5
HPBNDM250S4025	1/4	3/8	—	1/4	1.68	4	2.5
HPBNDM375S4038	3/8	1/2	—	3/8	1.81	5	2.5
HPBNDM500S4050	1/2	5/8	—	1/2	1.93	5	2.5
HPBNDM625S4063	5/8	5/8	.59	5/8	1.87	5	—
HPBNDM750S4075	3/4	3/4	.71	3/4	2.25	6	—

NOTE: For application data, see page P152.

HPFDM

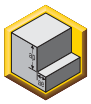




Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC633M Cutting Speed — vc SFM min	max	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. frac.	D1 — Diameter 1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min	max	dec.	0.250	0.313	0.375	0.500	0.625	0.750	1.000
P	3	1 x D	0.4 x D	1 x D	390	520	fz	.0017	.0021	.0025	.0032	.0037	.0042	.0050
	4	1 x D	0.4 x D	0.75 x D	300	490	fz	.0015	.0019	.0022	.0029	.0033	.0036	.0043
H	1	1 x D	0.4 x D	0.75 x D	260	460	fz	.0015	.0019	.0022	.0029	.0033	.0036	.0043
	2	1 x D	0.3 x D	0.5 x D	230	390	fz	.0011	.0014	.0017	.0021	.0024	.0027	.0031
	3	1 x D	0.15 x D	0.3 x D	200	300	fz	.0009	.0011	.0013	.0017	.0020	.0022	.0027
	4	1 x D	0.1 x D	0.15 x D	160	230	fz	.0006	.0008	.0009	.0011	.0013	.0015	.0018

NOTE: These 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.

HPRDM





Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC633M Cutting Speed — vc SFM min	max	Feed per Tooth — fz information is for side milling (A). For slotting (B), reduce fz by 20%. frac.	D1 — Diameter 3/16	1/4	5/16	3/8	1/2
		ap	ae	ap	min	max	dec.	.188	.250	.313	.375	.500
P	3	0.8 x D	0.5 x D	0.75 x D	390	520	IPT	.0011	.0015	.0020	.0023	.0029
	4	0.8 x D	0.4 x D	0.5 x D	300	490	IPT	.0010	.0014	.0017	.0020	.0026
	5	0.8 x D	0.5 x D	0.75 x D	200	330	IPT	.0009	.0012	.0016	.0018	.0023
	6	0.8 x D	0.4 x D	0.5 x D	160	250	IPT	.0008	.0010	.0013	.0015	.0019
M	1	0.8 x D	0.5 x D	0.75 x D	300	380	IPT	.0011	.0015	.0020	.0023	.0029
	2	0.8 x D	0.4 x D	0.75 x D	200	260	IPT	.0009	.0012	.0016	.0018	.0023
	3	0.8 x D	0.4 x D	0.75 x D	200	230	IPT	.0008	.0010	.0013	.0015	.0019
K	1	0.8 x D	0.5 x D	0.75 x D	390	490	IPT	.0013	.0018	.0023	.0027	.0034
	2	0.8 x D	0.5 x D	0.75 x D	360	460	IPT	.0011	.0015	.0020	.0023	.0029
	3	0.8 x D	0.4 x D	0.75 x D	360	430	IPT	.0009	.0012	.0016	.0018	.0023
S	1	0.8 x D	0.4 x D	0.75 x D	160	300	IPT	.0011	.0015	.0020	.0023	.0029
	2	0.8 x D	0.4 x D	0.75 x D	80	130	IPT	.0006	.0008	.0010	.0012	.0015
	3	0.8 x D	0.4 x D	0.75 x D	80	130	IPT	.0006	.0008	.0010	.0012	.0015
	4	0.8 x D	0.3 x D	0.5 x D	160	200	IPT	.0008	.0011	.0014	.0017	.0021
H	1	0.8 x D	0.5 x D	0.5 x D	260	460	IPT	.0010	.0014	.0017	.0020	.0026
	2	0.8 x D	0.2 x D	0.3 x D	230	390	IPT	.0008	.0010	.0013	.0015	.0019
	3	0.8 x D	0.15 x D	0.2 x D	200	300	IPT	.0006	.0008	.0010	.0012	.0015

NOTE: These 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 centers, please adjust parameters accordingly on >1/2" diameter.

HPBNDM



Material Group		3D Milling/Profiling		KC633M Cutting Speed — vc SFM		Feed per Tooth — Finishing									
							D1 — Diameter								
						frac.	1/8	5/32	3/16	1/4	5/16	3/8	1/2	5/8	3/4
		ap	ae	min	max	dec.	0.125	0.156	0.188	0.250	0.313	0.375	0.500	0.625	0.750
P	3	0.04 x D	0.04 x D	1360	1540	fz	.0033	.0042	.0052	.0070	.0090	.0105	.0135	.0157	.0175
	4	0.04 x D	0.04 x D	1190	1360	fz	.0031	.0039	.0047	.0063	.0081	.0093	.0120	.0139	.0152
H	1	0.03 x D	0.03 x D	950	1330	fz	.0033	.0041	.0050	.0068	.0086	.0100	.0128	.0148	.0163
	2	0.03 x D	0.03 x D	670	1140	fz	.0025	.0031	.0038	.0051	.0065	.0075	.0096	.0110	.0120
	3	0.02 x D	0.02 x D	710	1060	fz	.0021	.0026	.0032	.0043	.0054	.0063	.0082	.0095	.0107
	4	0.02 x D	0.02 x D	590	830	fz	.0014	.0017	.0021	.0028	.0036	.0042	.0054	.0063	.0070



Material Group		3D Milling/Profiling		KC633M Cutting Speed — vc SFM		Feed per Tooth — Semi-Finishing									
							D1 — Diameter								
						frac.	1/8	5/32	3/16	1/4	5/16	3/8	1/2	5/8	3/4
		ap	ae	min	max	dec.	0.125	0.156	0.188	0.250	0.313	0.375	0.500	0.625	0.750
P	3	0.1 x D	0.05 x D	890	1000	fz	.0022	.0027	.0033	.0045	.0059	.0068	.0088	.0102	.0114
	4	0.1 x D	0.05 x D	780	890	fz	.0020	.0025	.0030	.0041	.0053	.0061	.0078	.0090	.0099
H	1	0.07 x D	0.1 x D	660	920	fz	.0025	.0031	.0038	.0051	.0066	.0076	.0098	.0113	.0124
	2	0.05 x D	0.04 x D	530	910	fz	.0022	.0027	.0033	.0044	.0057	.0065	.0084	.0096	.0105
	3	0.03 x D	0.03 x D	570	860	fz	.0019	.0025	.0030	.0040	.0051	.0059	.0076	.0089	.0100
	4	0.03 x D	0.03 x D	480	670	fz	.0013	.0016	.0020	.0027	.0034	.0039	.0051	.0059	.0066



Material Group		3D Milling/Profiling		KC633M Cutting Speed — vc SFM		Feed per Tooth — Roughing									
							D1 — Diameter								
						frac.	1/8	5/32	3/16	1/4	5/16	3/8	1/2	5/8	3/4
		ap	ae	min	max	dec.	0.125	0.156	0.188	0.250	0.313	0.375	0.500	0.625	0.750
P	3	0.2 x D	0.1 x D	680	770	fz	.0010	.0012	.0015	.0020	.0026	.0030	.0039	.0046	.0051
	4	0.2 x D	0.1 x D	600	680	fz	.0009	.0011	.0014	.0018	.0023	.0027	.0035	.0040	.0044
H	1	0.15 x D	0.1 x D	460	640	fz	.0013	.0017	.0020	.0028	.0035	.0041	.0052	.0060	.0066
	2	0.1 x D	0.75 x D	390	670	fz	.0015	.0019	.0023	.0031	.0039	.0045	.0058	.0067	.0073
	3	0.05 x D	0.05 x D	450	680	fz	.0017	.0021	.0026	.0035	.0044	.0052	.0067	.0078	.0087
	4	0.05 x D	0.05 x D	380	530	fz	.0011	.0014	.0017	.0023	.0030	.0034	.0044	.0052	.0058

NOTE: These guidelines may require variations to achieve optimum results.

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.

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- Proprietary Beyond™ grade for exceptional tool life in titanium and stainless steels.

Advanced Technology

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- 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 3300 SFM increase metal removal rates.
- Tool life up to 5x that of carbide end mills.

Extensive Standard Offering

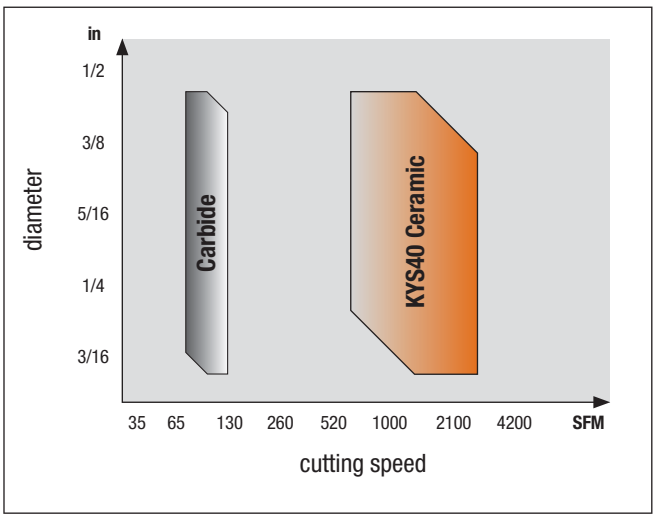
- 4-flute tooling for pocketing and slotting. Undersize end mills leaving stock for finishing operations.
- 6-flute tooling for face milling and profiling.

Customization

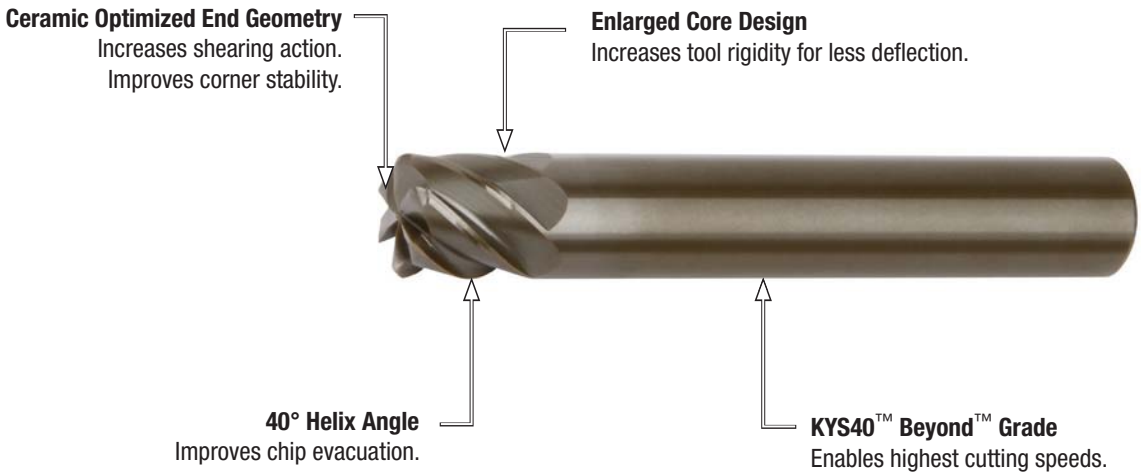
- Engineered solutions are available upon request.

Highest Cutting Speed Capability

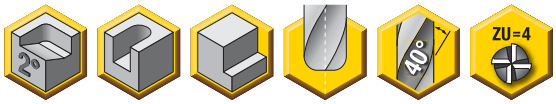
- Increase compared to carbide.



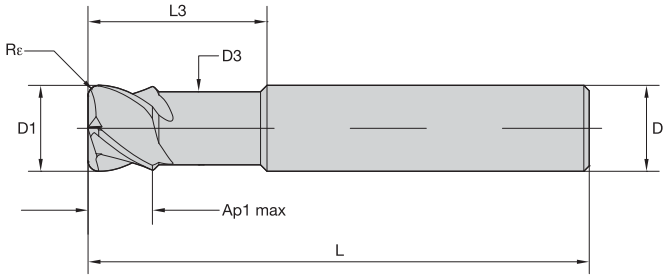



Ceramic Optimized End Geometry
Increases shearing action.
Improves corner stability.
Enlarged Core Design
Increases tool rigidity for less deflection.
40° Helix Angle
Improves chip evacuation.
KYS40™ Beyond™ Grade
Enables highest cutting speeds.

- Kennametal standard dimensions.
- Non-center cutting.
- Ramping up to 2,5°.
- Optimized geometry for roughing nickel-based high-temperature alloys.





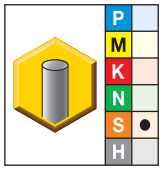


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤1/8"	-.00055/.00110"	≤1/8"	+0/-.00024"
>1/8–1/4"	-.00079/-.00150"	>1/8–1/4"	+0/-.00031"
>1/4–3/8"	-.00098/-.00185"	>1/4–3/8"	+0/-.00035"
>13/32–23/32"	-.00126/-.00232"	>13/32–23/32"	+0/-.00043"
>23/32–1-3/16"	-.00157/-.00287"	>23/32–1-3/16"	+0/-.00051"

beyond

EADE • 4 Flute with Neck • Inch

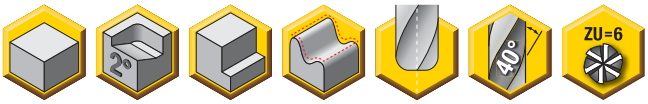


● first choice
○ alternate choice

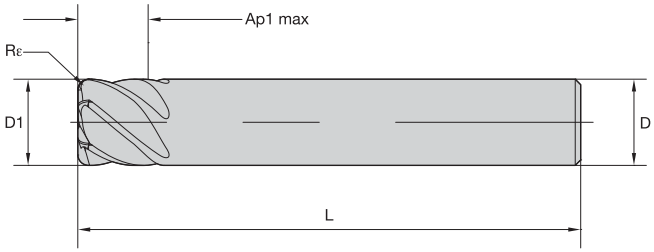
KYS40	D1	D1	D	D3	Ap1 max	L	L3	Rε
EADE0178J4AQX	–	.180	1/4	.173	9/64	2	3/8	.023
EADE0188J4AQX	3/16	.188	1/4	.180	9/64	2	3/8	.023
EADE0238J4AQB	–	.238	1/4	.229	3/16	2	1/2	.031
EADE0250J4AQB	1/4	.250	1/4	.240	3/16	2	1/2	.031
EADE0297J4AQX	19/64	.297	5/16	.285	15/64	2 1/4	5/8	.039
EADE0313J4AQX	5/16	.313	5/16	.300	15/64	2 1/4	5/8	.039
EADE0356J4AQX	–	.356	3/8	.341	9/32	2 1/2	3/4	.047
EADE0375J4AQX	3/8	.375	3/8	.360	9/32	2 1/2	3/4	.047
EADE0475J4AQC	–	.477	1/2	.458	3/8	2 3/4	1	.063
EADE0500J4AQC	1/2	.500	1/2	.480	3/8	2 3/4	1	.063

NOTE: For application data, see page P158.
For face milling, profiling, and 3D milling, do not exceed .019" of Ap.

- Kennametal standard dimensions.
- Non-center cutting.
- Ramping up to 2°.
- Optimized geometry for roughing nickel-based high-temperature alloys.





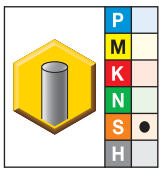


End Mill Tolerances

D1	tolerance e8	D	tolerance h6
≤1/8"	-.00055/.00110"	≤1/8"	+0/-.00024"
>1/8–1/4"	-.00079/-.00150"	>1/8–1/4"	+0/-.00031"
>1/4–3/8"	-.00098/-.00185"	>1/4–3/8"	+0/-.00035"
>13/32–23/32"	-.00126/-.00232"	>13/32–23/32"	+0/-.00043"
>23/32–1-3/16"	-.00157/-.00287"	>23/32–1-3/16"	+0/-.00051"

beyond

EADE • 6 Flute • Inch

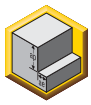


● first choice
○ alternate choice

KYS40	D1	D	Ap1 max	L	Rε
EADE0188J6ARX	3/16	3/16	9/64	2	.023
EADE0250J6ARB	1/4	1/4	3/16	2	.031
EADE0313J6ARX	5/16	5/16	15/64	2 1/4	.039
EADE0375J6ARX	3/8	3/8	9/32	2 1/2	.047
EADE0500J6ARC	1/2	1/2	3/8	2 3/4	.063

NOTE: For application data, see page P158.
For face milling, profiling, and 3D-milling, do not exceed .019" of Ap.

4-Flute with Neck • Inch

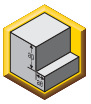




Material Group		Side Milling (A) and Slotting (B)			KYS40		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.					
		A		B	Cutting Speed — vc SFM			D1 — Diameter				
							frac.	3/16	1/4	5/16	3/8	1/2
		ap	ae	ap	min	max	dec.	.1875	.2500	.3125	.3750	.5000
S	3	Ap1 max	0.1 x D*	0,5 x D*	825	3300	IPT	.0094	.0100	.0109	.0113	.0133

NOTE: *For above cutting data, do not exceed an overall ae of .039".
Use ap of .039" as starting condition.

6-Flute • Inch





Material Group		Side Milling (A) and Profiling		KYS40		Recommended feed per tooth (IPT = inch/th) for side milling (A).					
		A		Cutting Speed — vc SFM			D1 — Diameter				
						frac.	3/16	1/4	5/16	3/8	1/2
		ap	ae	min	max	dec.	.1875	.2500	.3125	.3750	.5000
S	3	Ap1 max*	0.1 x D*	825	3300	IPT	.0094	.0100	.0109	.0113	.0133

NOTE: *For above cutting data, do not exceed an overall ae of .039".
Use ap of .039" as starting condition.

A New Dimension

HARVI™ II

The next generation high-performance end mill, HARVI II dramatically improves metal removal rates without reducing tool life.

- Best suited for applications in the aerospace, medical, die and mold, automotive, and general engineering markets.
- Outstanding performance in stainless steel, titanium, INCONEL®, and other high-temperature alloys and steels.
- Increased metal removal rates in roughing and finishing operations.



Advanced Technology

- Five unequally-spaced flutes for chatter-free machining at high feed rates.
- 1 x D full slotting capability in:
  - — Titanium
  - — Stainless steel

Tailored Grades

- Proprietary KCPM15™ Beyond™ grade.
- Universal KC643M™ grade.

Visit **kennametal.com** or contact your local Authorized Kennametal Distributor.

KENNAMETAL®

kennametal.com



EADE 4-Flute End Mill

CHALLENGE

- Roughing a slot on turbine blade.
- Depth of slot .866".
- INCONEL® 718 material.
- Dry machining.

SOLUTION

- Engineered solution EADE KYS40™ ceramic end mill with extended neck.
- Ø .449" (11,4mm) with 4 effective cutting edges and .059" (1,5mm) corner radii.

CUTTING DATA

- vc 2625 SFM
- fz .0012 IPT
- ap .0197"
- ae .866"

RESULT

- Customer proprietary information.

BENEFIT

- Machining time of 1 minute 54 seconds for one slot only.
- Metal removal rate of .9 in^3/m 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 .449" (11,4mm) with 4 effective cutting edges and standard neck.

CUTTING DATA

- vc 2116 SFM
- fz .0012 IPT
- ap .0197"
- ae .866"

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 .394" (10mm) with 6 effective cutting edges.

CUTTING DATA

- vc 1516 SFM
- fz .0012 IPT
- ap .0197–.0394"
- 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 .472" (12mm) with 6 effective cutting edges.

CUTTING DATA

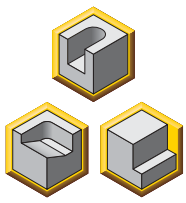
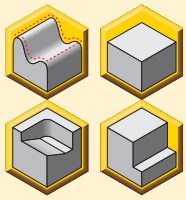
- vc 2228 SFM
- fz .0012 IPT
- ap varying up to .0197"
- ae varying

RESULT

- 2 blisk segments machined with one tool.
- 12 minute machining time per segment.

BENEFIT

- Unprecedented reduction in machining time.

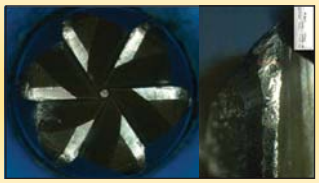
Materials to Cut	• Nickel-based high-temperature alloys. • Cobalt-based alloys after consulting technical assistance. • P6 and M1-3 stainless steels after consulting technical assistance. • Do not apply on iron-based high-temperature alloys.
Cutting Speed	• Maximum RPM machine can provide recommended cutting speed: 1.300–3.300 SFM. • Highly dynamic machines recommended. • Use of spindle speeders applicable (no wet coolant).
Feed Rate	• Refer to application data recommendation. • General starting condition fz .0012 IPT.
Depth of Cut	• Refer to application data recommendation. • General starting condition ap .019".
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-center cutting. • Ramping and helical interpolation possible under 2.5°. 
6-Flute EADE	• Profiling and face milling. • Non-center 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

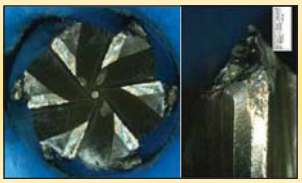


Used



Wear rate .019".
Still good to use.

End of Tool Life



Wear rate .055".
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. Pressurized 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.

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 adapters without modifications. Only use clamping sleeve in hydraulic chucks to avoid vibrations.

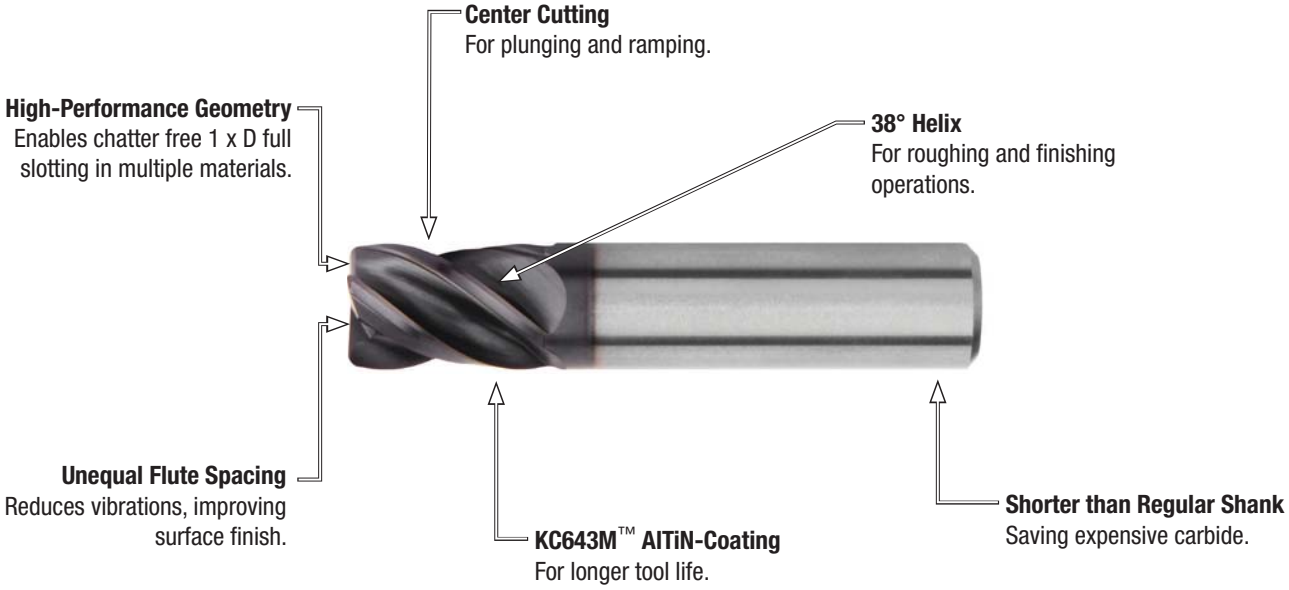
Tailored Grades

- Universal KC643M™ grade suitable for cutting steel, cast iron, stainless steel (wet), and titanium (wet).

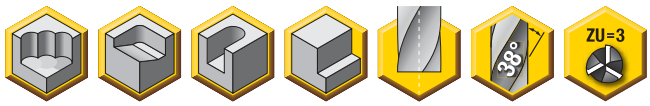
Extensive Standard Offering

- Diameter ranges 5/64–1/2".
- Straight shanks.

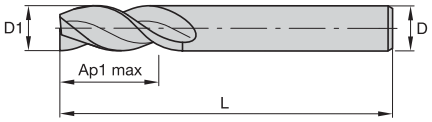



Center Cutting
For plunging and ramping.
High-Performance Geometry
Enables chatter free 1 x D full slotting in multiple materials.
38° Helix
For roughing and finishing operations.
Unequal Flute Spacing
Reduces vibrations, improving surface finish.
KC643M™ AlTiN-Coating
For longer tool life.
Shorter than Regular Shank
Saving expensive carbide.

- Kennametal standard dimensions.
- Center cutting.
- Unequal flute spacing.
- Roughing/finishing.





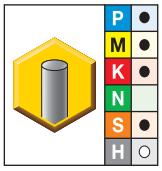


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

GOmill™

UEDE • 3-Flute • Sharp Edge



● first choice
○ alternate choice

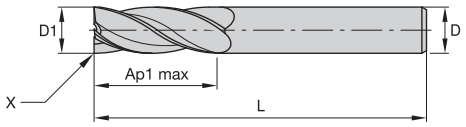
KC643M	D1	D	Ap1 max	L
UEDE0078J3AS	5/64	1/4	5/32	1 1/2
UEDE0094J3AS	3/32	1/4	5/32	1 1/2
UEDE0125J3AS	1/8	1/4	13/64	1 1/2
UEDE0156J3AS	5/32	1/4	17/64	1 1/2
UEDE0188J3AS	3/16	1/4	19/64	1 1/2
UEDE0250J3AS	1/4	1/4	21/64	1 1/2
UEDE0312J3AS	5/16	5/16	27/64	1 3/4
UEDE0375J3AS	3/8	3/8	31/64	2
UEDE0437J3AS	7/16	7/16	9/16	2 5/32
UEDE0500J3AS	1/2	1/2	5/8	2 5/32

NOTE: For application data, see page P170.
Use reducer sleeve when clamping in hydraulic chucks.

- Kennametal standard dimensions.
- Center cutting.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and finishing operations for fewer setups.





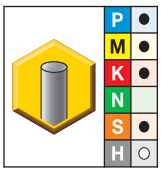


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

GOmill™

UEDE • 4-Flute • Chamfer



● first choice
○ alternate choice

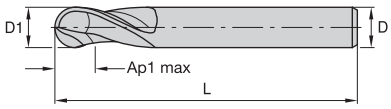
KC643M	D1	D	Ap1 max	L	BCH
UEDE0156J4AH	5/32	1/4	17/64	1 1/2	.016
UEDE0188J4AH	3/16	1/4	19/64	1 1/2	.016
UEDE0250J4AH	1/4	1/4	21/64	1 1/2	.016
UEDE0312J4AH	5/16	5/16	27/64	1 3/4	.016
UEDE0375J4AH	3/8	3/8	31/64	2	.016
UEDE0437J4AH	7/16	7/16	9/16	2 5/32	.016
UEDE0500J4AH	1/2	1/2	5/8	2 5/32	.016

NOTE: For application data, see page P170.
Use reducer sleeve when clamping in hydraulic chucks.

- Kennametal standard dimensions.
- Center cutting.
- Single tool for both semi-finishing and finishing operations for fewer setups.





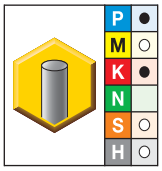


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

GOmill™

UEBD • 2-Flute • Ball Nose



● first choice
○ alternate choice

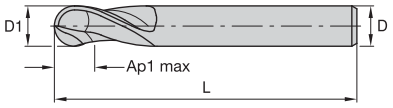
KC643M	D1	D	Ap1 max	L
UEBD0078J2A	5/64	1/4	5/32	1 1/2
UEBD0094J2A	3/32	1/4	5/32	1 1/2
UEBD0125J2A	1/8	1/4	13/64	1 1/2
UEBD0156J2A *	5/32	1/4	17/64	1 1/2
UEBD0188J2A	3/16	1/4	19/64	1 1/2
UEBD0250J2A	1/4	1/4	21/64	1 1/2
UEBD0312J2A *	5/16	5/16	27/64	1 3/4
UEBD0375J2A	3/8	3/8	31/64	2
UEBD0437J2A *	7/16	7/16	9/16	2 5/32
UEBD0500J2A	1/2	1/2	5/8	3

NOTE: For application data, see page P171.
Use reducer sleeve when clamping in hydraulic chucks.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- Kennametal standard dimensions.
- Center cutting.
- Unequal flute spacing minimizes chatter for smoother machining.
- Single tool for both roughing and semi-finishing operations for fewer setups.





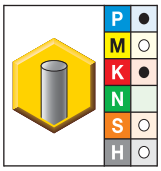


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

GOmill™

UEBD • 3-Flute • Ball Nose



● first choice
○ alternate choice

KC643M	D1	D	Ap1 max	L
UEBD0078J3A	5/64	1/4	5/32	1 1/2
UEBD0094J3A	3/32	1/4	5/32	1 1/2
UEBD0125J3A	1/8	1/4	13/64	1 1/2
UEBD0156J3A	5/32	1/4	17/64	1 1/2
UEBD0188J3A	3/16	1/4	19/64	1 1/2
UEBD0250J3A	1/4	1/4	21/64	1 1/2
UEBD0312J3A	5/16	5/16	27/64	1 3/4
UEBD0375J3A	3/8	3/8	31/64	2
UEBD0437J3A	7/16	7/16	9/16	2 5/32
UEBD0500J3A	1/2	1/2	5/8	2 5/32

NOTE: For application data, see page P171.
Use reducer sleeve when clamping in hydraulic chucks.

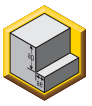
UEDE • 3-Flute • Sharp Edge

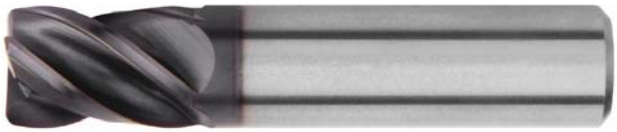




Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC643M Cutting Speed — vc SFM min	max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. frac.	D1 — Diameter 5/64	1/8	3/16	1/4	5/16	3/8	1/2
							dec.	0.08	0.13	0.19	0.250	0.31	0.38	0.50
P	0	1.5 x D	0.5 x D	1 x D	490	660	IPT	.0005	.0009	.0013	.0018	.0023	.0027	.0034
	1	1.5 x D	0.5 x D	1 x D	490	660	IPT	.0005	.0009	.0013	.0018	.0023	.0027	.0034
	2	1.5 x D	0.5 x D	1 x D	460	620	IPT	.0005	.0009	.0013	.0018	.0023	.0027	.0034
	3	1.5 x D	0.5 x D	1 x D	390	520	IPT	.0004	.0007	.0011	.0015	.0020	.0023	.0029
	4	1.5 x D	0.5 x D	0.75 x D	300	490	IPT	.0004	.0007	.0010	.0014	.0017	.0020	.0026
	5	1.5 x D	0.5 x D	1 x D	200	330	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023
	6	1.5 x D	0.5 x D	0.75 x D	160	250	IPT	.0003	.0005	.0008	.0010	.0013	.0015	.0019
M	1	1.5 x D	0.5 x D	1 x D	300	380	IPT	.0004	.0007	.0011	.0015	.0020	.0023	.0029
	2	1.5 x D	0.5 x D	1 x D	200	260	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023
	3	1.5 x D	0.5 x D	1 x D	200	230	IPT	.0003	.0005	.0008	.0010	.0013	.0015	.0019
K	1	1.5 x D	0.5 x D	1 x D	390	490	IPT	.0005	.0009	.0013	.0018	.0023	.0027	.0034
	2	1.5 x D	0.5 x D	1 x D	360	460	IPT	.0004	.0007	.0011	.0015	.0020	.0023	.0029
	3	1.5 x D	0.5 x D	1 x D	360	430	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023
S	1	1.5 x D	0.3 x D	0.3 x D	160	300	IPT	.0004	.0007	.0011	.0015	.0020	.0023	.0029
	2	1.5 x D	0.3 x D	0.3 x D	80	130	IPT	.0002	.0004	.0006	.0008	.0010	.0012	.0015
	3	1.5 x D	0.3 x D	0.3 x D	80	130	IPT	.0002	.0004	.0006	.0008	.0010	.0012	.0015
	4	1.5 x D	0.5 x D	1 x D	160	200	IPT	.0003	.0005	.0008	.0011	.0014	.0017	.0021
H	1	1.5 x D	0.5 x D	0.75 x D	260	460	IPT	.0004	.0007	.0010	.0014	.0017	.0020	.0026

UEDE • 4-Flute • Chamfer



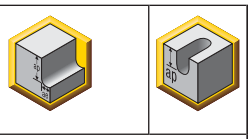


Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC643M Cutting Speed — vc SFM min	max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. frac.	D1 — Diameter 5/64	1/8	5/32	3/16	1/4	5/16	3/8	1/2
							dec.	.0781	.1250	.1563	.1875	.2500	.3125	.3750	.5000
P	0	1.5 x D	0.5 x D	1 x D	490	660	IPT	.0005	.0009	.0011	.0013	.0018	.0023	.0027	.0034
	1	1.5 x D	0.5 x D	1 x D	490	660	IPT	.0005	.0009	.0011	.0013	.0018	.0023	.0027	.0034
	2	1.5 x D	0.5 x D	1 x D	460	620	IPT	.0005	.0009	.0011	.0013	.0018	.0023	.0027	.0034
	3	1.5 x D	0.5 x D	1 x D	390	520	IPT	.0004	.0007	.0009	.0011	.0015	.0020	.0023	.0029
	4	1.5 x D	0.5 x D	0.75 x D	300	490	IPT	.0004	.0007	.0008	.0010	.0014	.0017	.0020	.0026
	5	1.5 x D	0.5 x D	1 x D	200	330	IPT	.0004	.0006	.0007	.0009	.0012	.0016	.0018	.0023
	6	1.5 x D	0.5 x D	0.75 x D	160	250	IPT	.0003	.0005	.0006	.0008	.0010	.0013	.0015	.0019
M	1	1.5 x D	0.5 x D	1 x D	300	380	IPT	.0004	.0007	.0009	.0011	.0015	.0020	.0023	.0029
	2	1.5 x D	0.5 x D	1 x D	200	260	IPT	.0004	.0006	.0007	.0009	.0012	.0016	.0018	.0023
	3	1.5 x D	0.5 x D	1 x D	200	230	IPT	.0003	.0005	.0006	.0008	.0010	.0013	.0015	.0019
K	1	1.5 x D	0.5 x D	1 x D	390	490	IPT	.0005	.0009	.0011	.0013	.0018	.0023	.0027	.0034
	2	1.5 x D	0.5 x D	1 x D	360	460	IPT	.0004	.0007	.0009	.0011	.0015	.0020	.0023	.0029
	3	1.5 x D	0.5 x D	1 x D	360	430	IPT	.0004	.0006	.0007	.0009	.0012	.0016	.0018	.0023
S	1	1.5 x D	0.3 x D	0.3 x D	160	300	IPT	.0004	.0007	.0009	.0011	.0015	.0020	.0023	.0029
	2	1.5 x D	0.3 x D	0.3 x D	80	130	IPT	.0002	.0004	.0005	.0006	.0008	.0010	.0012	.0015
	3	1.5 x D	0.3 x D	0.3 x D	80	130	IPT	.0002	.0004	.0005	.0006	.0008	.0010	.0012	.0015
	4	1.5 x D	0.5 x D	1 x D	160	200	IPT	.0003	.0005	.0006	.0008	.0011	.0014	.0017	.0021
H	1	1.5 x D	0.5 x D	0.75 x D	260	460	IPT	.0004	.0007	.0008	.0010	.0014	.0017	.0020	.0026

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.

UEBD • 2-Flute • Ball Nose

GOmill



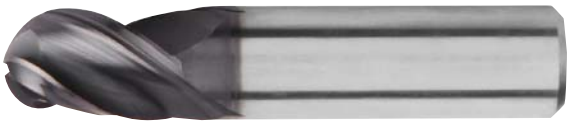


Material Group		Side Milling (A) and Slotting (B)			KC643M		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.							
		A		B	Cutting Speed — vc SFM			D1 — Diameter						
							frac.	5/64	1/8	3/16	1/4	5/16	3/8	1/2
		ap	ae	ap	min	max	dec.	0.08	0.13	0.19	0.25	0.31	0.38	0.50
P	0	1.5 x D	0.5 x D	1 x D	490	660	IPT	.0005	.0009	.0013	.0018	.0023	.0027	.0034
	1	1.5 x D	0.5 x D	1 x D	490	660	IPT	.0005	.0009	.0013	.0018	.0023	.0027	.0034
	2	1.5 x D	0.5 x D	1 x D	460	620	IPT	.0005	.0009	.0013	.0018	.0023	.0027	.0034
	3	1.5 x D	0.5 x D	1 x D	390	520	IPT	.0004	.0007	.0011	.0015	.0020	.0023	.0029
	4	1.5 x D	0.5 x D	0.75 x D	300	490	IPT	.0004	.0007	.0010	.0014	.0017	.0020	.0026
	5	1.5 x D	0.5 x D	1 x D	200	330	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023
	6	1.5 x D	0.5 x D	0.75 x D	160	250	IPT	.0003	.0005	.0008	.0010	.0013	.0015	.0019
M	1	1.5 x D	0.5 x D	1 x D	300	380	IPT	.0004	.0007	.0011	.0015	.0020	.0023	.0029
	2	1.5 x D	0.5 x D	1 x D	200	260	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023
	3	1.5 x D	0.5 x D	1 x D	200	230	IPT	.0003	.0005	.0008	.0010	.0013	.0015	.0019
K	1	1.5 x D	0.5 x D	1 x D	390	490	IPT	.0005	.0009	.0013	.0018	.0023	.0027	.0034
	2	1.5 x D	0.5 x D	1 x D	360	460	IPT	.0004	.0007	.0011	.0015	.0020	.0023	.0029
	3	1.5 x D	0.5 x D	1 x D	360	430	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023
S	1	1.5 x D	0.3 x D	0.3 x D	160	300	IPT	.0004	.0007	.0011	.0015	.0020	.0023	.0029
	2	1.5 x D	0.3 x D	0.3 x D	80	130	IPT	.0002	.0004	.0006	.0008	.0010	.0012	.0015
	3	1.5 x D	0.3 x D	0.3 x D	80	130	IPT	.0002	.0004	.0006	.0008	.0010	.0012	.0015
	4	1.5 x D	0.5 x D	1 x D	160	200	IPT	.0003	.0005	.0008	.0011	.0014	.0017	.0021
H	1	1.5 x D	0.5 x D	0.75 x D	260	460	IPT	.0004	.0007	.0010	.0014	.0017	.0020	.0026

UEBD • 3-flute • Ball Nose

GOmill





Material Group		Side Milling (A) and Slotting (B)			KC643M		Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.							
		A		B	Cutting Speed — vc SFM			D1 — Diameter						
							frac.	5/64	1/8	3/16	1/4	5/16	3/8	1/2
		ap	ae	ap	min	max	dec.	0.08	0.13	0.19	0.25	0.31	0.38	0.50
P	0	1.5 x D	0.5 x D	1 x D	490	660	IPT	.0005	.0009	.0013	.0018	.0023	.0027	.0034
	1	1.5 x D	0.5 x D	1 x D	490	660	IPT	.0005	.0009	.0013	.0018	.0023	.0027	.0034
	2	1.5 x D	0.5 x D	1 x D	460	620	IPT	.0005	.0009	.0013	.0018	.0023	.0027	.0034
	3	1.5 x D	0.5 x D	1 x D	390	520	IPT	.0004	.0007	.0011	.0015	.0020	.0023	.0029
	4	1.5 x D	0.5 x D	0.75 x D	300	490	IPT	.0004	.0007	.0010	.0014	.0017	.0020	.0026
	5	1.5 x D	0.5 x D	1 x D	200	330	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023
	6	1.5 x D	0.5 x D	0.75 x D	160	250	IPT	.0003	.0005	.0008	.0010	.0013	.0015	.0019
M	1	1.5 x D	0.5 x D	1 x D	300	380	IPT	.0004	.0007	.0011	.0015	.0020	.0023	.0029
	2	1.5 x D	0.5 x D	1 x D	200	260	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023
	3	1.5 x D	0.5 x D	1 x D	200	230	IPT	.0003	.0005	.0008	.0010	.0013	.0015	.0019
K	1	1.5 x D	0.5 x D	1 x D	390	490	IPT	.0005	.0009	.0013	.0018	.0023	.0027	.0034
	2	1.5 x D	0.5 x D	1 x D	360	460	IPT	.0004	.0007	.0011	.0015	.0020	.0023	.0029
	3	1.5 x D	0.5 x D	1 x D	360	430	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023
S	1	1.5 x D	0.3 x D	0.3 x D	160	300	IPT	.0004	.0007	.0011	.0015	.0020	.0023	.0029
	2	1.5 x D	0.3 x D	0.3 x D	80	130	IPT	.0002	.0004	.0006	.0008	.0010	.0012	.0015
	3	1.5 x D	0.3 x D	0.3 x D	80	130	IPT	.0002	.0004	.0006	.0008	.0010	.0012	.0015
	4	1.5 x D	0.5 x D	1 x D	160	200	IPT	.0003	.0005	.0008	.0011	.0014	.0017	.0021
H	1	1.5 x D	0.5 x D	0.75 x D	260	460	IPT	.0004	.0007	.0010	.0014	.0017	.0020	.0026

NOTE: Those guidelines may require variations to achieve optimum results.
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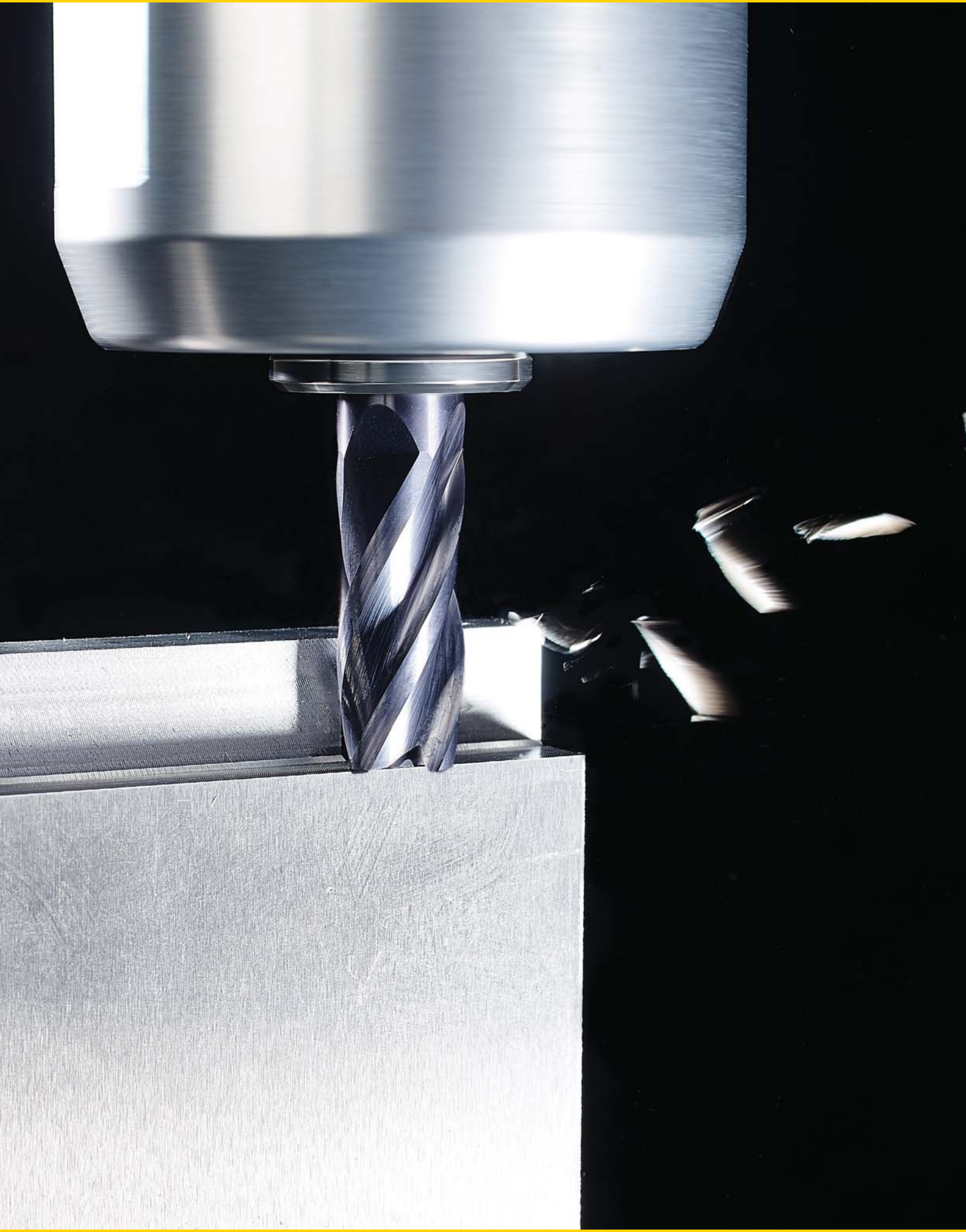


Solid End Milling • General Purpose Solid Carbide End Mills

GOmill Portfolio Overview Q2–Q3

GOmill GP 2-Flute End Mills Q4–Q12

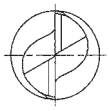
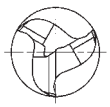
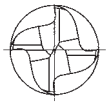
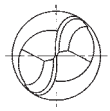
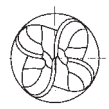
GOmill GP 3-Flute End Mills Q14–Q19

GOmill GP 4-Flute End Mills Q20–Q29

Catalog Numbering System Q30

GOmill GP Cross Reference Guide Q31–Q47

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:

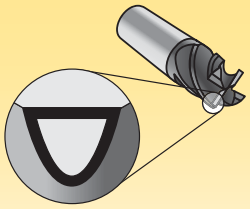
1. Tool overhang.
2. Coolant flow.
3. Machine and setup stability.
4. Machine power and torque.
5. Material to be machined.
6. Machine adapter size (CV40, CV50, HSK63, etc.).

Select Adapter per Technical Data/Characteristics

Technical data/characteristics	Toolholders				
	HydroForce™ high torque	Shrink Fit	Milling chuck	ER collet chuck	Weldon® adapter
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 adapter requires a shrinking unit.

Grades and Grade Descriptions

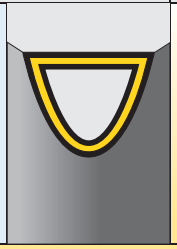


Coatings provide high-speed capability and are engineered for roughing to finishing.

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 characterized 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

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).

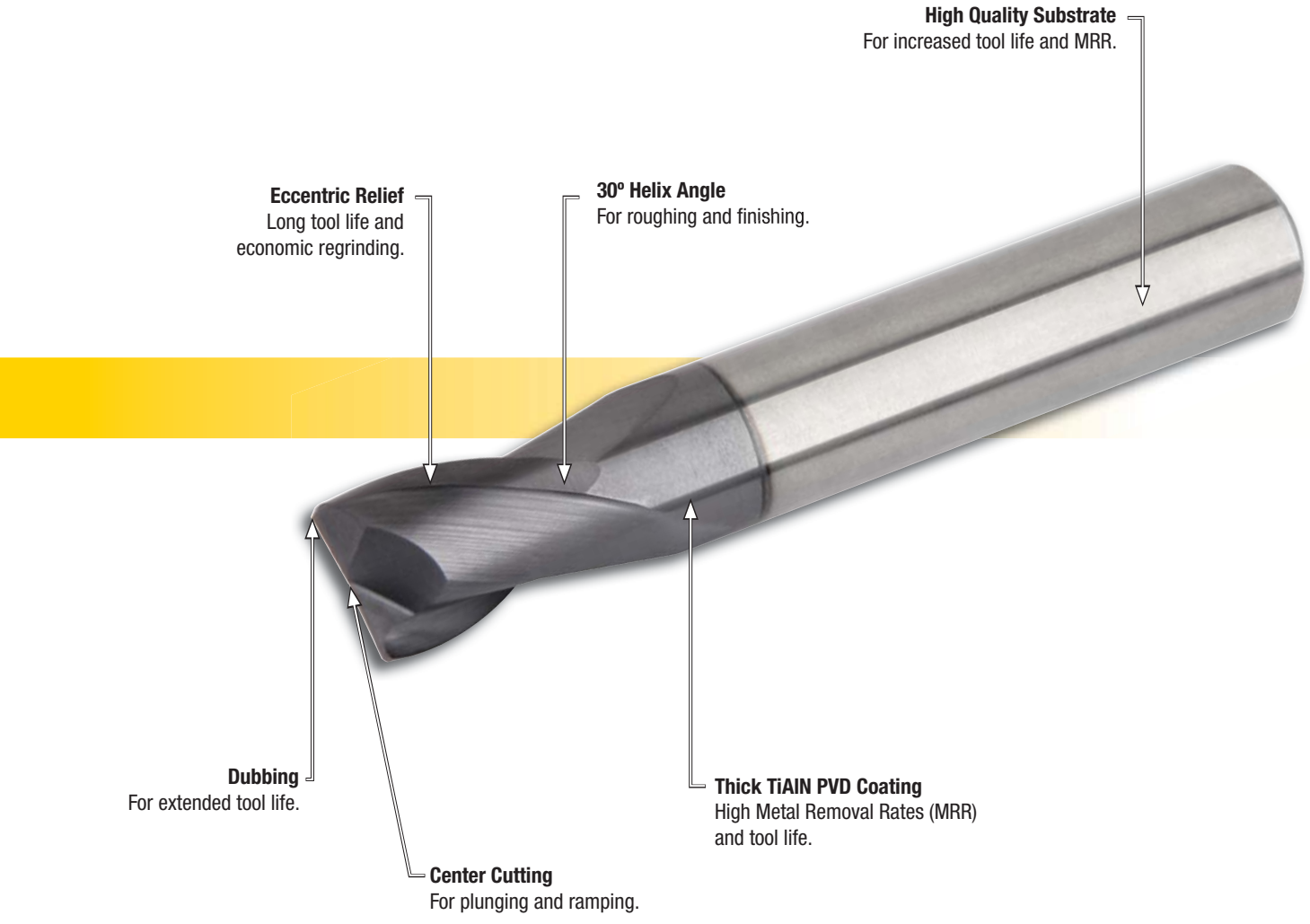
Customization

- Intermediate diameters available.

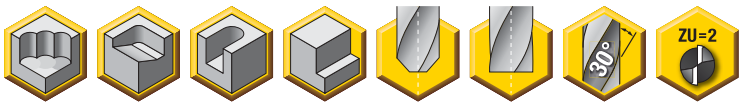
Extensive Standard Offering

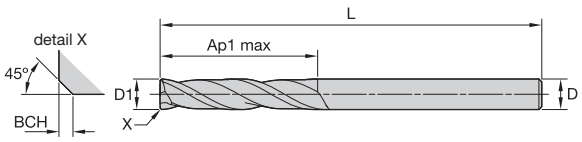
- Diameter range 1/64–1".
- Sharp edge, chamfer edge, and ball nose as standard offering.

Designed for roughing and finishing with one tool at a value price.



- Center cutting.



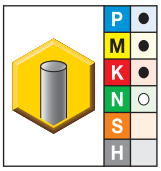


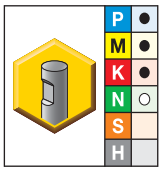


End Mill Tolerances

D1	tolerance	D	tolerance h6 + / -
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

2SE-2CH..IS-IR-IL-IX • 2 Flute • Inch



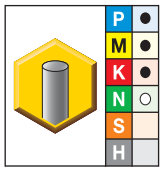


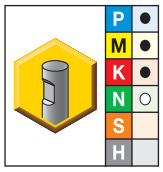
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
2SE0016IR003A	–	1/64	1/8	1/32	1 1/2	–
2SE0031IR007A	–	1/32	1/8	5/64	1 1/2	–
2SE0062IR012A	–	1/16	1/8	1/8	1 1/2	–
2SE0062IL018A	–	1/16	1/8	3/16	1 1/2	–
2SE0062IX050A	–	1/16	1/8	1/2	2	–
2SE0078IR018A	–	5/64	1/8	3/16	1 1/2	–
2SE0093IR018A	–	3/32	1/8	3/16	1 1/2	–
2SE0093IL037A	–	3/32	1/8	3/8	1 1/2	–
2SE0093IX062A	–	3/32	1/8	5/8	2	–
2SE0109IR037A	–	7/64	1/8	3/8	1 1/2	–
2CH0125IR025A	–	1/8	1/8	1/4	1 1/2	.010
2SE0125IR025A	–	1/8	1/8	1/4	1 1/2	–
2CH0125IL050A	–	1/8	1/8	1/2	1 1/2	.010
2SE0125IL050A	–	1/8	1/8	1/2	1 1/2	–
2CH0125IX075A	–	1/8	1/8	3/4	2 1/4	.010
2SE0125IX075A	–	1/8	1/8	3/4	2 1/4	–
2CH0140IR056A	–	9/64	3/16	9/16	2	.010
2SE0140IR056A	–	9/64	3/16	9/16	2	–
2CH0156IR031A	–	5/32	3/16	5/16	2	.010
2SE0156IR031A	–	5/32	3/16	5/16	2	–
2CH0156IL056A	–	5/32	3/16	9/16	2	.010
2SE0156IL056A	–	5/32	3/16	9/16	2	–
2CH0171IR062A	–	11/64	3/16	5/8	2	.010
2SE0171IR062A	–	11/64	3/16	5/8	2	–
2CH0187IR062A	–	3/16	3/16	5/8	2	.010
2SE0187IR062A	–	3/16	3/16	5/8	2	–
2CH0187IL075A	–	3/16	3/16	3/4	2 1/2	.010
2SE0187IL075A	–	3/16	3/16	3/4	2 1/2	–
2CH0187IX112A	–	3/16	3/16	1 1/8	3	.010
2SE0187IX112A	–	3/16	3/16	1 1/8	3	–
2CH0218IR043A	–	7/32	1/4	7/16	2	.016
2SE0218IR043A	–	7/32	1/4	7/16	2	–

(continued)

(2SE-2CH..IS-IR-IL-IX • 2 Flute • Inch — continued)



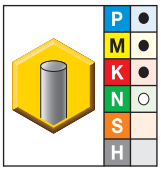


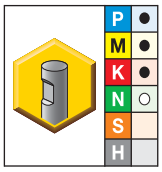
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
2CH0218IL062A	—	7/32	1/4	5/8	2 1/2	.016
2SE0218IL062A	—	7/32	1/4	5/8	2 1/2	—
2CH0250IS050A	—	1/4	1/4	1/2	2	.016
2SE0250IS050A	—	1/4	1/4	1/2	2	—
2CH0250IR075A	—	1/4	1/4	3/4	2 1/2	.016
2SE0250IR075A	—	1/4	1/4	3/4	2 1/2	—
2CH0250IL112A	—	1/4	1/4	1 1/8	3	.016
2SE0250IL112A	—	1/4	1/4	1 1/2	3	—
2CH0250IX150A	—	1/4	1/4	1 1/2	4	.016
2SE0250IX150A	—	1/4	1/4	1 1/2	4	—
2CH0281IR075A	—	9/32	5/16	3/4	2 1/2	.016
2SE0281IR075A	—	9/32	5/16	3/4	2 1/2	—
2CH0312IS050A	—	5/16	5/16	1/2	2	.016
2SE0312IS050A	—	5/16	5/16	1/2	2	—
2CH0312IR081A	—	5/16	5/16	13/16	2 1/2	.016
2SE0312IR081A	—	5/16	5/16	13/16	2 1/2	—
2CH0312IL112A	—	5/16	5/16	1 1/8	3	.016
2SE0312IL112A	—	5/16	5/16	1 1/8	3	—
2CH0312IX162A	—	5/16	5/16	1 5/8	4	.016
2SE0312IX162A	—	5/16	5/16	1 5/8	4	—
2CH0343IR100A	—	11/32	3/8	1	2 1/2	.020
2SE0343IR100A	—	11/32	3/8	1	2 1/2	—
2CH0375IS062A	—	3/8	3/8	5/8	2	.020
2SE0375IS062A	—	3/8	3/8	5/8	2	—
2CH0375IR100A	—	3/8	3/8	1	2 1/2	.020
2SE0375IR100A	—	3/8	3/8	1	2 1/2	—
2CH0375IL112A	—	3/8	3/8	1 1/8	3	.020
2SE0375IL112A	—	3/8	3/8	1 1/2	3	—
2CH0375IX175A	—	3/8	3/8	1 3/4	4	.020
2SE0375IX175A	—	3/8	3/8	1 3/4	4	—
2CH0406IR100A	—	13/32	7/16	1	2 3/4	.020
2SE0406IR100A	—	13/32	7/16	1	2 3/4	—
2CH0437IR062A	—	7/16	7/16	5/8	2 1/2	.020
2SE0437IR062A	—	7/16	7/16	5/8	2 1/2	—
2CH0437IL100A	—	7/16	7/16	1	2 1/2	.020
2SE0437IL100A	—	7/16	7/16	1	2 1/2	—
2CH0437IX200A	—	7/16	7/16	2	4	.020
2SE0437IX200A	—	7/16	7/16	2	4	—
2CH0468IR100A	—	15/32	1/2	1	3	.020
2SE0468IR100A	—	15/32	1/2	1	3	—
2CH0500IS062A	—	1/2	1/2	5/8	2 1/2	.020
2SE0500IS062A	—	1/2	1/2	5/8	2 1/2	—
2CH0500IR100A	2CH0500IR100B	1/2	1/2	1	3	.020
2SE0500IR100A	2SE0500IR100B	1/2	1/2	1	3	—
2CH0500IL200A	2CH0500IL200B	1/2	1/2	2	4	.020
2SE0500IL200A	2SE0500IL200B	1/2	1/2	2	4	—
2CH0500IX300A	2CH0500IX300B	1/2	1/2	3	6	.020
2SE0500IX300A	2SE0500IX300B	1/2	1/2	3	6	—

(continued)

(2SE-2CH..IS-IR-IL-IX • 2 Flute • Inch — continued)



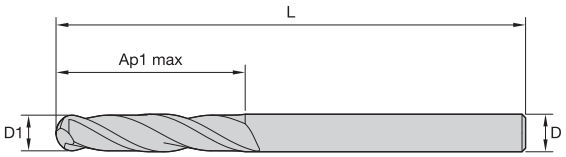


● first choice
○ alternate choice

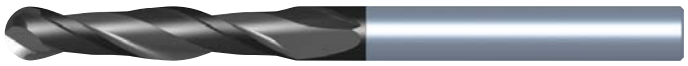
KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
2CH0562IR075A	**—**	9/16	9/16	3/4	3	.020
2SE0562IR075A	**—**	9/16	9/16	3/4	3	—
2CH0562IL125A	**2CH0562IL125B**	9/16	9/16	1 1/4	3 1/2	.020
2SE0562IL125A	**2SE0562IL125B**	9/16	9/16	1 1/4	3 1/2	—
2CH0562IX225A	**2CH0562IX225B**	9/16	9/16	2 1/4	5	.020
2SE0562IX225A	**2SE0562IX225B**	9/16	9/16	2 1/4	5	—
2CH0625IR075A	**—**	5/8	5/8	3/4	3	.020
2SE0625IR075A	**—**	5/8	5/8	3/4	3	—
2CH0625IL125A	**2CH0625IL125B**	5/8	5/8	1 1/4	3 1/2	.020
2SE0625IL125A	**2SE0625IL125B**	5/8	5/8	1 1/4	3 1/2	—
2CH0625IX225A	**2CH0625IX225B**	5/8	5/8	2 1/4	5	.020
2SE0625IX225A	**2SE0625IX225B**	5/8	5/8	2 1/4	5	—
2CH0687IR137A	**2CH0687IR137B**	11/16	3/4	1 3/8	4	.020
2SE0687IR137A	**2SE0687IR137B**	11/16	3/4	1 3/8	4	—
2CH0750IS100A	**—**	3/4	3/4	1	3	.020
2SE0750IS100A	**—**	3/4	3/4	1	3	—
2CH0750IR150A	**—**	3/4	3/4	1 1/2	4	.020
2SE0750IR150A	**—**	3/4	3/4	1 1/2	4	—
2CH0750IR225A	**2CH0750IR225B**	3/4	3/4	2 1/4	5	.020
2SE0750IR225A	**2SE0750IR225B**	3/4	3/4	2 1/4	5	—
2CH0750IL300A	**2CH0750IL300B**	3/4	3/4	3	6	.020
2SE0750IL300A	**2SE0750IL300B**	3/4	3/4	3	6	—
2CH0750IX400A	**2CH0750IX400B**	3/4	3/4	4	7	.020
2SE0750IX400A	**2SE0750IX400B**	3/4	3/4	4	7	—
2CH0875IR150A	**2CH0875IR150B**	7/8	7/8	1 1/2	4	.020
2SE0875IR150A	**2SE0875IR150B**	7/8	7/8	1 1/2	4	—
2CH0875IL225A	**2CH0875IL225B**	7/8	7/8	2 1/4	5	.020
2SE0875IL225A	**2SE0875IL225B**	7/8	7/8	2 1/4	5	—
2CH1000IS150A	**—**	1	1	1 1/2	4	.020
2SE1000IS150A	**—**	1	1	1 1/2	4	—
2CH1000IR225A	**2CH1000IR225B**	1	1	2 1/4	5	.020
2SE1000IR225A	**2SE1000IR225B**	1	1	2 1/4	5	—
2CH1000IL300A	**2CH1000IL300B**	1	1	3	6	.020
2SE1000IL300A	**2SE1000IL300B**	1	1	3	6	—
2CH1000IX400A	**2CH1000IX400B**	1	1	4	7	.020
2SE1000IX400A	**2SE1000IX400B**	1	1	4	7	—

NOTE: For application data, please see page Q11.

- Center cutting.



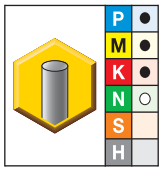




End Mill Tolerances

D1	tolerance	D	tolerance h6 + / -
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

2BN..IS-IR-IL-IX • 2 Flute • Ball Nose • Inch

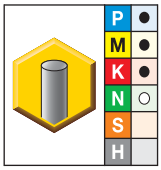


● first choice
○ alternate choice

KC633M	D1	D	length of cut Ap1 max	length L
2BN0031IR007A	1/32	1/8	5/64	1 1/2
2BN0047IR018A	3/64	1/8	3/16	1 1/2
2BN0063IR018A	1/16	1/8	3/16	1 1/2
2BN0094IR018A	3/32	1/8	3/16	1 1/2
2BN0094IL037A	3/32	1/8	3/8	1 1/2
2BN0109IR037A	7/64	1/8	3/8	1 1/2
2BN0125IS025A	1/8	1/8	1/4	1 1/2
2BN0125IR050A	1/8	1/8	1/2	1 1/2
2BN0125IL075A	1/8	1/8	3/4	2 1/4
2BN0125IX075A	1/8	1/8	3/4	3
2BN0156IR031A	5/32	3/16	5/16	2
2BN0156IL056A	5/32	3/16	9/16	2
2BN0187IS031A	3/16	3/16	5/16	1 1/2
2BN0187IR062A	3/16	3/16	5/8	2
2BN0187IL075A	3/16	3/16	3/4	2 1/2
2BN0187IX100A	3/16	3/16	1	4
2BN0219IR062A	7/32	1/4	5/8	2 1/2
2BN0250IS050A	1/4	1/4	1/2	2
2BN0250IR075A	1/4	1/4	3/4	2 1/2
2BN0250IR112A	1/4	1/4	1 1/8	3
2BN0250IL150A	1/4	1/4	1 1/2	4
2BN0250IX150A	1/4	1/4	1 1/2	6
2BN0312IR081A	5/16	5/16	13/16	2 1/2
2BN0312IL112A	5/16	5/16	1 1/8	3
2BN0312IX150A	5/16	5/16	1 1/2	6
2BN0375IS062A	3/8	3/8	5/8	2
2BN0375IR087A	3/8	3/8	7/8	2 1/2
2BN0375IL112A	3/8	3/8	1 1/8	3
2BN0375IX300A	3/8	3/8	3	6
2BN0406IR100A	13/32	7/16	1	2 1/2
2BN0437IR100A	7/16	7/16	1	2 1/2
2BN0500IS062A	1/2	1/2	5/8	2 1/2

(continued)

(2BN..IS-IR-IL-IX • 2 Flute • Ball Nose • Inch — continued)

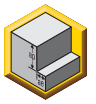


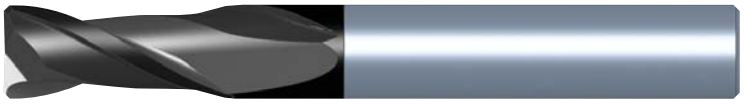
● first choice
○ alternate choice

KC633M	D1	D	length of cut Ap1 max	length L
2BN0500IR100A	1/2	1/2	1	3
2BN0500IX150A	1/2	1/2	1 1/2	6
2BN0500IL200A	1/2	1/2	2	4
2BN0500IX300A	1/2	1/2	3	6
2BN0625IR125A	5/8	5/8	1 1/4	3 1/2
2BN0625IL225A	5/8	5/8	2 1/4	5
2BN0625IX300A	5/8	5/8	3	6
2BN0750IS100A	3/4	3/4	1	3
2BN0750IR150A	3/4	3/4	1 1/2	4
2BN0750IL200A	3/4	3/4	2	6
2BN0750IX300A	3/4	3/4	3	6
2BN0875IR150A	7/8	7/8	1 1/2	4
2BN1000IR150A	1	1	1 1/2	4
2BN1000IL300A	1	1	3	6

NOTE: For application data, please see page Q12.

GOmill GP • 2SE/CH..IS-IR • 2 Flute • Short • Regular





Material Group		Side Milling (A) and Slotting (B) A ap	ae	B ap	KC633M Cutting Speed — vc SFM min		max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. D1 — Diameter inch	1/64 .0156	1/32 .0313	1/16 .0625	5/64 .0781	3/32 .0938	1/8 .1250	3/16 .1875	1/4 .2500	5/16 .3125	3/8 .3750	1/2 .5000	5/8 .6250	3/4 .7500	1 1.0000
P	0	Ap1 max	0.1 x D	0.5 x D	490	–	660	IPT	.0001	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	1	Ap1 max	0.1 x D	0.5 x D	490	–	660	IPT	.0001	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	0.5 x D	460	–	620	IPT	.0001	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	3	Ap1 max	0.1 x D	0.5 x D	390	–	520	IPT	.0001	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	Ap1 max	0.1 x D	0.5 x D	300	–	490	IPT	.0001	.0002	.0003	.0004	.0005	.0007	.0010	.0014	.0018	.0020	.0026	.0030	.0034	.0039
M	1	Ap1 max	0.1 x D	0.5 x D	300	–	380	IPT	.0001	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	Ap1 max	0.1 x D	0.5 x D	200	–	260	IPT	.0001	.0002	.0003	.0004	.0004	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	Ap1 max	0.1 x D	0.5 x D	390	–	490	IPT	.0001	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	0.5 x D	360	–	460	IPT	.0001	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	Ap1 max	0.1 x D	0.5 x D	820	–	3250	IPT	.0002	.0003	.0006	.0008	.0009	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	Ap1 max	0.1 x D	0.5 x D	820	–	2450	IPT	.0001	.0003	.0005	.0006	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	Ap1 max	0.1 x D	0.5 x D	820	–	2450	IPT	.0001	.0003	.0006	.0007	.0008	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090

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 centers, please adjust parameters accordingly on >1/2" diameter.

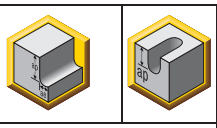
GOmill GP • 2SE/CH..IL-IX • 2 Flute • Long • Extra Long

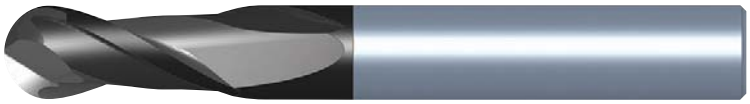



Material Group		Side Milling (A) A ap	ae	KC633M Cutting Speed — vc SFM min		max	Recommended feed per tooth (IPT = inch/th) for side milling (A). D1 — Diameter inch	1/16 .0156	5/64 .0781	3/32 .0938	1/8 .1250	3/16 .1875	1/4 .2500	5/16 .3125	3/8 .3750	1/2 .5000	5/8 .6250	3/4 .7500	1 1.0000
P	0	Ap1 max	0.1 x D	490	–	660	IPT	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	1	Ap1 max	0.1 x D	490	–	660	IPT	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	460	–	620	IPT	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	3	Ap1 max	0.1 x D	390	–	520	IPT	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	Ap1 max	0.1 x D	300	–	490	IPT	.0003	.0004	.0005	.0007	.0010	.0014	.0018	.0020	.0026	.0030	.0034	.0039
M	1	Ap1 max	0.1 x D	300	–	380	IPT	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	Ap1 max	0.1 x D	200	–	260	IPT	.0003	.0004	.0004	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	Ap1 max	0.1 x D	390	–	490	IPT	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	360	–	460	IPT	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	Ap1 max	0.1 x D	820	–	3250	IPT	.0006	.0008	.0009	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	Ap1 max	0.1 x D	820	–	2450	IPT	.0005	.0006	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	Ap1 max	0.1 x D	820	–	2450	IPT	.0006	.0007	.0008	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090

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 centers, please adjust parameters accordingly on >1/2" diameter.

GOmill GP • 2BN..IS-IR • 2 Flute • Ball Nose • Short • Regular

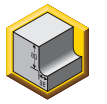
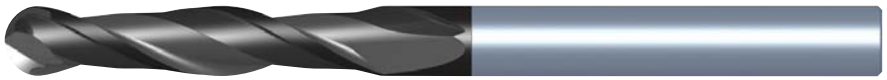




Material Group		Side Milling (A) and Slotting (B)			KC633M			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.														
		A		B	Cutting Speed — vc SFM			D1 — Diameter														
		ap	ae	ap	min		max	inch	1/32 .0313	1/16 .0625	5/64 .0781	3/32 .0938	1/8 .1250	3/16 .1875	1/4 .2500	5/16 .3125	3/8 .3750	1/2 .5000	5/8 .6250	3/4 .7500	1 1.0000
P	0	Ap1 max	0.1 x D	0.5 x D	490	–	660	IPT	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	1	Ap1 max	0.1 x D	0.5 x D	490	–	660	IPT	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	0.5 x D	460	–	620	IPT	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	3	Ap1 max	0.1 x D	0.5 x D	390	–	520	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	Ap1 max	0.1 x D	0.5 x D	300	–	490	IPT	.0002	.0003	.0004	.0005	.0007	.0010	.0014	.0018	.0020	.0026	.0030	.0034	.0039
M	1	Ap1 max	0.1 x D	0.5 x D	300	–	380	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	Ap1 max	0.1 x D	0.5 x D	200	–	260	IPT	.0002	.0003	.0004	.0004	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	Ap1 max	0.1 x D	0.5 x D	390	–	490	IPT	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	0.5 x D	360	–	460	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	Ap1 max	0.1 x D	0.5 x D	820	–	3250	IPT	.0003	.0006	.0008	.0009	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	Ap1 max	0.1 x D	0.5 x D	820	–	2450	IPT	.0003	.0005	.0006	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	Ap1 max	0.1 x D	0.5 x D	820	–	2450	IPT	.0003	.0006	.0007	.0008	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090

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 centers, please adjust parameters accordingly on >1/2" diameter.

GOmill GP • 2BN..IL-IX • 2 Flute • Ball Nose • Long • Extra Long

Material Group		Side Milling (A)		KC633M			Recommended feed per tooth (IPT = inch/th) for side milling (A).									
		A		Cutting Speed — vc SFM			D1 — Diameter									
		ap	ae	min		max	inch	3/32 .0938	1/8 .1250	3/16 .1875	1/4 .2500	5/16 .3125	3/8 .3750	1/2 .5000	5/8 .6250	3/4 .7500	1 1.0000
P	0	Ap1 max	0.1 x D	490	–	660	IPT	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	1	Ap1 max	0.1 x D	490	–	660	IPT	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	460	–	620	IPT	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	3	Ap1 max	0.1 x D	390	–	520	IPT	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	Ap1 max	0.1 x D	300	–	490	IPT	.0005	.0007	.0010	.0014	.0018	.0020	.0026	.0030	.0034	.0039
M	1	Ap1 max	0.1 x D	300	–	380	IPT	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	Ap1 max	0.1 x D	200	–	260	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	Ap1 max	0.1 x D	390	–	490	IPT	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	360	–	460	IPT	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	Ap1 max	0.1 x D	820	–	3250	IPT	.0009	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	Ap1 max	0.1 x D	820	–	2450	IPT	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	Ap1 max	0.1 x D	820	–	2450	IPT	.0008	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090

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 centers, please adjust parameters accordingly on >1/2" diameter.

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 catalog, and then manually inputting the tooling information from the catalog 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 maximizes every shift. **kennametal.com/novo**



GOmill™ GP General Purpose Solid Carbide End Mills · 3 Flute

Primary Application

GOmill GP system 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).

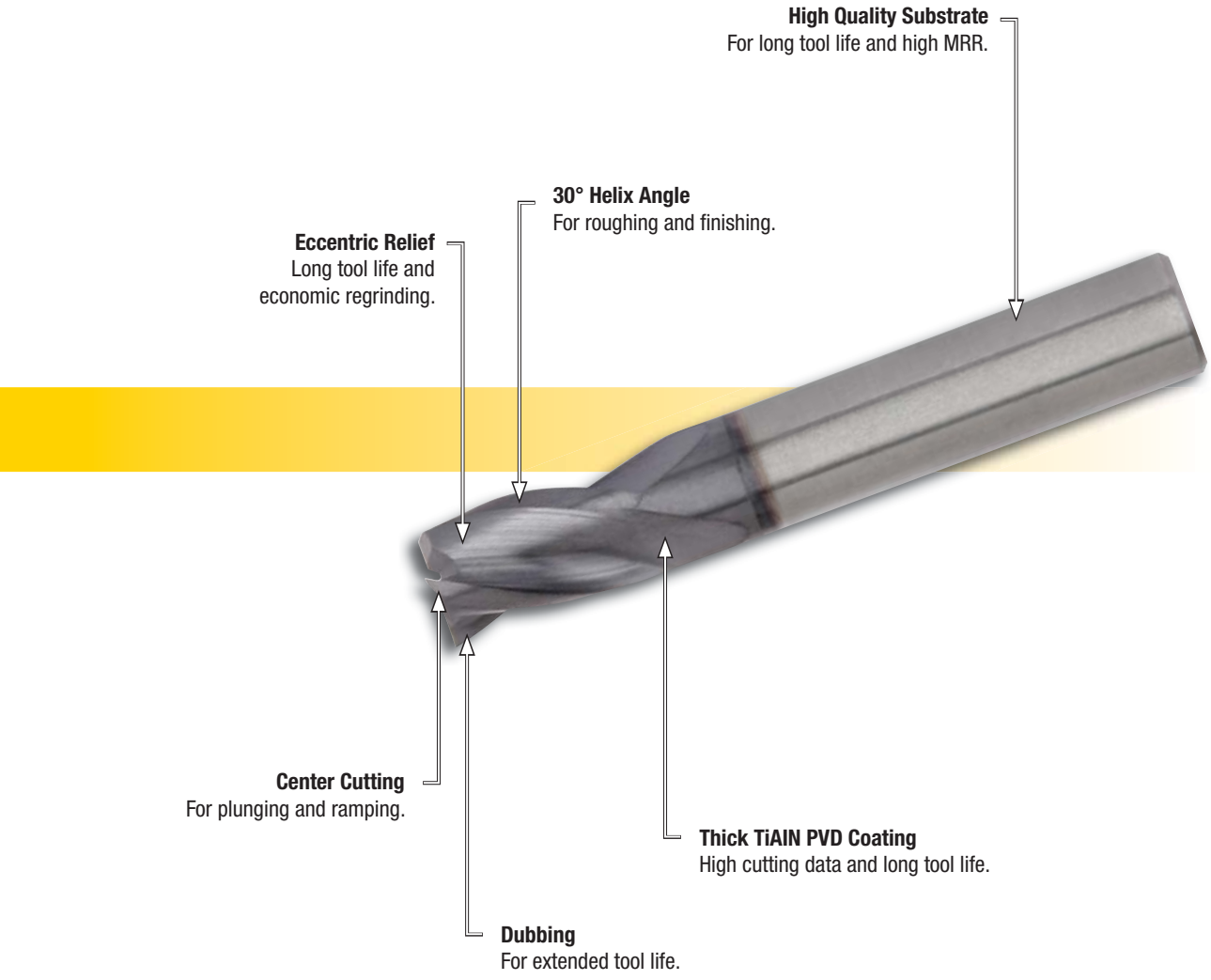
Customization

- Intermediate diameters available.

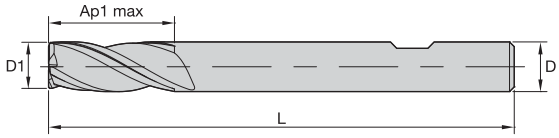
Extensive Standard Offering

- Diameter range 1/32–1".
- Sharp edge as standard offering.
- Four different lengths as factory standards in stock.

Designed for roughing and finishing with one tool at an economical price.



- Center cutting.

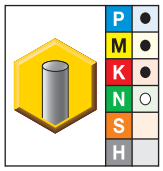


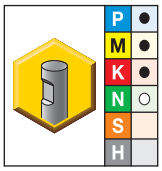


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

3SE..IS-IR-IL-IX • 3 Flute • Inch



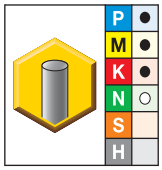


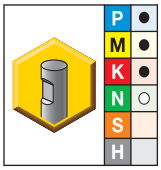
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L
3SE0031IR007A	–	1/32	1/8	5/64	1 1/2
3SE0047IR011A	–	3/64	1/8	7/64	1 1/2
3SE0062IR019A	–	1/16	1/8	3/16	1 1/2
3SE0078IR011A	–	5/64	1/8	7/64	1 1/2
3SE0094IR037A	–	3/32	1/8	3/8	1 1/2
3SE0109IR037A	–	7/64	1/8	3/8	1 1/2
3SE0125IR025A	–	1/8	1/8	1/4	1 1/2
3SE0125IL050A	–	1/8	1/8	1/2	2 1/2
3SE0125IX062A	–	1/8	1/8	5/8	3
3SE0156IR056A	–	5/32	3/16	9/16	2
3SE0188IS031A	–	3/16	3/16	5/16	2
3SE0188IR056A	–	3/16	3/16	9/16	2
3SE0188IL062A	–	3/16	3/16	5/8	3
3SE0188IX100A	–	3/16	3/16	1	4
3SE0219IR062A	–	7/32	1/4	5/8	2 1/2
3SE0219IL075A	–	7/32	1/4	3/4	2 1/2
3SE0250IS050A	–	1/4	1/4	1/2	2
3SE0250IR075A	–	1/4	1/4	3/4	2 1/2
3SE0250IL100A	–	1/4	1/4	1	3
3SE0250IX150A	–	1/4	1/4	1 1/2	4
3SE0281IR075A	–	9/32	5/16	3/4	2 1/2
3SE0281IL081A	–	9/32	5/16	13/16	2 1/2
3SE0312IR050A	–	5/16	5/16	1/2	2
3SE0312IL081A	–	5/16	5/16	13/16	2 1/2
3SE0375IS050A	–	3/8	3/8	1/2	2
3SE0375IR088A	–	3/8	3/8	7/8	2 1/2
3SE0375IL100A	–	3/8	3/8	1	2 1/2
3SE0375IX112A	–	3/8	3/8	1 1/8	3
3SE0437IR062A	–	7/16	7/16	5/8	2 1/2
3SE0437IL088A	–	7/16	7/16	7/8	2 1/2
3SE0437IX100A	–	7/16	7/16	1	2 1/2
3SE0500IR100A	–	1/2	1/2	1	3

(continued)

(3SE..IS-IR-IL-IX • 3 Flute • Inch — continued)



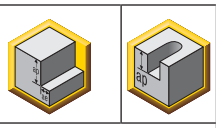


● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L
3SE0500IL200A	**–**	1/2	1/2	2	4
3SE0563IR112A	**3SE0563IR112B**	9/16	5/8	1 1/8	3 1/2
3SE0625IR075A	**3SE0625IR075B**	5/8	5/8	3/4	3
3SE0625IL125A	**3SE0625IL125B**	5/8	5/8	1 1/4	3 1/2
3SE0750IR100A	**–**	3/4	3/4	1	3
3SE0750IL150A	**3SE0750IL150B**	3/4	3/4	1 1/2	4
3SE0750IX225A	**3SE0750IX225B**	3/4	3/4	2 1/4	5
3SE1000IR150A	**–**	1	1	1 1/2	4
3SE1000IX225A	**3SE1000IX225B**	1	1	2 1/4	5

NOTE: For application data, please see pages Q18–Q19.

GOmill • 3SE..IS-IR • 3 Flute • Short • Regular





Material Group		Side Milling (A) and Slotting (B)			KC633M			Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%.													
		A		B	Cutting Speed — vc SFM				D1 — Diameter												
								frac.	1/32	1/16	5/64	3/32	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	ap	min		max	dec.	.0313	.0625	.0781	.0938	.1250	.1875	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
P	0	2.0 x D	0.1 x D	0.5 x D	490	–	660	IPT	.0002	.0005	.0006	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	1	2.0 x D	0.1 x D	0.5 x D	490	–	660	IPT	.0002	.0005	.0006	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	2	2.0 x D	0.1 x D	0.5 x D	460	–	620	IPT	.0002	.0005	.0006	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	3	2.0 x D	0.1 x D	0.5 x D	390	–	520	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	2.0 x D	0.1 x D	0.5 x D	300	–	490	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0014	.0017	.0020	.0026	.0030	.0034	.0039
M	1	2.0 x D	0.1 x D	0.5 x D	300	–	380	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	2.0 x D	0.1 x D	0.5 x D	200	–	260	IPT	.0002	.0003	.0004	.0005	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	2.0 x D	0.1 x D	0.5 x D	390	–	490	IPT	.0002	.0005	.0006	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	2	2.0 x D	0.1 x D	0.5 x D	360	–	460	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	2.0 x D	0.1 x D	0.5 x D	820	–	3250	IPT	.0003	.0007	.0008	.0010	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	2.0 x D	0.1 x D	0.5 x D	820	–	3250	IPT	.0003	.0005	.0006	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	2.0 x D	0.1 x D	0.5 x D	820	–	3250	IPT	.0003	.0006	.0007	.0008	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090

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 centers, please adjust parameters accordingly on diameters >1/2".

GOmill • 3SE..IL-IX • 3 Flute • Long • Extra Long



Material Group		Side Milling (A)		KC633M			Recommended feed per tooth (IPT = inch/th) for side milling (A).								
		A		Cutting Speed — vc SFM				D1 — Diameter							
							frac.	1/8	5/32	1/4	5/16	3/8	1/2	5/8	3/4	1
		ap	ae	min		max	dec.	.1250	.1563	.2500	.3125	.3750	.5000	.6250	.7500	1.0000
P	0	2.0 x D	0.1 x D	490	–	660	IPT	.0009	.0011	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	1	2.0 x D	0.1 x D	490	–	660	IPT	.0009	.0011	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	2	2.0 x D	0.1 x D	460	–	620	IPT	.0009	.0011	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	3	2.0 x D	0.1 x D	390	–	520	IPT	.0007	.0009	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	2.0 x D	0.1 x D	300	–	490	IPT	.0007	.0008	.0014	.0017	.0020	.0026	.0030	.0034	.0039
M	1	2.0 x D	0.1 x D	300	–	380	IPT	.0007	.0009	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	2.0 x D	0.1 x D	200	–	260	IPT	.0006	.0007	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	2.0 x D	0.1 x D	390	–	490	IPT	.0009	.0011	.0018	.0023	.0027	.0034	.0039	.0044	.0049
	2	2.0 x D	0.1 x D	360	–	460	IPT	.0007	.0009	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	2.0 x D	0.1 x D	820	–	3250	IPT	.0013	.0016	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	2.0 x D	0.1 x D	820	–	2450	IPT	.0010	.0013	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	2.0 x D	0.1 x D	820	–	2450	IPT	.0011	.0014	.0023	.0028	.0034	.0045	.0056	.0068	.0090

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 centers, please adjust parameters accordingly on diameters >1/2".

GOmill™ GP General Purpose Solid Carbide End Mills · 4 Flute

Primary Application

GOmill GP system 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).

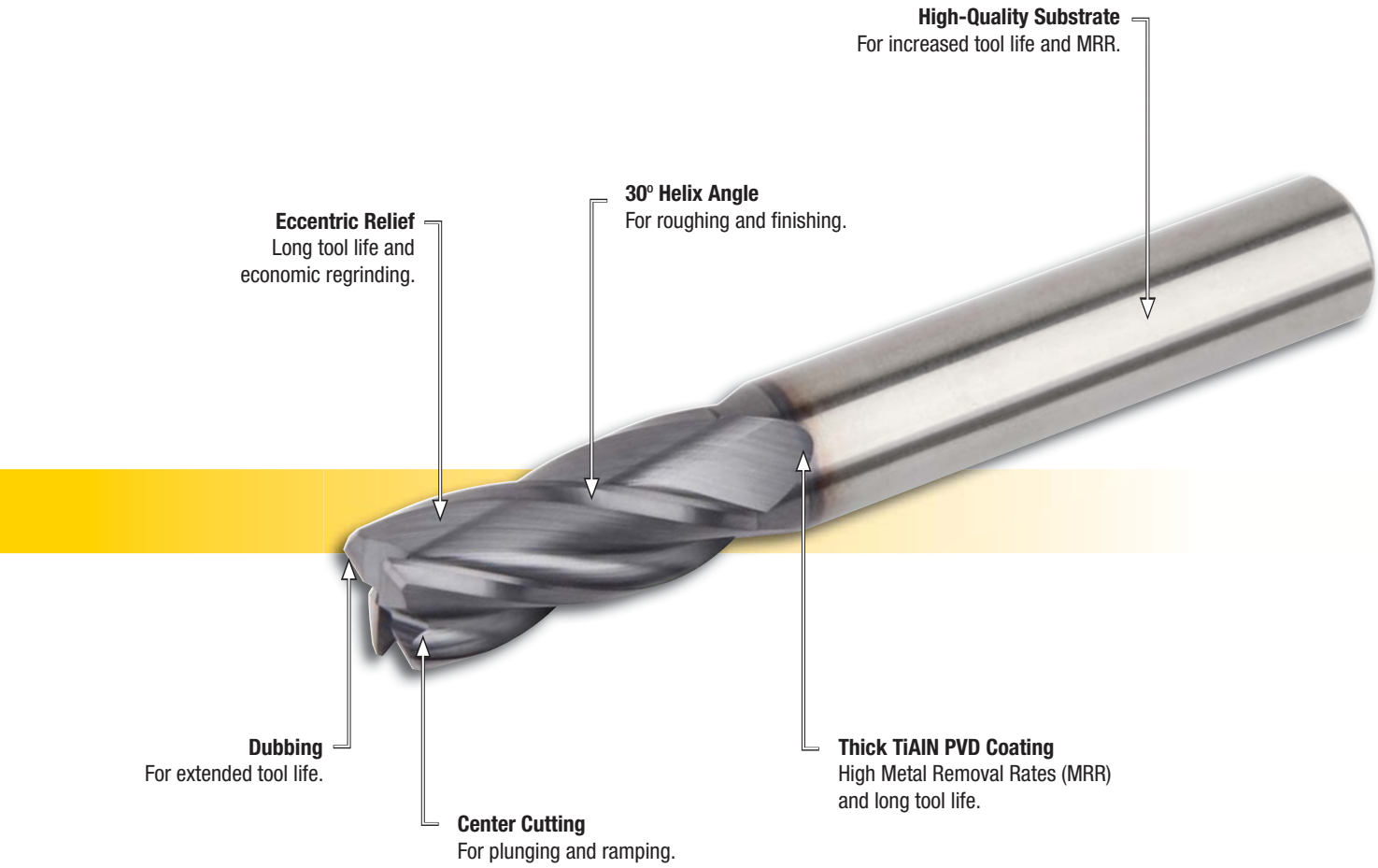
Customization

- Intermediate diameters available.

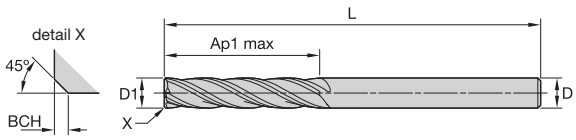
Extensive Standard Offering

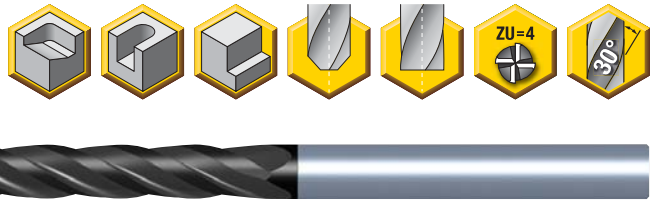
- Diameter range 1/64–1".
- Sharp edge, chamfer edge, and ball nose as standard offering.

Designed for roughing and finishing with one tool at a value price.



- Center cutting.

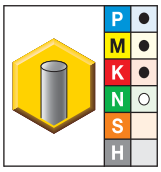


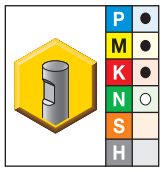


End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

4SE-4CH..IS-IR-IL-IX • 4 Flute • Inch



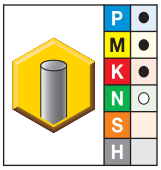


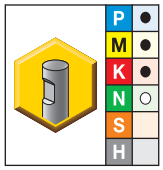
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
4SE0015IR003A	–	1/64	1/8	1/32	1 1/2	–
4SE0031IR008A	–	1/32	1/8	5/64	1 1/2	–
4SE0062IR010A	–	1/16	1/8	7/64	1 1/2	–
4SE0078IR018A	–	5/64	1/8	3/16	1 1/2	–
4SE0093IR037A	–	3/32	1/8	3/8	1 1/2	–
4SE0093IL062A	–	3/32	1/8	5/8	2	–
4SE0109IR037A	–	7/64	1/8	3/8	1 1/2	–
4CH0125IS025A	–	1/8	1/8	1/4	1 1/2	.010
4SE0125IS025A	–	1/8	1/8	1/4	1 1/2	–
4CH0125IR050A	–	1/8	1/8	1/2	1 1/2	.010
4SE0125IR050A	–	1/8	1/8	1/2	1 1/2	–
4CH0125IL075A	–	1/8	1/8	3/4	2 1/4	.010
4SE0125IL075A	–	1/8	1/8	3/4	2 1/4	–
4CH0125IX100A	–	1/8	1/8	1	3	.010
4SE0125IX100A	–	1/8	1/8	1	3	–
4CH0140IR056A	–	9/64	3/16	9/16	2	.010
4SE0140IR056A	–	9/64	3/16	9/16	2	–
4CH0156IR056A	–	5/32	3/16	9/16	2	.010
4SE0156IR056A	–	5/32	3/16	9/16	2	–
4CH0187IR062A	–	3/16	3/16	5/8	2	.010
4SE0187IR062A	–	3/16	3/16	5/8	2	–
4CH0187IS075A	–	3/16	3/16	3/4	1 1/2	.010
4SE0187IS075A	–	3/16	3/16	3/4	1 1/2	–
4CH0187IL075A	–	3/16	3/16	3/4	2 1/2	.010
4SE0187IL075A	–	3/16	3/16	3/4	2 1/2	–
4CH0187IX112A	–	3/16	3/16	1 1/8	3	.010
4SE0187IX112A	–	3/16	3/16	1 1/8	3	–
4CH0203IR062A	–	13/64	1/4	5/8	2 1/2	.016
4SE0203IR062A	–	13/64	1/4	5/8	2 1/2	–
4CH0218IR043A	–	7/32	1/4	7/16	2	.016
4SE0218IR043A	–	7/32	1/4	7/16	2	–
4CH0218IL062A	–	7/32	1/4	5/8	2 1/2	.016

(continued)

(4SE-4CH..IS-IR-IL-IX • 4 Flute • Inch — continued)



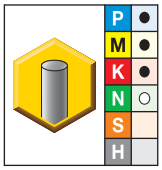


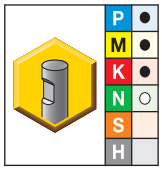
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
4SE0218IL062A	–	7/32	1/4	5/8	2 1/2	–
4CH0234IR075A	–	15/64	1/4	3/4	2 1/2	.016
4SE0234IR075A	–	15/64	1/4	3/4	2 1/2	–
4CH0250IS050A	–	1/4	1/4	1/2	2	.016
4SE0250IS050A	–	1/4	1/4	1/2	2	–
4CH0250IR075A	–	1/4	1/4	3/4	2 1/2	.016
4SE0250IR075A	–	1/4	1/4	3/4	2 1/2	–
4CH0250IL112A	–	1/4	1/4	1 1/8	3	.016
4SE0250IL112A	–	1/4	1/4	1 1/8	3	–
4CH0250IX150A	–	1/4	1/4	1 1/2	4	.016
4SE0250IX150A	–	1/4	1/4	1 1/2	4	–
4CH0265IR075A	–	17/64	5/16	3/4	2 1/2	.016
4SE0265IR075A	–	17/64	5/16	3/4	2 1/2	–
4CH0281IR075A	–	9/32	5/16	3/4	2 1/2	.016
4SE0281IR075A	–	9/32	5/16	3/4	2 1/2	–
4CH0296IR081A	–	19/64	5/16	13/16	2 1/2	.016
4SE0296IR081A	–	19/64	5/16	13/16	2 1/2	–
4CH0312IS050A	–	5/16	5/16	1/2	2	.016
4SE0312IS050A	–	5/16	5/16	1/2	2	–
4CH0312IR081A	–	5/16	5/16	13/16	2 1/2	.016
4SE0312IR081A	–	5/16	5/16	13/16	2 1/2	–
4CH0312IL112A	–	5/16	5/16	1 1/8	3	.016
4SE0312IL112A	–	5/16	5/16	1 1/8	3	–
4CH0312IX162A	–	5/16	5/16	1 5/8	4	.016
4SE0312IX162A	–	5/16	5/16	1 5/8	4	–
4CH0328IR100A	–	21/64	3/8	1	2 1/2	.020
4SE0328IR100A	–	21/64	3/8	1	2 1/2	–
4CH0343IR100A	–	11/32	3/8	1	2 1/2	.020
4SE0343IR100A	–	11/32	3/8	1	2 1/2	–
4CH0359IR100A	–	23/64	3/8	1	2 1/2	.020
4SE0359IR100A	–	23/64	3/8	1	2 1/2	–
4CH0375IS062A	–	3/8	3/8	5/8	2	.020
4SE0375IS062A	–	3/8	3/8	5/8	2	–
4CH0375IR100A	–	3/8	3/8	1	2 1/2	.020
4SE0375IR100A	–	3/8	3/8	1	2 1/2	–
4CH0375IL112A	–	3/8	3/8	1 1/8	3	.020
4SE0375IL112A	–	3/8	3/8	1 1/8	3	–
4CH0375IX175A	–	3/8	3/8	1 3/4	4	.020
4SE0375IX175A	–	3/8	3/8	1 3/4	4	–
4CH0390IR100A	–	25/64	7/16	1	2 3/4	.020
4SE0390IR100A	–	25/64	7/16	1	2 3/4	–
4CH0406IR100A	–	13/32	7/16	1	2 3/4	.020
4SE0406IR100A	–	13/32	7/16	1	2 3/4	–
4CH0421IR100A	–	27/64	7/16	1	2 3/4	.020
4SE0421IR100A	–	27/64	7/16	1	2 3/4	–
4CH0437IS100A	–	7/16	7/16	1	2 1/2	.020
4SE0437IS100A	–	7/16	7/16	1	2 1/2	–
4CH0437IR100A	–	7/16	7/16	1	2 3/4	.020
4SE0437IR100A	–	7/16	7/16	1	2 3/4	–
4CH0437IL200A	–	7/16	7/16	2	4	.020
4SE0437IL200A	–	7/16	7/16	2	4	–
4CH0437IX300A	–	7/16	7/16	3	6	.020

(continued)

(4SE-4CH..IS-IR-IL-IX • 4 Flute • Inch — continued)



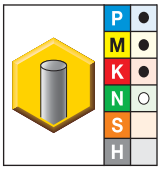


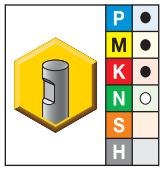
● first choice
○ alternate choice

KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
4SE0437IX300A	–	7/16	7/16	3	6	–
4CH0453IR100A	–	29/64	1/2	1	3	.020
4SE0453IR100A	–	29/64	1/2	1	3	–
4CH0468IR100A	–	15/32	1/2	1	3	.020
4SE0468IR100A	–	15/32	1/2	1	3	–
4CH0484IR100A	–	31/64	1/2	1	3	.020
4SE0484IR100A	–	31/64	1/2	1	3	–
4CH0500IS062A	–	1/2	1/2	5/8	2 1/2	.020
4SE0500IS062A	–	1/2	1/2	5/8	2 1/2	–
4CH0500IR100A	4CH0500IR100B	1/2	1/2	1	3	.020
4SE0500IR100A	4SE0500IR100B	1/2	1/2	1	3	–
4CH0500IL200A	4CH0500IL200B	1/2	1/2	2	4	.020
4SE0500IL200A	4SE0500IL200B	1/2	1/2	2	4	–
4CH0500IX300A	–	1/2	1/2	3	6	.020
4SE0500IX300A	–	1/2	1/2	3	6	–
4CH0562IR075A	–	9/16	9/16	3/4	3	.020
4SE0562IR075A	–	9/16	9/16	3/4	3	–
4CH0562IL125A	4CH0562IL125B	9/16	9/16	1 1/4	3 1/2	.020
4SE0562IL125A	4SE0562IL125B	9/16	9/16	1 1/4	3 1/2	–
4CH0562IX225A	–	9/16	9/16	2 1/4	5	.020
4SE0562IX225A	–	9/16	9/16	2 1/4	5	–
4CH0625IS075A	–	5/8	5/8	3/4	3	.020
4SE0625IS075A	–	5/8	5/8	3/4	3	–
4CH0625IR125A	4CH0625IR125B	5/8	5/8	1 1/4	3 1/2	.020
4SE0625IR125A	4SE0625IR125B	5/8	5/8	1 1/4	3 1/2	–
4CH0625IL225A	4CH0625IL225B	5/8	5/8	2 1/4	5	.020
4SE0625IL225A	4SE0625IL225B	5/8	5/8	2 1/4	5	–
4CH0625IX400A	–	5/8	5/8	4	7	.020
4SE0625IX400A	–	5/8	5/8	4	7	–
4CH0687IR137A	–	11/16	3/4	1 3/8	4	.020
4SE0687IR137A	–	11/16	3/4	1 3/8	4	–
4SE0750IS100A	–	3/4	3/4	1	3	–
4CH0750IR150A	4CH0750IR150B	3/4	3/4	1 1/2	4	.020
4SE0750IR150A	4SE0750IR150B	3/4	3/4	1 1/2	4	–
4CH0750IR225A	4CH0750IR225B	3/4	3/4	2 1/4	5	.020
4SE0750IR225A	4SE0750IR225B	3/4	3/4	2 1/4	5	–
4CH0750IL300A	4CH0750IL300B	3/4	3/4	3	6	.020
4SE0750IL300A	4SE0750IL300B	3/4	3/4	3	6	–
4CH0750IX400A	–	3/4	3/4	4	7	.020
4SE0750IX400A	–	3/4	3/4	4	7	–

(continued)

(4SE-4CH..IS-IR-IL-IX • 4 Flute • Inch — continued)



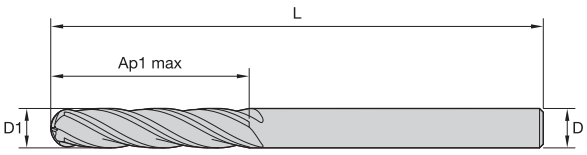


● first choice
○ alternate choice

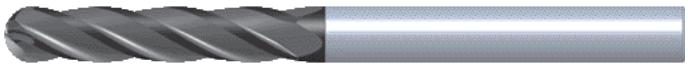
KC633M	KC633M	D1	D	length of cut Ap1 max	length L	BCH
4CH0875IR150A	**4CH0875IR150B**	7/8	7/8	1 1/2	4	.020
4SE0875IR150A	**4SE0875IR150B**	7/8	7/8	1 1/2	4	–
4CH0875IL225A	**4CH0875IL225B**	7/8	7/8	2 1/4	5	.020
4SE0875IL225A	**4SE0875IL225B**	7/8	7/8	2 1/4	5	–
4CH1000IS150A	**–**	1	–	1 1/2	4	.020
4CH1000IR225A	**4CH1000IR225B**	1	–	2 1/4	5	.020
4CH1000IL300A	**4CH1000IL300B**	1	–	3	6	.020
4CH1000IX400A	**–**	1	–	4	7	.020
4SE1000IS150A	**–**	1	1	1 1/2	4	–
4SE1000IR225A	**4SE1000IR225B**	1	1	2 1/4	5	–
4SE1000IL300A	**4SE1000IL300B**	1	1	3	6	–
4SE1000IX400A	**–**	1	1	4	7	–

NOTE: For application data, please see page Q28.

- Center cutting.



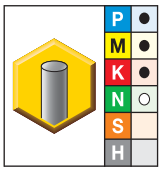




End Mill Tolerances

D1	tolerance	D	tolerance h6
All	+.000/- .002"	≤1/8"	+0/-.00024"
		>1/8–1/4"	+0/-.00031"
		>1/4–3/8"	+0/-.00035"
		>3/8–23/32"	+0/-.00043"
		>23/32–1 3/16"	+0/-.00051"

4BN..IS-IR-IL-IX • 4 Flute • Ball Nose • Inch

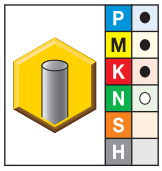


● first choice
○ alternate choice

KC633M	D1	D	length of cut Ap1 max	length L
4BN0031IR008A	1/32	1/8	5/64	1 1/2
4BN0047IR012A	3/64	1/8	1/8	1 1/2
4BN0062IR019A	1/16	1/8	3/16	1 1/2
4BN0078IR019A	5/64	1/8	3/16	1 1/2
4BN0094IR019A	3/32	1/8	3/16	1 1/2
4BN0094IL037A	3/32	1/8	3/8	1 1/2
4BN0109IR037A	7/64	1/8	3/8	1 1/2
4BN0125IS025A	1/8	1/8	1/4	1 1/2
4BN0125IR050A	1/8	1/8	1/2	1 1/2
4BN0125IL075A	1/8	1/8	3/4	2 1/4
4BN0125IX075A	1/8	1/8	3/4	3
4BN0141IR056A	9/64	3/16	9/16	2
4BN0156IR056A	5/32	3/16	9/16	2
4BN0172IR062A	11/64	3/16	5/8	2
4BN0187IR031A	3/16	3/16	5/16	1 1/2
4BN0187IL062A	3/16	3/16	5/8	2
4BN0187IX100A	3/16	3/16	1	4
4BN0203IR062A	13/64	1/4	5/8	2 1/2
4BN0219IR062A	7/32	1/4	5/8	2 1/2
4BN0234IR075A	15/64	1/4	3/4	2 1/2
4BN0250IS050A	1/4	1/4	1/2	2
4BN0250IR075A	1/4	1/4	3/4	2 1/2
4BN0250IR112A	1/4	1/4	1 1/8	3
4BN0250IL150A	1/4	1/4	1 1/2	4
4BN0250IX150A	1/4	1/4	1 1/2	6
4BN0281IR075A	9/32	5/16	3/4	2 1/2
4BN0312IS050A	5/16	5/16	1/2	2
4BN0312IR081A	5/16	5/16	13/16	2 1/2
4BN0312IL112A	5/16	5/16	1 1/8	3
4BN0312IX162A	5/16	5/16	1 5/8	4
4BN0344IR100A	11/32	3/8	1	2 1/2
4BN0375IS100A	3/8	3/8	1	2 1/2

(continued)

(4BN..IS-IR-IL-IX • 4 Flute • Ball Nose • Inch — continued)

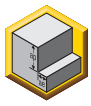


● first choice
○ alternate choice

KC633M	D1	D	length of cut Ap1 max	length L
4BN0375IL112A	3/8	3/8	1 1/8	3
4BN0375IR100A	3/8	3/8	1	4
4BN0375IX150A	3/8	3/8	1 1/2	6
4BN0437IR100A	7/16	1/2	1	2 1/2
4BN0500IS100A	1/2	1/2	1	3
4BN0500IR100A	1/2	1/2	1	4
4BN0500IX150A	1/2	1/2	1 1/2	6
4BN0500IR200A	1/2	1/2	2	4
4BN0500IL200A	1/2	1/2	2	4 1/2
4BN0500IX300A	1/2	1/2	3	6
4BN0562IR125A	9/16	9/16	1 1/4	3 1/2
4BN0625IR125A	5/8	5/8	1 1/4	3 1/2
4BN0625IL225A	5/8	5/8	2 1/4	5
4BN0750IR150A	3/4	3/4	1 1/2	4
4BN0750IL300A	3/4	3/4	3	6
4BN0875IR150A	7/8	7/8	1 1/2	4
4BN1000IR150A	1	1	1 1/2	4
4BN1000IL225A	1	1	2 1/4	5

NOTE: For application data, please see page Q29.

GOmill GP • 4SE/CH..IS-IR • 4 Flute • Short • Regular

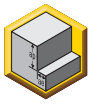




Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC633M Cutting Speed — vc SFM min		max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. D1 — Diameter inch	1/64 .0156	1/32 .0313	1/16 .0625	5/64 .0781	3/32 .0938	1/8 .1250	3/16 .1875	1/4 .2500	5/16 .3125	3/8 .3750	1/2 .5000	5/8 .6250	3/4 .7500	1 1.0000
P	0	Ap1 max	0.1 x D	0.5 x D	490	–	660	IPT	.0001	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	1	Ap1 max	0.1 x D	0.5 x D	490	–	660	IPT	.0001	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	0.5 x D	460	–	620	IPT	.0001	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	3	Ap1 max	0.1 x D	0.5 x D	390	–	520	IPT	.0001	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	Ap1 max	0.1 x D	0.5 x D	300	–	490	IPT	.0001	.0002	.0003	.0004	.0005	.0007	.0010	.0014	.0018	.0020	.0026	.0030	.0034	.0039
M	1	Ap1 max	0.1 x D	0.5 x D	300	–	380	IPT	.0001	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	Ap1 max	0.1 x D	0.5 x D	200	–	260	IPT	.0001	.0002	.0003	.0004	.0004	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	Ap1 max	0.1 x D	0.5 x D	390	–	490	IPT	.0001	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	0.5 x D	360	–	460	IPT	.0001	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	Ap1 max	0.1 x D	0.5 x D	300	–	380	IPT	.0002	.0003	.0006	.0008	.0009	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	Ap1 max	0.1 x D	0.5 x D	200	–	260	IPT	.0001	.0003	.0005	.0006	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	Ap1 max	0.1 x D	0.5 x D	390	–	490	IPT	.0001	.0003	.0006	.0007	.0008	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090

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 centers, please adjust parameters accordingly on >1/2" diameter.

GOmill GP • 4SE/CH..IL-IX • 4 Flute • Long • Extra Long




Material Group		Side Milling (A) A ap	A ae	KC633M Cutting Speed — vc SFM min		max	Recommended feed per tooth (IPT = inch/th) for side milling (A). D1 — Diameter inch	3/32 .0938	1/8 .1250	3/16 .1875	1/4 .2500	5/16 .3125	3/8 .3750	1/2 .5000	5/8 .6250	3/4 .7500	1 1.0000
P	0	Ap1 max	0.1 x D	490	–	660	IPT	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	1	Ap1 max	0.1 x D	490	–	660	IPT	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	460	–	620	IPT	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	3	Ap1 max	0.1 x D	390	–	520	IPT	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	Ap1 max	0.1 x D	300	–	490	IPT	.0005	.0007	.0010	.0014	.0018	.0020	.0026	.0030	.0034	.0039
M	1	Ap1 max	0.1 x D	300	–	380	IPT	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	Ap1 max	0.1 x D	200	–	260	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	Ap1 max	0.1 x D	390	–	490	IPT	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	360	–	460	IPT	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	Ap1 max	0.1 x D	820	–	3250	IPT	.0009	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	Ap1 max	0.1 x D	820	–	2450	IPT	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	Ap1 max	0.1 x D	820	–	2450	IPT	.0008	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090

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 centers, please adjust parameters accordingly on >1/2" diameter.

GOmill GP • 4BN..IS-IR • 4 Flute • Ball Nose • Short • Regular



Material Group		Side Milling (A) and Slotting (B) A ap	A ae	B ap	KC633M Cutting Speed — vc SFM min		max	Recommended feed per tooth (IPT = inch/th) for side milling (A). For slotting (B), reduce IPT by 20%. D1 — Diameter inch	1/32 .0313	1/16 .0625	5/64 .0781	3/32 .0938	1/8 .1250	3/16 .1875	1/4 .2500	5/16 .3125	3/8 .3750	1/2 .5000	5/8 .6250	3/4 .7500	1 1.0000
P	0	Ap1 max	0.1 x D	0.5 x D	490	–	660	IPT	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	1	Ap1 max	0.1 x D	0.5 x D	490	–	660	IPT	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	0.5 x D	460	–	620	IPT	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	3	Ap1 max	0.1 x D	0.5 x D	390	–	520	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	Ap1 max	0.1 x D	0.5 x D	300	–	490	IPT	.0002	.0003	.0004	.0005	.0007	.0010	.0014	.0018	.0020	.0026	.0030	.0034	.0039
M	1	Ap1 max	0.1 x D	0.5 x D	300	–	380	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	Ap1 max	0.1 x D	0.5 x D	200	–	260	IPT	.0002	.0003	.0004	.0004	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	Ap1 max	0.1 x D	0.5 x D	390	–	490	IPT	.0002	.0004	.0005	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	0.5 x D	360	–	460	IPT	.0002	.0004	.0004	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	Ap1 max	0.1 x D	0.5 x D	820	–	3250	IPT	.0003	.0006	.0008	.0009	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	Ap1 max	0.1 x D	0.5 x D	820	–	2450	IPT	.0003	.0005	.0006	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	Ap1 max	0.1 x D	0.5 x D	820	–	2450	IPT	.0003	.0006	.0007	.0008	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090

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 centers, please adjust parameters accordingly on >1/2" diameter.

GOmill GP • 4BN..IL-IX • 4 Flute • Ball Nose • Long • Extra Long

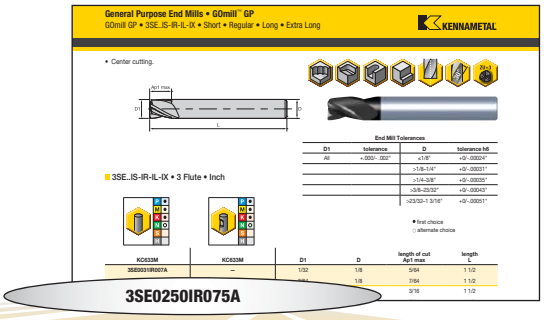


Material Group		Side Milling (A) A ap	A ae	KC633M Cutting Speed — vc SFM min		max	Recommended feed per tooth (IPT = inch/th) for side milling (A). D1 — Diameter inch	3/32 .0938	1/8 .1250	3/16 .1875	1/4 .2500	5/16 .3125	3/8 .3750	1/2 .5000	5/8 .6250	3/4 .7500	1 1.0000
P	0	Ap1 max	0.1 x D	490	–	660	IPT	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	1	Ap1 max	0.1 x D	490	–	660	IPT	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	460	–	620	IPT	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	3	Ap1 max	0.1 x D	390	–	520	IPT	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	4	Ap1 max	0.1 x D	300	–	490	IPT	.0005	.0007	.0010	.0014	.0018	.0020	.0026	.0030	.0034	.0039
M	1	Ap1 max	0.1 x D	300	–	380	IPT	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
	2	Ap1 max	0.1 x D	200	–	260	IPT	.0004	.0006	.0009	.0012	.0016	.0018	.0023	.0027	.0031	.0036
K	1	Ap1 max	0.1 x D	390	–	490	IPT	.0007	.0009	.0014	.0018	.0023	.0027	.0034	.0040	.0044	.0049
	2	Ap1 max	0.1 x D	360	–	460	IPT	.0005	.0007	.0011	.0015	.0020	.0023	.0029	.0034	.0039	.0045
N	1	Ap1 max	0.1 x D	820	–	3250	IPT	.0009	.0013	.0019	.0025	.0031	.0038	.0050	.0063	.0075	.0100
	2	Ap1 max	0.1 x D	820	–	2450	IPT	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050	.0060	.0080
	4	Ap1 max	0.1 x D	820	–	2450	IPT	.0008	.0011	.0017	.0023	.0028	.0034	.0045	.0056	.0068	.0090

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 centers, please adjust parameters accordingly on >1/2" diameter.

How Do Catalog Numbers Work?

Each character in our catalog number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



3	SE	0250	IR	075	A
Number of Flutes	End Mill Shape	Cutting Diameter inch	Standard	Ap1 max inch	Shank Style
2 = 2 Flute **3** = 3 Flute **4** = 4 Flute	**CH** = Chamfer Edge **BN** = Ball Nose **SE** = Sharp Edge		**IS** = Factory Standard Short **IR** = Factory Standard Regular **IL** = Factory Standard Long **IX** = Factory Standard Extra Long		**A** = Plain Shank **B** = Weldon® Shank

Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
1115547	HEC328S4	KC610M	6086587	4SE0328IR100A	KC633M
1115548	HEC875S4	KC610M	6086520	4SE0875IR150A	KC633M
1115565	BNEC031S2	KC610M	5876721	2BN0031IR007A	KC633M
1115567	BNEC875S2	KC610M	5876774	2BN0875IR150A	KC633M
1115568	BNEC250S2113	KC610M	5876750	2BN0250IR112A	KC633M
1115569	BNEC312S2113	KC610M	5876754	2BN0312IL112A	KC633M
1115570	BNEC375S2113	KC610M	5876758	2BN0375IL112A	KC633M
1115582	BNEC016S4	KC610M	no replacement	no replacement	no replacement
1115583	BNEC047S4	KC610M	5824030	4BN0047IR012A	KC633M
1115584	BNEC172S4	KC610M	5824512	4BN0172IR062A	KC633M
1115587	BNEC375S4113	KC610M	5824532	4BN0375IL112A	KC633M
1115588	BNEC125S4300	KC610M	no replacement	no replacement	no replacement
1115589	HEC062S2013	KC610M	6086330	2SE0062IR012A	KC633M
1115591	HEC250S2050	KC610M	6086399	2SE0250IS050A	KC633M
1115592	HEC312S2050	KC610M	6086404	2SE0312IS050A	KC633M
1115593	HEC375S2063	KC610M	6086409	2SE0375IS062A	KC633M
1115594	HEC438S2063	KC610M	6086414	2SE0437IR062A	KC633M
1115595	HEC500S2063	KC610M	6086418	2SE0500IS062A	KC633M
1115596	HEC750S2100	KC610M	6086449	2SE0750IS100A	KC633M
1115597	HEC062S4013	KC610M	no replacement	no replacement	no replacement
1115597	HEC062S4013	KC610M	5824318	4CH0062IR011A	KC633M
1115598	HEC125S4025	KC610M	6086561	4SE0125IS025A	KC633M
1115599	HEC156S4031	KC610M	6086567	4SE0156IR056A	KC633M
1115599	HEC156S4031	KC610M	no replacement	no replacement	no replacement
1115601	HEC250S4050	KC610M	6086576	4SE0250IS050A	KC633M
1115602	HEC500S4063	KC610M	6086333	4SE0500IS062A	KC633M
1115603	HEC750S4100	KC610M	6086515	4SE0750IS100A	KC633M
1115616	HEC2MS2	KC610M	5873010	2CH0200MR006A	KC633M
1115617	HEC3MS2	KC610M	no replacement	no replacement	no replacement
1115618	HEC4MS2	KC610M	no replacement	no replacement	no replacement
1115619	HEC5MS2	KC610M	no replacement	no replacement	no replacement
1115620	HEC6MS2	KC610M	no replacement	no replacement	no replacement
1115621	HEC7MS2	KC610M	5873028	2CH0700MR020A	KC633M
1115622	HEC8MS2	KC610M	5873029	2CH0800MR020A	KC633M
1115624	HEC10MS2	KC610M	no replacement	no replacement	no replacement
1115624	HEC10MS2	KC610M	no replacement	no replacement	no replacement
1115626	HEC12MS2	KC610M	no replacement	no replacement	no replacement
1115632	HEC25MS2	KC610M	no replacement	no replacement	no replacement
1115633	HEC35MS2	KC610M	5873015	2CH0350MR012A	KC633M
1115635	HEC45MS2	KC610M	no replacement	no replacement	no replacement
1115638	HEC100S2	KC610M	6086456	2SE1000IS150A	KC633M
1115640	HEC125S2	KC610M	6086388	2SE0125IL050A	KC633M
1115642	HEC156S2	KC610M	6086392	2SE0156IL056A	KC633M
1115644	HEC188S2	KC610M	6086394	2SE0187IR062A	KC633M
1115645	HEC219S2	KC610M	6086398	2SE0218IL062A	KC633M
1115646	HEC062S2	KC610M	6086329	2SE0062IL018A	KC633M
1115647	HEC250S2	KC610M	6086400	2SE0250IR075A	KC633M
1115649	HEC281S2	KC610M	6086403	2SE0281IR075A	KC633M
1115651	HEC016S2	KC610M	6086327	2SE0016IR003A	KC633M
1115652	HEC312S2	KC610M	6086405	2SE0312IR081A	KC633M
1115653	HEC047S2	KC610M	no replacement	no replacement	no replacement
1115653	HEC047S2	KC610M	no replacement	no replacement	no replacement
1115654	HEC266S2	KC610M	no replacement	no replacement	no replacement
1115655	HEC375S2	KC610M	6086410	2SE0375IR100A	KC633M
1115656	HEC328S2	KC610M	no replacement	no replacement	no replacement
1115657	HEC344S2	KC610M	6086408	2SE0343IR100A	KC633M
1115658	HEC438S2	KC610M	6086415	2SE0437IL100A	KC633M
1115661	HEC500S2	KC610M	6086419	2SE0500IR100A	KC633M
1115662	HEC469S2	KC610M	6086417	2SE0468IR100A	KC633M
1115665	HEC625S2	KC610M	6086446	2SE0625IL125A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
1115666	HEC688S2	KC610M	6086448	2SE0687IR137A	KC633M
1115667	HEC750S2	KC610M	6086450	2SE0750IR150A	KC633M
1115668	HEC094S2	KC610M	6086384	2SE0093IL037A	KC633M
1115669	HEC203S3	KC610M	no replacement	no replacement	no replacement
1115672	HEC016S4	KC610M	6086553	4SE0015IR003A	KC633M
1115673	HEC031S4	KC610M	5824317	4CH0031IR008A	KC633M
1115673	HEC031S4	KC610M	5824317	4CH0031IR008A	KC633M
1115674	HEC344S4	KC610M	6086588	4SE0343IR100A	KC633M
1115675	HEC360S4	KC610M	6086589	4SE0359IR100A	KC633M
1115678	HEC484S4	KC610M	6086603	4SE0484IR100A	KC633M
1115679	HEC125S2100	KC610M	no replacement	no replacement	no replacement
1115680	HEC125S2075	KC610M	6086389	2SE0125IX075A	KC633M
1115681	HEC125S4075	KC610M	6086563	4SE0125IL075A	KC633M
1115689	HEC100S3	KC610M	6143979	3SE1000IR150A	KC633M
1115691	HEC125S3	KC610M	6143910	3SE0125IL050A	KC633M
1115693	HEC156S3	KC610M	6143943	3SE0156IR056A	KC633M
1115694	HEC188S3	KC610M	6143945	3SE0188IR056A	KC633M
1115695	HEC219S3	KC610M	6143949	3SE0219IR062A	KC633M
1115696	HEC062S3	KC610M	6143905	3SE0062IR019A	KC633M
1115697	HEC250S3	KC610M	6143952	3SE0250IR075A	KC633M
1115698	HEC281S3	KC610M	6143955	3SE0281IR075A	KC633M
1115699	HEC312S3	KC610M	6143958	3SE0312IL081A	KC633M
1115701	HEC375S3	KC610M	6143964	3SE0375IL100A	KC633M
1115702	HEC438S3	KC610M	6143969	3SE0437IX100A	KC633M
1115705	HEC500S3	KC610M	6143970	3SE0500IR100A	KC633M
1115707	HEC625S3	KC610M	6143975	3SE0625IL125A	KC633M
1115710	HEC750S3	KC610M	6143977	3SE0750IL150A	KC633M
1115711	HEC094S3	KC610M	6143907	3SE0094IR037A	KC633M
1115714	HEC2MS4	KC610M	5824218	4CH0200MR006A	KC633M
1115715	HEC3MS4	KC610M	no replacement	no replacement	no replacement
1115716	HEC4MS4	KC610M	no replacement	no replacement	no replacement
1115717	HEC5MS4	KC610M	no replacement	no replacement	no replacement
1115718	HEC6MS4	KC610M	no replacement	no replacement	no replacement
1115719	HEC7MS4	KC610M	no replacement	no replacement	no replacement
1115720	HEC8MS4	KC610M	5824229	4CH0800MR020A	KC633M
1115721	HEC9MS4	KC610M	no replacement	no replacement	no replacement
1115722	HEC10MS4	KC610M	5824232	4CH1000MR022A	KC633M
1115723	HEC11MS4	KC610M	no replacement	no replacement	no replacement
1115724	HEC12MS4	KC610M	5824189	4CH1200DL026A	KC633M
1115725	HEC14MS4	KC610M	5824238	4CH1400MR032A	KC633M
1115726	HEC16MS4	KC610M	5824241	4CH1600MR032A	KC633M
1115727	HEC18MS4	KC610M	5824244	4CH1800MR038A	KC633M
1115728	HEC20MS4	KC610M	5824247	4CH2000MR038A	KC633M
1115729	HEC25MMS4	KC610M	no replacement	no replacement	no replacement
1115730	HEC25MS4	KC610M	no replacement	no replacement	no replacement
1115731	HEC35MS4	KC610M	no replacement	no replacement	no replacement
1115732	HEC45MS4	KC610M	no replacement	no replacement	no replacement
1115733	HEC100S4	KC610M	6086522	4SE1000IS150A	KC633M
1115734	HEC125S4	KC610M	6086562	4SE0125IR050A	KC633M
1115735	HEC156S4	KC610M	6086567	4SE0156IR056A	KC633M
1115736	HEC188S4	KC610M	6086568	4SE0187IR062A	KC633M
1115737	HEC219S4	KC610M	6086574	4SE0218IL062A	KC633M
1115738	HEC062S4	KC610M	5824318	4CH0062IR011A	KC633M
1115738	HEC062S4	KC610M	no replacement	no replacement	no replacement
1115739	HEC250S4	KC610M	6086577	4SE0250IR075A	KC633M
1115740	HEC281S4	KC610M	6086581	4SE0281IR075A	KC633M
1115741	HEC312S4	KC610M	6086584	4SE0312IR081A	KC633M
1115741	HEC312S4	KC610M	no replacement	no replacement	no replacement
1115742	HEC375S4	KC610M	6086591	4SE0375IR100A	KC633M
1115743	HEC438S4	KC610M	6086597	4SE0437IS100A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
1115744	HEC500S4	KC610M	6086334	4SE0500IR100A	KC633M
1115746	HEC625S4	KC610M	6086511	4SE0625IR125A	KC633M
1115747	HEC688S4	KC610M	6086514	4SE0687IR137A	KC633M
1115748	HEC750S4	KC610M	6086516	4SE0750IR150A	KC633M
1115749	HEC094S4	KC610M	6086558	4SE0093IR037A	KC633M
1115751	HEC047S4	KC610M	no replacement	no replacement	no replacement
1115751	HEC047S4	KC610M	no replacement	no replacement	no replacement
1115785	BNEC2MS2	KC610M	5874192	2BN0200MR006A	KC633M
1115786	BNEC3MS2	KC610M	no replacement	no replacement	no replacement
1115787	BNEC4MS2	KC610M	no replacement	no replacement	no replacement
1115788	BNEC5MS2	KC610M	no replacement	no replacement	no replacement
1115789	BNEC6MS2	KC610M	no replacement	no replacement	no replacement
1115791	BNEC8MS2	KC610M	no replacement	no replacement	no replacement
1115793	BNEC10MS2	KC610M	no replacement	no replacement	no replacement
1115804	BNEC100S2	KC610M	5876775	2BN1000IR150A	KC633M
1115805	BNEC125S2	KC610M	5876728	2BN0125IR050A	KC633M
1115806	BNEC156S2	KC610M	5876742	2BN0156IL056A	KC633M
1115807	BNEC188S2	KC610M	5876744	2BN0187IR062A	KC633M
1115808	BNEC219S2	KC610M	5876747	2BN0219IR062A	KC633M
1115809	BNEC062S2	KC610M	5876722	2BN0063IR018A	KC633M
1115810	BNEC250S2	KC610M	5876749	2BN0250IR075A	KC633M
1115812	BNEC312S2	KC610M	5876753	2BN0312IR081A	KC633M
1115815	BNEC500S2	KC610M	5876763	2BN0500IR100A	KC633M
1115816	BNEC562S2	KC610M	no replacement	no replacement	no replacement
1115817	BNEC625S2	KC610M	5876767	2BN0625IR125A	KC633M
1115819	BNEC750S2	KC610M	5876771	2BN0750IR150A	KC633M
1115820	BNEC094S2	KC610M	5876725	2BN0094IL037A	KC633M
1115821	BNEC2MS4	KC610M	no replacement	no replacement	no replacement
1115822	BNEC3MS4	KC610M	no replacement	no replacement	no replacement
1115823	BNEC5MS4	KC610M	no replacement	no replacement	no replacement
1115824	BNEC6MS4	KC610M	no replacement	no replacement	no replacement
1115825	BNEC7MS4	KC610M	no replacement	no replacement	no replacement
1115826	BNEC8MS4	KC610M	5824924	4BN0800DL019A	KC633M
1115828	BNEC10MS4	KC610M	5824925	4BN1000DL022A	KC633M
1115830	BNEC12MS4	KC610M	5824926	4BN1200DL026A	KC633M
1115836	BNEC25MS4	KC610M	no replacement	no replacement	no replacement
1115837	BNEC35MS4	KC610M	no replacement	no replacement	no replacement
1115838	BNEC45MS4	KC610M	no replacement	no replacement	no replacement
1115839	BNEC100S4	KC610M	5824557	4BN1000IR150A	KC633M
1115840	BNEC125S4	KC610M	5824507	4BN0125IR050A	KC633M
1115841	BNEC156S4	KC610M	5824511	4BN0156IR056A	KC633M
1115842	BNEC188S4	KC610M	5824514	4BN0187IL062A	KC633M
1115843	BNEC219S4	KC610M	5824517	4BN0219IR062A	KC633M
1115844	BNEC062S4	KC610M	5824501	4BN0062IR019A	KC633M
1115845	BNEC250S4	KC610M	5824520	4BN0250IR075A	KC633M
1115846	BNEC281S4	KC610M	5824524	4BN0281IR075A	KC633M
1115847	BNEC312S4	KC610M	5824526	4BN0312IR081A	KC633M
1115848	BNEC375S4	KC610M	5824530	4BN0375IS100A	KC633M
1115850	BNEC500S4	KC610M	5824535	4BN0500IS100A	KC633M
1115851	BNEC562S4	KC610M	5824551	4BN0562IR125A	KC633M
1115852	BNEC625S4	KC610M	5824552	4BN0625IR125A	KC633M
1115854	BNEC750S4	KC610M	5824554	4BN0750IR150A	KC633M
1115855	BNEC094S4	KC610M	5824504	4BN0094IL037A	KC633M
1115865	BNEC078S4	KC610M	5824502	4BN0078IR019A	KC633M
1115866	BNEC109S4	KC610M	5824505	4BN0109IR037A	KC633M
1115867	HEC078S2	KC610M	6086382	2SE0078IR018A	KC633M
1115868	HEC109S2	KC610M	no replacement	no replacement	no replacement
1115869	HEC109S4	KC610M	6086560	4SE0109IR037A	KC633M
1115870	HEC141S2	KC610M	6086390	2SE0140IR056A	KC633M
1115871	HEC172S2	KC610M	6086393	2SE0171IR062A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
1115872	HEC172S4	KC610M	no replacement	no replacement	no replacement
1115872	HEC172S4	KC610M	no replacement	no replacement	no replacement
1115872	HEC172S4	KC610M	no replacement	no replacement	no replacement
1115873	HEC203S2	KC610M	no replacement	no replacement	no replacement
1115874	HEC203S4	KC610M	6086572	4SE0203IR062A	KC633M
1115875	HEC234S2	KC610M	no replacement	no replacement	no replacement
1115876	HEC234S4	KC610M	6086575	4SE0234IR075A	KC633M
1115877	HEC297S4	KC610M	6086582	4SE0296IR081A	KC633M
1115878	HEC297S2	KC610M	no replacement	no replacement	no replacement
1115890	HEC031S2	KC610M	6086328	2SE0031IR007A	KC633M
1115894	BNEC031S4	KC610M	5824029	4BN0031IR008A	KC633M
1115895	HEC078S4	KC610M	6086556	4SE0078IR018A	KC633M
1115896	HEC266S4	KC610M	6086580	4SE0265IR075A	KC633M
1115896	HEC266S4	KC610M	6086580	4SE0265IR075A	KC633M
1115900	HEC6MS275M	KC610M	5873026	2CH0600ML028A	KC633M
1115901	HEC8MS275M	KC610M	5873031	2CH0800ML028A	KC633M
1115902	HEC10MS2100M	KC610M	no replacement	no replacement	no replacement
1115902	HEC10MS2100M	KC610M	no replacement	no replacement	no replacement
1115910	HEC6MS475M	KC610M	5824227	4CH0600ML028A	KC633M
1115911	HEC8MS475M	KC610M	5824230	4CH0800ML028A	KC633M
1115912	HEC141S4	KC610M	6086565	4SE0140IR056A	KC633M
1115913	HEC375S4063	KC610M	6086590	4SE0375IS062A	KC633M
1115914	HEC10MS4100M	KC610M	5824234	4CH1000MX045A	KC633M
1115915	HEC12MS4100M	KC610M	no replacement	no replacement	no replacement
1115919	HEC16MS4150M	KC610M	5824243	4CH1600MX075A	KC633M
1115921	HEC20MS4150M	KC610M	no replacement	no replacement	no replacement
1115923	BNEC6MS275M	KC610M	no replacement	no replacement	no replacement
1115934	BNEC6MS475M	KC610M	5824954	4BN0600MR030A	KC633M
1115935	BNEC8MS475M	KC610M	no replacement	no replacement	no replacement
1115936	BNEC10MS4100M	KC610M	5824956	4BN1000MR040A	KC633M
1115944	HEC469S4	KC610M	6086602	4SE0468IR100A	KC633M
1115945	HEC188S2075	KC610M	6086395	2SE0187IL075A	KC633M
1115946	HEC188S2113	KC610M	6086396	2SE0187IX112A	KC633M
1115947	HEC250S2113	KC610M	6086401	2SE0250IL112A	KC633M
1115948	HEC312S2113	KC610M	6086406	2SE0312IL112A	KC633M
1115949	HEC375S2113	KC610M	6086411	2SE0375IL112A	KC633M
1115952	HEC100S2225	KC610M	6086457	2SE1000IR225A	KC633M
1115953	HEC625S2225	KC610M	6086447	2SE0625IX225A	KC633M
1115954	HEC750S2225	KC610M	6086451	2SE0750IR225A	KC633M
1115955	HEC100S2300	KC610M	6086458	2SE1000IL300A	KC633M
1115957	HEC500S2300	KC610M	6086441	2SE0500IX300A	KC633M
1115959	HEC750S2300	KC610M	6086452	2SE0750IL300A	KC633M
1115960	HEC250S2150	KC610M	6086402	2SE0250IX150A	KC633M
1115961	HEC312S2163	KC610M	6086407	2SE0312IX162A	KC633M
1115962	HEC375S2175	KC610M	6086412	2SE0375IX175A	KC633M
1115963	HEC188S4075	KC610M	6086570	4SE0187IL075A	KC633M
1115964	BNEC500S4450	KC610M	5824539	4BN0500IL200A	KC633M
1115965	HEC188S4113	KC610M	6086571	4SE0187IX112A	KC633M
1115966	HEC250S4113	KC610M	6086578	4SE0250IL112A	KC633M
1115967	HEC312S4113	KC610M	6086585	4SE0312IL112A	KC633M
1115968	HEC375S4113	KC610M	6086592	4SE0375IL112A	KC633M
1115970	HEC500S4450	KC610M	no replacement	no replacement	no replacement
1115971	HEC100S4225	KC610M	6086523	4SE1000IR225A	KC633M
1115972	HEC625S4225	KC610M	6086512	4SE0625IL225A	KC633M
1115973	HEC750S4225	KC610M	6086517	4SE0750IR225A	KC633M
1115974	HEC100S4300	KC610M	6086524	4SE1000IL300A	KC633M
1115975	HEC438S4600	KC610M	6086600	4SE0437IX300A	KC633M
1115976	HEC500S4300	KC610M	6086336	4SE0500IX300A	KC633M
1115979	HEC750S4300	KC610M	6086518	4SE0750IL300A	KC633M
1115980	HEC250S4150	KC610M	6086579	4SE0250IX150A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
1115981	HEC312S4163	KC610M	6086586	4SE0312IX162A	KC633M
1115982	HEC375S4175	KC610M	6086593	4SE0375IX175A	KC633M
1115983	BNEC188S2300	KC610M	no replacement	no replacement	no replacement
1115984	BNEC250S2150	KC610M	5876751	2BN0250IL150A	KC633M
1115986	BNEC375S2175	KC610M	no replacement	no replacement	no replacement
1115987	BNEC100S2300	KC610M	5876776	2BN1000IL300A	KC633M
1115989	BNEC500S2300	KC610M	5876766	2BN0500IX300A	KC633M
1115990	BNEC625S2300	KC610M	5876769	2BN0625IX300A	KC633M
1115991	BNEC750S2600	KC610M	5876773	2BN0750IX300A	KC633M
1115992	BNEC188S4300	KC610M	no replacement	no replacement	no replacement
1115993	BNEC250S4150	KC610M	5824522	4BN0250IL150A	KC633M
1115994	BNEC312S4400	KC610M	5824528	4BN0312IX162A	KC633M
1115995	BNEC375S4175	KC610M	no replacement	no replacement	no replacement
1115996	HEC625S4075	KC610M	6086340	4SE0625IS075A	KC633M
1115997	BNEC100S4300	KC610M	no replacement	no replacement	no replacement
1115999	BNEC500S4300	KC610M	5824540	4BN0500IX300A	KC633M
1116000	BNEC625S4300	KC610M	no replacement	no replacement	no replacement
1116001	BNEC750S4600	KC610M	5824555	4BN0750IL300A	KC633M
1116031	HEC125S4100	KC610M	6086564	4SE0125IX100A	KC633M
1191644	BNEC062S2	K600	5876722	2BN0063IR018A	KC633M
1191659	BNEC250S2	K600	5876749	2BN0250IR075A	KC633M
1191660	BNEC250S4	K600	5824520	4BN0250IR075A	KC633M
1191669	BNEC4MS4	KC610M	5824952	4BN0400MR025A	KC633M
1191670	BNEC500S2	K600	5876763	2BN0500IR100A	KC633M
1191672	BNEC500S4	K600	5824535	4BN0500IS100A	KC633M
1191679	BNEC750S4	K600	5824554	4BN0750IR150A	KC633M
1192162	HEC100S2	K600	6086456	2SE1000IS150A	KC633M
1192163	HEC10MS2100M	K600	no replacement	no replacement	no replacement
1192163	HEC10MS2100M	K600	no replacement	no replacement	no replacement
1192164	HEC10MS2	K600	no replacement	no replacement	no replacement
1192164	HEC10MS2	K600	no replacement	no replacement	no replacement
1192165	HEC10MS4100M	K600	5824234	4CH1000MX045A	KC633M
1192166	HEC10MS4	K600	5824232	4CH1000MR022A	KC633M
1192168	HEC12MS2	K600	no replacement	no replacement	no replacement
1192169	HEC12MS4100M	K600	no replacement	no replacement	no replacement
1192171	HEC12MS4	K600	5824189	4CH1200DL026A	KC633M
1192174	HEC14MS4	K600	5824238	4CH1400MR032A	KC633M
1192177	HEC16MS4150M	K600	5824243	4CH1600MX075A	KC633M
1192178	HEC16MS4	K600	5824241	4CH1600MR032A	KC633M
1192179	HEC188S4	K600	6086568	4SE0187IR062A	KC633M
1192181	HEC18MS4	K600	5824244	4CH1800MR038A	KC633M
1192183	HEC20MS2	K600	5873050	2CH2000MR038A	KC633M
1192185	HEC20MS4	K600	5824247	4CH2000MR038A	KC633M
1192186	HEC250S2	K600	6086400	2SE0250IR075A	KC633M
1192187	HEC250S4	K600	6086577	4SE0250IR075A	KC633M
1192189	HEC25MMS4	K600	no replacement	no replacement	no replacement
1192192	HEC2MS2	K600	5873010	2CH0200MR006A	KC633M
1192194	HEC312S4	K600	no replacement	no replacement	no replacement
1192194	HEC312S4	K600	6086584	4SE0312IR081A	KC633M
1192196	HEC375S2	K600	6086410	2SE0375IR100A	KC633M
1192197	HEC375S4	K600	6086591	4SE0375IR100A	KC633M
1192198	HEC3MS2	K600	no replacement	no replacement	no replacement
1192199	HEC3MS4	K600	no replacement	no replacement	no replacement
1192200	HEC438S4	K600	6086597	4SE0437IS100A	KC633M
1192201	HEC4MS2	K600	no replacement	no replacement	no replacement
1192202	HEC4MS4	K600	no replacement	no replacement	no replacement
1192203	HEC500S2	K600	6086419	2SE0500IR100A	KC633M
1192204	HEC500S4	K600	6086334	4SE0500IR100A	KC633M
1192206	HEC5MS2	K600	no replacement	no replacement	no replacement
1192207	HEC5MS4	K600	no replacement	no replacement	no replacement

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
1192208	HEC625S3	K600	6143975	3SE0625IL125A	KC633M
1192209	HEC6MS275M	K600	5873026	2CH0600ML028A	KC633M
1192210	HEC6MS2	K600	no replacement	no replacement	no replacement
1192211	HEC6MS475M	K600	no replacement	no replacement	no replacement
1192212	HEC6MS4	K600	no replacement	no replacement	no replacement
1192213	HEC750S4	K600	6086516	4SE0750IR150A	KC633M
1192215	HEC8MS275M	K600	5873031	2CH0800ML028A	KC633M
1192216	HEC8MS2	K600	5873029	2CH0800MR020A	KC633M
1192218	HEC8MS4	K600	5824229	4CH0800MR020A	KC633M
1228656	HEC094S2	K600	6086384	2SE0093IL037A	KC633M
1232322	BNEC562S4	K600	5824551	4BN0562IR125A	KC633M
1232451	HEC438S3	K600	6143969	3SE0437IX100A	KC633M
1232452	HEC188S2	K600	6086394	2SE0187IR062A	KC633M
1232453	HEC500S3	K600	6143970	3SE0500IR100A	KC633M
1257524	BNEC016S2	KC610M	no replacement	no replacement	no replacement
1257525	BNEC016S2	K600	no replacement	no replacement	no replacement
1257527	BNEC031S2	K600	5876721	2BN0031IR007A	KC633M
1257530	BNEC031S4	K600	5824029	4BN0031IR008A	KC633M
1257531	BNEC047S2	KC610M	5876723	2BN0047IR018A	KC633M
1257532	BNEC047S2	K600	5876723	2BN0047IR018A	KC633M
1257534	BNEC047S4	K600	5824030	4BN0047IR012A	KC633M
1257537	BNEC062S4	K600	5824501	4BN0062IR019A	KC633M
1257539	BNEC078S2	KC610M	no replacement	no replacement	no replacement
1257540	BNEC078S2	K600	no replacement	no replacement	no replacement
1257541	BNEC078S4O	K600	5824502	4BN0078IR019A	KC633M
1257542	BNEC094S2	K600	5876725	2BN0094IL037A	KC633M
1257544	BNEC094S4	K600	5824504	4BN0094IL037A	KC633M
1257548	BNEC100S2	KC635M	5876775	2BN1000IR150A	KC633M
1257549	BNEC100S2	K600	5876775	2BN1000IR150A	KC633M
1257551	BNEC100S2300	K600	5876776	2BN1000IL300A	KC633M
1257553	BNEC100S4	KC635M	5824557	4BN1000IR150A	KC633M
1257554	BNEC100S4	K600	5824557	4BN1000IR150A	KC633M
1257557	BNEC100S4300	K600	no replacement	no replacement	no replacement
1257558	BNEC109S2	KC610M	5876726	2BN0109IR037A	KC633M
1257559	BNEC109S2	K600	5876726	2BN0109IR037A	KC633M
1257560	BNEC109S4O	K600	5824505	4BN0109IR037A	KC633M
1257568	BNEC125S2	KC635M	5876728	2BN0125IR050A	KC633M
1257569	BNEC125S2	K600	5876728	2BN0125IR050A	KC633M
1257571	BNEC125S2075	KC610M	5876729	2BN0125IL075A	KC633M
1257575	BNEC125S4	KC635M	5824507	4BN0125IR050A	KC633M
1257576	BNEC125S4	K600	5824507	4BN0125IR050A	KC633M
1257577	BNEC125S4075	KC610M	5824508	4BN0125IL075A	KC633M
1257578	BNEC125S4075	K600	5824508	4BN0125IL075A	KC633M
1257579	BNEC125S4300	K600	no replacement	no replacement	no replacement
1257584	BNEC141S4	KC610M	5824510	4BN0141IR056A	KC633M
1257585	BNEC156S2	K600	5876742	2BN0156IL056A	KC633M
1257587	BNEC156S4	K600	5824511	4BN0156IR056A	KC633M
1257594	BNEC172S4O	K600	5824512	4BN0172IR062A	KC633M
1257598	BNEC188S2	KC635M	5876744	2BN0187IR062A	KC633M
1257599	BNEC188S2	K600	5876744	2BN0187IR062A	KC633M
1257600	BNEC188S2075	KC610M	5876745	2BN0187IL075A	KC633M
1257601	BNEC188S2075	K600	5876745	2BN0187IL075A	KC633M
1257602	BNEC188S2300	K600	no replacement	no replacement	no replacement
1257605	BNEC188S4	KC635M	5824514	4BN0187IL062A	KC633M
1257606	BNEC188S4	K600	5824514	4BN0187IL062A	KC633M
1257607	BNEC188S4075	KC610M	no replacement	no replacement	no replacement
1257608	BNEC188S4075	K600	no replacement	no replacement	no replacement
1257609	BNEC188S4300	K600	no replacement	no replacement	no replacement
1257619	BNEC203S4	KC610M	5824516	4BN0203IR062A	KC633M
1257620	BNEC203S4	K600	5824516	4BN0203IR062A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
1257621	BNEC219S2	K600	5876747	2BN0219IR062A	KC633M
1257624	BNEC219S4O	K600	5824517	4BN0219IR062A	KC633M
1257626	BNEC234S4	KC610M	5824518	4BN0234IR075A	KC633M
1257629	BNEC250S2	KC635M	5876749	2BN0250IR075A	KC633M
1257631	BNEC250S2113	K600	5876750	2BN0250IR112A	KC633M
1257632	BNEC250S2150	K600	5876751	2BN0250IL150A	KC633M
1257634	BNEC250S4	KC635M	5824520	4BN0250IR075A	KC633M
1257636	BNEC250S4113	KC610M	5824521	4BN0250IR112A	KC633M
1257637	BNEC250S4113	K600	5824521	4BN0250IR112A	KC633M
1257638	BNEC250S4150	K600	5824522	4BN0250IL150A	KC633M
1257641	BNEC266S4	KC610M	no replacement	no replacement	no replacement
1257642	BNEC266S4	K600	no replacement	no replacement	no replacement
1257647	BNEC281S4	K600	5824524	4BN0281IR075A	KC633M
1257650	BNEC312S2	KC635M	5876753	2BN0312IR081A	KC633M
1257651	BNEC312S2	K600	5876753	2BN0312IR081A	KC633M
1257656	BNEC312S4	KC635M	5824526	4BN0312IR081A	KC633M
1257657	BNEC312S4	K600	5824526	4BN0312IR081A	KC633M
1257659	BNEC312S4113	KC610M	5824527	4BN0312IL112A	KC633M
1257660	BNEC312S4113	K600	5824527	4BN0312IL112A	KC633M
1257661	BNEC312S4400	K600	5824528	4BN0312IX162A	KC633M
1257665	BNEC344S4	KC610M	5824529	4BN0344IR100A	KC633M
1257674	BNEC375S2113	K600	5876758	2BN0375IL112A	KC633M
1257675	BNEC375S2175	K600	no replacement	no replacement	no replacement
1257677	BNEC375S4	KC635M	5824530	4BN0375IS100A	KC633M
1257678	BNEC375S4	K600	5824530	4BN0375IS100A	KC633M
1257680	BNEC375S4113	K600	5824532	4BN0375IL112A	KC633M
1257681	BNEC375S4175	K600	no replacement	no replacement	no replacement
1257706	BNEC500S2	KC635M	5876763	2BN0500IR100A	KC633M
1257708	BNEC500S2300	K600	5876766	2BN0500IX300A	KC633M
1257709	BNEC500S4	KC635M	5824535	4BN0500IS100A	KC633M
1257711	BNEC500S4450	K600	5824539	4BN0500IL200A	KC633M
1257712	BNEC500S4300	K600	5824540	4BN0500IX300A	KC633M
1257714	BNEC562S2	KC635M	no replacement	no replacement	no replacement
1257715	BNEC562S2	K600	no replacement	no replacement	no replacement
1257718	BNEC562S4	KC635M	5824551	4BN0562IR125A	KC633M
1257723	BNEC625S2	KC635M	5876767	2BN0625IR125A	KC633M
1257724	BNEC625S2	K600	5876767	2BN0625IR125A	KC633M
1257726	BNEC625S2300	K600	5876769	2BN0625IX300A	KC633M
1257728	BNEC625S4	KC635M	5824552	4BN0625IR125A	KC633M
1257729	BNEC625S4	K600	5824552	4BN0625IR125A	KC633M
1257732	BNEC625S4300	K600	no replacement	no replacement	no replacement
1257740	BNEC750S2	KC635M	5876771	2BN0750IR150A	KC633M
1257741	BNEC750S2	K600	5876771	2BN0750IR150A	KC633M
1257744	BNEC750S2600	K600	5876773	2BN0750IX300A	KC633M
1257746	BNEC750S4	KC635M	5824554	4BN0750IR150A	KC633M
1257750	BNEC750S4600	K600	5824555	4BN0750IL300A	KC633M
1257755	BNEC875S2	KC635M	5876774	2BN0875IR150A	KC633M
1257758	BNEC875S4	KC610M	5824556	4BN0875IR150A	KC633M
1257759	BNEC875S4	KC635M	5824556	4BN0875IR150A	KC633M
1257760	BNEC875S4	K600	5824556	4BN0875IR150A	KC633M
1272879	HEC016S2	K600	6086327	2SE0016IR003A	KC633M
1272882	HEC016S4	K600	6086553	4SE0015IR003A	KC633M
1272883	HEC031S2	K600	6086328	2SE0031IR007A	KC633M
1272884	HEC031S3	KC610M	6143903	3SE0031IR007A	KC633M
1272886	HEC031S4	K600	6086554	4SE0031IR008A	KC633M
1272887	HEC047S2	K600	no replacement	no replacement	no replacement
1272888	HEC047S3	KC610M	6143904	3SE0047IR011A	KC633M
1272889	HEC047S4	K600	no replacement	no replacement	no replacement
1272890	HEC062S2	K600	6086329	2SE0062IL018A	KC633M
1272891	HEC062S3	K600	6143905	3SE0062IR019A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
1272892	HEC062S4	K600	5824318	4CH0062IR011A	KC633M
1272894	HEC078S2	K600	6086382	2SE0078IR018A	KC633M
1272895	HEC078S4	K600	6086556	4SE0078IR018A	KC633M
1272896	HEC094S3	K600	6143907	3SE0094IR037A	KC633M
1272897	HEC094S4	K600	6086558	4SE0093IR037A	KC633M
1272900	HEC100S2	KC635M	6086456	2SE1000IS150A	KC633M
1272902	HEC100S2225	K600	6086457	2SE1000IR225A	KC633M
1272904	HEC100S3	K600	6143979	3SE1000IR150A	KC633M
1272905	HEC100S4	KC635M	6086522	4SE1000IS150A	KC633M
1272906	HEC100S4	K600	6086522	4SE1000IS150A	KC633M
1272908	HEC100S4225	K600	6086523	4SE1000IR225A	KC633M
1272910	HEC100S4300	K600	6086524	4SE1000IL300A	KC633M
1272911	HEC109S2	K600	no replacement	no replacement	no replacement
1272912	HEC109S3	K600	6143908	3SE0109IR037A	KC633M
1272912	HEC109S3	K600	6143908	3SE0109IR037A	KC633M
1272913	HEC109S4	K600	6086560	4SE0109IR037A	KC633M
1272915	HEC11MS4	K600	no replacement	no replacement	no replacement
1272917	HEC125S2	KC635M	6086388	2SE0125IL050A	KC633M
1272918	HEC125S2	K600	6086388	2SE0125IL050A	KC633M
1272919	HEC125S2075	K600	6086389	2SE0125IX075A	KC633M
1272920	HEC125S2100	K600	no replacement	no replacement	no replacement
1272921	HEC125S3	K600	6143910	3SE0125IL050A	KC633M
1272922	HEC125S4	KC635M	6086562	4SE0125IR050A	KC633M
1272923	HEC125S4	K600	6086562	4SE0125IR050A	KC633M
1272926	HEC125S4075	K600	6086563	4SE0125IL075A	KC633M
1272927	HEC125S4100	K600	6086564	4SE0125IX100A	KC633M
1272932	HEC141S2	K600	6086390	2SE0140IR056A	KC633M
1272933	HEC141S3	KC610M	6143942	3SE0141IR056A	KC633M
1272933	HEC141S3	KC610M	6143942	3SE0141IR056A	KC633M
1272934	HEC141S4	K600	6086565	4SE0140IR056A	KC633M
1272935	HEC156S2	K600	6086392	2SE0156IL056A	KC633M
1272936	HEC156S3	K600	6143943	3SE0156IR056A	KC633M
1272937	HEC156S4	K600	6086567	4SE0156IR056A	KC633M
1272942	HEC172S4	K600	no replacement	no replacement	no replacement
1272945	HEC188S2	KC635M	6086394	2SE0187IR062A	KC633M
1272948	HEC188S2075	K600	6086395	2SE0187IL075A	KC633M
1272949	HEC188S2113	K600	6086396	2SE0187IX112A	KC633M
1272950	HEC188S3	K600	6143945	3SE0188IR056A	KC633M
1272951	HEC188S4	KC635M	6086568	4SE0187IR062A	KC633M
1272954	HEC188S4075	K600	6086570	4SE0187IL075A	KC633M
1272956	HEC188S4113	K600	6086571	4SE0187IX112A	KC633M
1272957	HEC203S2	K600	no replacement	no replacement	no replacement
1272958	HEC203S4	K600	6086572	4SE0203IR062A	KC633M
1272959	HEC219S2	K600	6086398	2SE0218IL062A	KC633M
1272960	HEC219S3	K600	6143949	3SE0219IR062A	KC633M
1272962	HEC219S4	K600	6086574	4SE0218IL062A	KC633M
1272965	HEC234S2	K600	no replacement	no replacement	no replacement
1272967	HEC234S4	K600	6086575	4SE0234IR075A	KC633M
1272970	HEC250S2	KC635M	6086400	2SE0250IR075A	KC633M
1272973	HEC250S2113	K600	6086401	2SE0250IL112A	KC633M
1272974	HEC250S2150	K600	6086402	2SE0250IX150A	KC633M
1272975	HEC250S3	K600	6143952	3SE0250IR075A	KC633M
1272977	HEC250S4	KC635M	6086577	4SE0250IR075A	KC633M
1272981	HEC250S4113	K600	6086578	4SE0250IL112A	KC633M
1272982	HEC250S4150	K600	6086579	4SE0250IX150A	KC633M
1272987	HEC266S2	K600	no replacement	no replacement	no replacement
1272989	HEC281S2	K600	6086403	2SE0281IR075A	KC633M
1272990	HEC281S3	K600	6143955	3SE0281IR075A	KC633M
1272991	HEC281S4	K600	6086581	4SE0281IR075A	KC633M
1272992	HEC297S2	K600	no replacement	no replacement	no replacement

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
1272994	HEC297S4	K600	6086582	4SE0296IR081A	KC633M
1272996	HEC312S2	KC635M	6086405	2SE0312IR081A	KC633M
1272997	HEC312S2	K600	6086405	2SE0312IR081A	KC633M
1273000	HEC312S2113	K600	6086406	2SE0312IL112A	KC633M
1273001	HEC312S2163	K600	6086407	2SE0312IX162A	KC633M
1273002	HEC312S3	K600	6143958	3SE0312IL081A	KC633M
1273003	HEC312S4	KC635M	6086584	4SE0312IR081A	KC633M
1273005	HEC312S4113	K600	6086585	4SE0312IL112A	KC633M
1273006	HEC312S4163	K600	6086586	4SE0312IX162A	KC633M
1273008	HEC328S2	K600	no replacement	no replacement	no replacement
1273009	HEC328S3	KC610M	no replacement	no replacement	no replacement
1273011	HEC344S2	K600	6086408	2SE0343IR100A	KC633M
1273012	HEC344S3	KC610M	no replacement	no replacement	no replacement
1273013	HEC344S3	K600	no replacement	no replacement	no replacement
1273014	HEC344S4	K600	6086588	4SE0343IR100A	KC633M
1273015	HEC35MS2	K600	5873015	2CH0350MR012A	KC633M
1273020	HEC360S4	K600	6086589	4SE0359IR100A	KC633M
1273021	HEC375S2	KC635M	6086410	2SE0375IR100A	KC633M
1273024	HEC375S2113	K600	6086411	2SE0375IL112A	KC633M
1273025	HEC375S2175	K600	6086412	2SE0375IX175A	KC633M
1273026	HEC375S3	K600	6143964	3SE0375IL100A	KC633M
1273031	HEC375S4	KC635M	6086591	4SE0375IR100A	KC633M
1273034	HEC375S4113	K600	6086592	4SE0375IL112A	KC633M
1273035	HEC375S4175	K600	6086593	4SE0375IX175A	KC633M
1273040	HEC406S3	KC610M	no replacement	no replacement	no replacement
1273049	HEC438S2	KC635M	6086415	2SE0437IL100A	KC633M
1273050	HEC438S2	K600	6086415	2SE0437IL100A	KC633M
1273053	HEC438S4	KC635M	6086597	4SE0437IS100A	KC633M
1273056	HEC438S4600	K600	6086600	4SE0437IX300A	KC633M
1273058	HEC45MS4	K600	no replacement	no replacement	no replacement
1273067	HEC500S2	KC635M	6086419	2SE0500IR100A	KC633M
1273071	HEC500S2300	K600	6086441	2SE0500IX300A	KC633M
1273072	HEC500S4	KC635M	6086334	4SE0500IR100A	KC633M
1273076	HEC500S4450	K600	no replacement	no replacement	no replacement
1273079	HEC500S4300	K600	6086336	4SE0500IX300A	KC633M
1273086	HEC625S2	KC635M	6086446	2SE0625IL125A	KC633M
1273087	HEC625S2	K600	6086446	2SE0625IL125A	KC633M
1273089	HEC625S2225	K600	6086447	2SE0625IX225A	KC633M
1273093	HEC625S4	KC635M	6086511	4SE0625IR125A	KC633M
1273094	HEC625S4	K600	6086511	4SE0625IR125A	KC633M
1273096	HEC625S4225	K600	6086512	4SE0625IL225A	KC633M
1273099	HEC688S2	K600	6086448	2SE0687IR137A	KC633M
1273101	HEC688S4	K600	6086514	4SE0687IR137A	KC633M
1273104	HEC750S2	KC635M	6086450	2SE0750IR150A	KC633M
1273105	HEC750S2	K600	6086450	2SE0750IR150A	KC633M
1273107	HEC750S2225	K600	6086451	2SE0750IR225A	KC633M
1273108	HEC750S2300	K600	6086452	2SE0750IL300A	KC633M
1273109	HEC750S3	K600	6143977	3SE0750IL150A	KC633M
1273110	HEC750S4	KC635M	6086516	4SE0750IR150A	KC633M
1273112	HEC750S4225	K600	6086517	4SE0750IR225A	KC633M
1273113	HEC750S4300	K600	6086518	4SE0750IL300A	KC633M
1273117	HEC875S2	KC610M	6086454	2SE0875IR150A	KC633M
1273118	HEC875S2	K600	6086454	2SE0875IR150A	KC633M
1273121	HEC875S4	K600	6086520	4SE0875IR150A	KC633M
1287025	HEC062S4013	K600	5824318	4CH0062IR011A	KC633M
1287026	HEC094S2018	KC610M	6086383	2SE0093IR018A	KC633M
1287027	HEC094S4018	KC610M	5824320	4CH0093IR037A	KC633M
1287028	HEC094S4018	K600	5824320	4CH0093IR037A	KC633M
1287029	HEC125S2025	KC610M	6086387	2SE0125IR025A	KC633M
1287030	HEC125S2025	K600	6086387	2SE0125IR025A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
1287031	HEC125S4025	K600	6086561	4SE0125IS025A	KC633M
1287032	HEC156S2031	KC610M	6086391	2SE0156IR031A	KC633M
1287033	HEC156S2031	K600	6086391	2SE0156IR031A	KC633M
1287034	HEC156S4031	K600	6086567	4SE0156IR056A	KC633M
1287041	HEC250S2050	K600	6086399	2SE0250IS050A	KC633M
1287042	HEC250S4050	K600	6086576	4SE0250IS050A	KC633M
1287043	HEC312S2050	K600	6086404	2SE0312IS050A	KC633M
1287044	HEC312S4050	KC610M	6086583	4SE0312IS050A	KC633M
1287045	HEC312S4050	K600	6086583	4SE0312IS050A	KC633M
1287047	HEC375S2063	K600	6086409	2SE0375IS062A	KC633M
1287048	HEC438S2063	K600	6086414	2SE0437IR062A	KC633M
1287049	HEC438S4063	KC610M	6086597	4SE0437IS100A	KC633M
1287050	HEC438S4063	K600	6086597	4SE0437IS100A	KC633M
1287053	HEC500S2063	K600	6086418	2SE0500IS062A	KC633M
1287054	HEC500S4063	K600	6086333	4SE0500IS062A	KC633M
1287057	HEC625S2075	KC610M	6086445	2SE0625IR075A	KC633M
1287058	HEC625S2075	K600	6086445	2SE0625IR075A	KC633M
1287059	HEC625S4075	K600	6086340	4SE0625IS075A	KC633M
1287062	HEC750S2100	K600	6086449	2SE0750IS100A	KC633M
1287063	HEC750S4100	K600	6086515	4SE0750IS100A	KC633M
1331259	BNEC234S4	K600	5824518	4BN0234IR075A	KC633M
1333665	HEC047S3	K600	6143904	3SE0047IR011A	KC633M
1339881	HEC375S4063	K600	6086590	4SE0375IS062A	KC633M
1509014	HEC109S3	KC610M	6143908	3SE0109IR037A	KC633M
1515714	HEC141S3	K600	6143942	3SE0141IR056A	KC633M
1535110	BNEC141S4O	K600	5824510	4BN0141IR056A	KC633M
1562642	HEC281S4	KC635M	6086581	4SE0281IR075A	KC633M
1616172	HEC031S2	KC635M	6086328	2SE0031IR007A	KC633M
1616173	HEC031S4	KC635M	6086554	4SE0031IR008A	KC633M
1616174	HEC062S2	KC635M	6086329	2SE0062IL018A	KC633M
1616176	HEC062S4	KC635M	5824318	4CH0062IR011A	KC633M
1616177	HEC094S2	KC635M	6086384	2SE0093IL037A	KC633M
1616178	HEC094S4	KC635M	6086558	4SE0093IR037A	KC633M
1616179	HEC156S2	KC635M	6086392	2SE0156IL056A	KC633M
1616180	HEC156S4	KC635M	6086567	4SE0156IR056A	KC633M
1616181	HEC219S2	KC635M	6086398	2SE0218IL062A	KC633M
1616182	HEC219S4	KC635M	6086574	4SE0218IL062A	KC633M
1616183	HEC281S2	KC635M	6086403	2SE0281IR075A	KC633M
2229299	BNEC094S2	KC635M	5876725	2BN0094IL037A	KC633M
2229301	BNEC094S4	KC635M	5824504	4BN0094IL037A	KC633M
2234615	BNEC375S4300	KC635M	no replacement	no replacement	no replacement
2657737	HEC094S2063	K600	6086385	2SE0093IX062A	KC633M
2657738	HEC094S4063	K600	6086559	4SE0093IL062A	KC633M
2657739	HEC188S2031	K600	no replacement	no replacement	no replacement
2657740	HEC188S4031	K600	no replacement	no replacement	no replacement
2657741	HEC219S2044	K600	6086397	2SE0218IR043A	KC633M
2657742	HEC219S4044	K600	6086573	4SE0218IR043A	KC633M
2657763	HEC375S2088	K600	no replacement	no replacement	no replacement
2657764	HEC375S3088	K600	6143963	3SE0375IR088A	KC633M
2657765	HEC375S3113	K600	6143965	3SE0375IX112A	KC633M
2657766	HEC375S4088	K600	6086591	4SE0375IR100A	KC633M
2657773	HEC438S2200	K600	6086416	2SE0437IX200A	KC633M
2657774	HEC438S4100	K600	6086598	4SE0437IR100A	KC633M
2657775	HEC438S4200	K600	no replacement	no replacement	no replacement
2657776	HEC500S2200	K600	6086420	2SE0500IL200A	KC633M
2657777	HEC500S3200	K600	6143971	3SE0500IL200A	KC633M
2657778	HEC500S4200	K600	no replacement	no replacement	no replacement
2657779	HEC562S2075	K600	6086442	2SE0562IR075A	KC633M
2657780	HEC562S2125	K600	6086443	2SE0562IL125A	KC633M
2657781	HEC562S2225	K600	6086444	2SE0562IX225A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
2657782	HEC562S4075	K600	6086337	4SE0562IR075A	KC633M
2657783	HEC562S4125	K600	6086338	4SE0562IL125A	KC633M
2657784	HEC562S4225	K600	6086339	4SE0562IX225A	KC633M
2657785	HEC625S2400	K600	no replacement	no replacement	no replacement
2657786	HEC625S4400	K600	6086513	4SE0625IX400A	KC633M
2657787	HEC750S2400	K600	6086453	2SE0750IX400A	KC633M
2657788	HEC750S3225	K600	6143978	3SE0750IX225A	KC633M
2657789	HEC750S4400	K600	6086519	4SE0750IX400A	KC633M
2657791	HEC875S4225	K600	6086521	4SE0875IL225A	KC633M
2657792	HEC100S2400	K600	6086459	2SE1000IX400A	KC633M
2657793	HEC100S3225	K600	6143980	3SE1000IX225A	KC633M
2657794	HEC100S4400	K600	6086525	4SE1000IX400A	KC633M
2657797	HEC1250S2200	K600	no replacement	no replacement	no replacement
2657798	HEC1250S4200	K600	no replacement	no replacement	no replacement
2657799	BNEC094S2018	K600	5876724	2BN0094IR018A	KC633M
2657800	BNEC125S2025	K600	5876727	2BN0125IS025A	KC633M
2657801	BNEC125S2075L	K600	5876730	2BN0125IX075A	KC633M
2657802	BNEC156S2031	K600	5876741	2BN0156IR031A	KC633M
2657823	BNEC188S2031	K600	5876743	2BN0187IS031A	KC633M
2657824	BNEC188S2100	K600	5876746	2BN0187IX100A	KC633M
2657825	BNEC250S2050	K600	5876748	2BN0250IS050A	KC633M
2657826	BNEC250S2150L	K600	5876752	2BN0250IX150A	KC633M
2657827	BNEC312S2050	K600	no replacement	no replacement	no replacement
2657828	BNEC312S2150	K600	5876755	2BN0312IX150A	KC633M
2657829	BNEC375S2063	K600	5876756	2BN0375IS062A	KC633M
2657830	BNEC375S2088	K600	5876757	2BN0375IR087A	KC633M
2657831	BNEC406S2100	K600	5876760	2BN0406IR100A	KC633M
2657832	BNEC438S2100	K600	5876761	2BN0437IR100A	KC633M
2657833	BNEC500S2063	K600	5876762	2BN0500IS062A	KC633M
2657834	BNEC500S2150	K600	5876764	2BN0500IX150A	KC633M
2657835	BNEC500S2200	K600	5876765	2BN0500IL200A	KC633M
2657836	BNEC750S2100	K600	5876770	2BN0750IS100A	KC633M
2657837	BNEC750S2200	K600	5876772	2BN0750IL200A	KC633M
2657839	BNEC094S4018	K600	5824503	4BN0094IR019A	KC633M
2657840	BNEC125S4025	K600	5824506	4BN0125IS025A	KC633M
2657841	BNEC125S4075L	K600	5824509	4BN0125IX075A	KC633M
2657842	BNEC156S4031	K600	5824511	4BN0156IR056A	KC633M
2657843	BNEC188S4031	K600	5824513	4BN0187IR031A	KC633M
2657844	BNEC188S4100	K600	5824515	4BN0187IX100A	KC633M
2657845	BNEC250S4050	K600	5824519	4BN0250IS050A	KC633M
2657846	BNEC250S4150L	K600	5824523	4BN0250IX150A	KC633M
2657847	BNEC312S4050	K600	5824525	4BN0312IS050A	KC633M
2657848	BNEC312S4150	K600	no replacement	no replacement	no replacement
2657849	BNEC375S4063	K600	no replacement	no replacement	no replacement
2657850	BNEC375S4088	K600	no replacement	no replacement	no replacement
2657851	BNEC406S4100	K600	no replacement	no replacement	no replacement
2657852	BNEC438S4100	K600	5824534	4BN0437IR100A	KC633M
2657853	BNEC500S4063	K600	no replacement	no replacement	no replacement
2657854	BNEC500S4150	K600	5824537	4BN0500IX150A	KC633M
2657855	BNEC500S4200	K600	5824538	4BN0500IR200A	KC633M
2657856	BNEC750S4100	K600	no replacement	no replacement	no replacement
2657857	BNEC750S4200	K600	no replacement	no replacement	no replacement
2657858	BNEC125S2075	K600	5876729	2BN0125IL075A	KC633M
2881042	HEC094S2063	KC610M	6086385	2SE0093IX062A	KC633M
2881073	HEC094S4063	KC610M	6086559	4SE0093IL062A	KC633M
2881074	HEC188S2031	KC610M	no replacement	no replacement	no replacement
2881075	HEC188S4031	KC610M	no replacement	no replacement	no replacement
2881076	HEC219S2044	KC610M	6086397	2SE0218IR043A	KC633M
2881077	HEC219S4044	KC610M	6086573	4SE0218IR043A	KC633M
2881078	HEC375S2088	KC610M	no replacement	no replacement	no replacement

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
2881079	HEC375S3088	KC610M	6143963	3SE0375IR088A	KC633M
2881080	HEC375S3113	KC610M	6143965	3SE0375IX112A	KC633M
2881081	HEC375S4088	KC610M	6086591	4SE0375IR100A	KC633M
2881082	HEC391S2100	KC610M	no replacement	no replacement	no replacement
2881083	HEC391S4100	KC610M	6086594	4SE0390IR100A	KC633M
2881084	HEC406S2100	KC610M	6086413	2SE0406IR100A	KC633M
2881085	HEC406S4100	KC610M	6086595	4SE0406IR100A	KC633M
2881087	HEC422S4100	KC610M	6086596	4SE0421IR100A	KC633M
2881088	HEC438S2200	KC610M	6086416	2SE0437IX200A	KC633M
2881089	HEC438S4100	KC610M	6086598	4SE0437IR100A	KC633M
2881090	HEC438S4200	KC610M	6086599	4SE0437IL200A	KC633M
2881091	HEC500S2200	KC610M	6086420	2SE0500IL200A	KC633M
2881092	HEC500S3200	KC610M	6143971	3SE0500IL200A	KC633M
2881093	HEC500S4200	KC610M	6086335	4SE0500IL200A	KC633M
2881094	HEC562S2075	KC610M	6086442	2SE0562IR075A	KC633M
2881095	HEC562S2125	KC610M	6086443	2SE0562IL125A	KC633M
2881096	HEC562S2225	KC610M	6086444	2SE0562IX225A	KC633M
2881097	HEC562S4075	KC610M	6086337	4SE0562IR075A	KC633M
2881098	HEC562S4125	KC610M	6086338	4SE0562IL125A	KC633M
2881099	HEC562S4225	KC610M	6086339	4SE0562IX225A	KC633M
2881100	HEC750S3225	KC610M	6143978	3SE0750IX225A	KC633M
2881101	HEC100S3225	KC610M	6143980	3SE1000IX225A	KC633M
2887945	HEC250S4150L	K600	no replacement	no replacement	no replacement
2887946	HEC375S4150L	K600	no replacement	no replacement	no replacement
2888924	BNEC375S4300L	K600	no replacement	no replacement	no replacement
2888925	BNEC375S2300L	K600	5876759	2BN0375IX300A	KC633M
2890374	HEC094S2063	KC635M	6086385	2SE0093IX062A	KC633M
2890375	HEC094S4063	KC635M	6086559	4SE0093IL062A	KC633M
2890376	HEC188S2031	KC635M	no replacement	no replacement	no replacement
2890377	HEC188S4031	KC635M	6086569	4SE0187IS075A	KC633M
2890378	HEC219S2044	KC635M	6086397	2SE0218IR043A	KC633M
2890379	HEC219S4044	KC635M	6086573	4SE0218IR043A	KC633M
2890380	HEC375S2088	KC635M	6086410	2SE0375IR100A	KC633M
2890381	HEC062S2013	KC635M	6086330	2SE0062IR012A	KC633M
2890382	HEC062S4013	KC635M	5824318	4CH0062IR011A	KC633M
2890383	HEC375S4088	KC635M	6086591	4SE0375IR100A	KC633M
2890384	HEC094S2018	KC635M	6086383	2SE0093IR018A	KC633M
2890385	HEC094S4018	KC635M	5824320	4CH0093IR037A	KC633M
2890386	HEC125S2025	KC635M	6086387	2SE0125IR025A	KC633M
2890387	HEC125S4025	KC635M	6086561	4SE0125IS025A	KC633M
2890388	HEC125S2075	KC635M	6086389	2SE0125IX075A	KC633M
2890389	HEC125S4075	KC635M	6086563	4SE0125IL075A	KC633M
2890390	HEC438S2200	KC635M	6086416	2SE0437IX200A	KC633M
2890391	HEC438S4100	KC635M	6086598	4SE0437IR100A	KC633M
2890392	HEC438S4200	KC635M	6086599	4SE0437IL200A	KC633M
2890393	HEC500S2200	KC635M	6086420	2SE0500IL200A	KC633M
2890394	HEC125S2100	KC635M	no replacement	no replacement	no replacement
2890395	HEC500S4200	KC635M	6086335	4SE0500IL200A	KC633M
2890396	HEC125S4100	KC635M	6086564	4SE0125IX100A	KC633M
2890397	HEC562S2125	KC635M	6086443	2SE0562IL125A	KC633M
2890398	HEC562S2225	KC635M	6086444	2SE0562IX225A	KC633M
2890399	HEC156S2031	KC635M	6086391	2SE0156IR031A	KC633M
2890400	HEC562S4125	KC635M	6086338	4SE0562IL125A	KC633M
2890401	HEC562S4225	KC635M	6086339	4SE0562IX225A	KC633M
2890402	HEC156S4031	KC635M	6086567	4SE0156IR056A	KC633M
2890403	HEC188S2075	KC635M	6086395	2SE0187IL075A	KC633M
2890404	HEC188S4075	KC635M	no replacement	no replacement	no replacement
2890405	HEC188S2113	KC635M	no replacement	no replacement	no replacement
2890406	HEC188S4113	KC635M	6086571	4SE0187IX112A	KC633M
2890781	HEC250S2050	KC635M	6086399	2SE0250IS050A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
2890782	HEC250S4050	KC635M	6086576	4SE0250IS050A	KC633M
2890863	HEC250S2113	KC635M	6086401	2SE0250IL112A	KC633M
2890864	HEC250S4113	KC635M	6086578	4SE0250IL112A	KC633M
2890865	HEC250S2150	KC635M	6086402	2SE0250IX150A	KC633M
2890866	HEC250S4150	KC635M	6086579	4SE0250IX150A	KC633M
2890867	HEC250S4150L	KC635M	no replacement	no replacement	no replacement
2890868	HEC312S2050	KC635M	6086404	2SE0312IS050A	KC633M
2890869	HEC312S4050	KC635M	6086583	4SE0312IS050A	KC633M
2890870	HEC312S2113	KC635M	6086406	2SE0312IL112A	KC633M
2890871	HEC312S4113	KC635M	6086585	4SE0312IL112A	KC633M
2890872	HEC312S2163	KC635M	6086407	2SE0312IX162A	KC633M
2890873	HEC312S4163	KC635M	6086586	4SE0312IX162A	KC633M
2890874	HEC375S2063	KC635M	6086409	2SE0375IS062A	KC633M
2890875	HEC375S4063	KC635M	6086590	4SE0375IS062A	KC633M
2890876	HEC375S2113	KC635M	6086411	2SE0375IL112A	KC633M
2890877	HEC375S4113	KC635M	6086592	4SE0375IL112A	KC633M
2890878	HEC375S2175	KC635M	6086412	2SE0375IX175A	KC633M
2890879	HEC375S4175	KC635M	6086593	4SE0375IX175A	KC633M
2890880	HEC375S4150L	KC635M	no replacement	no replacement	no replacement
2890881	HEC438S2063	KC635M	6086414	2SE0437IR062A	KC633M
2890882	HEC438S4063	KC635M	6086597	4SE0437IS100A	KC633M
2890883	HEC500S2063	KC635M	6086418	2SE0500IS062A	KC633M
2890884	HEC500S4063	KC635M	6086333	4SE0500IS062A	KC633M
2890885	HEC500S2300	KC635M	6086441	2SE0500IX300A	KC633M
2890886	HEC500S4300	KC635M	6086336	4SE0500IX300A	KC633M
2890887	HEC625S2075	KC635M	6086445	2SE0625IR075A	KC633M
2890888	HEC625S4075	KC635M	6086340	4SE0625IS075A	KC633M
2890889	HEC625S2225	KC635M	6086447	2SE0625IX225A	KC633M
2890890	HEC625S4225	KC635M	6086512	4SE0625IL225A	KC633M
2890891	HEC625S2400	KC635M	no replacement	no replacement	no replacement
2890892	HEC625S4400	KC635M	6086513	4SE0625IX400A	KC633M
2890893	HEC750S2100	KC635M	6086449	2SE0750IS100A	KC633M
2890894	HEC750S4100	KC635M	6086515	4SE0750IS100A	KC633M
2890895	HEC750S2225	KC635M	6086451	2SE0750IR225A	KC633M
2890896	HEC750S4225	KC635M	6086517	4SE0750IR225A	KC633M
2890897	HEC750S2300	KC635M	6086452	2SE0750IL300A	KC633M
2890898	HEC750S4300	KC635M	6086518	4SE0750IL300A	KC633M
2890899	HEC750S2400	KC635M	6086453	2SE0750IX400A	KC633M
2890900	HEC750S4400	KC635M	6086519	4SE0750IX400A	KC633M
2890901	HEC875S2225	KC635M	6086455	2SE0875IL225A	KC633M
2890902	HEC875S4225	KC635M	6086521	4SE0875IL225A	KC633M
2890903	HEC100S2225	KC635M	6086457	2SE1000IR225A	KC633M
2890904	HEC100S4225	KC635M	6086523	4SE1000IR225A	KC633M
2890905	HEC100S2300	KC635M	6086458	2SE1000IL300A	KC633M
2890906	HEC100S4300	KC635M	6086524	4SE1000IL300A	KC633M
2890907	HEC100S2400	KC635M	6086459	2SE1000IX400A	KC633M
2890908	HEC100S4400	KC635M	6086525	4SE1000IX400A	KC633M
2890912	HEC1250S4200	KC635M	no replacement	no replacement	no replacement
2890918	BNEC031S2	KC635M	5876721	2BN0031IR007A	KC633M
2890919	BNEC031S4	KC635M	5824029	4BN0031IR008A	KC633M
2890920	BNEC062S2	KC635M	5876722	2BN0063IR018A	KC633M
2890921	BNEC062S4	KC635M	5824501	4BN0062IR019A	KC633M
2890922	BNEC094S2018	KC635M	5876724	2BN0094IR018A	KC633M
2890943	BNEC094S4018	KC635M	5824503	4BN0094IR019A	KC633M
2890944	BNEC125S2025	KC635M	5876727	2BN0125IS025A	KC633M
2890945	BNEC125S2075	KC635M	5876729	2BN0125IL075A	KC633M
2890946	BNEC125S2075L	KC635M	5876730	2BN0125IX075A	KC633M
2890947	BNEC125S4025	KC635M	5824506	4BN0125IS025A	KC633M
2890948	BNEC125S4075	KC635M	5824508	4BN0125IL075A	KC633M
2890949	BNEC125S4075L	KC635M	5824509	4BN0125IX075A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
2890950	BNEC156S2	KC635M	5876742	2BN0156IL056A	KC633M
2890951	BNEC156S2031	KC635M	5876741	2BN0156IR031A	KC633M
2890952	BNEC156S4	KC635M	5824511	4BN0156IR056A	KC633M
2890953	BNEC156S4031	KC635M	5824511	4BN0156IR056A	KC633M
2890954	BNEC188S2031	KC635M	5876743	2BN0187IS031A	KC633M
2890955	BNEC188S2075	KC635M	5876745	2BN0187IL075A	KC633M
2890956	BNEC188S2100	KC635M	5876746	2BN0187IX100A	KC633M
2890957	BNEC188S4031	KC635M	5824513	4BN0187IR031A	KC633M
2890958	BNEC188S4075	KC635M	no replacement	no replacement	no replacement
2890959	BNEC188S4100	KC635M	5824515	4BN0187IX100A	KC633M
2890960	BNEC250S2050	KC635M	5876748	2BN0250IS050A	KC633M
2890961	BNEC250S2113	KC635M	5876750	2BN0250IR112A	KC633M
2890962	BNEC250S2150	KC635M	5876751	2BN0250IL150A	KC633M
2890963	BNEC250S2150L	KC635M	5876752	2BN0250IX150A	KC633M
2890964	BNEC250S4050	KC635M	5824519	4BN0250IS050A	KC633M
2890965	BNEC250S4113	KC635M	5824521	4BN0250IR112A	KC633M
2890966	BNEC250S4150	KC635M	5824522	4BN0250IL150A	KC633M
2890967	BNEC250S4150L	KC635M	5824523	4BN0250IX150A	KC633M
2890968	BNEC312S2050	KC635M	no replacement	no replacement	no replacement
2890969	BNEC312S2113	KC635M	5876754	2BN0312IL112A	KC633M
2890970	BNEC312S2150	KC635M	5876755	2BN0312IX150A	KC633M
2890971	BNEC312S4050	KC635M	no replacement	no replacement	no replacement
2890972	BNEC312S4113	KC635M	5824527	4BN0312IL112A	KC633M
2890973	BNEC312S4150	KC635M	no replacement	no replacement	no replacement
2890974	BNEC375S2063	KC635M	5876756	2BN0375IS062A	KC633M
2890975	BNEC375S2088	KC635M	5876757	2BN0375IR087A	KC633M
2890976	BNEC375S2113	KC635M	5876758	2BN0375IL112A	KC633M
2890977	BNEC375S2175	KC635M	no replacement	no replacement	no replacement
2890978	BNEC375S2300	KC635M	5876759	2BN0375IX300A	KC633M
2890979	BNEC375S4063	KC635M	no replacement	no replacement	no replacement
2890980	BNEC375S4088	KC635M	no replacement	no replacement	no replacement
2890981	BNEC375S4113	KC635M	5824532	4BN0375IL112A	KC633M
2890982	BNEC375S4175	KC635M	no replacement	no replacement	no replacement
2890983	BNEC438S2100	KC635M	5876761	2BN0437IR100A	KC633M
2890984	BNEC438S4100	KC635M	5824534	4BN0437IR100A	KC633M
2890985	BNEC500S2063	KC635M	5876762	2BN0500IS062A	KC633M
2890986	BNEC500S2150	KC635M	5876764	2BN0500IX150A	KC633M
2890987	BNEC500S2200	KC635M	5876765	2BN0500IL200A	KC633M
2890988	BNEC500S2300	KC635M	5876766	2BN0500IX300A	KC633M
2890989	BNEC500S4063	KC635M	no replacement	no replacement	no replacement
2890990	BNEC500S4150	KC635M	5824537	4BN0500IX150A	KC633M
2890991	BNEC500S4200	KC635M	5824538	4BN0500IR200A	KC633M
2890992	BNEC500S4300	KC635M	5824540	4BN0500IX300A	KC633M
2890993	BNEC625S2300	KC635M	5876769	2BN0625IX300A	KC633M
2890994	BNEC625S4300	KC635M	no replacement	no replacement	no replacement
2890995	BNEC750S2100	KC635M	5876770	2BN0750IS100A	KC633M
2890996	BNEC750S2200	KC635M	5876772	2BN0750IL200A	KC633M
2890997	BNEC750S4100	KC635M	no replacement	no replacement	no replacement
2890998	BNEC750S4200	KC635M	5824555	4BN0750IL300A	KC633M
2890999	BNEC100S2300	KC635M	5876776	2BN1000IL300A	KC633M
2891000	BNEC100S4300	KC635M	no replacement	no replacement	no replacement
3016760	BNEC094S2018	KC610M	5876724	2BN0094IR018A	KC633M
3016761	BNEC094S4018	KC610M	5824503	4BN0094IR019A	KC633M
3016762	BNEC125S2025	KC610M	5876727	2BN0125IS025A	KC633M
3016773	BNEC125S2075L	KC610M	no replacement	no replacement	no replacement
3016774	BNEC125S4025	KC610M	5824506	4BN0125IS025A	KC633M
3016775	BNEC125S4075L	KC610M	5824509	4BN0125IX075A	KC633M
3016776	BNEC156S2031	KC610M	5876741	2BN0156IR031A	KC633M
3016777	BNEC156S4031	KC610M	5824511	4BN0156IR056A	KC633M
3016778	BNEC188S2031	KC610M	5876743	2BN0187IS031A	KC633M

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Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
3016779	BNEC188S2100	KC610M	5876746	2BN0187IX100A	KC633M
3016780	BNEC188S4031	KC610M	5824513	4BN0187IR031A	KC633M
3016781	BNEC188S4100	KC610M	5824515	4BN0187IX100A	KC633M
3016782	BNEC250S2050	KC610M	5876748	2BN0250IS050A	KC633M
3016783	BNEC250S2150L	KC610M	5876752	2BN0250IX150A	KC633M
3016784	BNEC250S4050	KC610M	5824519	4BN0250IS050A	KC633M
3016785	BNEC250S4150L	KC610M	5824523	4BN0250IX150A	KC633M
3016786	BNEC312S2050	KC610M	no replacement	no replacement	no replacement
3016787	BNEC312S2150	KC610M	5876755	2BN0312IX150A	KC633M
3016788	BNEC312S4050	KC610M	no replacement	no replacement	no replacement
3016789	BNEC312S4150	KC610M	no replacement	no replacement	no replacement
3016790	BNEC375S2063	KC610M	5876756	2BN0375IS062A	KC633M
3016791	BNEC375S2088	KC610M	5876757	2BN0375IR087A	KC633M
3016792	BNEC375S2300L	KC610M	5876759	2BN0375IX300A	KC633M
3018900	BNEC375S4063	KC610M	no replacement	no replacement	no replacement
3018901	BNEC375S4088	KC610M	no replacement	no replacement	no replacement
3018902	BNEC375S4300L	KC610M	no replacement	no replacement	no replacement
3018913	BNEC406S2100	KC610M	5876760	2BN0406IR100A	KC633M
3018914	BNEC406S4100	KC610M	no replacement	no replacement	no replacement
3018915	BNEC438S2100	KC610M	5876761	2BN0437IR100A	KC633M
3018916	BNEC438S4100	KC610M	5824534	4BN0437IR100A	KC633M
3018917	BNEC500S2063	KC610M	5876762	2BN0500IS062A	KC633M
3018918	BNEC500S2150	KC610M	5876764	2BN0500IX150A	KC633M
3018919	BNEC500S2200	KC610M	5876765	2BN0500IL200A	KC633M
3018920	BNEC500S4063	KC610M	no replacement	no replacement	no replacement
3018921	BNEC500S4150	KC610M	5824537	4BN0500IX150A	KC633M
3018922	BNEC500S4200	KC610M	5824538	4BN0500IR200A	KC633M
3018923	BNEC750S2100	KC610M	5876770	2BN0750IS100A	KC633M
3018924	BNEC750S2200	KC610M	5876772	2BN0750IL200A	KC633M
3018925	BNEC750S4100	KC610M	no replacement	no replacement	no replacement
3018926	BNEC750S4200	KC610M	no replacement	no replacement	no replacement
5046911	HEC313S4044	K600	6086583	4SE0312IS050A	KC633M
5046912	HEC250S4038	K600	6086576	4SE0250IS050A	KC633M
5046913	HEC438S4088	K600	6086597	4SE0437IS100A	KC633M
5046916	HEC47S2013	K600	no replacement	no replacement	no replacement
5046917	HEC500S2200L	K600	no replacement	no replacement	no replacement
5056432	HEC16S2	KC625M	6086327	2SE0016IR003A	KC633M
5056433	HEC31S2	KC625M	6086328	2SE0031IR007A	KC633M
5056434	HEC47S2	KC625M	no replacement	no replacement	no replacement
5056435	HEC63S2	KC625M	6086381	2SE0062IX050A	KC633M
5056436	HEC63S2018	KC625M	6086329	2SE0062IL018A	KC633M
5056437	HEC63S2013	KC625M	6086330	2SE0062IR012A	KC633M
5056439	HEC78S2	KC625M	6086382	2SE0078IR018A	KC633M
5056460	HEC94S2018	KC625M	6086383	2SE0093IR018A	KC633M
5056461	HEC094S2	KC625M	6086384	2SE0093IL037A	KC633M
5056465	HEC109S2	KC625M	no replacement	no replacement	no replacement
5056467	HEC125S2100	KC625M	no replacement	no replacement	no replacement
5056468	HEC125S2075	KC625M	6086389	2SE0125IX075A	KC633M
5056470	HEC125S2	KC625M	6086388	2SE0125IL050A	KC633M
5056471	HEC125S2025	KC625M	6086387	2SE0125IR025A	KC633M
5056472	HEC156S2031	KC625M	6086391	2SE0156IR031A	KC633M
5056475	HEC156S2	KC625M	6086392	2SE0156IL056A	KC633M
5056476	HEC188S2113	KC625M	6086396	2SE0187IX112A	KC633M
5056477	HEC188S2075	KC625M	6086395	2SE0187IL075A	KC633M
5056478	HEC188S2	KC625M	6086394	2SE0187IR062A	KC633M
5056479	HEC188S2031	KC625M	no replacement	no replacement	no replacement
5056490	HEC219S2044	KC625M	6086397	2SE0218IR043A	KC633M
5056495	HEC219S2	KC625M	6086398	2SE0218IL062A	KC633M
5056497	HEC250S2150	KC625M	6086402	2SE0250IX150A	KC633M
5056498	HEC250S2113	KC625M	6086401	2SE0250IL112A	KC633M

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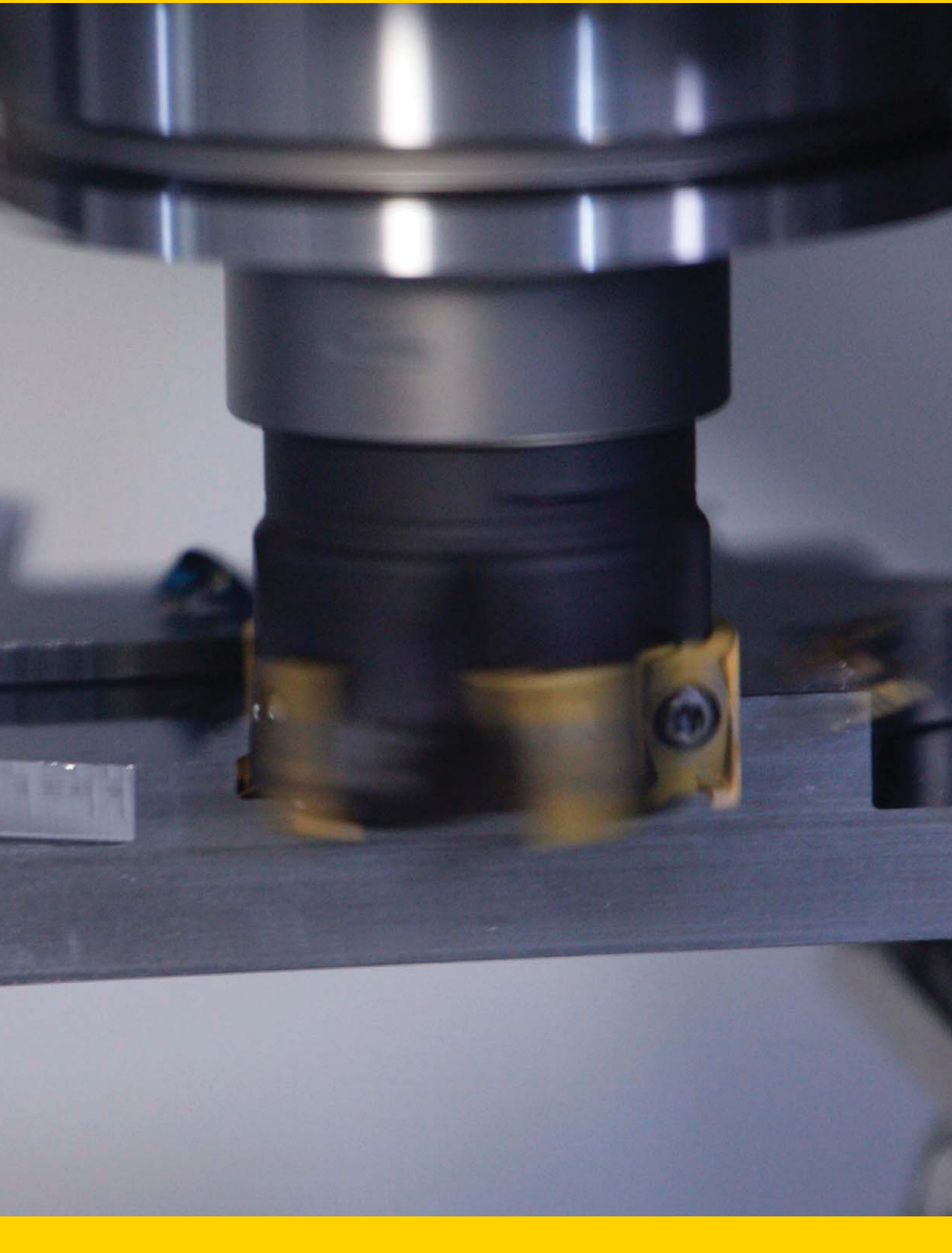
Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
5056499	HEC250S2	KC625M	6086400	2SE0250IR075A	KC633M
5056510	HEC250S2050	KC625M	6086399	2SE0250IS050A	KC633M
5056511	HEC312S2163	KC625M	6086407	2SE0312IX162A	KC633M
5056512	HEC312S2	KC625M	6086405	2SE0312IR081A	KC633M
5056513	HEC344S2	KC625M	6086408	2SE0343IR100A	KC633M
5056514	HEC375S2088	KC625M	no replacement	no replacement	no replacement
5056515	HEC375S2113	KC625M	6086411	2SE0375IL112A	KC633M
5056517	HEC438S2200	KC625M	6086416	2SE0437IX200A	KC633M
5056530	HEC438S2	KC625M	6086415	2SE0437IL100A	KC633M
5056532	HEC500S2300	KC625M	6086441	2SE0500IX300A	KC633M
5056534	HEC500S2200	KC625M	6086420	2SE0500IL200A	KC633M
5056535	HEC500S2	KC625M	6086419	2SE0500IR100A	KC633M
5056537	HEC500S2063	KC625M	6086418	2SE0500IS062A	KC633M
5056539	HEC625S2400	KC625M	no replacement	no replacement	no replacement
5056550	HEC625S2	KC625M	6086446	2SE0625IL125A	KC633M
5056553	HEC625S2075	KC625M	6086445	2SE0625IR075A	KC633M
5056554	HEC750S2300	KC625M	6086452	2SE0750IL300A	KC633M
5056555	HEC750S2	KC625M	6086450	2SE0750IR150A	KC633M
5056556	HEC750S2100	KC625M	6086449	2SE0750IS100A	KC633M
5056557	HEC875S2	KC625M	6086454	2SE0875IR150A	KC633M
5056558	HEC1000S2	KC625M	6086456	2SE1000IS150A	KC633M
5056858	HEC688S3138	K600	no replacement	no replacement	no replacement
5056859	HEC563S3113	K600	6143973	3SE0563IR112A	KC633M
5057012	HEC062S4050	K600	no replacement	no replacement	no replacement
5057013	HEC375S4100	K600	6086593	4SE0375IX175A	KC633M
5057014	HEC453S4100	K600	6086601	4SE0453IR100A	KC633M
5057015	HEC500S4100	K600	6086335	4SE0500IL200A	KC633M
5057016	HEC062S4050	KC625M	no replacement	no replacement	no replacement
5057017	HEC375S4100	KC625M	6086593	4SE0375IX175A	KC633M
5057018	HEC500S4100	KC625M	6086335	4SE0500IL200A	KC633M
5057019	HEC375S4100	KC635M	6086593	4SE0375IX175A	KC633M
5057070	HEC500S4100	KC635M	6086335	4SE0500IL200A	KC633M
5057071	BNEC625S4075	KC635M	no replacement	no replacement	no replacement
5057072	BNEC100S4225	KC625M	5824558	4BN1000IL225A	KC633M
5057073	BNEC625S4075	KC625M	no replacement	no replacement	no replacement
5057079	BNEC100S4225	K600	5824558	4BN1000IL225A	KC633M
5058636	HEC750S4	KC625M	6086516	4SE0750IR150A	KC633M
5058637	HEC500S4	KC625M	6086334	4SE0500IR100A	KC633M
5058638	HEC375S4088	KC625M	6086591	4SE0375IR100A	KC633M
5058639	HEC250S4	KC625M	6086577	4SE0250IR075A	KC633M
5058686	HECL750S2200	KC625M	6086452	2SE0750IL300A	KC633M
5058687	HECL625S2200	KC625M	no replacement	no replacement	no replacement
5058981	BNECL500S2150	K600	5876764	2BN0500IX150A	KC633M
5058983	BNECL500S2100	K600	5876765	2BN0500IL200A	KC633M
5058984	BNECL375S2150	K600	5876759	2BN0375IX300A	KC633M
5058985	BNECL375S2100	K600	no replacement	no replacement	no replacement
5058986	BNECL312S2150	K600	5876755	2BN0312IX150A	KC633M
5058987	BNECL312S2100	K600	no replacement	no replacement	no replacement
5058989	BNECL250S2150	K600	5876752	2BN0250IX150A	KC633M
5059060	BNECL250S2100	K600	5876750	2BN0250IR112A	KC633M
5059061	BNECL188S2100	K600	5876746	2BN0187IX100A	KC633M
5059062	BNECL125S2075	K600	5876730	2BN0125IX075A	KC633M
5059063	BNECL750S2200	KC625M	5876773	2BN0750IX300A	KC633M
5059065	BNECL500S2150	KC625M	5876764	2BN0500IX150A	KC633M
5059066	BNECL500S2100	KC625M	5876765	2BN0500IL200A	KC633M
5059110	BNECL438S2300	KC625M	no replacement	no replacement	no replacement
5059111	BNECL375S2300	KC625M	5876759	2BN0375IX300A	KC633M
5059113	BNECL375S2150	KC625M	5876759	2BN0375IX300A	KC633M
5059114	BNECL375S2100	KC625M	no replacement	no replacement	no replacement
5059115	BNECL312S2100	KC625M	no replacement	no replacement	no replacement

(continued)

(continued)

Old General Purpose			GOmill GP Replacement		
Order Number	Catalog Number	Grade	Order Number	Catalog Number	Grade
5059116	BNECL250S2150	KC625M	5876752	2BN0250IX150A	KC633M
5059118	BNECL250S2100	KC625M	5876750	2BN0250IR112A	KC633M
5059119	BNECL188S2100	KC625M	5876746	2BN0187IX100A	KC633M
5059161	BNECL125S2075	KC625M	5876730	2BN0125IX075A	KC633M
5061835	BNEC100S2225	K600	no replacement	no replacement	no replacement
5061837	BNEC750S2225	K600	no replacement	no replacement	no replacement
5061838	BNEC625S2225	K600	5876768	2BN0625IL225A	KC633M



Indexable Milling

Indexable Milling Introduction R2–R21

Face Milling S1–S126

Shoulder Milling T1–T136

Slot Milling U1–U41

Copy Milling V1–V159

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 Authorized 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™ 6°
- MEGA
- KBDM™
- KSCM™ PCD AluMill™
- Fix-Perfect 0° Aluminum

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

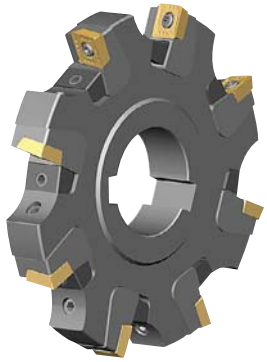
- KTMS™ T-Slot
- KVNS™
- SN
- LN
- KSSM™

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.

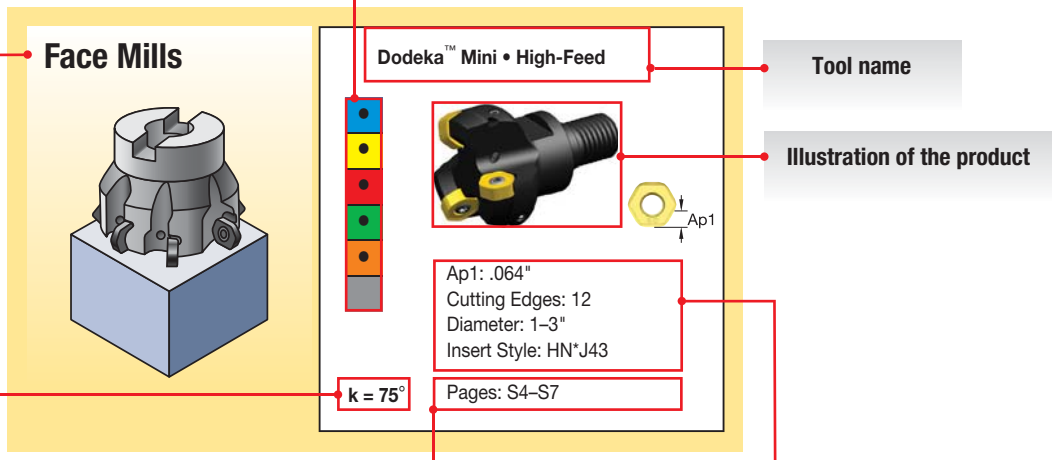
For every milling application, workpiece, or equipment need, we offer the best tools on the market, designed to reduce your machining time, provide superior surface finishes, and exceed your expectations!

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



Tool name

Illustration of the product

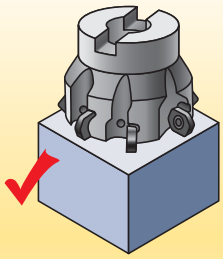
Lead angle

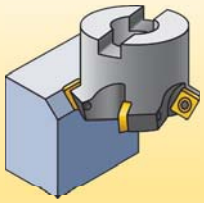
Location of introduction detail, tool bodies, inserts, and cutting data.

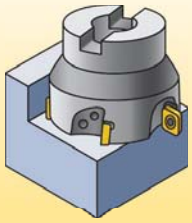
Select tool based on maximum depth of cut and diameter required:
Information is given in this area to provide specific detail as a quick reference.

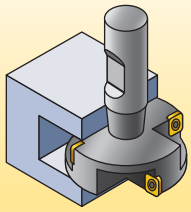
How to Navigate the 2018 Catalog

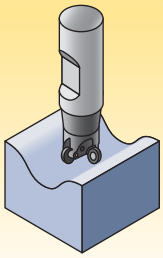
Step 1 • Select Application

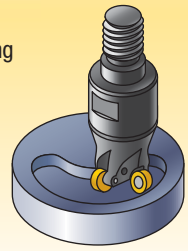

Face Milling

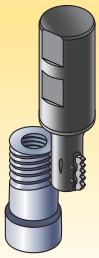

Chamfer Milling


Shoulder Milling (End Milling)


Slotting


Copy Milling

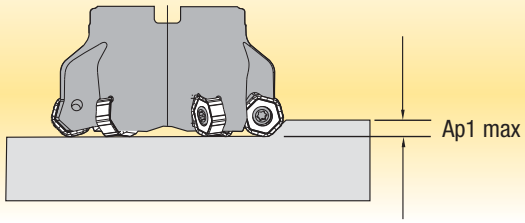

Ceramic Milling


Thread Milling

Step 2 • Select Workpiece Material

ISO Description		● first choice ○ alternate choice	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	Gray, ductile, CGI, and malleable cast irons >80 KSI
			K3	Ductile, CGI, and malleable cast irons >80 KSI
Non-Ferrous Materials	N		N1–N2	Aluminum alloys <12.2% Si
			N3	Aluminum 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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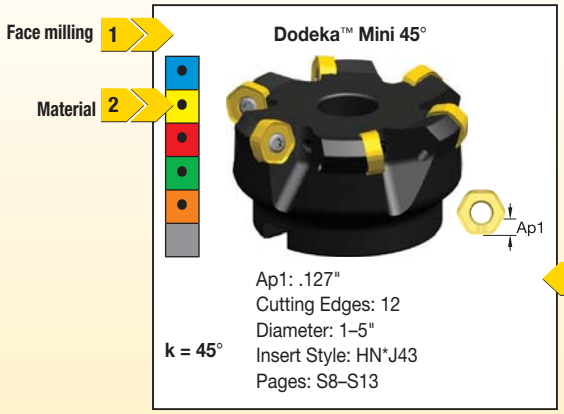
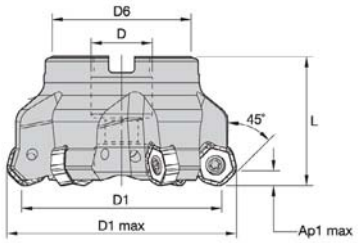
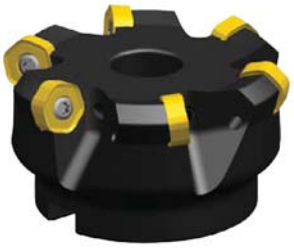
How to Navigate the 2018 Catalog *(continued)*

Step 4 • Select Milling Cutter from Application Selector



Select the Cutter





Dodeka Mini 45° • Shell Mills

order number	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	lbs	max RPM
4130426	KSHR150HN4345M3	1.500	1.822	.500	1.440	1.575	.127	4	.57	16700
4130427	KSHR150HN4345F3	1.500	1.822	.500	1.440	1.575	.127	5	.56	16700
4130428	KSHR200HN4345C3	2.000	2.321	.750	1.750	1.575	.127	4	.93	12500
4130429	KSHR200HN4345M3	2.000	2.321	.750	1.750	1.575	.127	5	.93	12500
4130430	KSHR200HN4345F3	2.000	2.321	.750	1.750	1.575	.127	6	.97	12500
4130431	KSHR250HN4345C3	2.500	2.821	.750	1.750	1.575	.127	4	1.20	10000
4130432	KSHR250HN4345M3	2.500	2.821	.750	1.750	1.575	.127	6	1.27	10000
4130493	KSHR250HN4345F3	2.500	2.821	.750	1.750	1.575	.127	8	1.29	10000

4

Step 5 • Insert Selection Guide

Insert Selection Guide

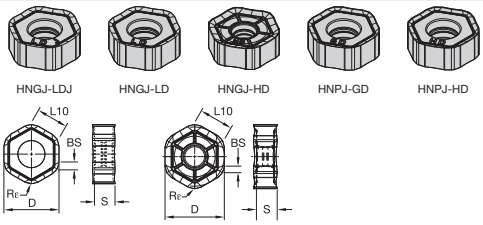
Material Group	Light Machining (Light geometry) wear resistance		General Purpose		Heavy Machining (Strong geometry) toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1 – P2	.E..LD	KCPM40	.S..GD	KCPM40	.S..HD	KCPM40
P3 – P4	.E..LD	KCPK30	.S..GD	KCPK30	.S..HD	KCPK30
P5 – P6	.E..LD	KC725M	.S..GD	KC725M	.S..HD	KCPK30
M1 – M2	.E..LD	KCS22M	.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	KCS20M	.S..GD	KCS20M	.S..HD	KCS20M
N1 – N2	.F..LDJ	KC410M	.F..LDJ	KC410M	.E..LD	KCS10M
N3	.F..LDJ	KC410M	.F..LDJ	KC410M	.E..LD	KCS10M
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	KCS10M	.E..LD	KCS10M	.E..LD	KCS10M

5

(continued)

How to Navigate the 2018 Catalog *(continued)*

Step 6 • Insert Chart, Providing the Inserts and Grades



HNPJ-GD

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ43ANSNGD	.472	.057	.254	.039	.175	.003	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 [IPT]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.F..LDJ	.005	.010	.019	.004	.007	.014	.003	.006	.012	.003	.006	.012	.003	.006	.011	.F..LDJ
.E..LD	.005	.014	.029	.004	.011	.021	.003	.009	.019	.003	.009	.017	.003	.008	.017	.E..LD
.S..GD	.010	.022	.038	.007	.016	.028	.006	.014	.024	.006	.013	.022	.006	.013	.022	.S..GD
.S..HD	.010	.024	.039	.007		.029	.006	.015	.025	.006	.014	.023	.006	.014	.023	.S..HD

7

NOTE: Use "Light Machining" values as starting feed ra

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 [SFM]

8

Material Group		SC6525			SP4019			SP6519			KCSM30			KCSM40			X400		
P	1	1460	1000	560	1245	900	560	1165	855	510	1460	1265	1180	–	–	–	1015	755	475
	2	1280	885	475	1085	785	475	1015	755	460	1200	1065	870	–	–	–	900	675	410
	3	1150	785	410	970	690	410	900	655	395	1115	950	770	–	–	–	785	590	375
	4	820	575	310	755	525	310	690	490	295	985	805	655	–	–	–	590	425	280
	5	625	475	310	590	425	280	560	410	280	805	755	655	675	575	475	–	–	–
	6	560	395	230	510	360	195	475	330	195	720	560	425	590	425	310	–	–	–
M	1	785	705	560	1100	785	475	1065	770	460	885	785	720	820	675	560	–	–	–
	2	755	625	475	985	705	425	920	675	410	805	705	575	705	575	475	–	–	–
	3	575	510	360	785	575	360	770	560	330	605	525	410	575	425	330	–	–	–
K	1	1540	1065	575	1295	950	575	1165	870	560	–	–	–	–	–	–	–	–	–
	2	1200	820	460	1000	720	460	950	690	425	–	–	–	–	–	–	–	–	–
	3	–	–	–	920	675	410	870	625	395	–	–	–	–	–	–	–	–	–
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.

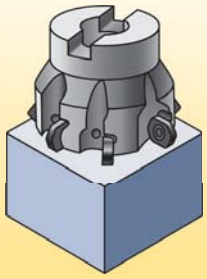
Choose the Application

- 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 • High-Feed



Ap1: .064"
Cutting Edges: 12
Diameter: 1–3"
Insert Style: HN*J43
k = 75° Pages: S4–S7

Dodeka™ Mini 45°



Ap1: .127"
Cutting Edges: 12
Diameter: 1–5"
Insert Style: HN*J43
k = 45° Pages: S8–S13

Dodeka™ Mini 30°



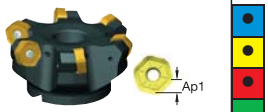
Ap1: .174"
Cutting Edges: 12
Diameter: 1.5–5"
Insert Style: HN*J43
k = 30° Pages: S14–S16

Dodeka™ • High Feed • 75°



Ap1: .087"
Cutting Edges: 12
Diameter: 2–6"
Insert Style: HN*J535
k = 75° Pages: S17–S19

Dodeka™



Ap1: .178"
Cutting Edges: 12
Diameter: 2–12"
Insert Style: HN*J535
k = 45° Pages: S20–S23

Dodeka MAX™



Ap1: .315"
Cutting Edges: 12
Diameter: 3–12"
Insert Style: HN*J75
k = 45° Pages: S24–S26

Mill 16™



Ap1: .217"
Cutting Edges: 16
Diameter: 2–10"
Split case: 12–20"
Insert Style: ON*X64
k= 46.5° Pages: S30–S34

KSSM™ 45°



Ap1: .260"
Cutting Edges: 4
Diameter: 1.26–7.87"
Insert Style: SE*T443
k= 45° Pages: S39–S41

KSOM™ Mini



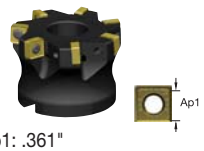
Ap1: .138" (8 cutting edges)
Ap2: .354" (4 cutting edges)
Diameter: 1.25–6"
Insert Style: OF*T53
k = 47° Pages: S44–S48

KSOM™



Ap1: .197" (8 cutting edges)
Ap2: .461" (4 cutting edges)
Diameter: 2.5–6"
Insert Style: OF*T64
k = 47° Pages: S50–S53

KSSM8+™ • IC10



Ap1: .361"
Cutting Edges: 8
Diameter: 2–4"
Insert Style: SN*J31
k= 2° Pages: S56–S57

KSSM8+ • IC12



Ap1: Ap1: .236" (-ENLD)
Ap1: .467" (-SNGD)
Cutting Edges: 8
Diameter: 2–6"
Insert Style: SN*J44
k= 3° Pages: S58–S60

Fix-Perfect™ 20° • Cast Iron • IC12



Ap1: .232" (8 cutting edges)
Ap2: .374" (4 cutting edges)
Diameter: 2–10"
Insert Style: SPHX1205
k = 20° Pages: S64–S66

Fix-Perfect™ 0° • Cast Iron • IC12



Ap1: .236" (8 cutting edges)
Ap1: .394" (4 cutting edges)
Diameter: 2–6"
Insert Style: SPHX1205
k = 0° Pages: S67–S69

Fix-Perfect™ 20° • Cast Iron • IC15



Ap1: .256" (8 cutting edges)
Ap2: .374" (4 cutting edges)
Diameter: 2–10"
Insert Style: SPHX15T6
k = 20° Pages: S70–S72

(continued)

(Face Mills Application Selection Guide — continued)

HexaCut™ 45° • Cast Iron



Ap1: .256"
Cutting Edges: 12
Diameter: 3.15–12"
Insert Style: HN*535
k = 45° Pages: S77–S80

HexaCut™ 30° • Cast Iron



Ap1: .315"
Cutting Edges: 12
Diameter: 3.15–12"
Insert Style: HN*535
k = 30° Pages: S82–S83

KSSR™ 6°



Ap1: .197"
Cutting Edges: 8
Diameter: 2.5–10"
Insert Style: SNXF43
k = 6° Pages: S88–S90

MEGA 45° • Heavy Duty



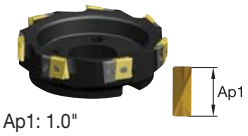
Ap1: .675"
Cutting Edges: 4
Diameter: 5–12"
Insert Style: LNPU86
k = 45° Pages: S94–S95

MEGA 60 • Heavy Duty



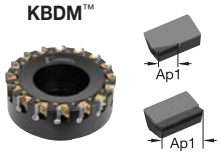
Ap1: .840"
Cutting Edges: 4
Diameter: 5–12"
Insert Style: LNPU76
k = 30° Pages: S98–S99

MEGA 90 • Heavy Duty



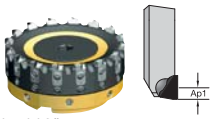
Ap1: 1.0"
Cutting Edges: 4
Diameter: 5–12"
Insert Style: LNPU76
k = 0° Pages: S100–S101

KBDM™



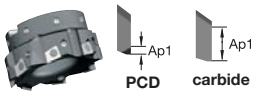
Ap1: 0.100/0.250/0.500"
Cutting Edges: 1
Diameter: 2.5–8"
Insert Style: KSDR10
Pages: S104–S106

KSCM™ AluMill™



Ap1: .118"
Cutting Edges: 1
Diameter: 2.5–12"
k = 0° Pages: S109–S111

Fix-Perfect™ 0° • Aluminum

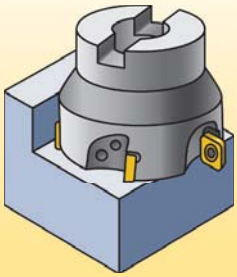


Ap1: .205" (PCD)
Ap1: .374" (carbide)
Cutting Edges: 4
Diameter: 1.5–8"
Insert Style: BGHX15L5
k = 0° Pages: S121–S125

● 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: .433"
Cutting Edges: 4
Diameter: .625–3"
Insert Style: LN*U43
Pages: T4–T10

k = 0°

Mill 4-15™



Ap1: .610"
Cutting Edges: 4
Diameter: 1–6"
Insert Style: LN*U54
Pages: T14–T20

k = 0°

Mill 1-7™



Ap1: .275"
Cutting Edges: 2
Diameter: .500–.745"
Insert Style: EP07
Pages: T24–T25

k = 0°

Mill 1-10™



Ap1: .396"
Cutting Edges: 2
Diameter: .500–4.00"
Insert Style: EC10
Pages: T29–T37

k = 0°

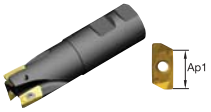
Mill 1-10™ Helical



Ap1: .70–1.80"
Cutting Edges: 2
Diameter: .750–2.00"
Insert Style: EC10
Pages: T40–T47

k = 0°

Mill 1-14™



Ap1: .551–.580"
Cutting Edges: 2
Diameter: .625–4.00"
Insert Style: EC14
Pages: T49–T59

k = 0°

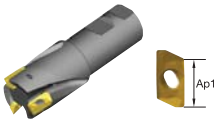
Mill 1-14™ Helical



Ap1: 1.10–2.13"
Cutting Edges: 2
Diameter: 1.25–2.50"
Insert Style: EC14
Pages: T63–T70

k = 0°

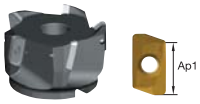
Mill 1-18™



Ap1: .64–.71"
Cutting Edges: 2
Diameter: .97–8.00"
Insert Style: EC18
Pages: T75–T85

k = 0°

Mill 1-25™



Ap1: .98"
Cutting Edges: 2
Diameter: 1.50–5.00"
Insert Style: KG25
Pages: T89–T93

k = 0°

5720VZ16



Ap: .630"
Cutting Edges: 2
Diameter: 1–3"
Insert Style: ZDET16M5
Pages: T96–T100

k = 0°

KSSM™ 0° IC 10



Ap1: .259"
Cutting Edges: 4
Diameter: .750–3.0"
Insert Style: SP*T31
Pages: T107–T112

k = 0°

KSSM™ 0° IC 12



Ap1: .361"
Cutting Edges: 4
Diameter: 2.00–10.00"
Insert Style: SD*T43
Pages: T113–T117

k = 0°

KSSM™ • Helical 0° IC 12



Ap1: 1.691–4.110"
Cutting Edges: 4
Diameter: 2.00–3.00"
Insert Style: SD*T43
Pages: T119–T124

k = 0°

5230VS09



Cutting Edges: 4
Diameter: 2"
Insert Style: SD*T09
Pages: T127–T130

k = 0°

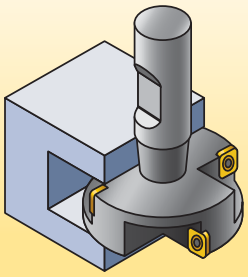
5230VS12



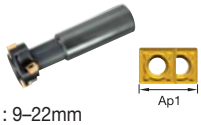
Cutting Edges: 4
Diameter: 2–4"
Insert Style: SDHT1204/
SDMW1204
Pages: T131–T133

k = 0°

Slotting



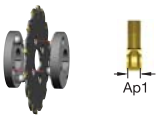
KTMS™ Slotting Cutter



k = 0°

Ap1: 9–22mm
Cutting Edges: 4
Diameter: 21–50mm
Insert Style: SDMT
Pages: U3–U4

KVNS™ A2™ Slotting Cutters



k = 0°

Ap1: .063–.245"
Cutting Edge: 1
Diameter: 2.5–10"
Pages: U7–U10

0° SN Slotting Cutters



k = 0°

B min: .161–.187"
Cutting Edges: 4
Diameter: 3–6"
Insert Style: SNHX
Pages: U13–U15

0° LN Slotting Cutters



k = 0°

B min: .250–.500"
Cutting Edges: 4
Diameter: 2.5–8"
Insert Style: LNEU/LNEQ
Pages: U17–U22

KSSM™ Slotting Cutters • IC 10



k = 0°

B min: .551–.709"
Cutting Edges: 4
Diameter: 4–12"
Insert Style: SP*T10T3
Pages: U25–U31

KSSM™ Slotting Cutters • IC 12



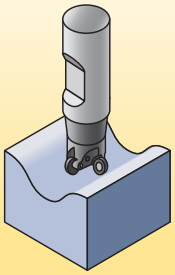
k = 0°

B min: .709–.917"
Cutting Edges: 4
Diameter: 5–12"
Insert Style: SD*T1204
Pages: U32–U40

● 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



Ap1: .035"
Cutting Edges: 4
Diameter: .625–1.250"
Insert Style: XP*T0603
Pages: V4–V8

7792VXD09



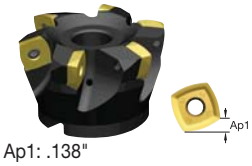
Ap1: .059"
Cutting Edges: 4
Diameter: 1–2"
Insert Style: XD*T0904
Pages: V9–V16

7792VXD12



Ap1: .098"
Cutting Edges: 4
Diameter: 1.25–6.3"
Insert Style: XD*T1205
Pages: V17–V24

7792VXE16



Ap1: .138"
Cutting Edges: 4
Diameter: 1.5–6"
Insert Style: XE*1605
Pages: V25–V29

KenFeed™ 2X Series



Ap1: .059"
Cutting Edges: 6
Diameter: 1–3"
Insert Style: WOEJ09
Pages: V36–V40

HF

Rodeka™ 10



Ap1: .200"
Cutting Edges: 8
Diameter: 1–2"
Insert Style: RN*J10
Pages: V44–V50

Rodeka™ IC12



Ap1: .117"/.236"
Cutting Edges: 12/8
Diameter: 1.25–4"
Insert Style: RN*J12
Pages: V51–V57

Round

Rodeka 16



Ap1: .156"
Cutting Edges: 12
Diameter: 1.5–5"
Insert Style: RN*J16
Pages: V58–V60

Rodeka 12X



Ap1: .236"
Cutting Edges: 8
Diameter: 1.575–3.15"
Insert Style: RNGJ12
Pages: V62–V64

KSRM™ • IC12



Ap1: .236"
Diameter: 1.25–4"
Insert Style: RP*T1204
Pages: V68–V73

Round

KSRM™ • IC16



Ap1: .315"
Diameter: 1.5–6"
Insert Style: RP*T1605
Pages: V75–V79

Round

KSRM™ • IC 1/2"



Ap1: .250"
Diameter: 1.25–3"
Insert Style: RP*T43
Pages: V81–V85

Round

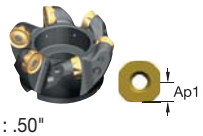
KSRM™ • IC 3/4"



Ap1: .375"
Diameter: 2–8"
Insert Style: RCGT64
Pages: V87–V90

Round

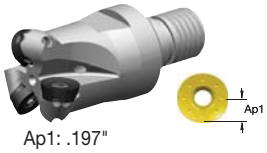
KSRM™ • IC 1.0"



Ap1: .50"
Diameter: 3–8"
Insert Style: RCGT86
Pages: V91–V93

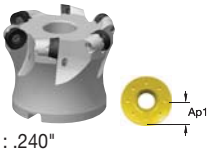
Round

7713VR10



Ap1: .197"
Diameter: 1–2.5"
Insert Style: RP*10
Pages: V97–V101

7713VR12



Ap1: .240"
Diameter: 1–3"
Insert Style: RP*12
Pages: V102–V107

(continued)

(Copy Mills Application Selection Guide — continued)

5505VX



Ap1: .625-2"
Diameter: .625-2"
Insert Style: XPNT
Pages: V111–V118

Ball Nose End Mills • KDMB™



Ap1: .125–.625"
Diameter: .25–1.25"
Insert Style: KDMB
Pages: V121–V131

KDMT™ High Feed



Ap1: up to .04"
Diameter: .5–.75"
Insert Style: KDMT
Pages: V132–V135

HF

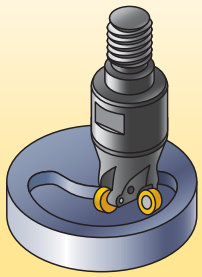
Z-Axis Plunge Mill



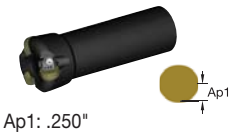
Ap1: .433"
Diameter: 1.25–6"
Insert Style: SD*T43
Pages: V139–V143

k = 1.5°

Ceramic Mills



KCRA



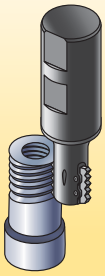
Ap1: .250"
Diameter: 1.5–3"
Insert Style: RNGN43
Pages: V148–V151

KIPR



Ap: .249"
Diameter: .625–1.5"
Insert Style: RPG2150/
RPG32/RPG43
Pages: V155–V159

Thread Mills



Indexable Thread Mills • Parallel and Conical Threads



Inserts: TM24, TM25, TM40, TM41
Diameter: .450–2.320"
Pages: W4–W27

KTMD U Series



Diameter: 580–2.090"
Pages: W29–W37

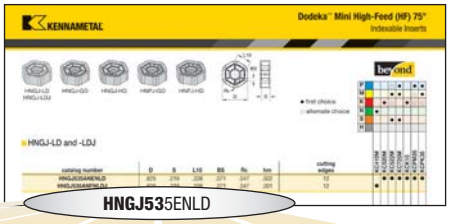
TMS Thread Milling System



Diameter: .354–1.811"
Mini Shank: STN10
Normal Shank: STN11, STN16, STN27
Long Shank: STN16, STN27
Pages: W39–W47

How Do Catalog Numbers Work?

Each character in our catalog number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



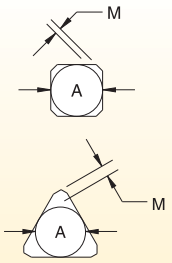
H — Insert Shape

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	

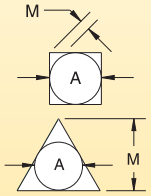
N — Insert Clearance Angle

A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°

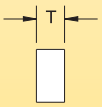
G — Tolerance Class



Indexable inserts with facets/wipers



Indexable inserts with corner radii



Insert thickness

J — Geometry and Clamping Type

5 — Size

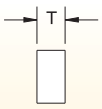
A	symbol
1.000	8
.750	6
.625	5
.500	4
.375	3
.250	2



inscribed circle "A"

For shapes A, L, and X, see position #1; use length of leading cutting edge in increments of 1/4".

3 — Thickness



insert thickness

T	in 1/16"
.0938	1.5
.125	2
.1562	2.5
.1875	3
.2188	3.5
.2500	4
.3125	5

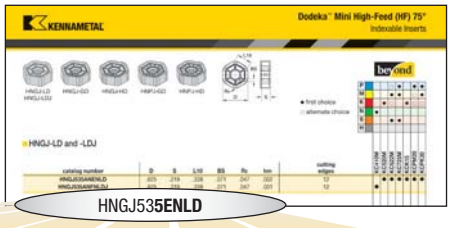
tolerance class	tolerance on "A"	tolerance on "M"	tolerance on "T"	tolerance class	tolerance on "A"	tolerance on "M"	tolerance on "T"
A	.001	.0002	.001	J	.002–.005*	.0002	.001
B	.001	.0002	.005	K	.002–.005*	.0005	.001
C	.001	.0005	.001	L	.002–.005*	.001	.001
D	.001	.0005	.005	M	.002–.005*	.003–.008*	.005
E	.001	.001	.001	N	.002–.005*	.003–.008*	.001
F	.0005	.0002	.001	P**	.0015	.0015	.0015
G	.001	.001	.005	U	.003–.010*	.005–.015*	.005
H	.0005	.0005	.001	—	—	—	—

*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
.1875–.3937	.002	.003	.003	.005
.4375–.5625	.003	.005	.005	.008
.5906–.8125	.004	.007	.006	.011
.8661–1.188	.005	.010	.007	.015
1.250–1.378	.006	.010	.008	.015

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.



5	E	N	–	L	D	
Corner Configuration	Cutting Edge Form	Insert Hand	Facet Width	Edge Prep Size	Rake Face Angle	Added Info

Cutting Edge Form

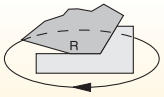
F Sharp

E Honed

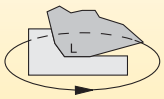
T T-land

S Honed T-land

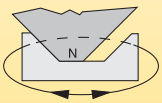
Insert Hand



direction of cutter rotation



direction of cutter rotation



direction of cutter rotation

Facet Width

.0312	2
.0469	3
.0625	4
.0938	6

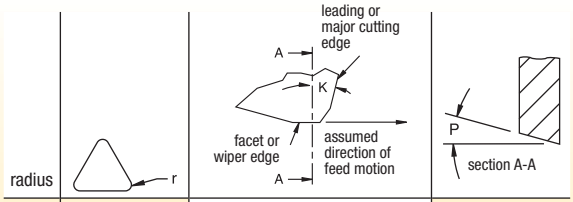
Facet width is number of 1/64" increments (1/32" for old styles).

Edge Prep Size

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

Added Info

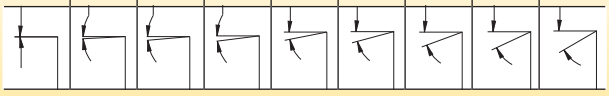
J = Polished rake face
P = Partial T-land
W = Wiper/radiused facet



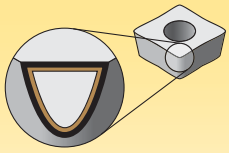
radius				wiper edge clearance P	
0	.004	If letter is replaced by number(s), refer to table for radius "r".		A	3°
0.5	.008			B	5°
1	1/64			C	7°
2	1/32	lead angle K		D	15°
3	3/64	A	45°	E	20°
4	1/16	D	handed 30°	F	25°
5	5/64	K	neutral 30°	G	30°
6	3/32	E	handed 15°	N	0°
7	7/64	L	neutral 15°	P	11°
8	1/8	P	0°		

Rake Face Angle

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.

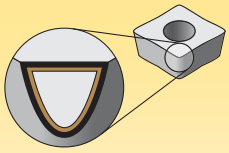


Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

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 aluminum 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. GH is suitable for machining of aluminum 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	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	K, N						
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	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 aluminum with <10% silicon and other non-ferrous materials.	N	N	N						



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

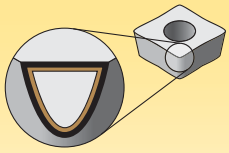
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

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 aluminum <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 aluminum 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 mold 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.

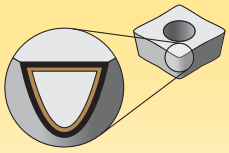
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

Preferred grade.

wear resistance ← → toughness

Grades

Coating	Grade Description		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 mold 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 maximize 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 maximize productivity wherever strength and reliability are needed.	K									



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

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M	Stainless Steel
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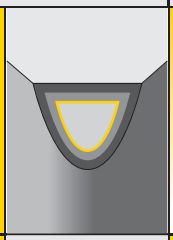
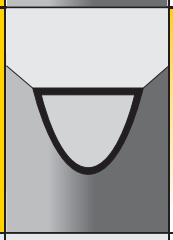
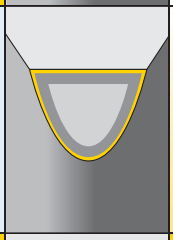
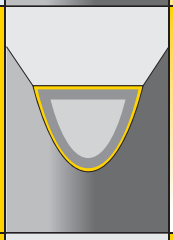
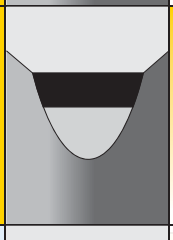
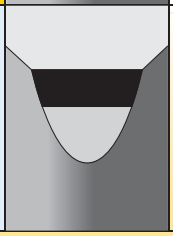
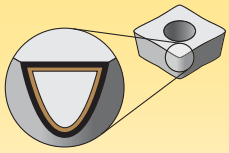
S	High-Temp Alloys
H	Hardened Materials

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					■	■	■	■	
			K					■	■	■	■	
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					■	■	■	■	
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					■	■	■		
			S				■	■	■	■		
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.	M					■	■	■	■	
			S					■	■	■	■	
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.	N	■	■	■						
KD1410		A PCD-tip brazed to carbide for machining aluminum with a very high silicon content, abrasive non-ferrous materials, and fiber-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.	N		■	■						

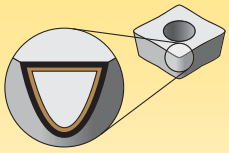


Coatings provide high-speed capability and are engineered for finishing to heavy roughing.

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

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 aluminum 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 aluminum 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 gray 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
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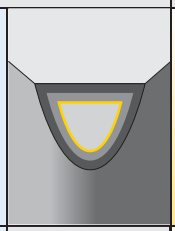
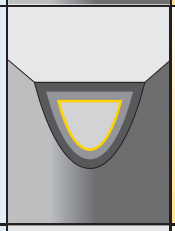
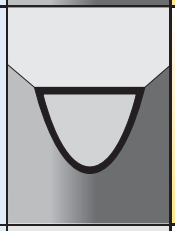
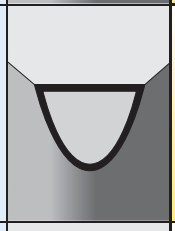
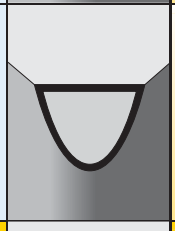
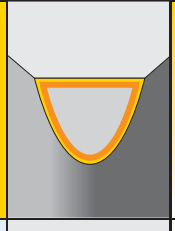
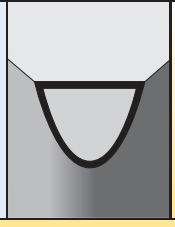
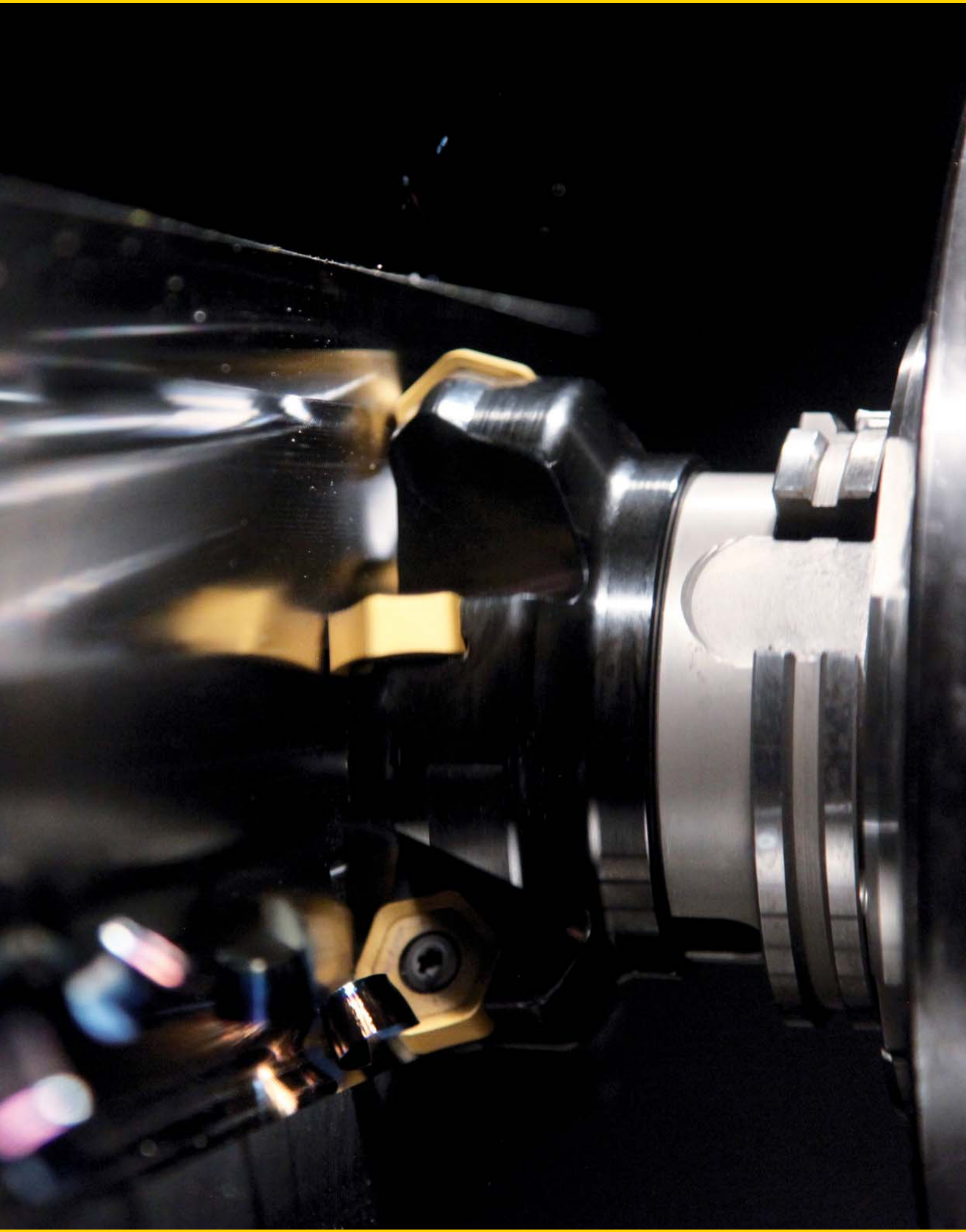
S	High-Temp Alloys
H	Hardened Materials

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–S26

Mill 16 • 16-Edged Inserts for Machining Cast Iron Materials S28–S35

KSSM 45° • Conventional Machining S38–S41

KSOM Mini • KSOM • Best in Class-Free Cutting Face Mills S42–S53

KSSM8+ • 8-Edged Double-Sided Face Mills with Lead Angle Close to 0° S54–S60

Fix-Perfect • Cast Iron Rougher and Finisher S62–S73

HexaCut Series • Machining Automotive Components S74–S84

KSSR • Cast Iron • Roughing and Finishing 6° Lead S86–S90

MEGA 45 • For True Heavy-Duty Machining S92–S95

MEGA 60/90 • For True Heavy-Duty Machining S96–S101

KBDM • PCD Face Milling S102–S107

KSCM AluMill S108–S118

Fix-Perfect Aluminum S120–S126

Dodeka™ Series

Leader in Advanced Face Milling Applications

Primary Application

Dodeka Mini, Dodeka, and Dodeka MAX™ platform face milling boosters 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

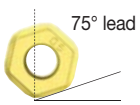
Dodeka Series • Most comprehensive face milling platform on the market. Providing an excellent cost-per-cutting edge with market leading performance. The Dodeka Series platform will cover all your face milling application needs.

All cutter body variations can be loaded with one insert style.

Dodeka Mini High-Feed 75°
Dodeka High-Feed 75°



12 True Cutting Edges



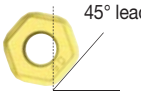
Dodeka Mini	**Ap1 max = .065"**
Dodeka	**Ap1 max = .087"**

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



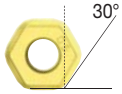
Dodeka Mini	**Ap1 max = .127"**
Dodeka	**Ap1 max = .178"**
Dodeka MAX	**Ap1 max = .315"**

Best-in-class leader in face milling up to Ap1 max = .315".

Dodeka Mini 30°



12 True Cutting Edges



Dodeka Mini	**Ap1 max = .171"**

Achieve a higher axial depth-of-cut capability up to Ap1 = .174" with standard Dodeka Mini inserts.



Dodeka™ Mini Series

insert size HN.J43
Ap1 max = .171"
pages S4–S16



Dodeka

insert size HN.J535
Ap1 max = .178"
pages S17–S23

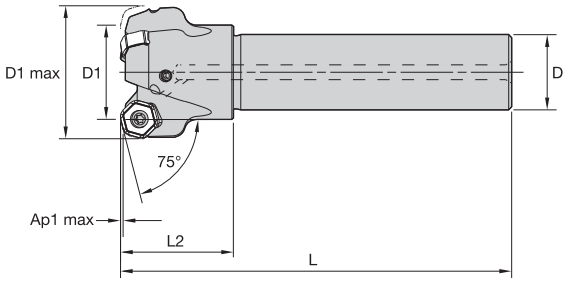


Dodeka MAX™

insert size HN.J75
Ap1 max = .315"
pages S24–S26

P M K N S **Applicable in most material groups • Excellent results in machining titanium**

- High-feed capability.
- .06" depth-of-cut capability.
- Twelve cutting edges per insert.





Dodeka Mini High-Feed 75° • Cylindrical End Mills

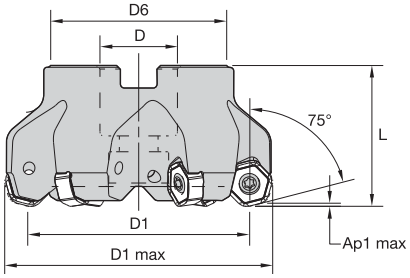
order number	catalog number	D1	D1 max	D	L	L2	Ap1 max	Z	lbs	max RPM
4136407	**KSHRHF100D02C075HN43L480**	1.000	1.518	.750	4.800	1.250	.064	2	.73	19800
4136408	**KSHRHF100D03C075HN43L480**	1.000	1.518	.750	4.800	1.250	.064	3	.69	19800
4136410	**KSHRHF125D04C100HN43L520**	1.250	1.768	1.000	5.200	1.500	.065	4	1.28	17600

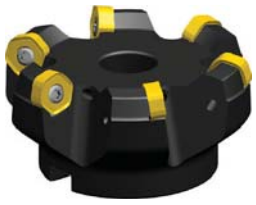
Spare Parts

D1	insert screw	in. lbs.	wrench
1.000	**193.492**	31	**170.025**
1.250	**193.492**	31	**170.025**

- Twelve cutting edges per insert.
- High-feed capability.







Dodeka Mini High-Feed 75° • Shell Mills

order number	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	lbs	max RPM
4136411	KSHRHF150HN43F3	1.500	2.018	.750	1.750	1.575	.065	5	.75	16700
4136412	KSHRHF200HN43M3	2.000	2.517	.750	1.750	1.575	.065	5	1.10	12500
4136413	KSHRHF250HN43M3	2.500	3.017	.750	1.750	1.575	.065	6	1.49	10000
4136414	KSHRHF300HN43M4	3.000	3.517	1.000	2.189	1.750	.065	8	2.21	8300

Spare Parts

D1	 insert screw	 in. lbs.	 wrench	 socket-head cap screw
1.500	193.492	31	170.025	S445
2.000	193.492	31	170.025	S445
2.500	193.492	31	170.025	S445
3.000	193.492	31	170.025	S458



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.

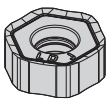
Insert Selection Guide

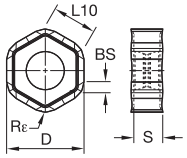
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄———	———►	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPM40	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPK30
P5–P6	.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 aluminum.

● first choice
○ alternate choice


HNGJ-LDJ

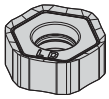


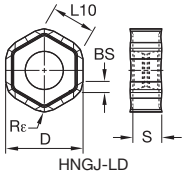
HNGJ-LDJ

HNGJ-LDJ

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ43ANFNLDJ	.472	.060	.254	.039	.176	.001	12	●	●	–	–	–	–	–	–	–	–

- First choice for light machining.


HNGJ-LD



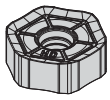
HNGJ-LD

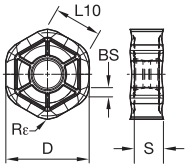
HNGJ-LD

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ43ANENLD	.472	.060	.254	.039	.176	.002	12	–	–	●	●	●	●	●	●	●	–
HNGJ438ANENLD	.472	—	.253	.126	.177	.002	12	–	–	–	–	–	●	–	●	–	–

Face Milling

• First choice for high-performance heavy roughing.


HNGJ-HD



HNGJ-HD

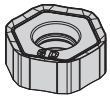
● first choice
○ alternate choice

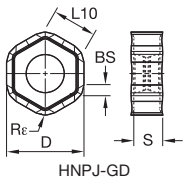
P					○	●		●	●	○
M					●	●		●	○	●
K			●	●	○		●	○		
N	●	●	○							
S					●	●				●
H										

HNGJ-HD

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ43ANSNHD	.472	.057	.254	.039	.173	.006	12	–	–	–	–	●	–	●	●	●	●

• First choice for general purpose.


HNPJ-GD

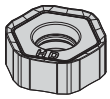


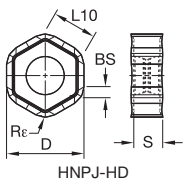
HNPJ-GD

HNPJ-GD

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ43ANSNGD	.472	.057	.254	.039	.175	.003	12	–	–	–	●	●	●	●	●	●	●

• First choice for heavy roughing.


HNPJ-HD



HNPJ-HD

HNPJ-HD

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ43ANSNHD	.472	.057	.254	.039	.173	.006	12	–	–	–	●	●	●	●	●	●	●
HNPJ438ANSNHD	.472	–	.253	.126	.174	.004	12	–	–	–	–	●	●	●	●	●	●

Recommended Starting Feeds

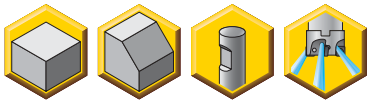
Recommended Starting Feeds [IPT]

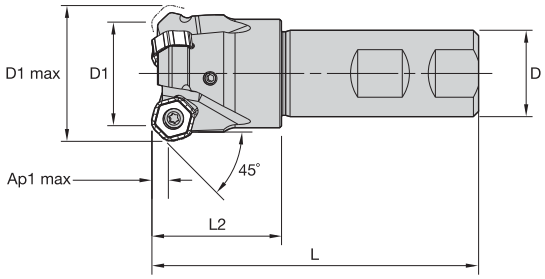
Light Machining	General Purpose	Heavy Machining

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	.018	**.051**	.089	.013	**.036**	.063	.010	**.027**	.047	.008	**.024**	.041	.008	**.022**	.037	.F..LDJ
.E..LD	.020	**.066**	.112	.015	**.047**	.079	.011	**.035**	.058	.010	**.030**	.051	.009	**.028**	.046	.E..LD
.S..GD	.036	**.086**	.132	.026	**.061**	.092	.019	**.045**	.068	.017	**.039**	.059	.015	**.036**	.054	.S..GD
.S..HD	.036	**.093**	.153	.026	**.066**	.106	.019	**.049**	.078	.017	**.042**	.068	.015	**.039**	.062	.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.







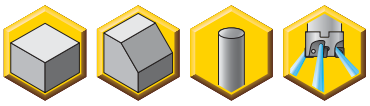
Dodeka Mini 45° • Weldon® End Mills

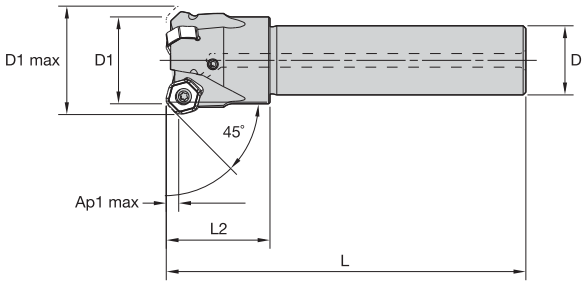
order number	catalog number	D1	D1 max	D	L	L2	Ap1 max	Z	lbs	max RPM
4130514	**KSHR100D02W075HN06**	1.000	1.322	.750	3.280	1.250	.127	2	.46	19800
4130515	**KSHR100D03W075HN06**	1.000	1.322	.750	3.280	1.250	.127	3	.44	19800
4130516	**KSHR125D03W100HN06**	1.250	1.572	1.000	3.780	1.500	.127	3	.88	17600
4130517	**KSHR125D04W100HN06**	1.250	1.572	1.000	3.780	1.500	.127	4	.89	17600

Spare Parts

D1	 insert screw	 in. lbs.	 wrench
1.000	**193.492**	31	**170.025**
1.250	**193.492**	31	**170.025**

- Twelve cutting edges per insert.
- Maximum number of teeth per diameter.
- Productivity booster in all materials.







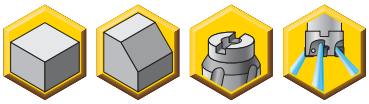
Dodeka Mini 45° • Cylindrical End Mills

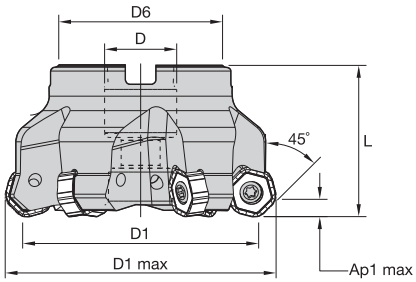
order number	catalog number	D1	D1 max	D	L	L2	Ap1 max	Z	lbs	max RPM
4130518	**KSHR100D02C075HN06L480**	1.000	1.322	.750	4.800	1.250	.127	2	.64	19800
4130519	**KSHR100D03C075HN06L480**	1.000	1.322	.750	4.800	1.250	.127	3	.62	19800
4130533	**KSHR100D03C100HN06L800**	1.000	1.322	1.000	8.000	1.250	.127	3	1.64	19800
4130520	**KSHR125D03C100HN06L520**	1.250	1.572	1.000	5.200	1.500	.127	3	1.19	17600
4130521	**KSHR125D04C100HN06L520**	1.250	1.572	1.000	5.200	1.500	.127	4	1.20	17600

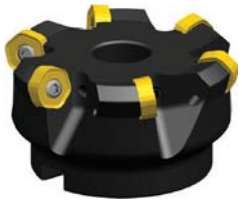
Spare Parts

D1	 insert screw	 in. lbs.	 wrench
1.000	**193.492**	31	**170.025**
1.250	**193.492**	31	**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	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	lbs	max RPM
4130426	**KSHR150HN4345M3**	1.500	1.822	.500	1.440	1.575	.127	4	.57	16700
4130427	**KSHR150HN4345F2**	1.500	1.822	.500	1.440	1.575	.127	5	.56	16700
4130428	**KSHR200HN4345C3**	2.000	2.321	.750	1.750	1.575	.127	4	.93	12500
4130429	**KSHR200HN4345M3**	2.000	2.321	.750	1.750	1.575	.127	5	.93	12500
4130430	**KSHR200HN4345F3**	2.000	2.321	.750	1.750	1.575	.127	6	.97	12500
4130431	**KSHR250HN4345C3**	2.500	2.821	.750	1.750	1.575	.127	4	1.20	10000
4130432	**KSHR250HN4345M3**	2.500	2.821	.750	1.750	1.575	.127	6	1.27	10000
4130493	**KSHR250HN4345F3**	2.500	2.821	.750	1.750	1.575	.127	8	1.29	10000
4130494	**KSHR300HN4345C4**	3.000	3.321	1.000	2.189	1.750	.127	5	1.90	8300
4130495	**KSHR300HN4345M4**	3.000	3.321	1.000	2.189	1.750	.127	8	2.09	8300
4130496	**KSHR300HN4345F4**	3.000	3.321	1.000	2.189	1.750	.127	10	2.07	8300
4130497	**KSHR400HN4345C6**	4.000	4.321	1.500	3.661	1.750	.127	6	3.48	6300
4130498	**KSHR400HN4345M6**	4.000	4.321	1.500	3.661	1.750	.127	9	3.66	6300
4130499	**KSHR400HN4345F6**	4.000	4.321	1.500	3.661	1.750	.127	12	3.62	6300
4130500	**KSHR500HN4345C6**	5.000	5.320	1.500	3.652	2.380	.127	8	6.38	5000
4130501	**KSHR500HN4345M6**	5.000	5.320	1.500	3.652	2.380	.127	12	6.59	5000
4130502	**KSHR500HN4345F6**	5.000	5.320	1.500	3.652	2.380	.127	16	6.70	5000

Spare Parts

D1	insert screw	in. lbs.	wrench	socket-head cap screw	coolant lock screw assembly
1.500	**193.492**	31	**170.025**	**S424**	**–**
2.000	**193.492**	31	**170.025**	**S445**	**–**
2.500	**193.492**	31	**170.025**	**S445**	**–**
3.000	**193.492**	31	**170.025**	**S458**	**–**
4.000	**193.492**	31	**170.025**	**–**	**S2165C**
5.000	**193.492**	31	**170.025**	**–**	**S2163C**

Insert Selection Guide

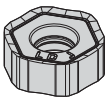
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPM40	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPK30
P5–P6	.E..LD	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

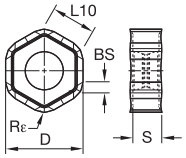
Indexable Inserts

- First choice for machining aluminum.

● first choice
○ alternate choice

		K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P						○	●		●	●	○
M						●	●		●	○	●
K				●	●	○		●	○		
N		●	●	○							
S						●	●				●
H											


HNGJ-LDJ

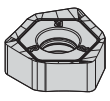


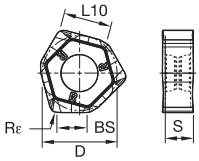
HNGJ-LDJ

HNGJ-LDJ

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ43ANFNLDJ	.472	.060	.254	.039	.176	.001	12	●	●	–	–	–	–	–	–	–	–

- Wiper insert for fine finishing aluminum.


Wiper XNGJ *



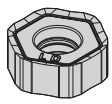
Wiper XNGJ *

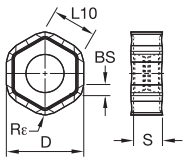
XNGJ-LDJ3W

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
XNGJ43ANFNLDJ3W	.472	.189	.283	.063	.178	.001	3	–	●	–	–	–	–	–	–	–	–

* For wiper insert XNGJ, 3 left-hand (LH) and 3 right-hand (RH) wiper edges per insert.

- First choice for light machining.


HNGJ-LD*



HNGJ-LD*

● first choice
○ alternate choice

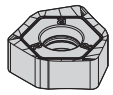
P					○	●		●	●	○
M					●	●		●	○	●
K			●	●	○		●	○		
N	●	●	○							
S					●	●				●
H										

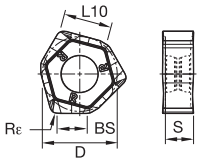
HNGJ-LD

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ43ANENLD	.472	.060	.254	.039	.176	.002	12	–	–	●	●	●	●	●	●	●	–
HNGJ438ANENLD	.472	—	.253	.126	.177	.002	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 *

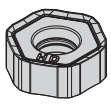


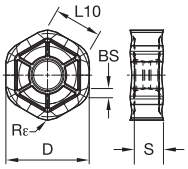
Wiper XNGJ *

XNGJ-LD3W

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
XNGJ43ANENLD3W	.472	.189	.283	.063	.178	.002	3	–	–	●	–	●	●	–	–	●	●

* For wiper insert XNGJ, 3 left-hand (LH) and 3 right-hand (RH) wiper edges per insert.


HNGJ-HD



HNGJ-HD

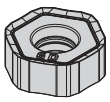
HNGJ-HD

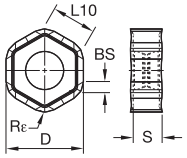
catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ43ANSNHD	.472	.057	.254	.039	.173	.006	12	–	–	–	–	●	–	–	–	●	●

- First choice for general purpose.

● first choice
○ alternate choice

		K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P						○	●		●	●	○
M						●	●		●	○	●
K				●	●	○		●	○		
N		●	●	○							
S						●	●				●
H											


HNPJ-GD

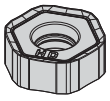


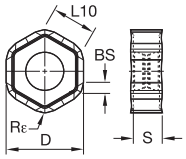
HNPJ-GD

HNPJ-GD

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ43ANSNGD	.472	.057	.254	.039	.175	.003	12	–	–	–	●	●	●	●	●	●	●

- First choice for heavy roughing.


HNPJ-HD



HNPJ-HD

HNPJ-HD

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ43ANSNHD	.472	.057	.254	.039	.173	.006	12	–	–	–	●	●	●	●	●	●	●
HNPJ438ANSNHD	.472	—	.253	.126	.174	.004	12	–	–	–	–	●	●	●	●	●	●

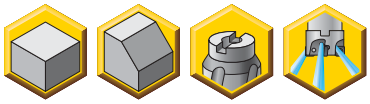
Recommended Starting Feeds [IPT]

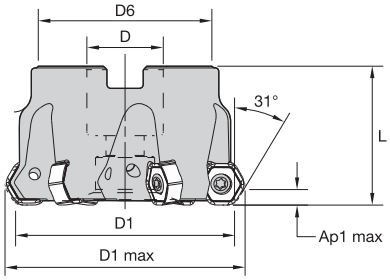
Light Machining	General Purpose	Heavy Machining

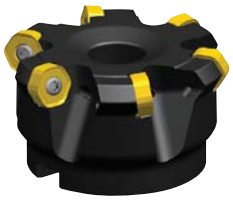
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	.007	**.018**	.032	.005	**.013**	.023	.004	**.010**	.017	.003	**.009**	.015	.003	**.008**	.014	.F..LDJ
.E..LD	.007	**.024**	.040	.005	**.017**	.029	.004	**.013**	.021	.003	**.011**	.019	.003	**.010**	.017	.E..LD
.S..GD	.013	**.031**	.046	.009	**.022**	.033	.007	**.016**	.025	.006	**.014**	.022	.006	**.013**	.020	.S..GD
.S..HD	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.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 30° • Shell Mills

order number	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	lbs	max RPM
4136389	**KSHRHD150HN43M2**	1.500	1.750	.500	1.440	1.575	.171	4	.48	16700
4136390	**KSHRHD150HN43F2**	1.500	1.750	.500	1.440	1.575	.171	5	.48	16700
4136391	**KSHRHD200HN43C3**	2.000	2.250	.750	1.750	1.575	.171	4	.85	12500
4136392	**KSHRHD200HN43M3**	2.000	2.250	.750	1.750	1.575	.171	5	.87	12500
4136394	**KSHRHD250HN43M3**	2.500	2.750	.750	1.750	1.575	.171	6	1.21	10000
4136395	**KSHRHD300HN43C4**	3.000	3.250	1.000	2.189	1.750	.171	5	1.86	8300
4136396	**KSHRHD300HN43M4**	3.000	3.250	1.000	2.189	1.750	.171	8	1.96	8300
4136397	**KSHRHD400HN43C6**	4.000	4.249	1.500	3.661	1.750	.171	6	3.36	6300
4136399	**KSHRHD500HN43C6**	5.000	5.249	1.500	3.652	2.380	.171	8	6.31	5000
4136400	**KSHRHD500HN43M6**	5.000	5.249	1.500	3.652	2.380	.171	12	6.53	5000

Spare Parts

D1	 insert screw	 in. lbs.	 wrench	 socket-head cap screw	 coolant lock screw assembly
1.500	**193.492**	31	**170.025**	**S424**	**–**
2.000	**193.492**	31	**170.025**	**S445**	**–**
2.500	**193.492**	31	**170.025**	**S445**	**–**
3.000	**193.492**	31	**170.025**	**S458**	**–**
4.000	**193.492**	31	**170.025**	**–**	**S2165C**
5.000	**193.492**	31	**170.025**	**–**	**S2163C**

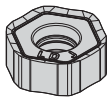
Insert Selection Guide

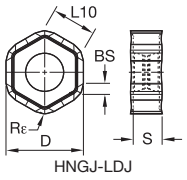
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPM40	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPK30
P5–P6	.E..LD	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 aluminum.

● first choice
○ alternate choice

		K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P						○	●		●	●	○
M						●	●		●	○	●
K				●	●	○		●	○		
N		●	●	○							
S						●	●				●
H											


HNGJ-LDJ

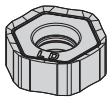


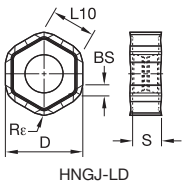
HNGJ-LDJ

HNGJ-LDJ

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ43ANFNLDJ	.472	.060	.254	.039	.176	.001	12	●	●	–	–	–	–	–	–	–	–

- First choice for light machining.

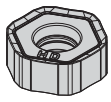

HNGJ-LD

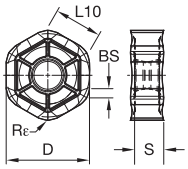


HNGJ-LD

HNGJ-LD

catalog number	D	BS	L10	Rε	S	hm	cutting edges	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ43ANENLD	.472	.060	.254	.039	.176	.002	12	–	–	●	●	●	●	●	●	●	–
HNGJ438ANENLD	.472	–	.253	.126	.177	.002	12	–	–	–	–	–	●	–	●	–	–


HNGJ-HD



HNGJ-HD

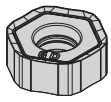
● first choice
○ alternate choice

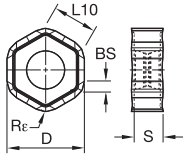
		K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P					○	●	●		●	●	○
M						●	●		●	○	●
K				●	●	○		●	○		
N		●	●	○							
S						●	●				●
H											

HNGJ-HD

catalog number	D	BS	L10	Rε	S	hm	cutting edges
HNGJ43ANSNHD	.472	.057	.254	.039	.173	.006	12

- First choice for general purpose.


HNPJ-GD

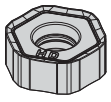


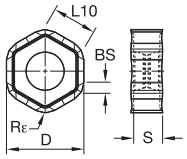
HNPJ-GD

HNPJ-GD

catalog number	D	BS	L10	Rε	S	hm	cutting edges
HNPJ43ANSNGD	.472	.057	.254	.039	.175	.003	12

- First choice for heavy roughing.


HNPJ-HD



HNPJ-HD

HNPJ-HD

catalog number	D	BS	L10	Rε	S	hm	cutting edges
HNPJ43ANSNHD	.472	.057	.254	.039	.173	.006	12
HNPJ438ANSNHD	.472	—	.253	.126	.174	.004	12

Face Milling

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

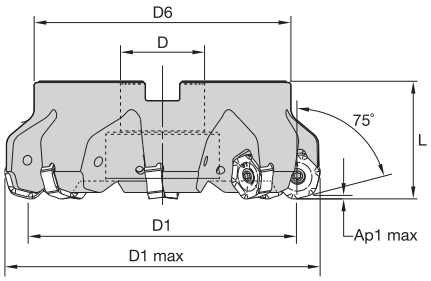
Light Machining	General Purpose	Heavy Machining

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	.005	**.015**	.026	.004	**.011**	.019	.003	**.008**	.014	.003	**.007**	.012	.002	**.006**	.011	.F..LDJ
.E..LD	.006	**.019**	.032	.004	**.014**	.023	.003	**.010**	.017	.003	**.009**	.015	.003	**.008**	.014	.E..LD
.S..GD	.011	**.025**	.038	.008	**.018**	.027	.006	**.013**	.020	.005	**.012**	.018	.005	**.011**	.016	.S..GD
.S..HD	.011	**.027**	.043	.008	**.019**	.031	.006	**.014**	.023	.005	**.013**	.020	.005	**.012**	.018	.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.
- .08" depth-of-cut capability.
- Twelve cutting edges per insert.







Dodeka High-Feed 75° • Shell Mills

order number	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	lbs	max RPM
4047419	KSHRHF200HN5315C3	2.000	2.746	.750	1.750	1.595	.087	4	1.13	11300
4047420	KSHRHF250HN5315C3	2.500	3.245	.750	2.144	1.595	.087	5	1.60	8900
4047421	KSHRHF300HN5315C4	3.000	3.745	1.000	2.346	1.770	.087	6	2.23	7400
4047422	KSHRHF400HN5315C5	4.000	4.744	1.250	3.819	1.770	.087	8	3.91	5800
4047583	KSHRHF500HN5315C6	5.000	5.416	1.500	3.810	2.400	.087	9	6.87	4700
4047584	KSHRHF600HN5315C8	6.000	6.748	2.000	4.880	2.400	.087	12	10.51	4000

Spare Parts



D1	insert screw	in. lbs.	wrench	socket-head cap screw	socket-head cap screw with coolant groove	coolant lock screw	coolant lock screw	coolant shower plate
2.000	193.492	31	170.025	S445	S445CG	–	–	–
2.500	193.492	31	170.025	S445	S445CG	–	–	–
3.000	193.492	31	170.025	S458	S458CG	–	–	–
4.000	193.492	31	170.025	–	–	S2162C	–	–
5.000	193.492	31	170.025	–	–	–	420.201	470.240
6.000	193.492	31	170.025	–	–	–	420.241	470.241

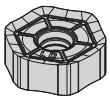
Insert Selection Guide

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	–	–	**–**	**–**	–	–

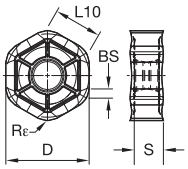
Indexable Inserts

beyond

- First choice for light machining and aluminum.



HNGJ-LD
HNGJ-LDJ



HNGJ-LD
HNGJ-LDJ

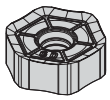
● first choice
○ alternate choice

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

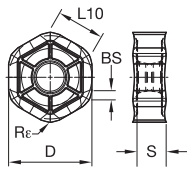
HNGJ-LDJ and -LD

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ535ANFNLDJ	.625	.219	.338	.071	.047	.001	12	●	–	–	–	–	–	–	–	–
HNGJ535ANENLD	.625	.219	.338	.071	.047	.002	12	–	●	●	●	●	●	–	●	–

- First choice for general purpose.



HNGJ-GD



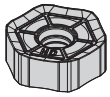
HNGJ-GD

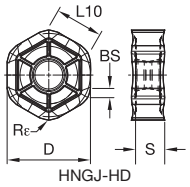
HNGJ-GD

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ535ANSNGD	.625	.219	.338	.071	.047	.004	12	–	–	–	●	●	●	●	●	–

Face Milling

- First choice for heavy roughing.


HNGJ-HD



HNGJ-HD

● first choice
○ alternate choice

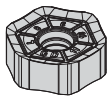
beyond

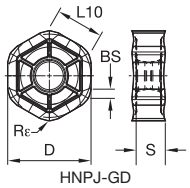
P			○	●		●	●	○	
M			●	●		●	○	●	
K		●	○		●	○			●
N	●								
S			●	●				●	
H									

HNGJ-HD

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ535ANSNHD	.625	.215	.338	.065	.047	.007	12	–	●	–	●	●	●	●	●	–
HNGJ53511ANSNHD	.625	.214	.334	—	.171	.008	12	–	●	–	●	–	●	●	●	–

- First choice for general purpose.


HNPJ-GD

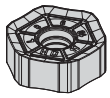


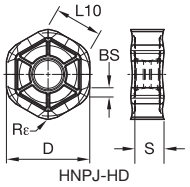
HNPJ-GD

HNPJ-GD

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNPJ535ANSNGD	.625	.219	.338	.071	.047	.004	12	–	●	●	●	●	●	●	–	–

- First choice for heavy roughing.


HNPJ-HD



HNPJ-HD

HNPJ-HD

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNPJ535ANSNHD	.625	.215	.338	.065	.047	.007	12	–	●	●	●	●	●	●	●	–
HNPJ53511ANSNHD	.625	.214	.334	—	.171	.005	12	–	–	●	●	●	●	●	●	–

Recommended Starting Feeds

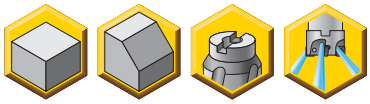
Recommended Starting Feeds [IPT]

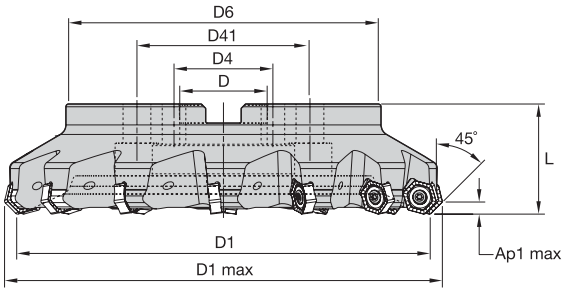
Light Machining	General Purpose	Heavy Machining

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	.018	**.051**	.089	.013	**.036**	.063	.010	**.027**	.047	.008	**.024**	.041	.008	**.022**	.037	.F..LDJ
.E..LD	.025	**.073**	.112	.018	**.052**	.079	.014	**.039**	.058	.012	**.034**	.051	.011	**.031**	.046	.E..LD
.S..GD	.036	**.079**	.129	.026	**.056**	.090	.019	**.042**	.066	.017	**.036**	.058	.015	**.033**	.053	.S..GD
.S..HD	.036	**.093**	.153	.026	**.066**	.106	.019	**.049**	.078	.017	**.042**	.068	.015	**.039**	.062	.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.
- Through-coolant on cutters <4.0" diameter. 5.0" diameter cutters and above do not have through-coolant.
- Soft cutting action.



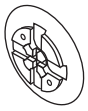




Dodeka 45° • Shell Mills

order number	catalog number	D1	D1 max	D	D4	D41	D6	L	Ap1 max	Z	lbs	max RPM
3326850	KSHR200HN5345C3	2.000	2.434	.750	–	–	1.593	1.570	.178	4	.81	12500
3326851	KSHR200HN5345M3	2.000	2.434	.750	–	–	1.593	1.570	.178	5	.82	12500
3747124	KSHR250HN5345XC3	2.500	2.933	.750	–	–	1.986	1.570	.177	5	1.25	10000
3326852	KSHR250HN5345C3	2.500	2.933	.750	–	–	1.986	1.570	.178	6	1.32	10000
3326923	KSHR250HN5345M3	2.500	2.933	.750	–	–	1.986	1.570	.178	7	1.34	10000
3747125	KSHR300HN5345XC4	3.000	3.433	1.000	–	–	2.189	1.750	.177	5	1.86	8300
3326924	KSHR300HN5345C4	3.000	3.433	1.000	–	–	2.189	1.750	.178	6	1.79	8300
3326925	KSHR300HN5345M4	3.000	3.433	1.000	–	–	2.032	1.750	.178	9	1.97	8300
3747126	KSHR400HN5345XC5	4.000	4.232	1.250	–	–	2.722	1.750	.177	6	3.17	6300
3326926	KSHR400HN5345C5	4.000	4.432	1.250	–	–	2.722	1.750	.178	8	2.93	6300
3326927	KSHR400HN5345M5	4.000	4.432	1.250	–	–	2.722	1.750	.178	11	3.14	6300
3747127	KSHR500HN5345XC6	5.000	5.431	1.500	–	–	3.652	2.380	.177	8	6.20	5000
3326928	KSHR500HN5345C6	5.000	5.431	1.500	–	–	3.652	2.380	.178	10	5.94	5000
3326929	KSHR500HN5345M6	5.000	5.431	1.500	–	–	3.652	2.380	.178	14	6.21	5000
3747128	KSHR600HN5345XC8	6.000	6.432	2.000	–	–	4.722	2.380	.177	10	9.01	4100
3326930	KSHR600HN5345C8	6.000	6.432	2.000	–	–	4.722	2.380	.178	12	9.10	4100
3326931	KSHR600HN5345M8	6.000	6.432	2.000	–	–	4.722	2.380	.178	16	9.36	4100
3494648	KSHR800HN5345C10	8.000	8.432	2.500	4.000	–	5.118	2.380	.177	16	13.14	3130
3494649	KSHR1000HN5345C10	10.000	10.433	2.500	4.000	–	7.120	2.380	.177	20	24.52	2510
3494650	KSHR1200HN5345C10	12.000	12.433	2.500	4.000	7.000	9.016	3.150	.177	24	42.66	2090

Spare Parts

D1	 insert screw	 in. lbs.	 wrench	 socket-head cap screw	 socket-head cap screw with coolant groove	 coolant lock screw	 coolant lock screw assembly	 coolant shower plate
2.000	**193.492**	31	**170.025**	**S445**	**S445CG**	–	–	–
2.500	**193.492**	31	**170.025**	**S445**	**S445CG**	–	–	–
3.000	**193.492**	31	**170.025**	**S458**	**S458CG**	–	–	–
4.000	**193.492**	31	**170.025**	–	–	–	**S2162C**	–
5.000	**193.492**	31	**170.025**	–	–	**420.201**	–	**470.240**
6.000	**193.492**	31	**170.025**	–	–	**420.241**	–	**470.241**
8.000	**193.492**	31	**170.025**	–	–	–	–	**470.242**
10.000	**193.492**	31	**170.025**	–	–	–	–	**470.243**
12.000	**193.492**	31	**170.025**	–	–	–	–	**470.244**

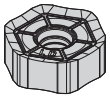
NOTE: Please order all spare parts separately.

Insert Selection Guide

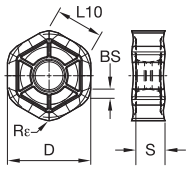
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPK30	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPK30
P5–P6	.E..LD	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	–	–	–	–	–	–

beyond

- First choice for light machining and aluminum.



HNGJ-LD
HNGJ-LDJ



HNGJ-LD
HNGJ-LDJ

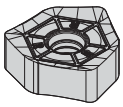
● first choice
○ alternate choice

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

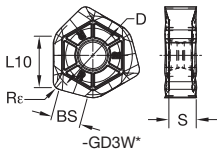
HNGJ-LDJ and -LD

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ535ANFNLDJ	.625	.219	.338	.071	.047	.001	12	●	–	–	–	–	–	–	–	–
HNGJ535ANENLD	.625	.219	.338	.071	.047	.002	12	–	●	●	●	●	●	–	●	–

- Wiper insert for excellent surface floor finish.



-GD3W*



-GD3W*

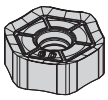
XNGJ-LDJ3W and -GD3W

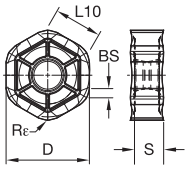
catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
XNGJ535ANFNLDJ3W	.625	.217	.377	.230	.063	.001	3	●	–	–	–	–	–	–	–	–
XNGJ535ANSNGD3W	.625	.217	.377	.230	.063	.004	3	–	–	–	●	●	●	–	●	–

*3 left-hand (LH) and 3 right-hand (RH) wiper edges per insert.

beyond

- First choice for general purpose.


HNGJ-GD



HNGJ-GD

● first choice
○ alternate choice

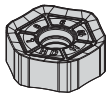
| | | |

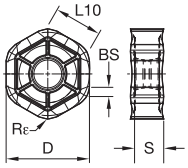
beyond

- First choice for heavy roughing.

● first choice
○ alternate choice

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


HNPJ-HD

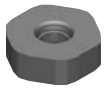


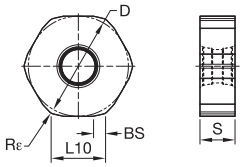
HNPJ-HD

HNPJ-HD

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNPJ535ANSNHD	.625	.215	.338	.065	.047	.007	12	–	●	●	●	●	●	●	●	–
HNPJ53511ANSNHD	.625	.214	.334	—	.171	.005	12	–	–	●	●	●	●	●	●	–

- Ceramic KYON 3500 for machining gray cast iron with high cutting speed.


HNEC-ANSN



HNEC-ANSN

HNEC-ANSN Ceramic Insert

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNEC535ANSN	.625	.219	.361	.077	.047	.008	12	–	–	–	–	–	–	–	–	●

Recommended Starting Feeds

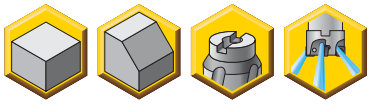
Recommended Starting Feeds [IPT]

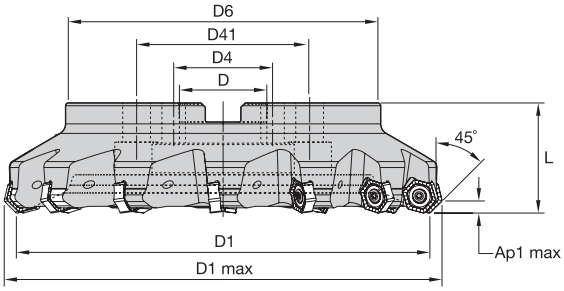
Light Machining	General Purpose	Heavy Machining

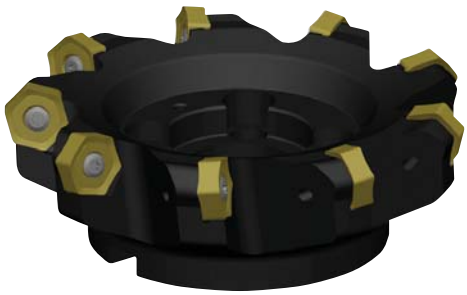
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	.007	**.018**	.032	.005	**.013**	.023	.004	**.010**	.017	.003	**.009**	.015	.003	**.008**	.014	.F..LDJ
.E..LD	.009	**.026**	.040	.007	**.019**	.029	.005	**.014**	.021	.004	**.012**	.019	.004	**.011**	.017	.E..LD
.S..GD	.013	**.028**	.045	.009	**.020**	.032	.007	**.015**	.024	.006	**.013**	.021	.006	**.012**	.019	.S..GD
.S..HD	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.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.



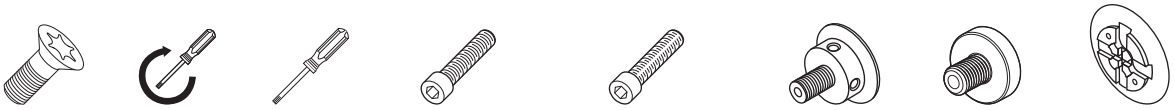




Dodeka MAX 45° • Shell Mills

order number	catalog number	D1	D1 max	D	D4	D6	L	Ap1 max	Z	lbs	max RPM
4057578	**KSHR300HN7545M4**	3.000	3.682	1.000	—	2.188	1.750	.315	4	2.14	8300
4057579	**KSHR400HN7545M5**	4.000	4.682	1.250	—	2.875	1.750	.315	5	3.18	6300
4057580	**KSHR500HN7545M6**	5.000	5.682	1.500	—	3.812	2.375	.315	6	6.40	5000
4057581	**KSHR600HN7545M8**	6.000	6.682	2.000	—	5.000	2.375	.315	9	9.87	4100
4057582	**KSHR800HN7545M10**	8.000	8.682	2.500	4.000	5.000	2.375	.315	12	13.55	3130
4057576	**KSHR1000HN7545C10**	10.000	10.682	2.500	4.000	6.963	2.375	.315	12	25.80	2510
4057583	**KSHR1000HN7545M10**	10.000	10.682	2.500	4.000	6.963	2.375	.315	14	13.55	2510

Spare Parts



D1	insert screw	in. lbs.	Torx Plus wrench	socket-head cap screw	socket-head cap screw with coolant groove	coolant lock screw assembly	coolant lock screw	coolant shower plate
3.000	**193.531**	71	**TTP25**	**S458**	**S458CG**	—	—	—
4.000	**193.531**	71	**TTP25**	—	—	**S2162C**	—	—
5.000	**193.531**	71	**TTP25**	—	—	—	**420.201**	**470.240**
6.000	**193.531**	71	**TTP25**	—	—	—	**420.241**	**470.241**
8.000	**193.531**	71	**TTP25**	—	—	—	—	**470.242**
10.000	**193.531**	71	**TTP25**	—	—	—	—	**470.243**

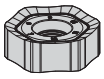
NOTE: Adjustable torque wrench (order number 6197561) and Torx Plus bit (order number 6205892 BTQTP25L90) may be purchased separately in order to ensure proper torque setting.

Insert Selection Guide

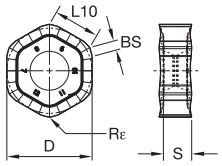
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GD	KCPM40	**.S..GD**	**KCPK30**	.S..HD	KCPM40
P3–P4	.E..GD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPK30
P5–P6	.E..GD	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	KC520M
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

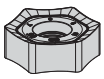
● first choice
○ alternate choice

		KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P			●		●	●	○
M			●		○	○	●
K		●		●	●		
N							
S			●				●
H							

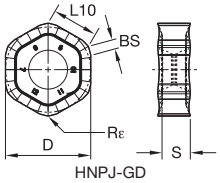
HNGJ-GD

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ75ANENGD	.875	.292	.505	.074	.047	.002	12	–	●	–	●	●	–

- First choice for general purpose.



HNPJ-GD

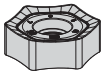


HNPJ-GD

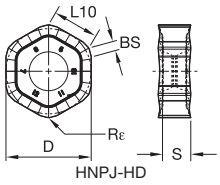
HNPJ-GD

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ755ANSNGD	.875	.296	.505	–	.079	.005	12	●	●	–	●	–	–

- First choice for heavy roughing.



HNPJ-HD



HNPJ-HD

● first choice
○ alternate choice

		KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P			●		●	●	○
M			●		○	○	●
K		●		●	●		
N							
S			●				●
H							

HNPJ-HD

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ75ANSNHD	.875	.288	.505	.074	.047	.010	12	–	●	●	●	●	●
HNPJ755ANSNHD	.875	.292	.505	—	.079	.009	12	–	●	–	●	●	–
HNPJ759ANSNHD	.875	.289	.505	—	.138	.009	12	●	–	●	●	–	–

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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	.009	**.026**	.046	.007	**.019**	.033	.005	**.014**	.025	.004	**.012**	.022	.004	**.011**	.020	.E..GD
.S..GD	.013	**.029**	.050	.009	**.021**	.036	.007	**.016**	.027	.006	**.014**	.023	.006	**.013**	.021	.S..GD
.S..HD	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.S..HD

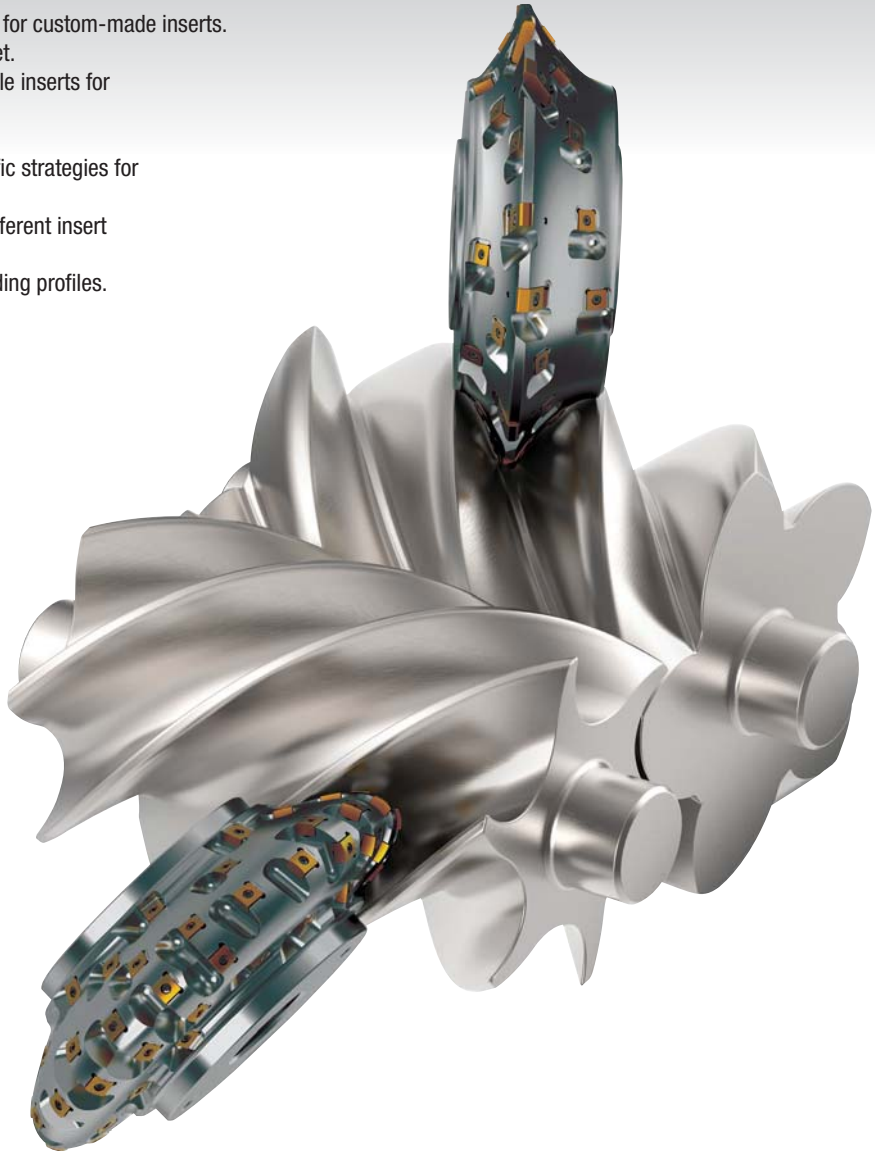
NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

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 standardized processes for custom-made inserts.
- Solutions for all machines currently on the market.
- Very close contour profile with standardized profile inserts for minimum grinding allowance.
- Tools can be used in many different materials.
- Increased productivity through application-specific strategies for optimized 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 Authorized Kennametal Distributor or at **kennametal.com**.

KENNAMETAL®

kennametal.com

Mill 16™

Face Mills for Cast Iron Machining.



Screw-On Clamping



Wedge Clamping

Features

- 16 effective cutting edges per insert.
- Ap1 max = .216" (5,5mm).
- Coarse, medium and fine pitch cutters.
- Cutter bodies with pocket seat numbering system.
- Cutter diameter range = 1.969–9.843" (50–250mm).
- High-precision periphery ground inserts.
- Inserts with cutting edge numbering system.
- Lower cutting forces.
- Clearance on second main cutting edge.

Benefits

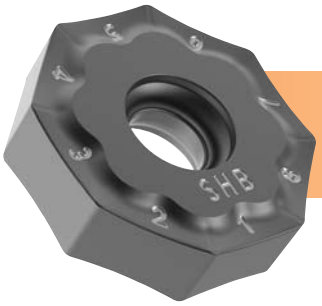
- Low cost per edge to cut cost per part (CPP).
- Perfect fit for most cast iron face milling requirements.
- High feed rates to boost productivity and reduce cycle time.
- Comprehensive standard offering to address most needs of the shop floor.
- Improved axial runout and tool life.
- Very smooth cutting action and lower cutting forces.
- Orientated edge positioning to support axial and radial runout.
- Reliable cutting above Ap1 = .216" (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

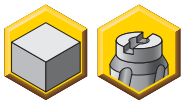


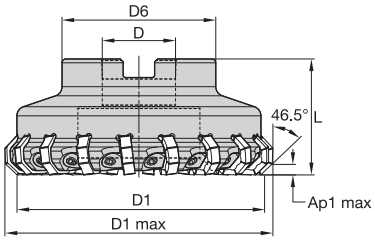


Innovative insert design to reduce cutting forces and increase productivity at lower cost per edge.

- 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	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	lbs	max RPM
6001979	**MILL16E200Z05ON08W**	2.000	2.495	.750	2.000	2.000	.215	5	1.45	11100
6001980	**MILL16E250Z06ON08W**	2.500	2.995	.750	2.000	2.000	.215	6	2.03	9300
6134103	**MILL16E300Z08ON08W**	3.000	3.495	1.000	2.189	1.750	.215	8	2.17	8200
6002121	**MILL16E300Z10ON08W**	3.000	3.495	1.000	2.189	1.750	.215	10	2.06	8200
6134104	**MILL16E400Z10ON08W**	4.000	4.494	1.250	3.150	2.000	.215	10	4.27	6800
6002122	**MILL16E400Z14ON08W**	4.000	4.494	1.250	3.150	2.000	.215	14	4.09	6800
6134105	**MILL16E500Z14ON08W**	5.000	5.494	1.500	3.150	2.375	.215	14	6.55	5900
6002123	**MILL16E500Z18ON08W**	5.000	5.494	1.500	3.150	2.375	.215	18	6.38	5900
6134106	**MILL16E600Z16ON08W**	6.000	6.494	2.000	3.937	2.381	.215	16	8.68	5300
6002124	**MILL16E600Z22ON08W**	6.000	6.494	2.000	3.937	2.381	.215	22	8.39	5300
6134107	**MILL16E800Z20ON08W**	8.000	8.494	2.500	5.118	2.400	.215	20	14.60	4500
6002125	**MILL16E800Z28ON08W**	8.000	8.494	2.500	5.118	2.400	.215	28	14.29	4500
6134108	**MILL16E1000Z24ON08W ***	10.000	10.494	2.500	5.512	2.400	.215	24	22.08	4000
6019339	**MILL16E1000Z34ON08W**	10.000	10.494	2.500	5.512	2.400	.215	34	21.69	4000

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

Spare Parts





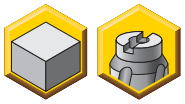


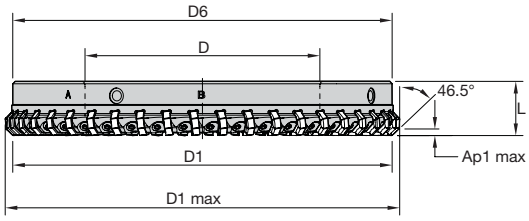


D1	wedge	wedge screw	in. lbs.	wrench	mounting screw with coolant grooves	adjustable torque wrench	bit SW3 for adjustable torque wrench
2.000	**CW16**	**12748601000**	62	**12148044900**	**KLSS0714C**	**DTQ50140**	**BTQSW3L90**
2.500	**CW16**	**12748601000**	62	**12148044900**	**–**	**DTQ50140**	**BTQSW3L90**
3.000	**CW16**	**12748601000**	62	**12148044900**	**–**	**DTQ50140**	**BTQSW3L90**
4.000	**CW16**	**12748601000**	62	**12148044900**	**–**	**DTQ50140**	**BTQSW3L90**
5.000	**CW16**	**12748601000**	62	**12148044900**	**–**	**DTQ50140**	**BTQSW3L90**
6.000	**CW16**	**12748601000**	62	**12148044900**	**–**	**DTQ50140**	**BTQSW3L90**
8.000	**CW16**	**12748601000**	62	**12148044900**	**–**	**DTQ50140**	**BTQSW3L90**
10.000	**CW16**	**12748601000**	62	**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	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	lbs	max RPM
6202190	**MILL16E1200Z42ON08WSC ***	12.000	12.494	7.677	12.000	1.772	.215	42	22.48	3600
6202291	**MILL16E1400Z48ON08WSC ***	14.000	14.494	9.055	14.000	1.772	.215	48	30.97	3300
6202292	**MILL16E1600Z56ON08WSC ***	16.000	16.494	11.024	16.000	1.772	.215	56	37.15	3100
6202293	**MILL16E2000Z70ON08WSC ***	20.000	20.494	14.961	20.000	1.772	.215	70	48.45	2800

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

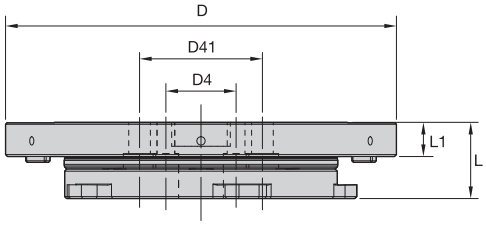
Spare Parts






D1	wedge	wedge screw	in. lbs.	wrench
12.000	**CW16**	**12748601000**	62	**12148044900**
14.000	**CW16**	**12748601000**	62	**12148044900**
16.000	**CW16**	**12748601000**	62	**12148044900**
20.000	**CW16**	**12748601000**	62	**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.





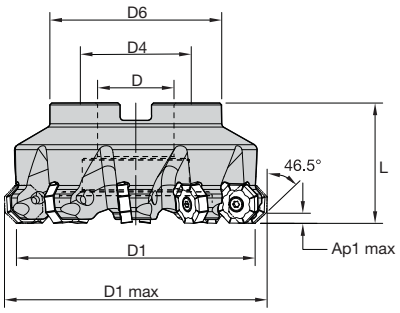
Carrier Flange Assembly

order number	catalog number	D	D4	D41	L1	L	lbs
6152251	**D315CFA ***	12.402	4.000	7.000	1.339	3.071	59.29
6152252	**D355CFA ***	13.976	4.000	7.000	1.378	3.071	81.99
6152253	**D400CFA ***	15.748	4.000	7.000	1.378	3.071	112.34
6152254	**D500CFA ***	19.685	4.000	7.000	1.378	3.071	192.59

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.



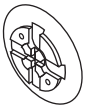




Mill 16 • Screw-On Clamping

order number	catalog number	D1	D1 max	D	D4	D6	L	Ap1 max	Z	lbs	max RPM
6159069	**MILL16E200Z04ON08SC**	2.000	2.498	.750	–	1.969	1.580	.216	4	.90	14500
6159070	**MILL16E250Z04ON08SC**	2.500	2.973	.750	–	1.969	1.576	.220	4	1.29	12200
6159072	**MILL16E300Z05ON08SC**	3.000	3.473	1.000	–	2.362	1.751	.220	5	2.17	10700
6159074	**MILL16E400Z06ON08SC**	4.000	4.473	1.250	–	3.150	2.001	.220	6	4.11	8900
6159076	**MILL16E500Z08ON08SC**	5.000	5.473	1.500	–	3.543	2.376	.220	8	6.85	7700
6159078	**MILL16E600Z10ON08SC**	6.000	6.472	2.000	–	3.937	2.382	.220	10	8.07	7000
6159080	**MILL16E800Z10ON08SC**	8.000	8.472	2.500	4.000	5.118	2.401	.220	10	14.17	5900
6159082	**MILL16E1000Z12ON08SC**	10.000	10.472	2.500	4.000	5.512	2.401	.220	12	23.86	5200

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus wrench	 socket-head cap screw	 socket-head cap screw with coolant groove	 coolant lock screw	 coolant shower plate
2.000	**MS2060**	40	**TTP20**	–	**KLSS0714C**	–	–
2.500	**MS2060**	40	**TTP20**	**S445**	–	–	–
3.000	**MS2060**	40	**TTP20**	**S458**	–	–	–
4.000	**MS2060**	40	**TTP20**	–	–	**420.162**	–
5.000	**MS2060**	40	**TTP20**	–	–	**420.201**	**470.232**
6.000	**MS2060**	40	**TTP20**	–	–	**420.241**	**470.241**
8.000	**MS2060**	40	**TTP20**	–	–	–	**470.242**
10.000	**MS2060**	40	**TTP20**	–	–	–	**470.243**

Insert Selection Guide

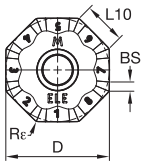
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	.E..LE	KC514M	.S..GP	KC514M	.S..HB	KC514M
K3	.E..LE	KCK20	.S..GP	KCK20	.S..HB	KCK15
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

Indexable Inserts

- ...ANENLE = semi-finishing with improved surface floor finish.
- ...ENLE = light machining.

● first choice
○ alternate choice


ONGX08-LE



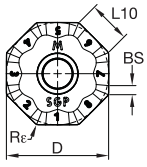
ONGX08-LE

ONGX-LE • High-Precision Periphery Ground

catalog number	D	S	L10	BS	Rε	hm	KC514M	KCK15	KCK20	KCPK30	KY3500
ONGX64ANENLE	.787	.229	.323	.059	.031	.002	●	●	●	–	–
ONGX645ENLE	.787	.229	.326	—	.079	.002	●	●	●	–	–

- ...ANSNGP = medium roughing with improved surface floor finish.
- ...SNGP = medium roughing with low cutting forces.


ONGX-GP



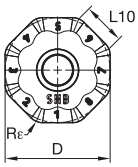
ONGX-GP

ONGX-GP • High-Precision Periphery Ground

catalog number	D	S	L10	BS	Rε	hm	KC514M	KCK15	KCK20	KCPK30	KY3500
ONGX64ANSNGP	.787	.229	.323	.059	.031	.006	●	●	●	–	–
ONGX645SNGP	.787	.229	.326	—	.079	.006	●	●	●	●	–

- First choice for heavy roughing.


ONGX-HB



ONGX-HB

● first choice
○ alternate choice

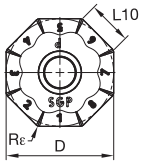
P	
M	
K	● ● ● ● ●
N	
S	
H	

ONGX-HB • High-Precision Periphery Ground

catalog number	D	S	L10	BS	Rε	hm	KC514M	KCK15	KCK20	KCPK30	KY3500
ONGX642SNHB	.787	.229	.326	–	.032	.007	●	●	–	–	–
ONGX645SNHB	.787	.229	.326	–	.079	.007	●	●	●	●	–
ONGX648SNHB	.787	.229	.326	–	.118	.007	●	●	●	–	–

- Medium roughing with lower cutting forces.


ONPX-GP



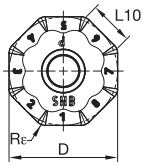
ONPX-GP

ONPX-GP • Precision Pressed and Sintered to Size

catalog number	D	S	L10	BS	Rε	hm	KC514M	KCK15	KCK20	KCPK30	KY3500
ONPX642SNGP	.787	.229	.326	–	.032	.006	–	●	●	●	–

- Heavy roughing with regular performance.


ONPX-HB



ONPX-HB

ONPX-HB • Precision Pressed and Sintered to Size

catalog number	D	S	L10	BS	Rε	hm	KC514M	KCK15	KCK20	KCPK30	KY3500
ONPX645SNHB	.787	.229	.326	–	.079	.007	–	●	●	●	–

Face Milling

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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	.009	**.026**	.046	.007	**.019**	.033	.005	**.014**	.025	.004	**.012**	.022	.004	**.011**	.020	.E..LE
.S..GP	.013	**.029**	.049	.009	**.021**	.035	.007	**.016**	.026	.006	**.014**	.023	.006	**.012**	.021	.S..GP
.S..HB	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.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 catalog.

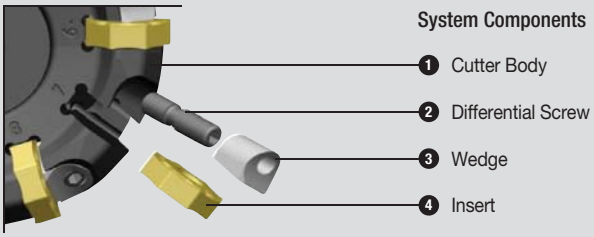


- Maintenance and repair of cutters should only be carried out by Kennametal.
- The tools must only be used in combination with suitable tool adapters and machine spindles.
- Use only the recommended torque settings when assembling the cutters for use. For further information contact the KMT CAS Team.

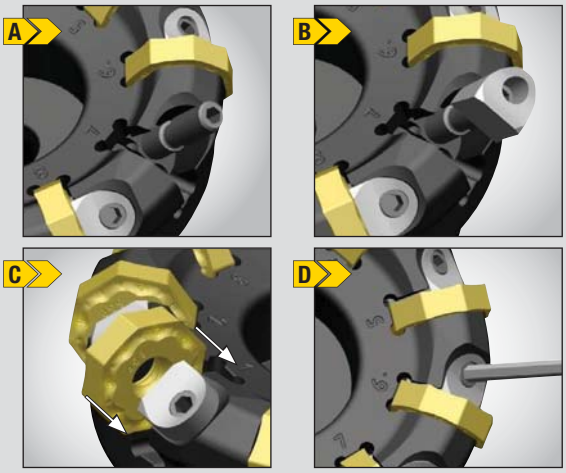
* These assembly instructions relate only to the Kennametal Mill 16 Face Mill family and not to its connection to a spindle or spindle adapter.

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 ❷ into the cutter body ❶ by approximately 2 turns using a 3mm hex wrench.

B. Place wedge ❸ on differential screw ❷ and fasten into the cutter body.

C. Push insert ❹ into the pocket seat by hand in the direction shown.

D. Clamp insert ❹ with wedge ❸ by rotating the differential screw with a clamping force of MA = 18 in/lbs (2 Nm). 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 = 62 in/lbs (7 Nm).

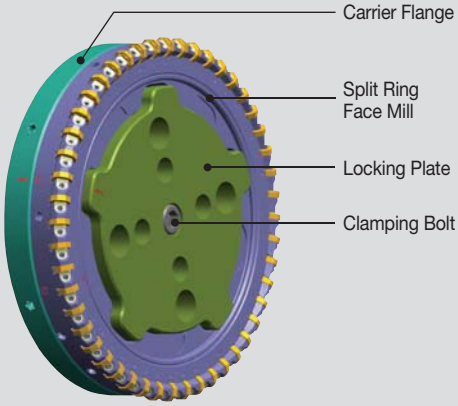
Split Cutter Assembly Instructions

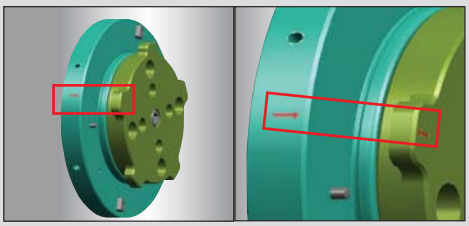
Please read and follow the instructions below for safe and productive application.

User Information

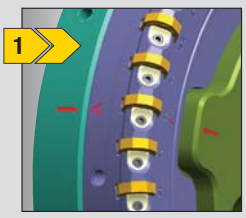
These assembly instructions relate only to Kennametal split-case milling cutters and not to its connection to a spindle or spindle adapter.

System Components

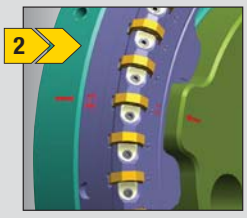




Initial position must be in such a way that the arrows in the carrier flange and locking plate coincide with each other.



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 • 5.3–47.8 in. lbs (0,6–5,4 Nm)



3641463



3641464

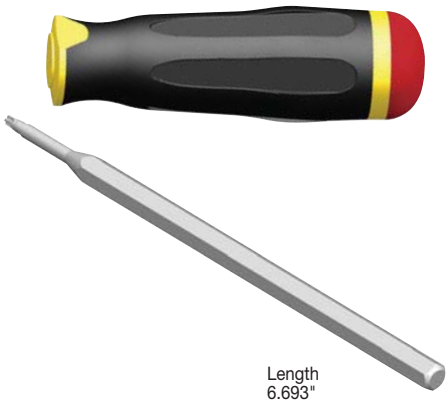


3641465

Order Number	ANSI/ISO Catalog 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
6.693"
(170mm)

Adjustable torque wrenches • 3.7–10.3 in. lbs (5–14 Nm)

Order Number	ANSI/ISO Catalog 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.

KSSM™ 45°

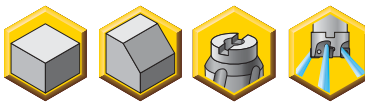
Universal face mill for conventional machining.

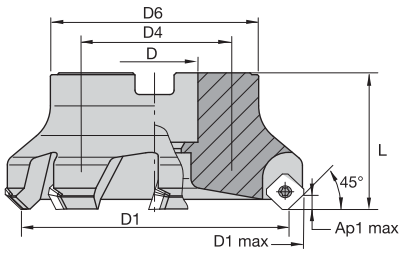


Features and Benefits

- Insert SE.T1404.
- Ap1 max = .260".
- Four true cutting edges.
- Pocket seat protection with carbide shims.
- Easy handling and rapid insert change.

- Consumes less power.
- Rapid insert changes.







KSSM 45° • Shell Mills

order number	catalog number	D1	D1 max	D	D4	D6	L	Ap1 max	Z	lbs	max RPM
1817866	**KSSISR197SE44345C3**	1.970	2.515	.750	–	1.750	1.575	.260	3	.87	22500
1817867	**KSSISR197SE44345M3**	1.970	2.515	.750	–	1.750	1.575	.260	4	.88	22500
1817868	**KSSISR248SE44345C4**	2.480	3.024	1.000	–	2.190	1.575	.260	4	1.31	20200
1817869	**KSSISR248SE44345M4**	2.480	3.024	1.000	–	2.190	1.575	.260	5	1.30	20200
1817870	**KSSISR315SE44345C4**	3.150	3.691	1.000	–	2.190	1.969	.260	4	2.16	18000
1817871	**KSSISR315SE44345M4**	3.150	3.691	1.000	–	2.190	1.969	.260	6	2.19	18000
1817872	**KSSISR394SE44345C5**	3.940	4.477	1.250	–	2.880	1.969	.260	5	3.58	16000
1817933	**KSSISR394SE44345M5**	3.940	4.477	1.250	–	2.880	1.969	.260	7	3.60	16000
1817934	**KSSISR492SE44345C6**	4.920	5.460	1.500	–	3.810	2.480	.260	6	6.50	14400
1817935	**KSSISR492SE44345M6**	4.920	5.460	1.500	–	3.810	2.480	.260	8	6.56	14400
1817936	**KSSISR630SE44345C6**	6.300	6.836	1.500	–	3.810	2.480	.260	7	9.91	12500
1817937	**KSSISR630SE44345M6**	6.300	6.836	1.500	–	3.810	2.480	.260	10	10.03	12500
1817938	**KSSISR787SE44345C10**	7.870	8.410	2.500	4.000	6.125	2.480	.260	8	13.24	11300
1817939	**KSSISR787SE44345M10**	7.870	8.410	2.500	4.000	6.125	2.480	.260	12	13.37	11300

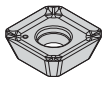
Spare Parts

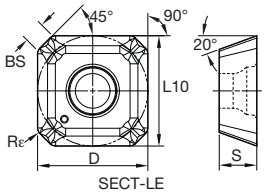
D1	insert screw	in. lbs.	Torx Plus driver	shim	shim screw	hex driver	in. lbs.	socket-head cap screw
1.970	**MS2078**	35	**DT15IP**	–	–	–	–	**S2043**
2.480	**MS2078**	35	**DT15IP**	–	–	–	–	**S2044**
3.150	**MS2078**	35	**DT15IP**	**SM455**	**SRS3**	**DH35M**	40	–
3.940	**MS2078**	35	**DT15IP**	**SM455**	**SRS3**	**DH35M**	40	–
4.920	**MS2078**	35	**DT15IP**	**SM455**	**SRS3**	**DH35M**	40	–
6.300	**MS2078**	35	**DT15IP**	**SM455**	**SRS3**	**DH35M**	40	–
7.870	**MS2078**	35	**DT15IP**	**SM455**	**SRS3**	**DH35M**	40	–

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

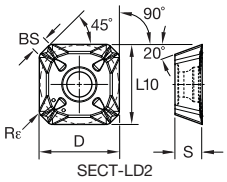
beyond

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

SECT-LE

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SECT443AEFN7LE	.551	.188	.551	.104	.039	.001	4	●	–	–	–	–	–	–	–	–


SECT-LD2

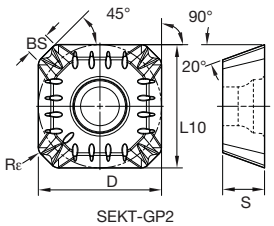


SECT-LD2

SECT-LD2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SECT443AEEN7LD2	.551	.188	.551	.104	.039	.002	4	–	–	●	–	–	–	–	–	–


SEKT-GP2

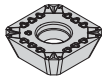


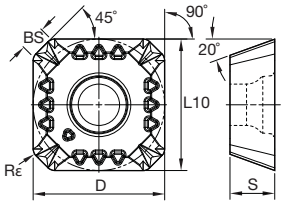
SEKT-GP2

SEKT-GP2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SEKT443AEEN7GP2	.551	.188	.551	.104	.039	.002	4	–	●	●	●	●	–	–	●	–
SEKT443AESN7GP2	.551	.188	.551	.104	.039	.004	4	–	●	●	●	●	–	–	●	–

Face Milling


SEPT-GB2



SEPT-GB2

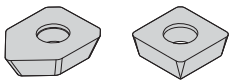
beyond

● first choice
○ alternate choice

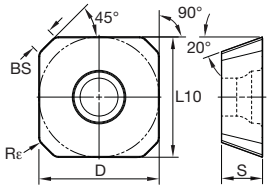
P			●		●		○	●		
M			●		○	○	●	○		
K		●		●	○		○		●	
N	●									
S			●			●	●			
H										

SEPT-GB2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SEPT443AEEN7GB2	.551	.188	.551	.104	.039	.003	4	–	–	●	●	●	–	–	–	–
SEPT443AESN7GB2	.551	.188	.551	.104	.039	.005	4	–	–	●	●	●	–	–	–	–


SECW-GNW

SECW-GN



SECW-GNW
SECW-GN

SECW-GN

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SECW443AESN7GN	.551	.188	.551	.104	.039	.006	4	–	–	–	–	–	–	–	–	●

SECW-GNW

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCSM30	KC522M	KCPM40	KY3500
SECW443AEEN22GNW	.551	.188	.325	.325	.063	.002	2	–	–	●	–	–	–	–	–	–

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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	.007	**.024**	.040	.005	**.017**	.029	.004	**.013**	.021	.003	**.011**	.019	.003	**.010**	.017	.F..LE
.E..LD2	.007	**.025**	.045	.005	**.018**	.032	.004	**.013**	.024	.003	**.012**	.021	.003	**.011**	.019	.E..LD2
.E..LD	.009	**.026**	.046	.007	**.019**	.033	.005	**.014**	.024	.004	**.012**	.021	.004	**.011**	.020	.E..LD
.E..GP	.007	**.025**	.050	.005	**.018**	.036	.004	**.013**	.027	.003	**.012**	.023	.003	**.011**	.021	.E..GP
.E..GP2	.009	**.029**	.050	.007	**.021**	.036	.005	**.016**	.027	.004	**.014**	.023	.004	**.012**	.021	.E..GP2
.E..GB2	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.E..GB2
.S..GP2	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.S..GP2
.S..GB2	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.S..GB2
.S..GN	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.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

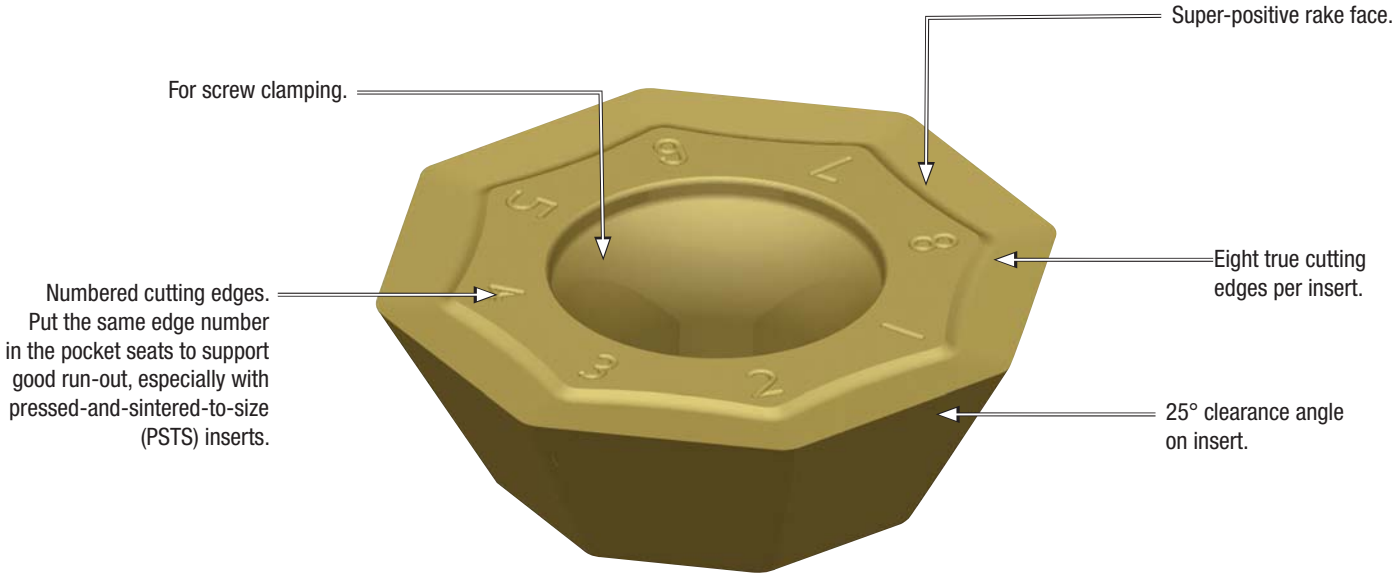
Primary Application

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.

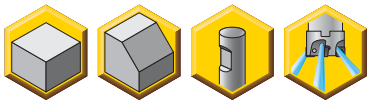




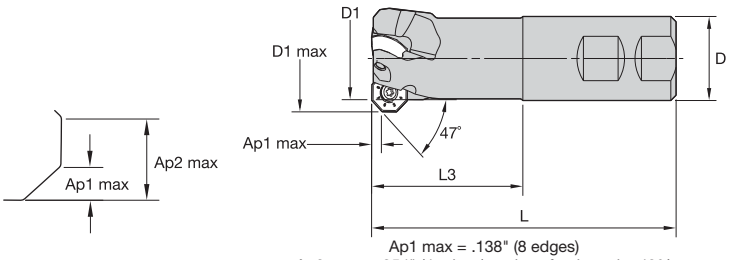
KSOM Mini: insert OF*T53
— Ap1 max = .138" (8 indexes)
— Ap2 max = .354" (4 indexes)

KSOM insert OF*T64
— Ap1 max = .197" (8 indexes)
— Ap2 max = .461" (4 indexes)

- Eight cutting edges per insert.
- Super soft cutting.







Ap1 max = .138" (8 edges)
Ap2 max = .354" (4 edges); reduce feed rate by 40%

KSOM Mini • Weldon® End Mills

order number	catalog number	D1	D1 max	D	L	L3	Ap1 max	Z	max ramp angle	lbs	max RPM
3093625	**KSOM125OF5345M3**	1.250	1.610	.750	3.047	1.000	.138	2	11.0°	.53	20050
3093600	**KSOM125OF5345F5**	1.250	1.610	1.250	4.530	2.250	.138	3	11.0°	1.45	20050
3093627	**KSOM150OF5345M3**	1.500	1.856	.750	3.047	1.000	.138	3	8.0°	.60	16710
3093623	**KSOM150OF5345F3**	1.500	1.856	.750	3.047	1.000	.138	4	8.0°	.56	16710

Spare Parts

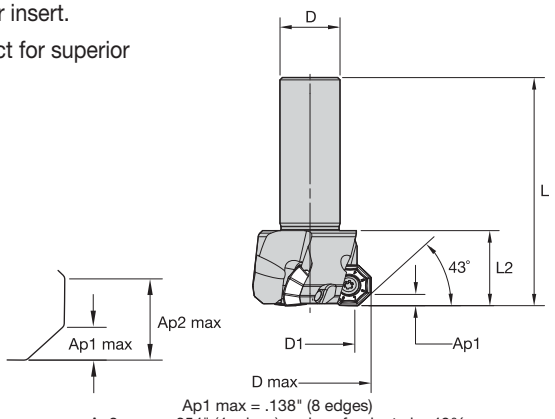
D1	 insert screw	 in. lbs.	 Torx Plus wrench
1.250	**193.433**	53	**TTP15**
1.500	**193.433**	53	**TTP15**

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 effect for superior surface floor finishing.







Ap1 max = .138" (8 edges)
Ap2 max = .354" (4 edges); reduce feed rate by 40%

Cylindrical End Mills

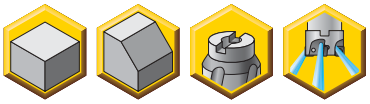
order number	catalog number	D1	D1 max	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
5358938	**KSOM125Z03C100OF53X**	1.250	1.603	1.000	3.280	1.000	.138	3	11.0°	.74	20050

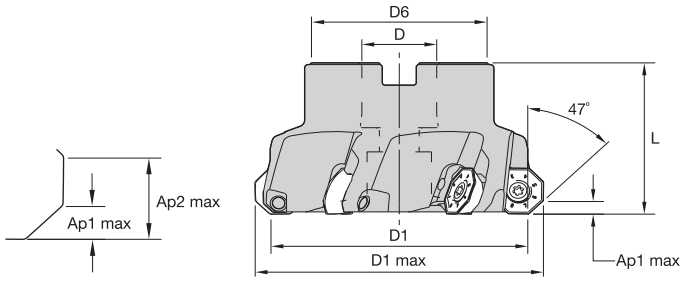
Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus wrench
1.250	**193.433**	53	**TTP15**

NOTE: Adjustable torque wrench (order number 6197561) and bit TorxPlus20 (order number 6205891) may be purchased separately in order to ensure proper torque setting.

- Eight cutting edges per insert.
- Super soft cutting.





Ap1 max = .138" (8 edges)
Ap2 max = .354" (4 edges); reduce feed rate by 40%

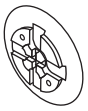


KSOM Mini • Shell Mills

order number	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	max ramp angle	lbs	max RPM
5359020	**KSOM150Z04OF53S050X**	1.500	1.850	.500	1.440	1.575	.138	4	8.0°	.58	16710
3093634	**KSOM200OF5345M3**	2.000	2.350	.750	1.593	1.570	.138	4	5.2°	.85	12530
5359021	**KSOM200Z06OF53S075X**	2.000	2.346	.750	1.750	1.570	.138	6	5.2°	.88	12530
3093635	**KSOM250OF5345M3**	2.500	2.846	.750	1.986	1.570	.138	5	3.8°	1.38	10030
5359023	**KSOM250Z07OF53S075X**	2.500	2.843	.750	2.144	1.570	.138	7	3.8°	1.43	10030
3093636	**KSOM300OF5345M4**	3.000	3.343	1.000	2.031	1.750	.138	6	3.0°	1.88	8350
5359024	**KSOM300Z09OF53S100X**	3.000	3.341	1.000	2.188	1.750	.138	9	3.0°	1.98	8350
3093637	**KSOM400OF5345M5**	4.000	4.340	1.250	2.722	1.750	.138	7	2.1°	2.77	6270
3093638	**KSOM500OF5345M6**	5.000	5.340	1.500	3.652	2.380	.138	8	1.6°	5.63	5010
3093632	**KSOM500OF5345F6**	5.000	5.340	1.500	3.652	2.380	.138	12	1.6°	6.07	5010

NOTE: "X" in the catalog number stands for improved finishing capabilities.

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus wrench	 socket-head cap screw	 coolant lock screw	 coolant lock screw	 coolant shower plate
1.500	**193.433**	53	**TTP15**	**S424**	–	–	–
2.000	**193.433**	53	**TTP15**	**S445**	–	–	–
2.500	**193.433**	53	**TTP15**	**S445**	–	–	–
3.000	**193.433**	53	**TTP15**	**S458**	–	–	–
4.000	**193.433**	53	**TTP15**	–	**S2162C**	–	–
5.000	**193.433**	53	**TTP15**	–	–	**420.201**	**470.240**

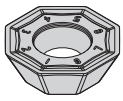
NOTE: Adjustable torque wrench (order number 6197561) and bit TorxPlus15 (order number 6205880) may be purchased separately in order to ensure proper torque setting.

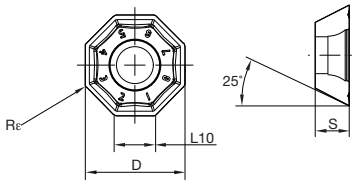
Insert Selection Guide

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	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	–	–	**–**	**–**	–	–

Indexable Inserts

- First choice for machining aluminum with low feed rate.


OF.T-LNJ



OF.T-LNJ

● first choice
○ alternate choice

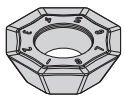
beyond

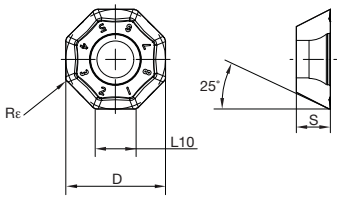
P					○	●		●	●	○
M					●	●		○	○	●
K				●	○		●	○		
N		●	●							
S					●	●				●
H										

OFKT-LNJ

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFKT53AFFN4LNJ	.579	.197	.236	–	.031	.001	8	●	–	–	–	–	–	–	–	–

- First choice for machining aluminum.


OF.T-LBJ

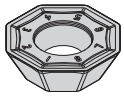


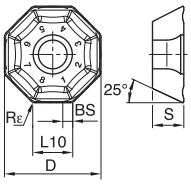
OF.T-LBJ

OFKT-LBJ

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFKT53AFEN4LBJ	.579	.197	.236	–	.031	.001	8	–	●	–	–	–	–	–	–	–
OFKT53AFFN4LBJ	.579	.197	.236	–	.031	.001	8	●	–	–	–	–	–	–	–	–

- First choice for light machining.
- -LB light geometry is the first choice for turbine blade applications.


OF.T-LB



OF.T-LB

● first choice
○ alternate choice

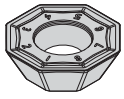
beyond

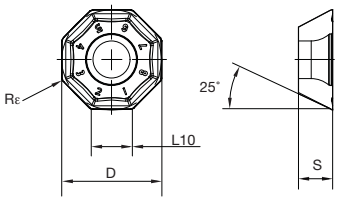
P					○	●		●	●	○
M					●	●		○	○	●
K				●	○		●	○		
N	●	●								
S					●	●				●
H										

OFKT-LB

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFKT53AFEN6LB	.579	.197	.236	.048	.031	.004	8	–	–	–	●	●	●	●	–	●
OFKT53AFSN6LB	.579	.197	.236	.048	.031	.009	8	–	–	●	●	●	–	●	–	–

- First choice for general purpose.
- -GB medium geometry for roughing and finishing operations on all materials.


OF.T-GB

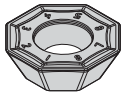


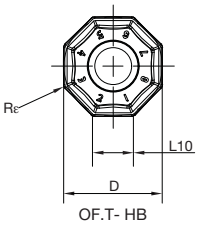
OF.T-GB

OFKT-GB

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFKT53AFEN4GB	.579	.197	.236	—	.031	.006	8	–	–	●	●	●	●	●	●	●

- First choice for heavy roughing.


OF.T- HB

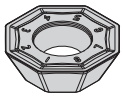


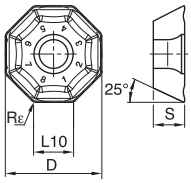
OF.T- HB

OFKT-HB

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFKT53AFSN4HB	.579	.197	.236	—	.031	.008	8	–	–	–	●	●	–	●	–	●

- First choice for general purpose.
- -GB medium geometry for roughing and finishing operations on all materials.


OF.T-GB



OF.T-GB

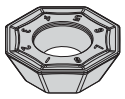
● first choice
○ alternate choice

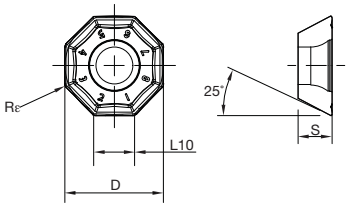
		KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
P					○	●		●	●	○
M					●	●		○	○	●
K				●	○		●	○		
N		●	●							
S					●	●				●
H										

OFPT-GB

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFPT53AFEN4GB	.579	.197	.236	—	.031	.006	8	–	–	●	–	●	●	●	●	–

- First choice for heavy roughing.


OF.T- HB



OF.T- HB

OFPT-HB

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFPT53AFSN4HB	.579	.197	.236	—	.031	.008	8	–	–	●	–	●	●	●	–	●

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

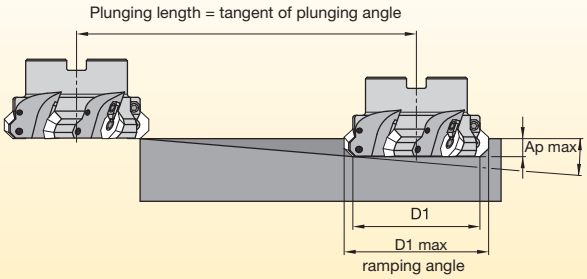
Light Machining	General Purpose	Heavy Machining

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	.007	**.025**	.041	.005	**.018**	.030	.004	**.013**	.022	.003	**.012**	.019	.003	**.011**	.018	.F..LBJ
.F..LNJ	.007	**.025**	.041	.005	**.018**	.030	.004	**.013**	.022	.003	**.012**	.019	.003	**.011**	.018	.F..LNJ
.E..LBJ	.007	**.025**	.045	.005	**.018**	.033	.004	**.013**	.024	.003	**.012**	.021	.003	**.011**	.019	.E..LBJ
.E..LB	.014	**.029**	.047	.010	**.021**	.034	.007	**.016**	.025	.006	**.014**	.022	.006	**.013**	.020	.E..LB
.S..LB	.014	**.029**	.051	.010	**.021**	.037	.007	**.016**	.027	.006	**.014**	.024	.006	**.012**	.022	.S..LB
.E..GB	.014	**.034**	.055	.010	**.025**	.039	.007	**.018**	.029	.006	**.016**	.025	.006	**.015**	.023	.E..GB
.S..HB	.014	**.034**	.059	.010	**.025**	.042	.007	**.018**	.031	.006	**.016**	.027	.006	**.015**	.025	.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

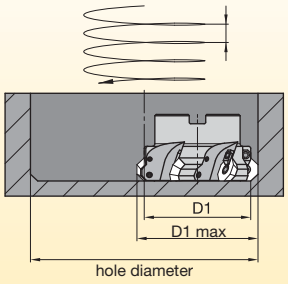
Ramping



Inch version

D1 inch	D1 max inch	Ap max inch	ramping angle (°)	ramping length inch
1.25	1.61	.354	11,0	1.82
1.50	1.85	.354	8,0	2.52
2.00	2.35	.354	5,2	3.89
2.50	2.85	.354	3,8	5.34
3.00	3.34	.354	3,0	6.76
4.00	4.34	.354	2,1	9.66
5.00	5.34	.354	1,6	12.69
6.00	6.34	.354	1,3	15.61

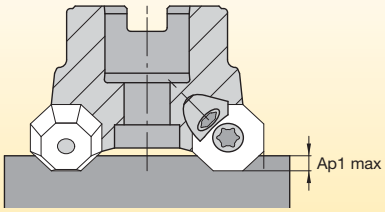
Helical Interpolation



Inch version

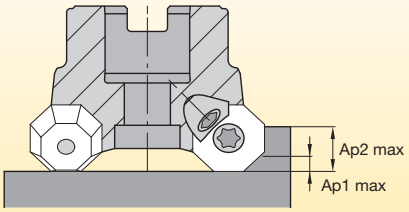
D1 inch	D1 max inch	hole diameter min inch	hole diameter max inch	Ap/Rev inch
1.25	1.61	2.41	3.20	.185
1.50	1.85	2.91	3.69	.185
2.00	2.35	3.90	4.68	.185
2.50	2.85	4.93	5.68	.185
3.00	3.34	5.89	6.68	.185
4.00	4.34	7.89	8.67	.185
5.00	5.34	9.89	10.67	.185
6.00	6.34	11.89	12.67	.185

Plunging



max plunging depth	inch
Ap1 max	.13

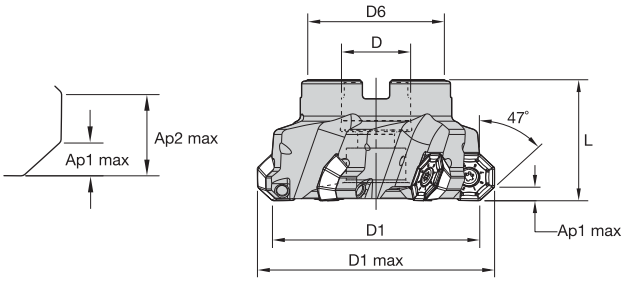
Face Milling



max DOC Ap	inch	chipload (fz)
Ap1 max	.14	1 x fz
Ap2 max	.35	0,6 x fz

- Eight cutting edges per insert.
- Super soft cutting.





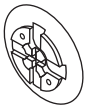
Ap1 max = .138" (8 edges)
Ap2 max = .354" (4 edges); reduce feed rate by 40%



KSOM • Shell Mills

order number	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	max ramp angle	lbs	max RPM
3093645	**KSOM250OF6445M3**	2.500	2.945	.750	1.986	1.750	.197	4	5.5°	1.47	10100
3093640	**KSOM250OF6445F3**	2.500	2.945	.750	1.986	1.750	.197	5	5.5°	1.29	10100
3093646	**KSOM300OF6445M4**	3.000	3.441	1.000	2.031	1.750	.197	4	4.2°	1.83	7900
3093641	**KSOM300OF6445F4**	3.000	3.441	1.000	2.031	1.750	.197	6	4.2°	1.68	7900
3093647	**KSOM400OF6445M5**	4.000	4.436	1.250	2.722	1.750	.197	5	2.9°	2.69	6300
3093642	**KSOM400OF6445F5**	4.000	4.436	1.250	2.722	1.750	.197	8	2.9°	2.79	6300
3093648	**KSOM500OF6445M6**	5.000	5.433	1.500	3.652	2.380	.197	6	2.2°	5.54	5000
3093643	**KSOM500OF6445F6**	5.000	5.433	1.500	3.652	2.380	.197	10	2.2°	5.94	5000
3093649	**KSOM600OF6445M8**	6.000	6.431	2.000	4.722	2.380	.197	7	1.8°	8.51	3900
3093644	**KSOM600OF6445F8**	6.000	6.431	2.000	4.722	2.380	.197	12	1.8°	8.66	3900

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus wrench	 socket-head cap screw	 coolant lock* screw assembly	 coolant* lock screw	 coolant* shower plate
2.500	**193.409**	53	**TTP20**	**S445**	–	–	–
3.000	**193.409**	53	**TTP20**	**S458**	–	–	–
4.000	**193.409**	53	**TTP20**	–	**S2162C**	–	–
5.000	**193.409**	53	**TTP20**	–	–	**420.201**	**470.240**
6.000	**193.409**	53	**TTP20**	–	–	**420.241**	**470.241**

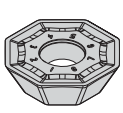
* Coolant clamping screw and coolant cap must be purchased separately.

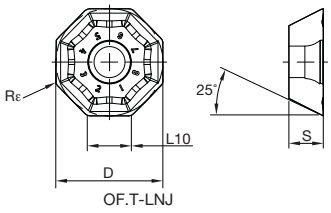
NOTE: Adjustable torque wrench (order number 6197561) and bit TorxPlus20 (order number 6205891) may be purchased separately in order to ensure proper torque setting.

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	–	–	**–**	**–**	–	–

- First choice for machining aluminum.


OF.T-LNJ



OF.T-LNJ

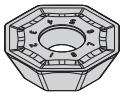
● first choice
○ alternate choice

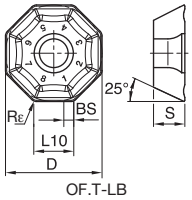
P				○	●		●	●		○
M				●	●		○	○	○	●
K			●	○		●	○			
N		●								
S				●	●				●	●
H										

OFKT-LNJ

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
OFKT64AFFN6LNJ	.736	.236	.295	–	.047	.001	8	●	–	–	–	–	–	–	–	–

- First choice for light machining.


OF.T-LB



OF.T-LB

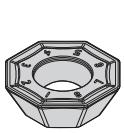
OFKT-LB

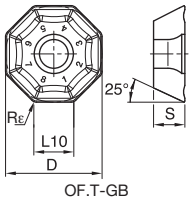
catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
OFKT64AFEN6LB	.736	.236	.295	.083	.047	.004	8	–	–	●	●	–	●	–	–	●
OFKT64AFSN6LB	.736	.236	.295	.083	.047	.009	8	–	–	–	●	–	●	–	–	–

- First choice for general purpose.
- -GB medium geometry for roughing and finishing operations on all materials.

● first choice
○ alternate choice

		KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○	●		●	●		○
M				●	●		○	○	○	●
K			●	○		●	○			
N		●								
S				●	●				●	●
H										


OF.T-GB

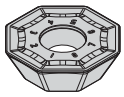


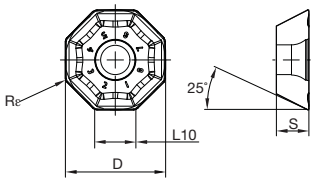
OF.T-GB

OFKT-GB

catalog number	D	S	L10	BS	Rε	hm	cutting edges
OFKT64AFEN6GB	.736	.236	.295	—	.047	.006	8

- First choice for heavy roughing.


OF.T- HB

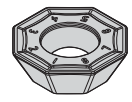


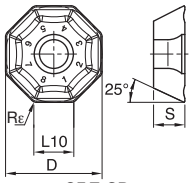
OF.T- HB

OFKT-HB

catalog number	D	S	L10	BS	Rε	hm	cutting edges
OFKT64AFSN6HB	.736	.236	.295	—	.047	.008	8

- First choice for general purpose.


OF.T-GB

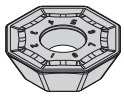


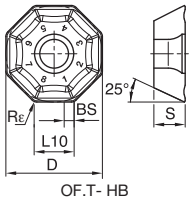
OF.T-GB

OFPT-GB

catalog number	D	S	L10	BS	Rε	hm	cutting edges
OFPT64AFEN6GB	.736	.236	.295	—	.047	.006	8

- First choice for heavy roughing.


OF.T- HB



OF.T- HB

OFPT-HB

catalog number	D	S	L10	BS	Rε	hm	cutting edges
OFPT64AFSN6HB	.736	.236	.295	—	.047	.008	8

Face Milling

Recommended Starting Feeds [IPT]

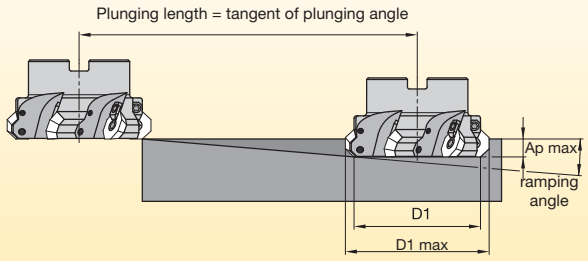
Light Machining	General Purpose	Heavy Machining

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	.007	**.027**	.048	.005	**.019**	.035	.004	**.015**	.026	.003	**.013**	.022	.003	**.012**	.021	.F..LNJ
.E..LB	.014	**.029**	.047	.010	**.021**	.034	.007	**.016**	.025	.006	**.014**	.022	.006	**.013**	.020	.E..LB
.S..LB	.014	**.029**	.053	.010	**.021**	.038	.007	**.016**	.028	.006	**.014**	.025	.006	**.012**	.022	.S..LB
.E..GB	.014	**.034**	.055	.010	**.025**	.039	.007	**.018**	.029	.006	**.016**	.026	.006	**.015**	.023	.E..GB
.S..HB	.014	**.034**	.059	.010	**.025**	.042	.007	**.018**	.031	.006	**.016**	.027	.006	**.015**	.025	.S..HB

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

KSOM Application • OF.T07L6

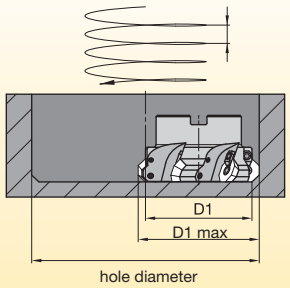
Ramping



Inch version

D1 inch	D1 max inch	Ap max inch	ramping angle (°)	ramping length inch
2.50	2.94	.46	5.5	4.78
3.00	3.44	.46	4.2	6.27
4.00	4.43	.46	2.9	9.09
5.00	5.43	.46	2.2	11.99
6.00	6.43	.46	1.8	14.65

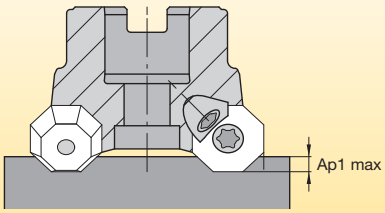
Helical Interpolation



Inch version

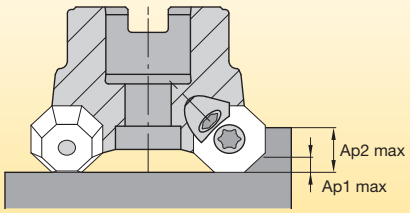
D1 inch	D1 max inch	hole diameter min inch	hole diameter max inch	Ap/Rev inch
2.50	2.94	4.872	5.748	.248
3.00	3.44	5.868	6.744	.248
4.00	4.43	7.863	8.739	.248
5.00	5.43	9.859	10.736	.248
6.00	6.43	11.857	12.733	.248

Plunging



max plunging depth	inch
Ap1 max	.17

Face Milling



max DOC Ap	inch	chipload (fz)
Ap1 max	.20	1 x fz
Ap2 max	.46	0,6 x fz

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 0° shoulder**.

Features and Benefits

Features

- Double-sided insert with 8 cutting edges.
- Face mill with close to a 0° shoulder.
  - IC 10 (2° lead)
  - IC 12,7 (3° lead)
- Medium and fine density cutters.
- -LD and -GD geometry inserts.

Benefits

- Maximized 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.

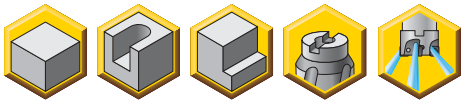


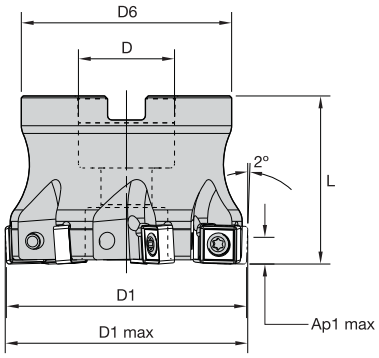


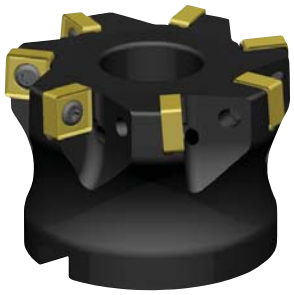
Optimized Cutting Forces
4° axial and 10° radial rake
angles reduce power consumption.

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	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	lbs	max RPM
5420251	**KSSM88D200SN3125S075Z05**	2.000	2.025	.750	1.750	1.750	.361	5	.85	32500
5420252	**KSSM88D200SN3125S075Z06**	2.000	2.025	.750	1.750	1.750	.361	6	.85	32500
5420255	**KSSM88D300SN3125S100Z07**	3.000	3.025	1.000	2.190	1.750	.361	7	1.82	25500
5420257	**KSSM88D300SN3125S100Z09**	3.000	3.419	1.000	2.190	1.750	.361	9	1.82	25500
5420258	**KSSM88D400SN3125S150Z08**	4.000	4.025	1.500	3.380	2.000	.361	8	3.73	21700

NOTE: Standard milling cutters will accept insert nose radii up to .078" without modification.

Spare Parts

D1	 insert screw	 in. lbs.	 Torx driver	 socket-head cap screw	 coolant lock screw assembly
2.000	**193.492**	35.000	**DT15**	**S445**	**–**
3.000	**193.492**	35.000	**DT15**	**S458**	**–**
4.000	**193.492**	35.000	**DT15**	**–**	**S-2165-C**

NOTE: For coolant shower plates (MCC..), only use low-presssure coolant.

Insert Selection Guide

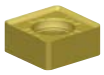
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KC725M	**.E..LD**	**KCPK30**	.S..GD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..GD	KCPM40
P5–P6	.E..LD	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	–	–	**–**	**–**	–	–

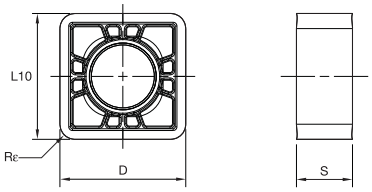
Indexable Inserts

- First choice for light machining of cast iron and steel.
- Low cutting forces.

● first choice
○ alternate choice

	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
P		○	●			●	●	○
M		●	●			○	●	●
K	●	○		●	●	○		
N								
S		●	●				○	●
H								


SNHJ-LD

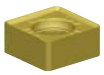


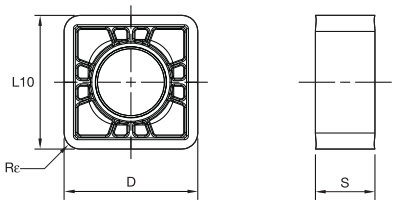
SNHJ-LD

SNHJ-LD

catalog number	D	S	L10	Rε	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
SNHJ31252ENLD	.394	.157	.394	.031	.002	8	●	–	●	●	–	●	–	–
SNHJ31253ENLD	.394	.157	.394	.047	.002	8	–	–	●	●	–	–	–	–

- First choice for general purpose machining.


SNPJ-GD



SNPJ-GD

SNPJ-GD

catalog number	D	S	L10	Rε	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
SNPJ31252SNGD	.394	.157	.394	.031	.003	8	●	–	–	●	–	●	●	–
SNPJ31253SNGD	.394	.157	.394	.047	.003	8	–	–	–	●	–	–	●	–

Recommended Starting Feeds

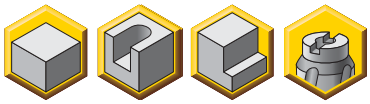
Recommended Starting Feeds [IPT]

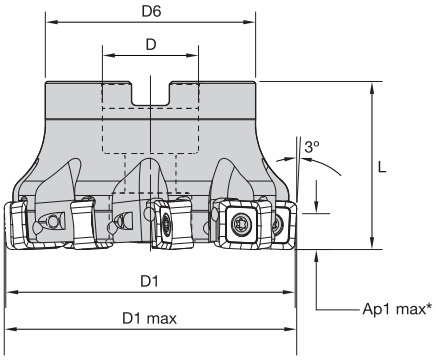
Light Machining	General Purpose	Heavy Machining

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	.007	**.016**	.028	.005	**.012**	.020	.004	**.009**	.015	.003	**.008**	.013	.003	**.007**	.012	.E..LD
.S..GD	.009	**.020**	.032	.007	**.015**	.023	.005	**.011**	.017	.004	**.009**	.015	.004	**.009**	.014	.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	catalog number	D1	D1 max	D	D6	L	Ap1 max*	Z	lbs	max RPM
5420150	**KSSM87D200SN440S075Z05**	2.000	2.045	.750	1.750	1.750	.236	5	.81	22500
5420154	**KSSM87D300SN440S100Z07**	3.000	3.045	1.000	2.190	1.750	.236	7	1.86	17400
5420155	**KSSM87D300SN440S100Z09**	3.000	3.045	1.000	2.190	1.750	.236	9	1.83	17400
5420156	**KSSM87D400SN440S150Z08**	4.000	4.045	1.500	3.380	2.000	.236	8	3.69	14700
5420157	**KSSM87D400SN440S150Z11**	4.000	4.045	1.500	3.380	2.000	.236	11	3.68	14700
5420160	**KSSM87D600SN440S150Z12**	6.000	6.045	1.500	3.380	2.380	.236	12	8.17	11700
5420161	**KSSM87D600SN440S150Z16**	6.000	6.045	1.500	3.380	2.380	.236	16	8.16	11700

NOTE: Standard milling cutters will accept insert nose radii up to .078" without modification.
*Ap1 max. .236" using insert SNHJ442ENLD.
*Ap1 max. .467" using insert SNPJ442SNGD.

Spare Parts

D1	insert screw	in. lbs.	Torx driver	socket-head cap screw	coolant lock screw assembly
2.000	**193.492**	35.000	**DT15**	**S445**	**–**
3.000	**193.492**	35.000	**DT15**	**S458**	**–**
4.000	**193.492**	35.000	**DT15**	**–**	**S2165C**
6.000	**193.492**	35.000	**DT15**	**–**	**S2163C**

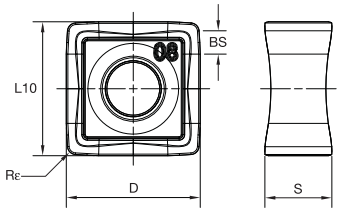
NOTE: For coolant shower plates (MCC..), only use low-pressure coolant.

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	–	–	**–**	**–**	–	–

- First choice for light machining of cast iron and steel.


SNHJ-LD



SNHJ-LD

● first choice
○ alternate choice

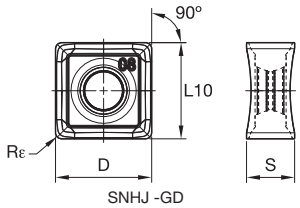
P			○	●			●	●	○
M			●	●			○	●	●
K		●	○		●	●	○		
N									
S			●	●				○	●
H									

SNHJ-LD

catalog number	D	S	BS	L10	Rε	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
SNHJ442ENLD	.500	.250	.086	.500	.031	.002	8	●	–	●	●	–	●	–	–
SNHJ444ENLD	.500	.250	.059	.500	.063	.002	8	●	–	●	●	–	●	–	–

- First choice for high-performance roughing.


SNHJ -GD

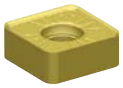


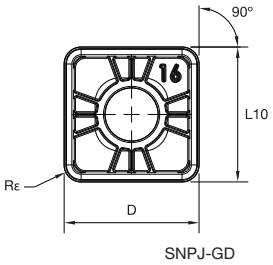
SNHJ -GD

SNHJ-GD

catalog number	D	S	L10	Rε	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
SNHJ442SNGD	.500	.250	.500	.031	.005	8	●	●	–	●	–	●	●	●

- First choice for regular roughing.


SNPJ-GD



SNPJ-GD

● first choice
○ alternate choice

beyond

	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
P	○	●	●			●	●	○
M		●	●			○	●	●
K	●	○		●	●	○		
N								
S		●	●				○	●
H								

SNPJ-GD

catalog number	D	S	L10	Rε	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCK20	KCPK30	KCPM40	KCSM40
SNPJ442SNGD	.500	.178	.500	.031	.005	8	●	–	–	●	–	●	●	–
SNPJ444SNGD	.500	.178	.500	.063	.005	8	–	–	–	●	–	●	●	–

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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	.007	**.018**	.033	.005	**.013**	.024	.004	**.010**	.018	.003	**.009**	.015	.003	**.008**	.014	.E..LD
.S..GD	.009	**.023**	.036	.007	**.017**	.026	.005	**.013**	.019	.004	**.011**	.017	.004	**.010**	.016	.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 optimize vibration, performance, and cutting action, depending on the application.



Experience the advantages at your Authorized 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

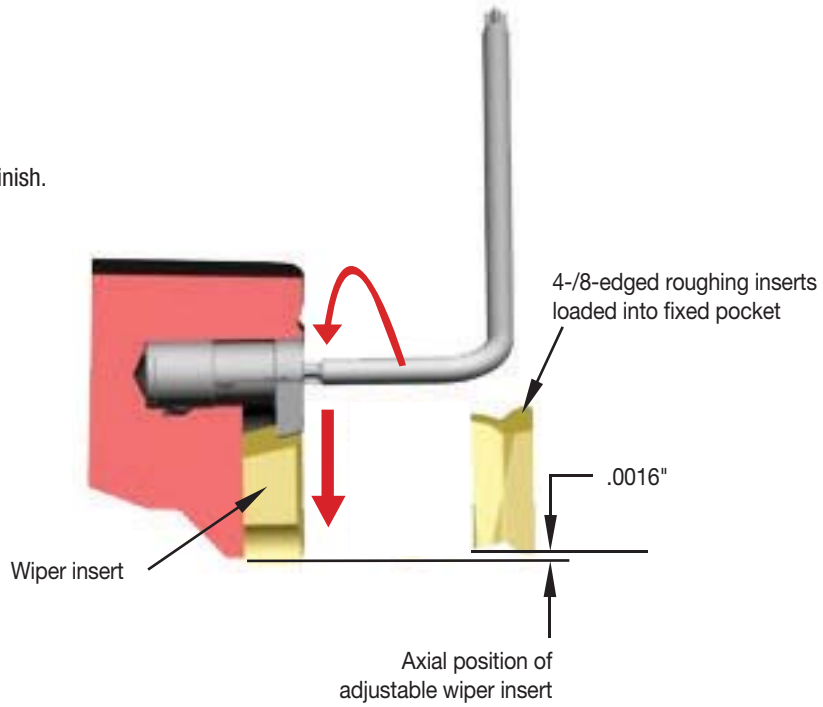
Fix-Perfect Cast Iron 20° and 0° Roughing and Finishing in One Tool

- 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.

*Finisher inch cutters available as custom solution







Fix-Perfect™ *Finisher



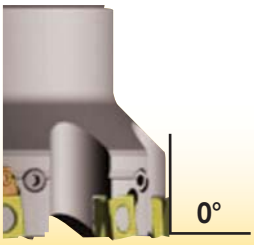
Fix-Perfect Cast Iron

Fix-Perfect Cast Iron 20º and 0º

Fix-Perfect 20°

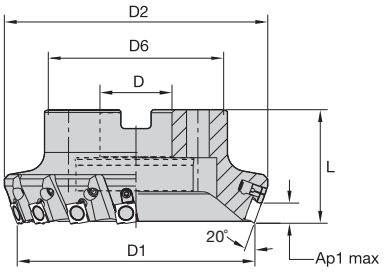


Fix-Perfect 0°



*Finisher inch cutters available as custom solution

- Eight cutting edges per insert.
- Rough and finish in one operation.
- Tangential mounted inserts deliver higher feed rates.
- Adjustable pockets (D1 = 3–10").



Ap1max: .232" (8 edges)
Ap2 max: .374" (4 edges); reduce feed rate by 30%



Fix-Perfect 20° • Shell Mills

order number	catalog number	D1	D	D2	D4	D6	L	Ap1 max	Z	Z ADJ	lbs	max RPM
1724429	**50A04RP70SP12CUFP**	2.000	.750	2.504	—	1.750	1.750	.232	4	0	1.24	8595
1724378	**50A05RP70SP12CUFP**	2.000	.750	2.504	—	1.750	1.750	.232	5	0	1.19	8595
1724379	**63A07RP70SP12CUFP**	2.500	.750	2.988	—	1.750	1.750	.232	7	0	1.55	6876
1724432	**80A06RP70SP12C1WUFP**	3.000	1.000	3.504	—	2.190	1.750	.232	6	1	2.21	5730
1724380	**80A08RP70SP12C2WUFP**	3.000	1.000	3.504	—	2.190	1.750	.232	8	2	2.43	5730
1532258	**100B08RP70SP12C2WUFP**	4.000	1.500	4.488	—	2.880	1.750	.232	8	2	3.30	4298
1724391	**100B12RP70SP12C3WUFP**	4.000	1.500	4.488	—	2.880	1.750	.232	12	3	3.10	4298
1532257	**125B10RP70SP12C2WUFP**	5.000	1.500	5.504	—	3.810	2.375	.232	10	2	6.50	3438
1724434	**160B12RP70SP12C3WUFP**	6.000	2.000	6.504	—	4.882	2.375	.232	12	3	10.10	2865
1724395	**160B18RP70SP12C3WUFP**	6.000	2.000	6.504	—	4.882	2.375	.232	18	3	10.10	2865
1532255	**200C16RP70SP12C4WUFP**	8.000	2.500	8.504	4.000	5.120	2.375	.232	16	4	14.10	2149
1532254	**250C20RP70SP12C4WUFP**	10.000	2.500	10.504	4.000	7.120	2.375	.232	20	4	29.30	1719

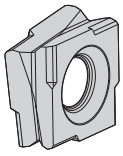
Spare Parts

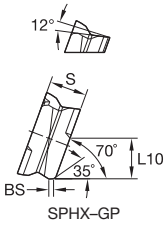
D1	adjusting element	adjusting element screw	Torx wrench	clamp stud	set screw	hex wrench	in. lbs.	socket-head cap screw
2.000	—	—	—	**410.081**	**121.612**	**170.003**	45	**S445**
2.500	—	—	—	**410.081**	**121.612**	**170.003**	45	**S445**
3.000	**479.100**	**193.300**	**KT9**	**410.081**	**121.612**	**170.003**	45	**S458**
4.000	**479.100**	**193.300**	**KT9**	**410.081**	**121.612**	**170.003**	45	—
5.000	**479.100**	**193.300**	**KT9**	**410.081**	**121.612**	**170.003**	45	—
6.000	**479.100**	**193.300**	**KT9**	**410.081**	**121.612**	**170.003**	45	—
8.000	**479.100**	**193.300**	**KT9**	**410.081**	**121.612**	**170.003**	45	—
10.000	**479.100**	**193.300**	**KT9**	**410.081**	**121.612**	**170.003**	45	—

NOTE: Please order spare parts separately.
Torque wrench (KTW45) and 3mm hex bit (69709922164) 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



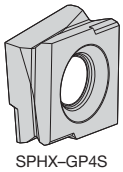
SPHX–GP

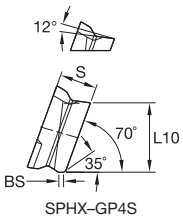
● first choice
○ alternate choice

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

SPHX-GP • Roughing

catalog number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX1205ZCELGP	.213	.217	.028	.002	8	–	●	●	–	–	–	–
SPHX1205ZCERGP	.213	.217	.028	.002	8	–	●	●	–	●	–	–
SPHX1205ZCSRGP	.213	.217	.028	.006	8	–	–	●	–	●	–	–
SPHX1205ZCTLGPK	.213	.217	.028	.009	8	–	–	–	–	–	–	●
SPHX1205ZCTRGP	.213	.217	.028	.009	8	–	–	–	●	–	–	–
SPHX1205ZCTRGPK	.213	.217	.028	.009	8	–	–	–	–	–	–	●

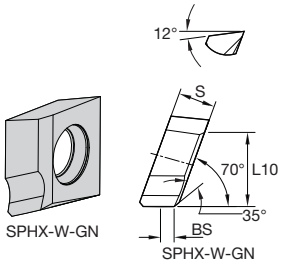

SPHX–GP4S



SPHX–GP4S

SPHX-GP4S • Roughing

catalog number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX1205ZCERGP4S	.395	.217	.028	.002	4	–	–	●	–	–	–	–
SPHX1205ZCTRGP4SK	.396	.217	.028	.009	4	–	–	–	–	–	–	●

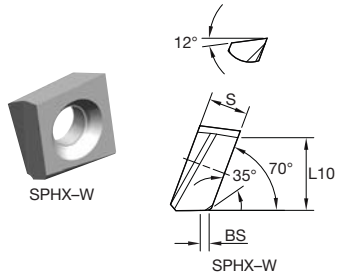


● first choice
○ alternate choice

		K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
P								
M								
K		●	●	●	○	○	●	●
N								
S								
H								

SPHX-W • Finishing • GN

catalog number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX1205ZCERGNT1W	.394	.217	.079	.001	1	–	–	–	–	–	●	–
SPHX1205ZCFRGN1W	.394	.217	.079	.001	1	–	●	●	–	–	–	–
SPHX1205ZCFRGN1WK	.394	.217	.079	.001	1	–	–	–	–	–	–	●



SPHX-W • Finishing • GP

catalog number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX1205ZCER-GP1W	.394	.217	.079	.001	1	–	●	●	–	–	–	–
SPHX1205ZCTR-GP1WK	.394	.217	.079	.009	1	–	–	–	–	–	–	●

NOTE: SPHX-W: Wiper Facet BS = .08".

Face Milling

Recommended Starting Feeds

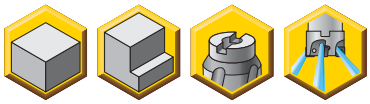
Recommended Starting Feeds [IPT]

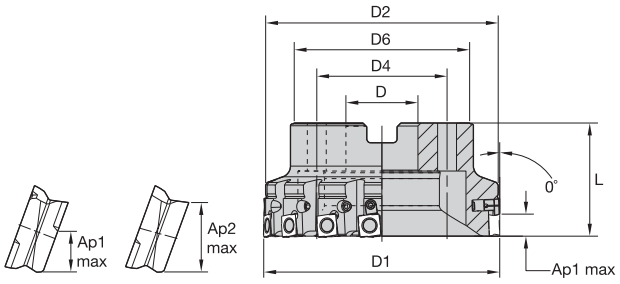
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..GP	.006	**.020**	.038	.004	**.014**	.027	.003	**.011**	.020	.003	**.009**	.018	.002	**.009**	.016	.E..GP
.T..GP	.010	**.025**	.040	.007	**.018**	.029	.005	**.013**	.021	.005	**.012**	.019	.004	**.011**	.017	.T..GP
.S..GP	.010	**.025**	.040	.007	**.018**	.029	.005	**.013**	.021	.005	**.012**	.019	.004	**.011**	.017	.S..GP

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Eight cutting edges per insert.
- Rough and finish in one operation.
- Tangential mounted inserts deliver higher feed rates.
- Adjustable pockets (D1 = 3–6").





Ap1 max = .236" (8 edges)
Ap2 max = .394" (4 edges); reduce feed rate by 30%



Fix-Perfect 0° • Shell Mills

order number	catalog number	D1	D	D2	D6	L	Ap1 max	Z	Z ADJ	lbs	max RPM
1724407	**50A04RP90SP12CUFP**	2.000	.750	1.929	1.750	1.750	.236	4	0	.93	8595
1514498	**50A05RP90SP12CUFP**	2.000	.750	1.929	1.750	1.750	.236	5	0	.93	8595
1724409	**63A05RP90SP12CUFP**	2.500	.750	2.433	1.750	1.750	.236	5	0	1.24	6876
1724417	**80A06RP90SP12C1WUFP**	3.000	1.000	2.906	2.190	1.750	.236	6	1	1.81	5730
1724339	**80A08RP90SP12C2WUFP**	3.000	1.000	2.906	2.190	1.750	.236	8	2	1.90	5730
1724419	**100B08RP90SP12C2WUFP**	4.000	1.500	3.906	2.882	1.750	.236	8	2	2.60	4298
1724351	**100B12RP90SP12C3WUFP**	4.000	1.500	3.906	2.882	1.750	.236	12	3	2.86	3130
1724421	**125B10RP90SP12C2WUFP**	5.000	1.500	4.906	3.811	2.375	.236	10	2	6.30	3438
1724353	**125B15RP90SP12C3WUFP**	5.000	1.500	4.906	3.811	2.375	.236	15	3	6.40	3438
1724424	**160B12RP90SP12C3WUFP**	6.000	2.000	5.906	4.882	2.375	.236	12	3	9.10	2865

Spare Parts

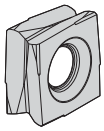
D1	adjusting element	Torx wrench	clamp stud	set screw	hex wrench	in. lbs.	socket-head cap screw
2.000	–	–	**410.081**	**121.612**	**170.003**	45	**S446**
2.500	–	–	**410.081**	**121.612**	**170.003**	45	**S445**
3.000	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	45	**S458**
4.000	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	45	–
5.000	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	45	–
6.000	**479.100**	**KT9**	**410.081**	**121.612**	**170.003**	45	–

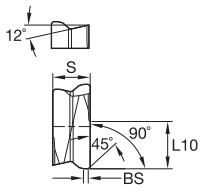
NOTE: Adjustable torque wrench (order number 6197561) and 3mm hex bit (order number 6205876) may be purchased separately in order to ensure proper torque setting.

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..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	–	–	–	–	–	–

Indexable Inserts • SPHX1205... • Roughing


SPHX-GPB



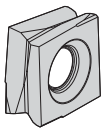
SPHX-GPB

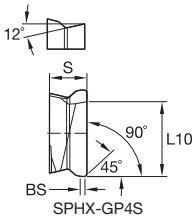
● first choice
○ alternate choice

		K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
P							○	●		
M							○	●		
K		●	●	●	○	○			●	●
N										
S							○	●		
H										

SPHX-GPB • Roughing

catalog number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
SPHX120508PCSRGP	.256	.217	—	.002	8	–	–	●	–	–	–	–	–	–
SPHX1205PCELGPB	.259	.217	.028	.001	8	–	–	●	–	–	–	–	–	–
SPHX1205PCERGPB	.259	.217	.028	.001	8	–	●	●	–	●	–	–	–	–
SPHX1205PCSRGPB	.259	.217	.028	.006	8	–	–	●	–	●	–	●	–	–
SPHX1205PCTLGPBK	.259	.217	.028	.009	8	–	–	–	–	–	–	–	–	●
SPHX1205PCTRGPB	.259	.217	.028	.009	8	–	–	–	●	–	–	–	–	–
SPHX1205PCTRGPBK	.259	.217	.028	.009	8	–	–	–	–	–	–	–	–	●

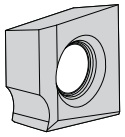

SPHX-GP4S

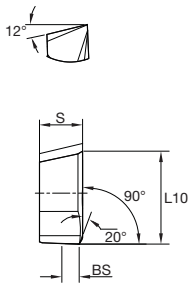


SPHX-GP4S

SPHX-GP4S • Roughing

catalog number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
SPHX1205PCERGP4SB	.436	.217	.028	.001	4	–	●	●	–	–	–	–	–	–
SPHX1205PCTRGP4SBK	.436	.217	.028	.009	4	–	–	–	–	–	–	–	–	●


SPHX-GN1WB
SPHX-GN1WBK



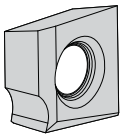
SPHX-GN1WB
SPHX-GN1WBK

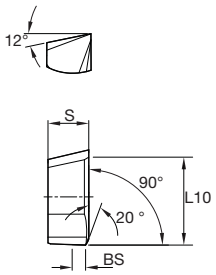
● first choice
○ alternate choice

		K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
P						○	●			
M						○	●			
K		●	●	●	○	○			●	●
N										
S						○	●			
H										

SPHX-W • Finishing • GN

catalog number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
SPHX1205PCERGN1WB	.433	.205	.079	.002	1	–	–	–	–	●	–	–	–	–
SPHX1205PCERGNT1WB	.500	.217	.079	.001	1	–	–	–	–	–	–	–	●	–
SPHX1205PCFLGN1WB	.433	.217	.079	.001	1	–	–	●	–	–	–	–	–	–
SPHX1205PCFRGN1WB	.433	.205	.079	.001	1	–	●	●	●	–	–	●	–	–
SPHX1205PCFRGN1WBK	.433	.205	.079	.001	1	–	–	–	–	–	–	–	–	●


SPHX-GP1WB



SPHX-GP1WB

SPHX-W • Finishing • GP

catalog number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KC715M	KC725M	KB1340	KY3500
SPHX1205PCELGPB	.259	.217	.028	.001	8	–	–	●	–	–	–	–	–	–
SPHX1205PCER-GP1WB	.433	.217	.079	.001	1	–	●	●	–	–	–	–	–	–
SPHX1205PCTR-GP1WBK	.433	.217	.079	.009	1	–	–	–	–	–	–	–	–	●

NOTE: SPHX-W-GP: Wiper Facet BS = .08".

Face Milling

Recommended Starting Feeds

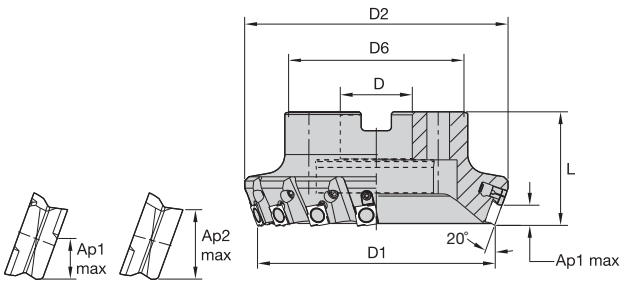
Recommended Starting Feeds [IPT]

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	.005	**.019**	.033	.003	**.013**	.023	.003	**.010**	.018	.002	**.009**	.015	.002	**.008**	.014	.E..GPB
.T..GPB	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.T..GPB
.S..GPB	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.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.



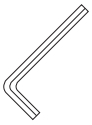


Ap1max: .256" (8 edges)
Ap2 max: .374" (4 edges); reduce feed rate by 30%

Fix-Perfect 20° • Shell Mills

order number	catalog number	D1	D	D2	D6	L	Ap1 max	Z	Z ADJ	lbs	max RPM
1806847	**125B08RP70SP15C2WUFP**	5.000	1.500	5.559	3.807	2.375	.256	8	2	7.00	3500
1806848	**160B10RP70SP15C2WUFP**	6.000	2.000	6.559	4.877	2.375	.256	10	2	10.40	2800

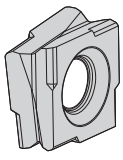
Spare Parts

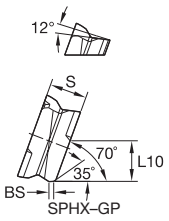
D1	 adjusting element	 adjusting element screw	 Torx wrench	 clamp stud	 clamp screw	 hex wrench	 in. lbs.
5.000	**479.100**	**193.300**	**KT9**	**410.084**	**121.616**	**170.003**	45
6.000	**479.100**	**193.300**	**KT9**	**410.084**	**121.616**	**170.003**	45

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..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	–	–	–	–	–	–


SPHX–GP



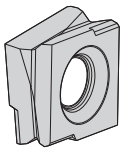
SPHX–GP

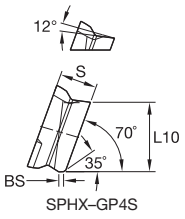
● first choice
○ alternate choice

		K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
P								
M								
K		●	●	●	○	○	●	●
N								
S								
H								

SPHX-GP • Roughing

catalog number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX15T6ZCERGP	.257	.260	.047	.001	8	–	–	●	–	●	–	–
SPHX15T6ZCSRGP	.257	.260	.047	.006	8	●	–	–	–	●	–	–
SPHX15T6ZCTRGPK	.256	.260	.047	.009	8	–	–	–	–	–	–	●

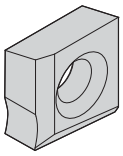

SPHX–GP4S

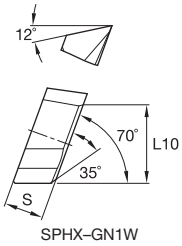


SPHX–GP4S

SPHX-GP4S • Roughing

catalog number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX15T6ZCERGP4S	.492	.260	.047	.002	4	–	–	●	–	–	–	–
SPHX15T6ZCTRGP4SK	.493	.260	.047	.009	4	–	–	–	–	–	–	●


SPHX–GN1W



SPHX–GN1W

● first choice
○ alternate choice

		K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
P								
M								
K		●	●	●	○	○	●	●
N								
S								
H								

SPHX-GN1W • Finishing

catalog number	L10	S	BS	hm	cutting edges	K110M	KC520M	KCK15	KTPK20	KCPK30	KB1340	KY3500
SPHX15T6ZCFRGN1W	.433	.260	.106	.001	1	–	–	●	–	–	–	–

Recommended Starting Feeds

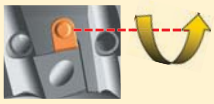
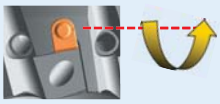
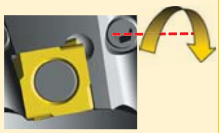
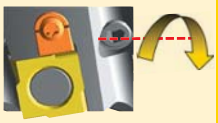
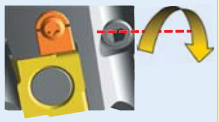
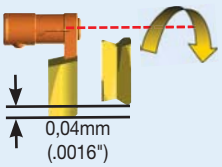
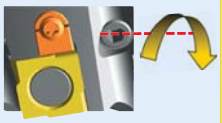
Recommended Starting Feeds [IPT]

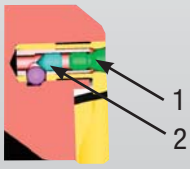
Light Machining	General Purpose	Heavy Machining

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	.005	**.020**	.035	.004	**.014**	.025	.003	**.011**	.019	.002	**.009**	.016	.002	**.009**	.015	.E..GP
.S..GP	.010	**.025**	.040	.007	**.018**	.029	.005	**.013**	.021	.005	**.012**	.019	.004	**.011**	.017	.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} = 44 in. lbs.				–
3 Tighten adjusting element gently	–		–	–
4 Insert finishing insert and pre-tighten SW 3 M_{VG} = 9 in. lbs.	–	–	–	
5 The finishing insert is positioned .0016" in front of the highest roughing insert	–	–	–	
6 Tighten the finishing insert M_{An} = 44 in. lbs.	–	–	–	



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 = 3000 SFM. 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 program 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 program 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.

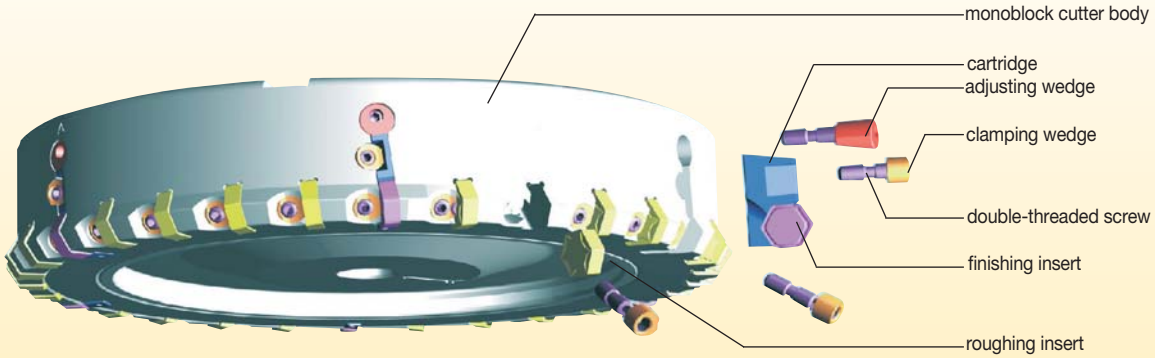


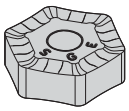
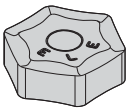
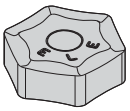
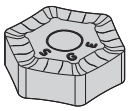
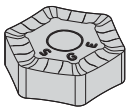
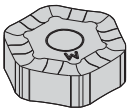
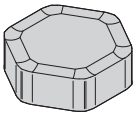
HNHX0905..SNGE
New geometry with improved rake and edge prep design for roughing operations.



HNPX0905..SNGE
New stable geometry for heavy roughing in severe machining conditions.

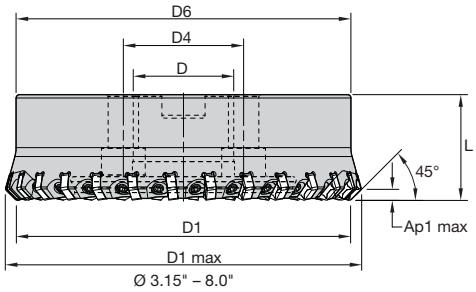
HexaCut 30° Cutter Body Design with Fixed and Adjustable Pocket Seats



			▼= 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°	.256"	■ OR	■ OR	■ OR	■	■	■	
▼	30°	.315"	■ OR	■ OR	■ OR	■	■		
▼▼	30°	.040"		■	■ OR	■ OR	■		■
▼/▼▼	30°	.315"	■ OR	■ OR	■ OR	■	■		

NOTE: Z = number of cutting edges.

- Monoblock cutter design.
- Twelve cutting edges per insert.
- High feed rates.
- CGI milling solution.





HexaCut Shell Mills • Monoblock Cutter Design • Right Hand

order number	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	lbs	max RPM
2402838	**K400B14RF45HN09C**	4.000	4.500	1.250	4.000	1.970	.256	14	5.00	3400
2402839	**K500B18RF45HN09C**	5.000	5.500	1.500	5.000	2.380	.256	18	10.00	3000

NOTE: Split case design with adapter flange for D1 = 10" and D1 = 12" can be ordered as preferred custom solution standard.

Spare Parts

				
D1	**wedge**	**wedge screw**	**in. lbs.**	**wrench**
4.000	**12748358200**	**12748600900**	62	**12148044900**
5.000	**12748358200**	**12748600900**	62	**12148044900**

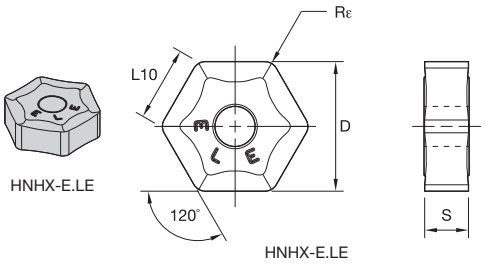
NOTE: Adjustable torque wrench (order number 6197561) and 3mm hex bit (order number 6205876) may be purchased separately in order to ensure proper torque setting.

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	–	–	–	–	–	–

Indexable Inserts • HexaCut • HN..0905...

- For semi-finishing and light roughing operations.



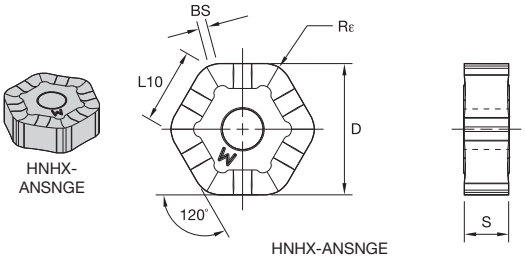
● first choice
○ alternate choice

	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
P						
M						
K	●	●	●	●	●	●
N						
S						
H						

HNHX-E.LE

catalog number	D	S	L10	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNHX5354ENLE	.638	.219	.368	.063	.002	12	●	●	–	–	–	–
HNHX5355ENLE	.638	.219	.368	.079	.002	12	●	●	–	–	–	–

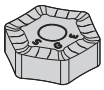
- Roughing geometry with integrated wiper facet for advanced floor finish.

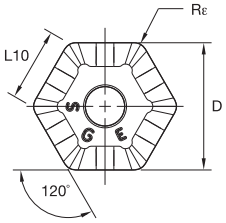


HNHX-ANSNGE

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNHX53ANSNGE	.638	.219	.351	.044	.047	.006	12	●	●	–	–	–	–

- Roughing geometry with improved rake design for lower cutting forces.


HNHX-S.GE



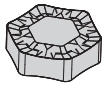
HNHX-S.GE

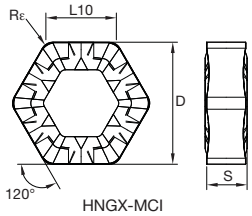
● first choice
○ alternate choice

P	
M	
K	●
N	
S	
H	

HNHX-S.GE

catalog number	D	S	L10	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNHX5354SNGE	.638	.219	.368	.063	.006	12	●	●	–	–	–	–
HNHX5355SNGE	.638	.219	.368	.079	.006	12	●	●	–	–	–	–
HNHX5358SNGE	.638	.219	.368	.118	.006	12	–	●	–	–	–	–

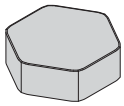

HNGX-MCI

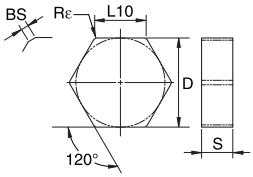


HNGX-MCI

HNGX-MCI

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNGX5358MCI	.638	.219	.368	—	.118	.002	12	–	●	–	–	–	–


HNEN-SN

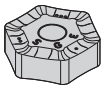


HNEN-SN

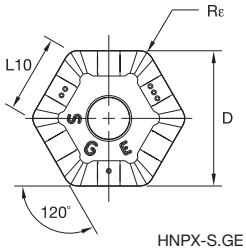
HNEN-SN

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNEN090508S	.625	.219	.361	—	.031	.008	12	–	–	–	–	–	●
HNEN0905ANSN	.625	.222	.361	—	—	.008	12	–	–	–	–	●	●
HNEN0905XNSN	.638	.219	.368	.051	—	.008	12	–	–	–	–	–	●

- Heavy roughing geometry for severe machining conditions.



HNPX-S.GE



HNPX-S.GE



● first choice
○ alternate choice

		KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
P							
M							
K		●	●	●	●	●	●
N							
S							
H							

HNPX-S.GE

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KCK15	KCK20	KCPK30	KD200	KY3500
HNPX5354SNGE	.638	.219	.368	–	.063	.006	12	–	●	–	–	–	–
HNPX5355SNGE	.638	.219	.368	–	.079	.006	12	–	●	–	–	–	–
HNPX5358SNGE	.638	.219	.368	–	.118	.006	12	–	●	–	–	–	–

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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	.010	**.026**	.046	.007	**.019**	.033	.006	**.014**	.025	.005	**.012**	.021	.004	**.011**	.020	...MCI
.E..LE	.010	**.025**	.046	.007	**.018**	.033	.006	**.014**	.025	.005	**.012**	.021	.004	**.011**	.020	.E..LE
.S..GE	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	.S..GE
...SN	.013	**.033**	.053	.009	**.024**	.038	.007	**.018**	.028	.006	**.015**	.025	.006	**.014**	.023	...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 17 in. lbs. and then tightened to a final torque of 62 in. lbs.

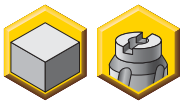
ATTENTION

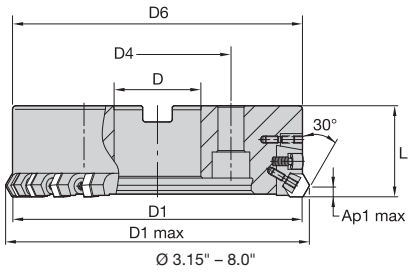
At each tool adjustment, the body, indexable inserts, and spare parts must be checked and replaced, if necessary. Before each tool use, the double-threaded screws of the indexable inserts and the stops must be tightened in the specified order to a torque of 62 in. lbs. In addition, even if the cartridges 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 26 in. lbs. If not, they must be re-tightened to this torque.

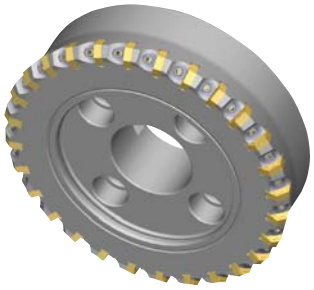
NOTE: The tools must only be used in accordance with their function. We accept no liability for their improper use. Changes of any kind and/or printing errors are not valid grounds for claims.



- CGI milling solution.
- Monoblock cutter design.
- High feed rates.
- Twelve cutting edges.



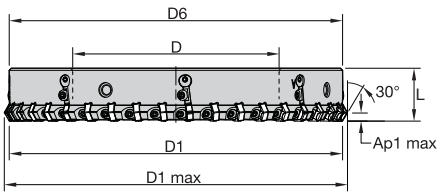




HexaCut Shell Mills • Monoblock Cutter Design with Adjustable Pockets • Right Hand

order number	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	Z ADJ	lbs	max RPM
2430830	**K315A62RF60HN09C**	3.150	3.490	1.000	3.150	2.000	.315	8	2	3.50	3900
2430931	**K600B164RF60HN09C**	6.000	6.340	2.000	6.000	2.380	.315	20	4	15.80	2600

NOTE: Split case design with adapter flange for D1=10" and D1=12" can be ordered as preferred custom solution standard.





HexaCut Shell Mills • Split Case Design

order number	catalog number	D1	D1 max	D	D6	L	Ap1 max	Z	Z ADJ	lbs	max RPM
6202335	**K1200Z328RF60HN09WSC**	12.000	12.369	7.677	12.000	1.969	.300	40	8	25.87	1800

NOTE: For carrier flange assembly order number, please see page S31.

Spare Parts







D1	clamp wedge	axial adjustment wedge	wedge screw	lbs	wrench
3.150	**12748358200**	**12748308500**	**12748600900**	4	**12148044900**
6.000	**12748358200**	**12748308500**	**12748600900**	16	**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.

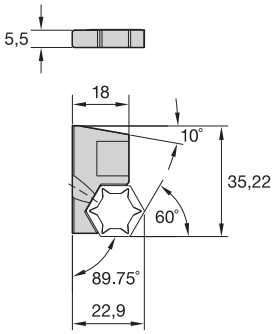
Setup for Roughing:

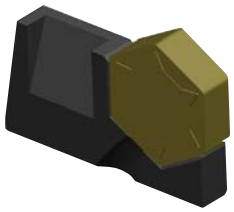
For a cutting depth of <.315" and an achievable surface finish of Ra >3,2.

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.





order number	catalog number
2018164	12748500200

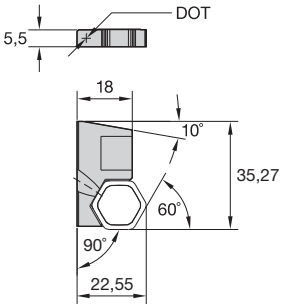
NOTE: Cartridges need to be ordered separately. Number of adjustable pockets (Z ADJ) related to cutting.

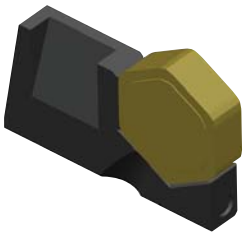
Setup for Finishing:

For a cutting depth of <.039" 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).





order number	catalog number
2018166	12748500400

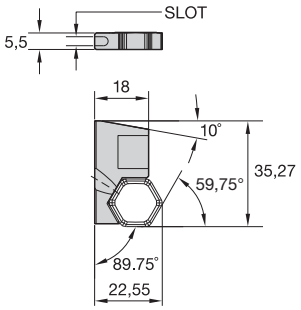
NOTE: Cartridges need to be ordered separately. Number of adjustable pockets (Z ADJ) related to cutting.

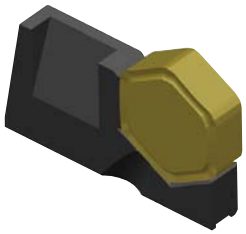
Setup for Finishing Cartridge for Low Axial Cutting Forces: (Reduced Lead Angle to Support Increased Clearance on the Wiper Edge).

For a cutting depth of <.039" 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).





order number	catalog number
2033468	12748503400

NOTE: Cartridges need to be ordered separately. Number of adjustable pockets (Z ADJ) related to cutting.

CBN Cartridge

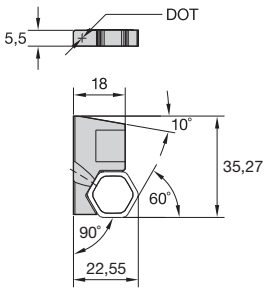
For a cutting depth of <1mm and an achievable surface finish of Ra 1,6.

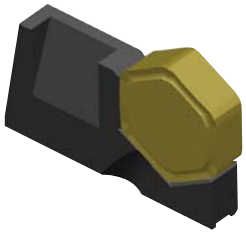
Semi-finishing insert:

HNEN0905AMSN KY3500 (loaded into fixed pocket seats).

Finishing wiper insert:

HNEN905ANSN KD200 (loaded into finishing cartridge).



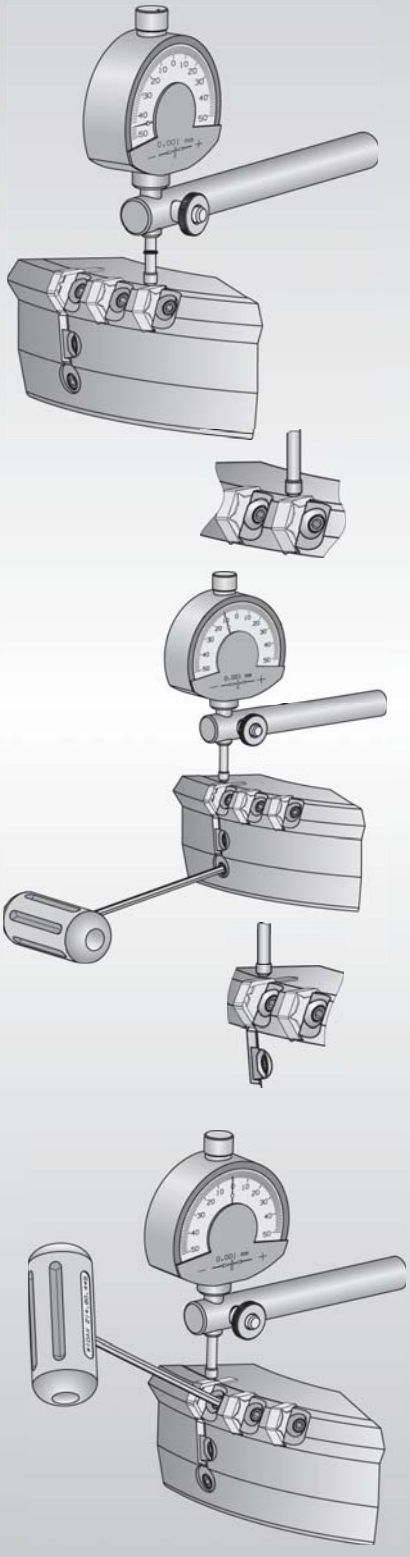


order number	catalog number
3400879	12748500500

Insert setting procedure

This procedure is to be used on all 30° 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 26 in. lbs.
3. Mount all inserts, making sure they are seated properly in the pocket, and torque the insert lock wedge screws to 26 in. lbs.
4. Torque the wedge screws for all fixed pocket inserts to 62 in. lbs.
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 .008–.012" below the fixed pocket inserts.
7. Torque the insert lock wedge screw and the cartridge lock wedge screw to 26 in. lbs.
8. Adjust the axial position to .0010–.0015" above the fixed pocket inserts.
9. Loosen the cartridge insert lock wedge screws and then re-torque to 26 in. lbs.
10. Adjust the axial position to the final dimension, .0015–.0020" above the highest fixed pocket insert.
11. Torque the insert lock wedge screws and the cartridge lock wedge screws to 62 in. lbs.
12. Conduct a final check of the axial runout and position.



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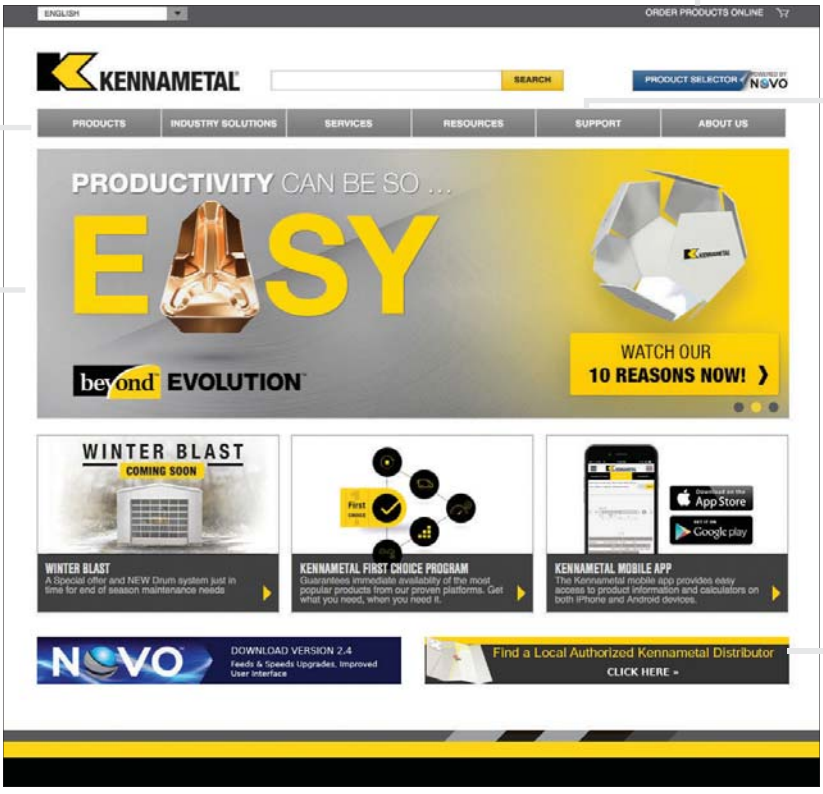

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The KSSR™ 6° Inserts

Primary Application

The Kennametal new line of KSSR 6° 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, KSSR 6° inserts can be used for all fine and coarse pitch styles.

*Left-hand cutters are available as non-stock standard.

Features and Benefits

KSSR 6° Features

- Available in metric and inch products, diameters from 2.5–4"; for larger diameter custom solution is available.
- Fine and coarse pitch styles.
- Easy to use and to adjust with shorter setup time.
- Wiper inserts in carbide and ceramic provide excellent surface quality.

Improved Versatility

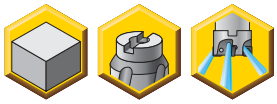
- Proven solution for the automotive segment.
- Right- and *left-hand cutters, ideal for transfer lines.
- Premium grades in carbide and ceramic for applications in cast and ductile irons and alloy steels.
- Inserts are neutral and can be used for right- or left-hand cutting.

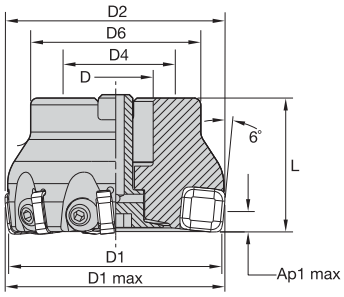


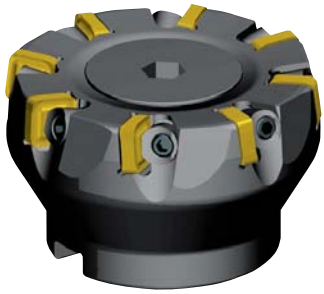
Unrivaled Benefits

- Capability: .20" maximum depth of cut.
- Excellent accuracy:
  Radial = +/- .0001"
  Axial = adjustable +/- .0001"
- Inserts have eight true cutting edges.

- Eight cutting edges per insert.
- Fast and easy insert indexing.
- Highest feed rates.
- CGI specialist.







KSSR 6° • Shell Mills • Right Hand • Fixed Pockets

order number	catalog number	D1	D1 max	D	D2	D6	L	Ap1 max	Z	lbs	max RPM
2476832	**KSSR250SN434M3**	2.500	2.579	.750	2.520	1.770	1.500	.200	9	1.10	7500
2476963	**KSSR300SN434M4**	3.000	3.079	1.000	3.017	2.200	1.750	.200	11	1.98	6300
2476964	**KSSR400SN434M5**	4.000	4.079	1.250	4.014	2.870	1.750	.200	15	3.08	4700

NOTE: Coolant screw and coolant cap must be ordered separately.
2466094 and 2466095 are non-stock standard.

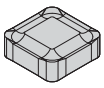
Spare Parts

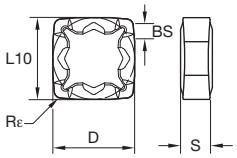
D1	 clamp wedge	 wedge screw	 in. lbs.	 wrench
2.500	**12748358200**	**12748600900**	62	**12148044900**
3.000	**12748358200**	**12748600900**	62	**12148044900**
4.000	**12748358200**	**12748600900**	62	**12148044900**

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..LD	KCK15	**.S..GP**	**KCK15**	.S..HE	KCK15
K3	.E..LD	KCK20	**.S..GP**	**KCK20**	.S..HE	KCK20
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–


SNXF-LD



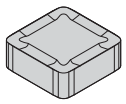
SNXF-LD

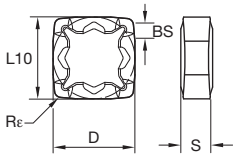
● first choice
○ alternate choice

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

SNXF-LD

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
SNXF433ENLD	.500	.180	.500	—	.047	.002	8	●	●	●	●	●	–
SNXF43ZNENLD	.500	.174	.500	.067	.063	.002	8	●	●	●	●	●	–

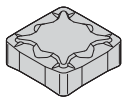

SNXF-GP

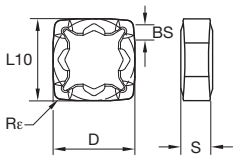


SNXF-GP

SNXF-GP

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
SNXF433SNGP	.500	.184	.500	—	.047	.002	8	●	●	●	●	●	–
SNXF43ZNSNGP	.500	.184	.500	.040	.047	.003	8	●	●	●	●	●	–

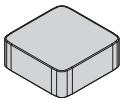

SNXF-HE

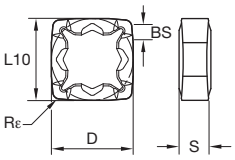


SNXF-HE

SNXF-HE

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
SNXF433SNHE	.500	.183	.500	—	.047	.002	8	–	●	●	●	●	–
SNXF43ZNSNHE	.500	.183	.500	.039	.047	.002	8	●	–	●	●	●	–


SNXF-SN



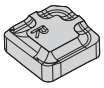
SNXF-SN

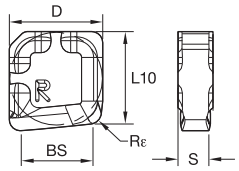
● first choice
○ alternate choice

P	
M	
K	
N	
S	
H	

SNXF-SN

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
SNXF433AMSN	.500	.187	.500	—	.047	.008	8	–	–	–	–	–	●
SNXF43ZNAMSN	.500	.187	.500	.039	.047	.008	8	–	–	–	–	–	●

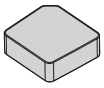

XNXF-LDW

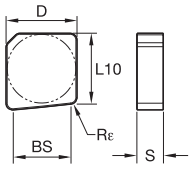


XNXF-LDW

XNXF-LDW

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
XNXF43ZNENLDW	.500	.174	.500	.374	.063	.002	2	–	–	●	–	–	–


XNXF-ENW



XNXF-ENW

XNXF-ENW

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC514M	KC524M	KCK15	KCK20	KCPK30	KY3500
XNXF43ZNENW	.500	.188	.500	.374	.047	.008	2	–	–	–	–	–	●

Face Milling

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

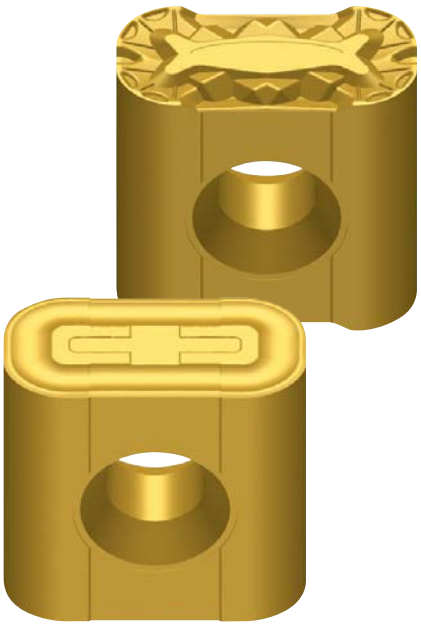
Light Machining	General Purpose	Heavy Machining

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	.007	**.018**	.033	.005	**.013**	.024	.004	**.010**	.018	.003	**.009**	.015	.003	**.008**	.014	.E..LD
.S..GP	.008	**.020**	.036	.006	**.015**	.026	.004	**.011**	.019	.004	**.009**	.017	.003	**.009**	.015	.S..GP
.S..HE	.007	**.020**	.038	.005	**.015**	.027	.004	**.011**	.020	.003	**.010**	.018	.003	**.009**	.016	.S..HE
.A..SN	.009	**.023**	.038	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.018	.004	**.010**	.016	.A..SN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

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.



Visit **kennametal.com** or contact your local Authorized Kennametal Distributor.

KENNAMETAL®

kennametal.com

MEGA 45°

Superior Heavy-Duty Milling

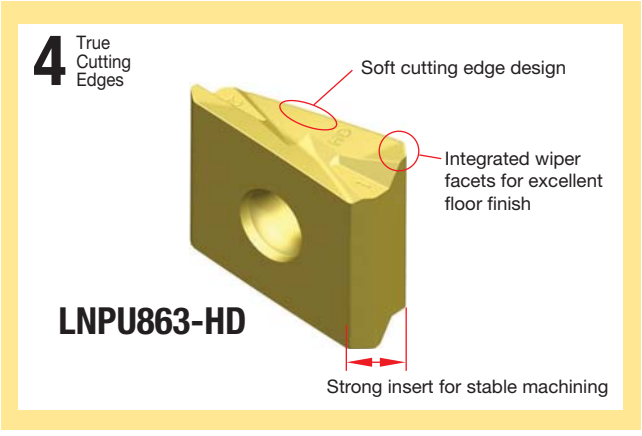
Primary Application

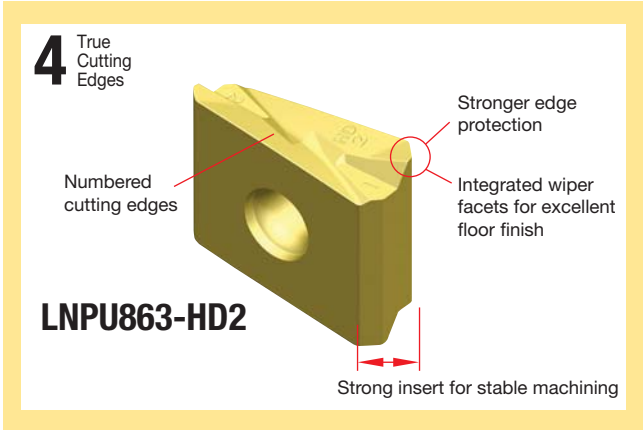
With four true cutting edges per heavy-duty MEGA 45° insert, you are getting the low cost per edge and high productivity you need and have come to expect from Kennametal. The soft cutting edge design enables 30% lower cutting forces, and the carbide shim provides protection to the cutter body. Choose MEGA 45° inserts for all steel and cast iron indexable milling needs.

Features and Benefits

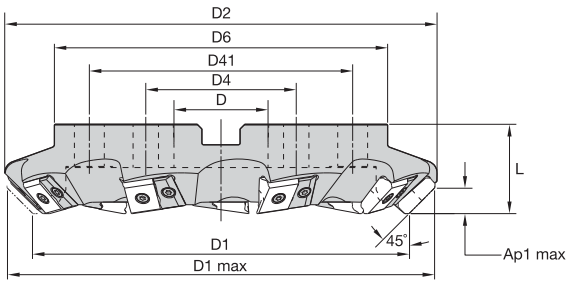
Features	Benefits
• Four true cutting edges per heavy-duty MEGA 45° insert.	• Low cost per edge and high productivity.
• Soft cutting edge design.	• 30% lower cutting forces.
• Up to 30% increased Metal Removal Rates (MRR).	• Performance leader in steel and cast iron materials.
• Carbide pocket shims.	• Excellent cutter body protection.
• Cutting edge numbering system.	• Improved run out 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
LNPU863-HD
Strong insert for stable machining


4 True Cutting Edges
Stronger edge protection
Numbered cutting edges
Integrated wiper facets for excellent floor finish
LNPU863-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	catalog number	D1	D1 max	D	D2	D4	D41	D6	L	Ap1 max	Z	lbs	max RPM
4032274	**MEGA45D500LN863M6**	5.000	6.391	1.500	6.700	—	—	3.810	2.375	.675	6	9.18	12520
4032277	**MEGA45D800LN863M10**	8.000	9.392	2.500	9.550	4.000	—	6.500	2.375	.675	9	19.86	9890
4105177	**MEGA45D1000LN863C10**	10.000	11.392	2.500	11.500	4.000	7.000	8.858	2.375	.675	9	28.04	8850
4032278	**MEGA45D1000LN863M10 ***	10.000	11.392	2.500	11.500	4.000	7.000	8.858	2.375	.675	11	29.05	8850
4105178	**MEGA45D1200LN863C10**	12.000	13.392	2.500	13.500	4.000	7.000	8.858	3.150	.675	10	47.50	8080
4032279	**MEGA45D1200LN863M10**	12.000	13.392	2.500	13.500	4.000	7.000	8.858	3.150	.675	13	48.82	8080

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

Spare Parts

D1	insert screw	in. lbs.	shim	universal bit torque driver	drive bit
5.000	**MS1162**	45	**SM-906**	**DTQ3054**	**BTQT25**
8.000	**MS1162**	45	**SM-906**	**DTQ3054**	**BTQT25**
10.000	**MS1162**	45	**SM-906**	**DTQ3054**	**BTQT25**
12.000	**MS1162**	45	**SM-906**	**DTQ3054**	**BTQT25**

NOTE: Shim screw: MS1162.

Left-handed shim



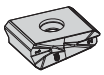
catalog number
SM-906LH

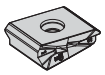
NOTE: Left hand inserts and shims available as standard line items. Left hand cutter bodies to be requested as tailor-made custom solutions. Please refer to the Innovations 2016 Catalog A-15-04498 (Page D60) for the Insert Selection Guide and Cutting Data Recommendation.

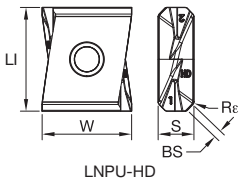
Insert Selection Guide

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	–	–	**–**	**–**	–	–

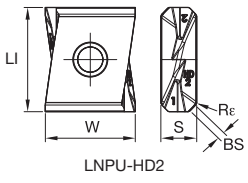
Indexable Inserts


LNPU-HD


LNPU-HD2



LNPU-HD



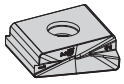
LNPU-HD2

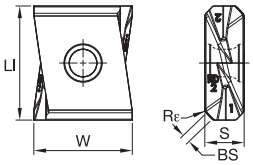
● first choice
○ alternate choice

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

LNPU-HD

catalog number	LI	BS	W	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
LNPU863ANSRHD	1.142	.088	.985	.047	.394	.009	4	–	●	●	●	–	–
LNPU863ANSRHD2	1.142	.088	.986	.047	.394	.009	4	–	–	–	●	●	●


LNPU-HD2



LNPU-HD2

LNPU-HD2 • Left Hand

catalog number	LI	BS	W	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
LNPU863ANSLHD	1.142	.088	.985	.047	.394	.009	4	–	–	–	●	●	–
LNPU863ANSLHD2	1.142	.088	.986	.047	.394	.009	4	–	–	–	●	●	–

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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	.013	**.033**	.053	.009	**.023**	.038	.007	**.018**	.028	.006	**.015**	.024	.006	**.014**	.022	.S..HD
.S..HD2	.013	**.036**	.060	.009	**.026**	.043	.007	**.019**	.032	.006	**.017**	.028	.006	**.015**	.025	.S..HD2

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

MEGA 60 and 90

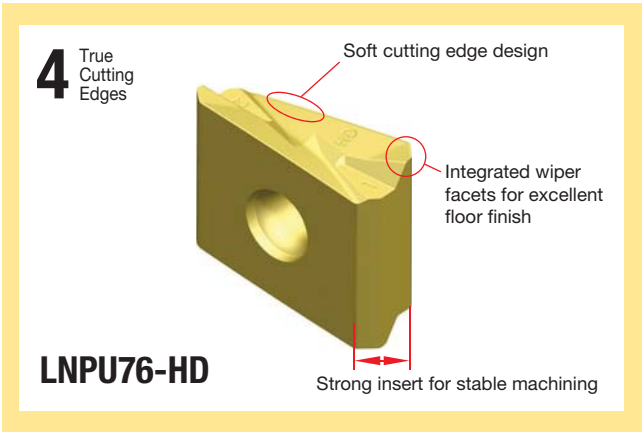
Primary Application

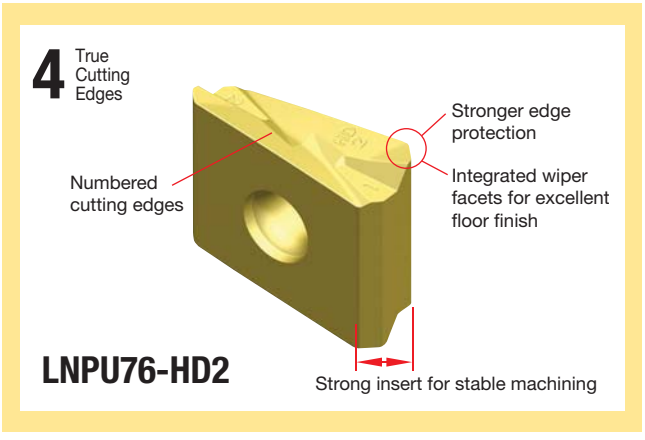
The real performance booster in heavy-duty milling. With four true cutting edges per heavy-duty insert, you are getting the low cost per edge and high productivity you need and have come to expect from Kennametal. The soft cutting edge design enables 30% lower cutting forces, and the carbide shim provides protection to the cutter body. Choose MEGA 60 and MEGA 90 for all steel and cast iron indexable milling needs.

Features and Benefits

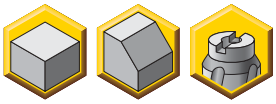
Features	Benefits
• Four true cutting edges per heavy-duty MEGA 60 and 90 insert.	• Low cost per edge and high productivity.
• Soft cutting edge design.	• 30% lower cutting forces.
• Up to 30% increased Metal Removal Rates (MRR).	• Performance leader in steel and cast iron materials.
• Carbide pocket 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.

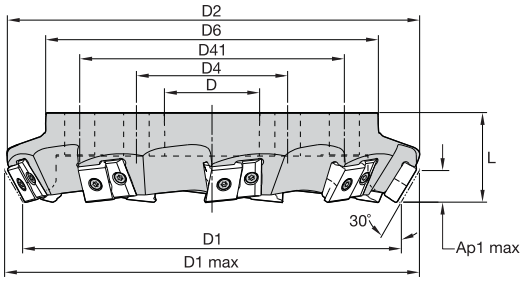



4 True Cutting Edges
Soft cutting edge design
Integrated wiper facets for excellent floor finish
LNPU76-HD
Strong insert for stable machining


4 True Cutting Edges
Stronger edge protection
Numbered cutting edges
Integrated wiper facets for excellent floor finish
LNPU76-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	catalog number	D1	D1 max	D	D2	D4	D41	D6	L	Ap1 max	Z	lbs	max RPM
4147496	**MEGA60D500LN76M6**	5.000	5.982	1.500	6.181	—	—	3.810	2.375	.843	6	8.03	11040
4147497	**MEGA60D600LN76M8**	6.000	6.982	2.000	7.126	—	—	5.000	2.375	.842	7	11.07	10080
4147499	**MEGA60D800LN76M10**	8.000	8.981	2.500	8.976	4.000	—	6.500	2.375	.842	9	17.83	8720
4147523	**MEGA60D1200LN76M10** *	12.000	12.981	2.500	12.953	4.000	7.000	8.858	3.150	.841	13	41.92	7120

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

Spare Parts

D1	insert screw	in. lbs.	shim	universal bit torque driver	drive bit
5.000	**MS1162**	45	**SM-906**	**DTQ3054**	**BTQT25**
6.000	**MS1162**	45	**SM-906**	**DTQ3054**	**BTQT25**
8.000	**MS1162**	45	**SM-906**	**DTQ3054**	**BTQT25**
12.000	**MS1162**	45	**SM-906**	**DTQ3054**	**BTQT25**

NOTE: Shim screw: MS1162.

Left-handed shim



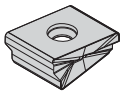
catalog number
SM-906LH

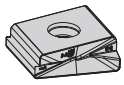
NOTE: Left hand inserts and shims available as standard line items. Left hand cutter bodies to be requested as tailor-made custom solutions. Please refer to the Innovations 2016 Catalog A-15-04498 (Page D60) for the Insert Selection Guide and Cutting Data Recommendation.

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	–	–	**–**	**–**	–	–

Indexable Inserts


LNPU-HD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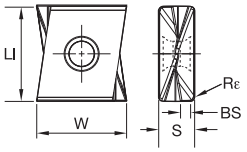
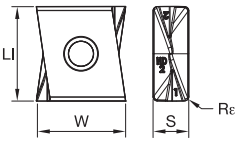


LNPU-HD



LNPU-HD2

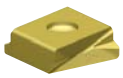
● first choice
○ alternate choice

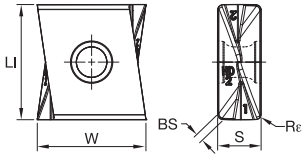
beyond

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

LNPU-HD/-HD2

catalog number	LI	BS	W	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
LNPU763PNSRHD	1.043	.091	.985	.047	.394	.009	4	–	●	●	●	●	–
LNPU763PNSRHD2	1.043	.091	.984	.047	.394	.009	4	–	–	–	●	●	●


LNPU-HD



LNPU-HD

LNPU-HD2

catalog number	LI	BS	W	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
LNPU763PNSLHD2	1.043	.091	.984	.047	.394	.009	4	●	–	–	●	●	–

Recommended Starting Feeds

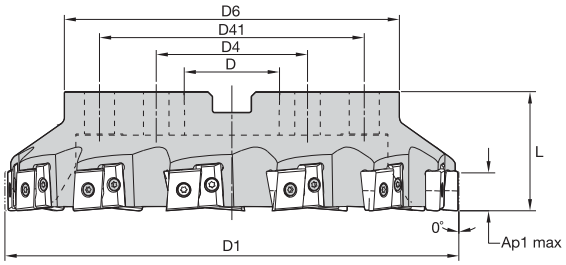
Recommended Starting Feeds [IPT]

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	.011	**.027**	.043	.008	**.019**	.031	.006	**.014**	.023	.005	**.013**	.020	.005	**.012**	.018	.S..HD
.S..HD2	.011	**.027**	.048	.008	**.019**	.034	.006	**.014**	.025	.005	**.013**	.022	.005	**.012**	.020	.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.

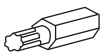




MEGA 90 • Shell Mills

order number	catalog number	D1	D	D4	D41	D6	L	Ap1 max	Z	lbs	max RPM
4136381	**MEGA90D500LN76M6**	5.000	1.500	—	—	3.810	2.375	1.002	6	6.86	9990
4136382	**MEGA90D600LN76M8**	6.000	2.000	—	—	5.000	2.375	1.002	7	10.23	9120
4136385	**MEGA90D1000LN76C10**	10.000	2.500	4.000	—	6.500	2.375	1.002	9	22.48	7060
4136387	**MEGA90D1200LN76C10**	12.000	2.500	4.000	7.000	8.858	3.150	1.002	10	38.12	6440
4136388	**MEGA90D1200LN76M10**	12.000	2.500	4.000	7.000	8.858	3.150	1.002	13	38.21	6440

Spare Parts

D1	 insert screw	 in. lbs.	 shim	 universal bit torque driver	 drive bit
5.000	**MS1162**	45	**SM-906**	**DTQ3054**	**BTQT25**
6.000	**MS1162**	45	**SM-906**	**DTQ3054**	**BTQT25**
10.000	**MS1162**	45	**SM-906**	**DTQ3054**	**BTQT25**
12.000	**MS1162**	45	**SM-906**	**DTQ3054**	**BTQT25**

NOTE: Shim screw: MS1162.

Left-handed shim

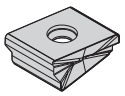


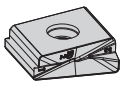
catalog number
SM-906LH

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 Catalog 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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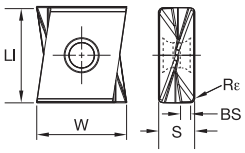
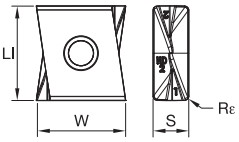


LNPU-HD



LNPU-HD2

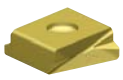
● first choice
○ alternate choice

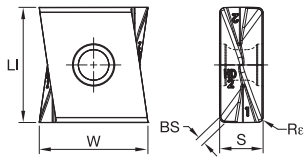
beyond

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

LNPU-HD/-HD2

catalog number	LI	BS	W	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
LNPU763PNSRHD	1.043	.091	.985	.047	.394	.009	4	–	●	●	●	●	–
LNPU763PNSRHD2	1.043	.091	.984	.047	.394	.009	4	–	–	–	●	●	●


LNPU-HD



LNPU-HD

LNPU-HD2

catalog number	LI	BS	W	Rε	S	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
LNPU763PNSLHD2	1.043	.091	.984	.047	.394	.009	4	●	–	–	●	●	–

Recommended Starting Feeds [IPT]

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	.009	**.023**	.037	.007	**.017**	.026	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..HD
.S..HD2	.009	**.023**	.041	.007	**.017**	.029	.005	**.013**	.022	.004	**.011**	.019	.004	**.010**	.018	.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.



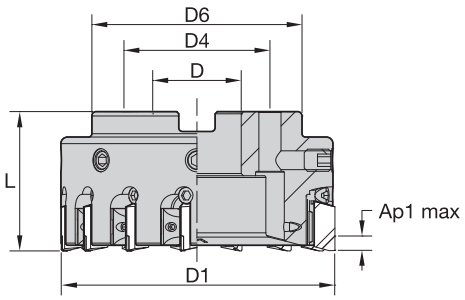
Features and Benefits

- Cutter bodies manufactured from hard anodized aluminum 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 0.0002" (0,005mm), with a total adjustment of 0.032" (0,8mm).
- Two grades, KD1400™ and KD1425™, provide options in maximizing efficiencies based upon application.
- Roughing, semi-finishing, and fine-finishing with one platform.
- Two corner radii — 0.031 and 0.093" (0,8 and 2,4mm).
- Mini-tip insert for finishing applications.
- All standard inserts have a 0.06" (1,5mm) wiper facet for better surface qualities.
- Full face wiper available as a standard item.

Delivering Customer-Driven Performance for 20+ Years.









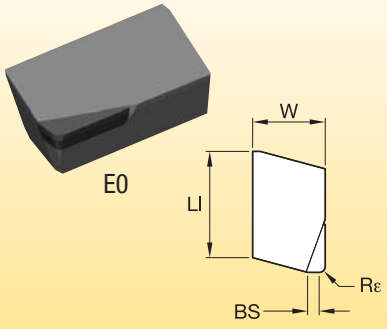
Face Mills

order number	catalog number	D1	D	D4	D6	L	Z	Z ADJ	lbs	max RPM
6044579	**KBDM250SD06**	2.500	1.000	–	2.441	2.000	6	6	1.00	20000
6044580	**KBDM300SD08**	3.000	1.000	–	2.190	2.000	8	8	1.40	20000
6044711	**KBDM400SD12**	4.000	1.250	–	2.875	2.000	12	12	2.50	17320
6044712	**KBDM500SD16**	5.000	1.500	–	3.812	2.375	16	16	4.40	15500
6044713	**KBDM600SD18**	6.000	1.500	–	3.812	2.375	18	18	7.00	14150
6044714	**KBDM800SD24**	8.000	2.500	4.000	5.000	2.375	24	24	1.40	12240

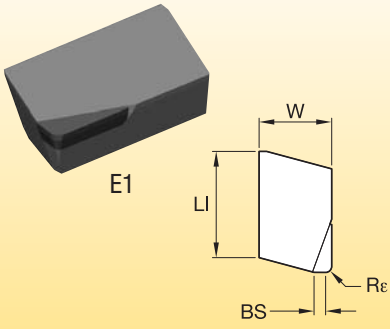
Spare Parts

D1	screw	wedge	wedgelock screw	coolant lock screw	coolant shower plate
2.500	**LS103**	**HDWM5EUS**	**SWSM515**	**SALS25**	**–**
3.000	**LS103**	**HDWM5EUS**	**SWSM515**	**SALS30**	**–**
4.000	**LS103**	**HDWM5EUS**	**SWSM515**	**SALS40**	**–**
5.000	**LS103**	**HDWM5EUS**	**SWSM515**	**SALS50**	**–**
6.000	**LS103**	**HDWM5EUS**	**SWSM515**	**SALS6150**	**–**
8.000	**LS103**	**HDWM5EUS**	**SWSM515**	**–**	**SSP8**

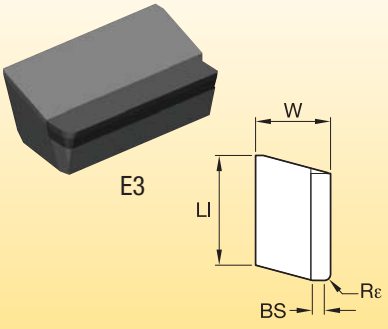
Technical Information • Ap1 max for PCD Inserts



Ap1 max .100"



Ap1 max .250"



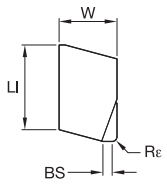
Ap1 max .500"

Insert Selection Guide • KBDM • Inch

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	

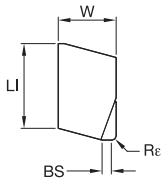
PCD Inserts • KSDR Mini-Tip • E0

catalog number	LI	W	BS	Rε	hm	KD1400	KD1425
KSDR100031E0W0S	.624	.375	—	.031	.001	●	●
KSDR100031E0W4S	.625	.375	.060	.031	.001	●	●

NOTE: For Mini-tip (E0), Ap1 max = .100".



E1



E1

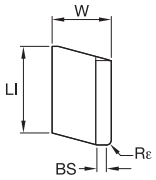
PCD Inserts • KSDR • E1

catalog number	LI	W	BS	Rε	hm	KD1400	KD1425
KSDR100031E1W4S	.625	.375	.060	.031	.001	●	●
KSDR100093E1W4S	.625	.375	.060	.093	.001	●	●

NOTE: For E1 inserts, Ap1 max = .250".



E3



E3

● first choice
○ alternate choice

P			
M			
K			
N		●	●
S			
H			

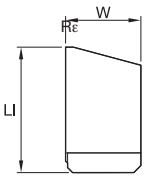
PCD Inserts • KSDR • E3

catalog number	LI	W	BS	Rε	hm	KD1400	KD1425
KSDR100031E3W4S	.625	.375	.060	.031	.001	●	●

NOTE: For Full Edge (E3), Ap1 max = .500".



KSDR



KSDR

PCD Inserts • KSDR Wiper

catalog number	LI	W	BS	Rε	hm	KD1400	KD1425
KSDR102S	.625	.375	.035	–	.001	●	●

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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…..	.005	**.014**	.023	.003	**.010**	.017	.003	**.008**	.013	.002	**.007**	.011	.002	**.006**	.010	.KSDR…..

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Face Milling

PCD Custom Solutions for Indexable Milling

- Diameters up to 21.65" (550mm).
- Integral shank options, ie, HSK.
- Left-hand rotation.
- Internal coolant capable.
- PCD lengths up to 0.50" (12,7mm).
- Specific edge preps and nose radii available.



Insert Setting and Fine Adjustment Procedure

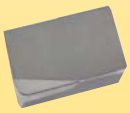
Face Mills

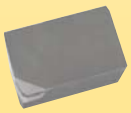
- Apply a small amount of lubricant to the following areas:
  - — Pocket area where the wedge slides.
  - — Threads of the insert locking screw.
  - — Threads of the axial adjustment screw.
- Install cartridges applying light torque to the wedge assembly locking screw.
- Turn axial adjustment screw until the cartridge is .0004–.0006" (0,01–0,015mm) below the final set height.
- Tighten the wedge assembly locking screw to 31 In/lbs and (4 Nm) 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 0.0002" (0,005um) 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 inserts.
- Clean the pockets of the cutter completely.





KBDM Wiper Setup

- Set Wiper 0.0006–0.0008" (15–20 microns) 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 0.28" (7,1mm) advancement before another wiper would be needed.
- Wiper radius is 30.0" (762mm).
- 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: 0.008" (0,2mm)
# 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 10.0" (250mm) and 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 program is specifically engineered to deliver best-in-class performance in high-volume aluminum 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™ program for reconditioning worn cartridges, you can reduce inventory costs as well!

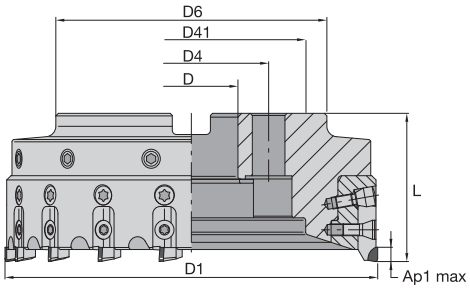
Features and Benefits

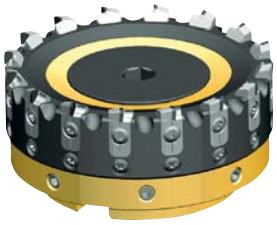
- Anti-vibration cutter design.
- Best rigidity for high feed rates.
- Unique dovetail wedge clamping design.
- No radial movement of cartridges.
- Centrifugal force protection cartridge design.
- Integrated chip gash into cartridge.
- Quick setup and easy adjust concept.
- Flexible cartridge configuration.
- No bur cartridges for fine finishing.
- Blue Box™ service.



- PCD cartridge face mill for high production aluminum face milling.
- Rough and finish in one operation.
- Precision balanceable cutter bodies produce mirror-finish surfaces.







KSCM AluMill • Shell Mills

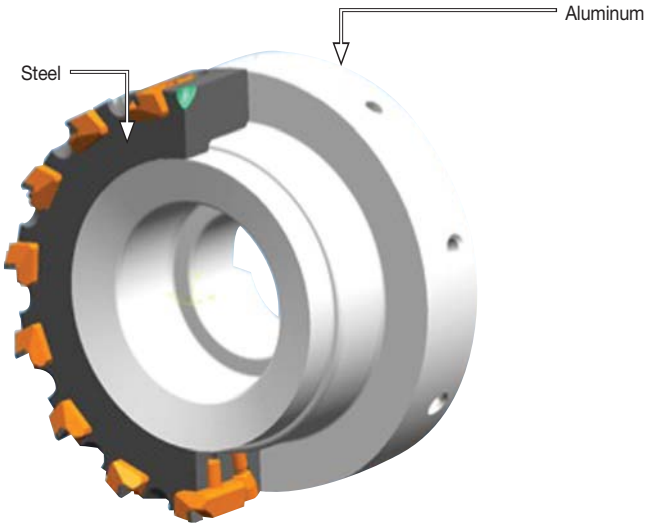
order number	catalog number	D1	D	D6	L	Z	Z ADJ	lbs	max RPM
2982056	**KSCM125R16CAB40U**	5.000	1.500	3.772	2.380	16	16	5.46	19100

NOTE: Ap1 max is dependent on the cartridge configuration; see the values listed under the cartridges.

Spare Parts

D1	cartridge screw	drive bit	coolant lock screw	balancing screw
5.000	**193.465**	**170.279**	**420.042**	**193.462**

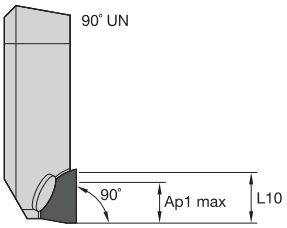
NOTE: All cutters are bi-metallic except the 3.00" (80mm) diameter.
Ap1 max is dependent on the cartridge configuration; see the values listed under the cartridges.
Please order KSCM cutters bodies and cartridges separately.



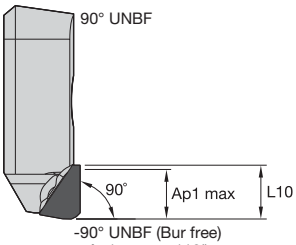
Cartridge Selection Guide

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	–	–	–	–	–	–

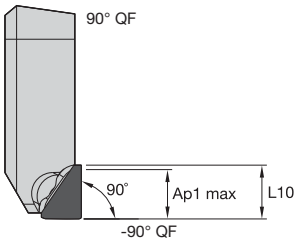
Cartridges • KSCM AluMill



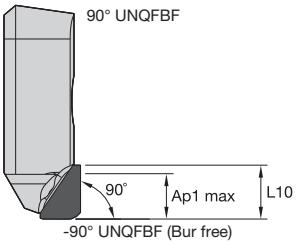
-90° UN
Ap1 max = .118"



-90° UNBF (Bur free)
Ap1 max = .118"



-90° QF
Ap1 max = .118"



-90° UNQFBF (Bur free)
Ap1 max = .118"

cartridge combination	ratio	max ap	surface quality
UN	—	.118	Rz 2–Rz 4
UN + QF	3:1	.118	Rz 1,5–Rz 2,5
PT + UN	X:1	.118	Rz 3,2–Rz 17

● first choice
○ alternate choice

		KD1400	KD1420
P			
M			
K			
N		●	●
S			
H			

Cartridges • KSCM AluMill • 90° -UN

catalog number	KRI ANSI	L10	hm	KD1400	KD1420
KSCMCA90UN	0	.240	.001	–	●

Cartridges • KSCM AluMill • 90° -UNBF

catalog number	KRI ANSI	L10	hm	KD1400	KD1420
KSCMA90UNBF	—	.244	—	●	●
KSCMCA90UNBF	0	.242	.001	–	●

NOTE: KSCMA90UNBF & KSCMA90QFBF should be the 1st choice solutions for KSCM PCD milling applications.
For setup instructions reference pages S117-S118.

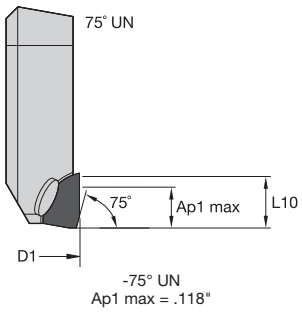
Cartridges • KSCM AluMill • 90° -QF

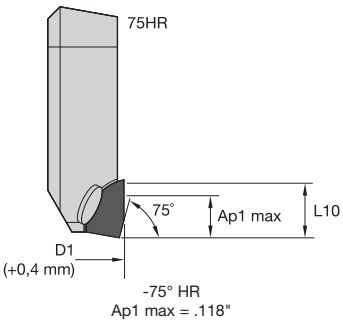
catalog number	KRI ANSI	L10	hm	KD1400	KD1420
KSCMCA90QF	0	.244	.001	–	●

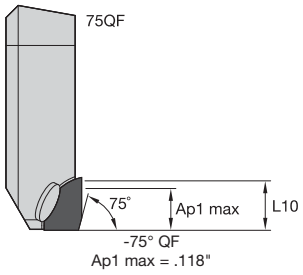
Cartridges • KSCM AluMill • 90° -QFBF

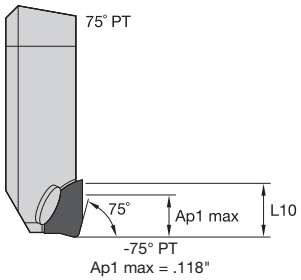
catalog number	KRI ANSI	L10	hm	KD1400	KD1420
KSCMA90QFBF	—	.244	—	●	●
KSCMCA90QFBF	0	.244	.001	–	●

NOTE: KSCMA: Blanks without PCD segment, if cutter is not fully loaded with cartridges.
For low horsepower machines and cutter configurations with less effective teeth.









● first choice
○ alternate choice

P		
M		
K		
N	●	●
S		
H		

Cartridges • KSCM AluMill • 75° -UN

catalog number	KRI ANSI	L10	hm	KD1400	KD1420
KSCMCA75UN	15	.240	.001	–	●

Cartridges • KSCM AluMill • 75° -HR

catalog number	KRI ANSI	L10	hm	KD1400	KD1420
KSCMCA75HR	15	.213	.001	–	●

Cartridges • KSCM AluMill • 75° -QF

catalog number	KRI ANSI	L10	hm	KD1400	KD1420
KSCMCA75QF	15	.240	.001	–	●

Cartridges • KSCM AluMill • 75° -PT

catalog number	KRI ANSI	L10	hm	KD1400	KD1420
KSCMCA75PT	15	.240	.001	–	●

NOTE: KSCMA: Blanks without PCD segment, if cutter is not fully loaded with cartridges.
For low horsepower machines and cutter configurations with less effective teeth.

cartridge combination	ratio	max ap	surface quality
UN	–	.118	Rz 2–Rz 4
UN + QF	3:1	.118	Rz 1,5–Rz 2,5
PT + UN	X:1	.118	Rz 3,2–Rz 17

Recommended Starting Feeds

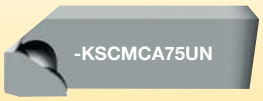
Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

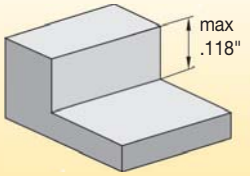
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
KCSM…	.005	**.014**	.023	.003	**.010**	.017	.003	**.008**	.013	.002	**.007**	.011	.002	**.006**	.010	KCSM…

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Tool Configuration • Universal Cartridge

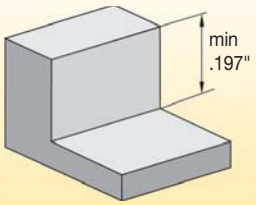


Face milling cutter fitted entirely with universal cartridges.



Depth of Cut:
max .118"

Surface Quality:
Rz2 - Rz4

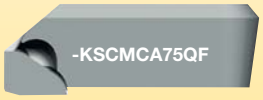


Contouring:
PCD cutting edge length = .197"

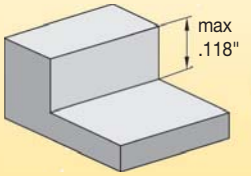
Tool Configuration • Universal Cartridge



+ Finishing Cartridge

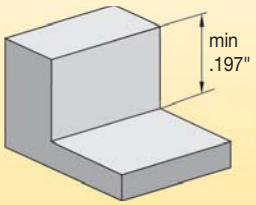


Fitting the face milling cutter with universal and finishing cartridges in a ratio of approximately 3:1.



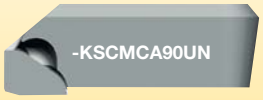
Depth of Cut:
max .118"

Surface Quality:
Rz1,5 - Rz2,5

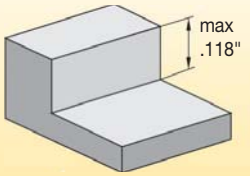


Contouring:
PCD cutting edge length = .197"

Tool Configuration • Edge Cartridge

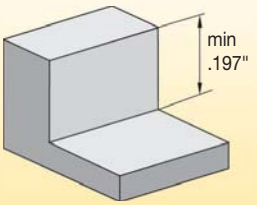


Fitting the face milling cutter entirely with edge cartridges.



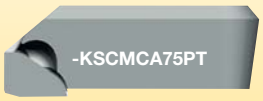
Depth of Cut:
max .118"

Surface Quality:
Rz2 - Rz4

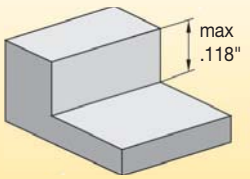


Contouring:
PCD cutting edge length = .197"

Tool Configuration • Cartridge for Defined Surfaces

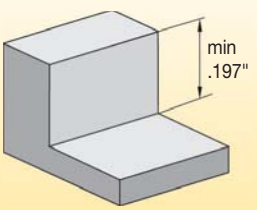


Fitting the face milling cutter entirely with cartridges for defined surfaces.



Depth of Cut:
max .118"

Surface Quality:
Rz3,2 - Rz17



Contouring:
PCD cutting edge length = .197"

Tool Configuration • Universal Cartridge, 75° Face Milling







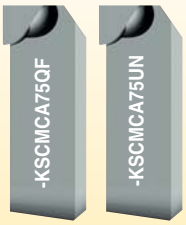
1. Insert cartridges into the body.
2. Screw in the clamping screws (RH), and tighten to 88 in. lbs.
3. Screw in the adjusting screws (RH), and tighten to 26 in. lbs.

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 88 in. lbs.
3. Screw in the adjusting screws (RH), and tighten to 26 in. lbs.

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 .0003" + .0008". 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 88 in. lbs.
3. Screw in the adjusting screws (RH), and tighten to 26 in. lbs

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 7 ft. lbs.
3. Screw in the adjusting screws (RH), and tighten to 26 in. lbs.



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.



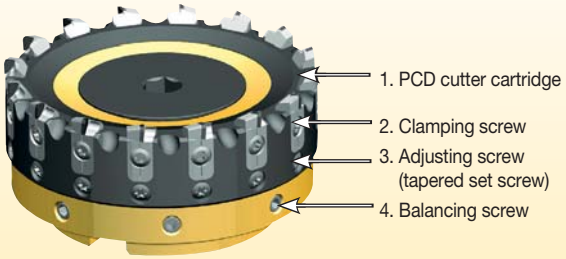


NOTE: The process must be repeated when the cartridges are changed. To dismantle, remove the adjusting element (Part 3), clamping screw (Part 2), and cartridge (Part 1).

Instruction for Mounting the Face Milling Cutter on the Appropriate Toolholder

User Information:

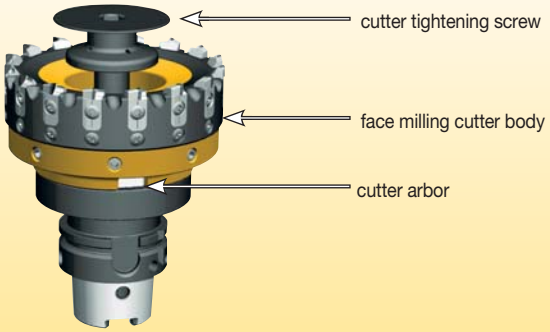
- Tools conform to EN ISO 15641.
- Absolute cleanliness must be observed when assembling the face milling cutter.
- An optimum cutting result will only be achieved by adjusting and balancing the complete tool system (face milling cutter + toolholder).
- Balancing is achieved with the aid of the balancing 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 arbor. 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 (adapter diameter 40): **184 ft. lbs.**
M16 (adapter diameter 32): **110 ft. lbs.**
M12 (adapter diameter 27): **59 ft. lbs.**

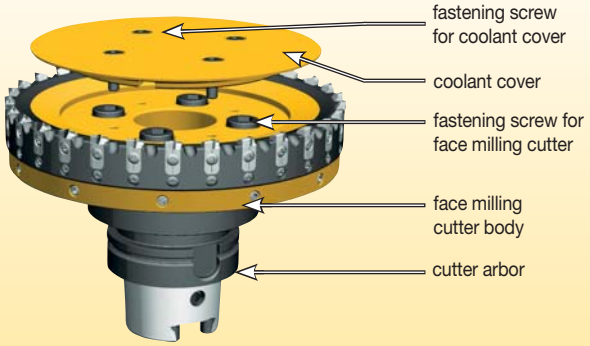


Mounting the Face Milling Cutter (Dimensions Similar to DIN 8030 Form C)

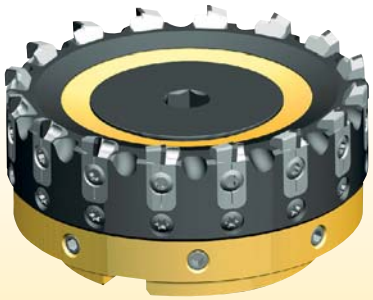
Place the body of the face milling cutter on the arbor. Ensure that the contact faces are clean. Screw in the fastening bolt (RH) and tighten with the appropriate torque. Put the aluminum coolant cover in place and fasten with the Torx fastening screws.

Tightening torque for the face milling cutter fastening screws:
M20: 184 ft. lbs.
M16: 81 ft. lbs.
M12: 36 ft. lbs.

Tightening torque for the coolant cover fastening screws:
M8: 13 ft. lbs.

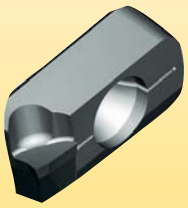


KSCM AluMill
Reconditioning Service



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.

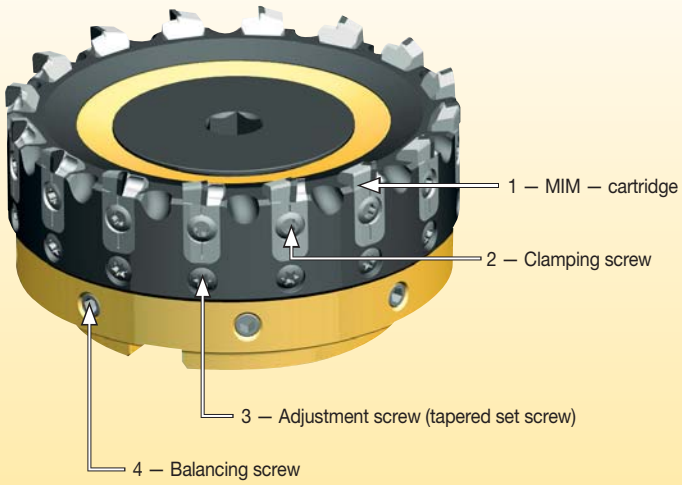
• Tool diameter and length remain constant.



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.

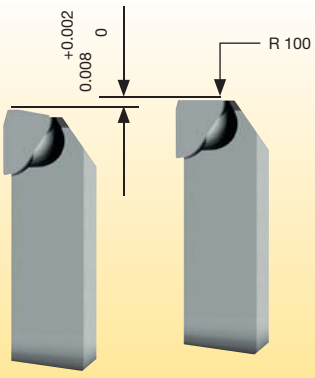


5 Determine which cartridge is in the highest axial position.

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.

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.

Visit **kennametal.com** or contact your local Authorized Kennametal Distributor.

KENNAMETAL®

kennametal.com

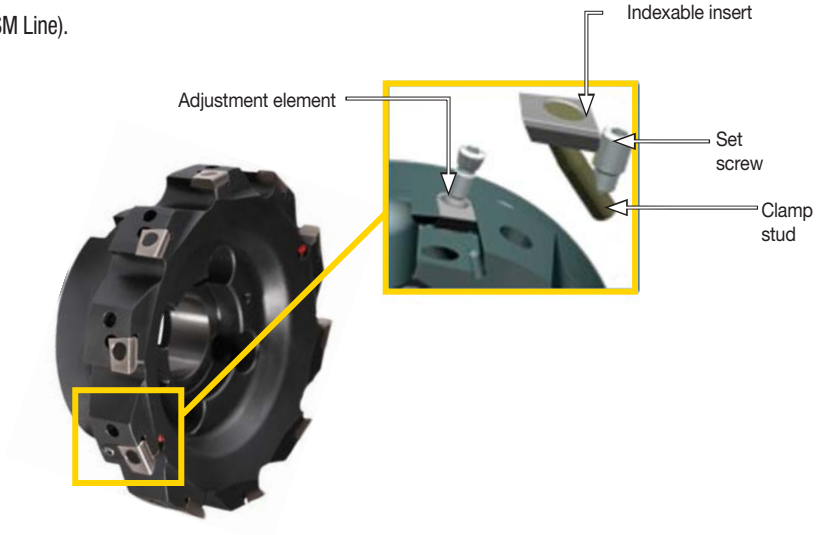
Fix-Perfect™ 0° Aluminum

Primary Application

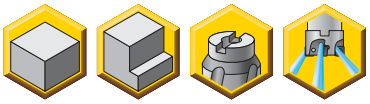
The Fix-Perfect 0° milling cutter is excellent for machining aluminum and non-ferrous materials. The 24° positive rake provides free cutting action while producing superior finishes and flatness.

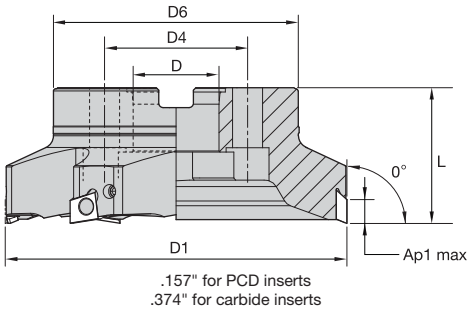
Features and Benefits

- Achieve true 0º 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 = 3.74".



- Excellent for milling aluminum and non-ferrous materials.
- Good choice for thin-wall or poorly fixtured workpieces.
- 24° positive rake enables free cutting action.
- Produces excellent finish and flatness.
- Maximum speed is 6,500 SFM.





.157" for PCD inserts
.374" for carbide inserts



Fix-Perfect • Shell Mills • M Line • Fixed Pockets

order number	catalog number	D1	D	D6	L	Ap1 max	Z	lbs	max RPM
2235052	**50A03RP90BG15CUM**	2.000	.750	1.750	1.570	.374	3	.90	12530
2235053	**63A03RP90BG15CUM**	2.500	.750	1.750	1.570	.374	3	1.10	10030
2235054	**80A03RP90BG15CUM**	3.000	1.000	2.189	1.750	.374	3	1.60	8350
2235055	**100B04RP90BG15CUM**	4.000	1.250	2.880	1.750	.374	4	2.80	6270
2235056	**125B05RP90BG15CUM**	5.000	1.500	3.810	2.380	.374	5	5.40	5010
2235057	**160B06RP90BG15CUM**	6.000	2.000	4.880	2.380	.374	6	8.50	4180

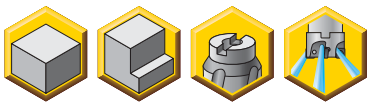
* 8-, 10-, and 12-inch diameter cutters are non-stock standards.

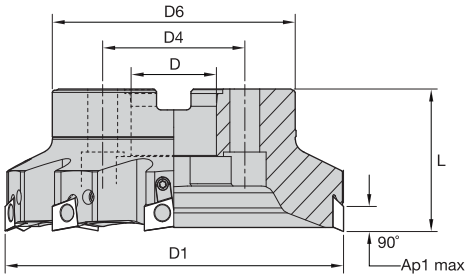
Spare Parts

D1	clamp stud	set screw	hex wrench	in. lbs.	socket-head cap screw	coolant lock screw	coolant shower plate
2.000	**410.083**	**420.060**	**170.003**	45	**S446**	**420.101 SCREW**	**–**
2.500	**410.083**	**420.060**	**170.003**	45	**S445**	**420.101 SCREW**	**–**
3.000	**410.083**	**420.060**	**170.003**	45	**S458**	**420.121**	**–**
4.000	**410.083**	**420.060**	**170.003**	45	**–**	**420.161**	**–**
5.000	**410.083**	**420.060**	**170.003**	45	**–**	**420.201**	**470.240**
6.000	**410.083**	**420.060**	**170.003**	45	**–**	**420.241**	**470.241**

NOTE: Please order spare parts separately.
Torque wrench (KTW45) and 3mm hex bit (69709922164) may be purchased separately to ensure proper torque setting.

- High-speed Machining.
- Produces excellent surface finish and flatness.
- Fixed and adjustable pockets.







Fix-Perfect • Shell Mills • PM Line • Fixed and Adjustable Pockets

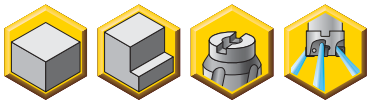
order number	catalog number	D1	D	D6	L	Ap1 max	Z	Z ADJ	lbs	max RPM
1803174	**40A02RP90BG15CUPM**	1.500	.500	1.250	1.570	.375	2	0	.49	33418
1803175	**50A03RP90BG15CUPM**	2.000	.750	1.750	1.570	.375	3	0	.84	25063
1803177	**63A04RP90BG15C1WUPM**	2.500	.750	1.750	1.570	.375	4	1	1.17	22750
1803178	**80A05RP90BG15C1WUPM**	3.000	1.000	2.032	1.750	.375	5	1	1.85	16710
1805715	**80A06RP90BG15C2WUPM**	3.000	1.000	2.032	1.750	.375	6	2	1.85	16710
1803179	**100B06RP90BG15C2WUPM**	4.000	1.250	2.724	1.750	.375	6	2	3.22	12500
1805716	**100B08RP90BG15C2WUPM**	4.000	1.250	2.724	1.750	.375	8	2	3.22	12500
1806465	**125B08RP90BG15C2WUPM**	5.000	1.500	3.810	2.375	.375	8	2	5.95	10000
1806466	**160B10RP90BG15C2WUPM**	6.000	2.000	4.880	2.375	.394	10	2	9.26	8500

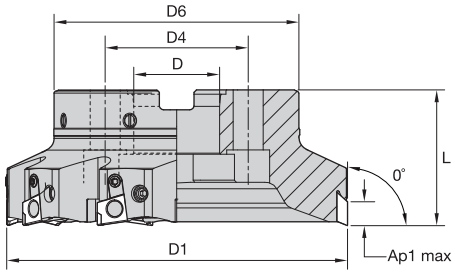
Spare Parts

D1	Torx wrench	clamp stud	set screw	hex wrench	in. lbs.	socket-head cap screw	coolant lock screw	coolant shower plate
1.500	**KT15**	**410.083**	**420.060**	**170.003**	45	**S425**	**420.081**	**–**
2.000	**KT15**	**410.083**	**420.060**	**170.003**	45	**S446**	**420.101 SCREW**	**–**
2.500	**KT15**	**410.083**	**420.060**	**170.003**	45	**S445**	**420.101 SCREW**	**–**
3.000	**KT15**	**410.083**	**420.060**	**170.003**	45	**S458**	**420.121**	**–**
4.000	**KT15**	**410.083**	**420.060**	**170.003**	45	**–**	**420.161**	**–**
5.000	**KT15**	**410.083**	**420.060**	**170.003**	45	**–**	**420.201**	**470.240**
6.000	**KT15**	**410.083**	**420.060**	**170.003**	45	**–**	**420.241**	**470.241**

NOTE: Please order spare parts separately.
For all diameters: adjusting element screw 193.337.
If the adjusting element needs to be replaced, please return the cutter to the Kennametal Service Center.
Torque wrench (KTW45 and 3mm hex bit (69709922164) may be purchased separately to ensure proper torque setting.

- Produces excellent surface finish and flatness.
- High-speed machining.



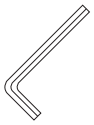




Fix-Perfect • Shell Mills • HPM Line • All Pockets Adjustable

order number	catalog number	D1	D	D6	L	Ap1 max	Z	Z ADJ	lbs	max RPM
1805720	**63A04RP90BG15C4WUHPM**	2.500	.750	1.750	1.570	.374	4	4	1.17	20051
1805745	**80A05RP90BG15C5WUHPM**	3.000	1.000	2.190	1.750	.374	5	5	1.83	16710

Spare Parts

D1	 adjusting element screw	 Torx wrench	 clamp stud	 set screw	 hex wrench	 in. lbs.	 socket-head cap screw	 coolant lock screw
2.500	**193.326**	**KT15**	**410.083**	**420.060**	**170.003**	45	**S445**	**420.101 SCREW**
3.000	**193.326**	**KT15**	**410.083**	**420.060**	**170.003**	45	**S458**	**420.121**

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.
Cutters with 4" have an aluminum body.
Torque wrench (KTW45) and 3mm hex bit (69709922164) may be purchased separately to ensure proper torque setting.

Insert Selection Guide

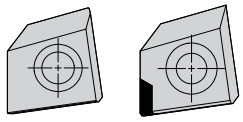
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	BGHX...	K110M	**BGHX...**	**KC510M**	BGHX...	KD1415
N3	BGHX...	K110M	**BGHX...**	**KD1410**	BGHX...	KD1410
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

Indexable Inserts for Fix-Perfect • BGHX15L5...

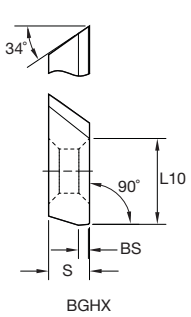
- Roughing Fix-Perfect inserts for aluminum and non-ferrous materials.
- 0.374" (9,5mm) max depth of cut.
- Two cutting edges.

● first choice
○ alternate choice

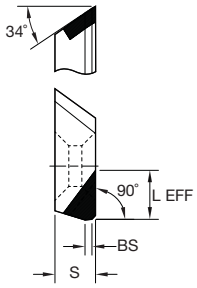
	K110M	KC510M	KD1410	KD1415
P				
M				
K				
N	●	●	●	●
S				
H				


BGHX

BGHX



BGHX



BGHX

Face Milling

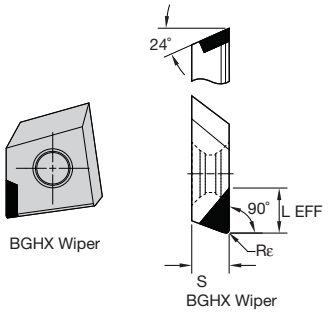
BGHX • Roughing

catalog number	L10	S	BS	Rε	hm	cutting edges	K110M	KC510M	KD1410	KD1415
BGHX15L5PCERGGT	.205	.197	.035	–	.001	1	–	–	●	●
BGHX15L5PCFRGG	.413	.197	.048	–	.001	2	●	●	–	–
BGHX15L5PCTRGG	.413	.197	.048	–	.001	2	●	●	–	–
BGHX15L5PCERGGTM	–	.197	.047	–	.001	1	–	–	●	–

- Roughing Fix-Perfect inserts for aluminum and non-ferrous materials.
- 0.374" (9,5mm) max depth of cut.
- Two cutting edges with corner radii.

● first choice
○ alternate choice

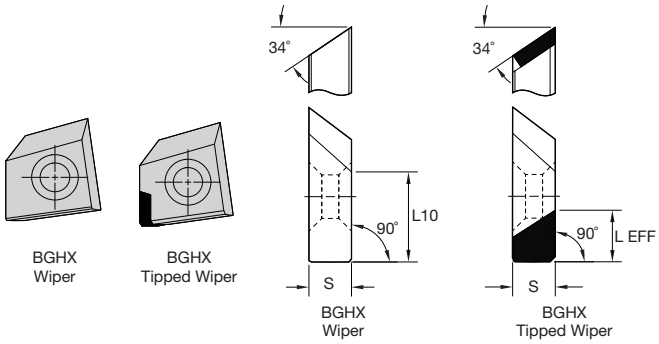
P					
M					
K					
N	●	●	●	●	
S					
H					



BGHT • Roughing with Radius

catalog number	L10	S	BS	Rε	hm	cutting edges	K110M	KC510M	KD1410	KD1415
BGHX15L504ERGET	.205	.197	—	.016	.001	1	–	–	–	●
BGHX15L504PCFRGG	.413	.197	.047	.016	.001	2	●	–	–	–
BGHX15L508PCFRGG	.413	.197	.047	.031	.001	2	●	●	–	–
BGHX15L515PCFRGG	.413	.197	.047	.059	.001	2	●	●	–	–

- Roughing Fix-Perfect inserts for aluminum and non-ferrous materials.
- 0.374" (9,5mm) max depth of cut.
- Two cutting edges.



BGHX-ET • Finishing

catalog number	L10	S	BS	Rε	hm	cutting edges	K110M	KC510M	KD1410	KD1415
BGHX15L5PCSRLET	.236	.197	.035	—	.001	1	–	–	●	●
BGHX15L5PCTRHET	.236	.197	.035	—	.001	1	–	–	●	–

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

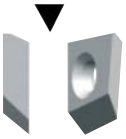
Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
BGHX...	.005	**.014**	.023	.003	**.010**	.017	.003	**.008**	.013	.002	**.007**	.011	.002	**.006**	.010	BGHX...

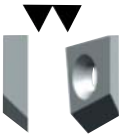
NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

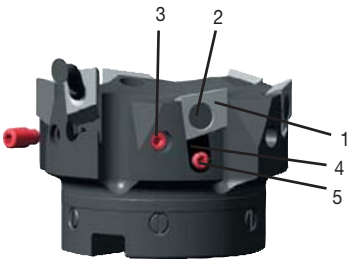
Introduction to Fitting Cutting Bodies

Roughing indexable inserts
BGHX15L5PC..GG.

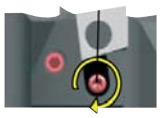
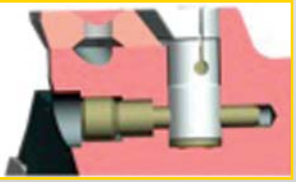
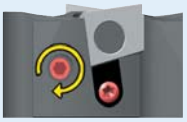


Finishing indexable inserts
BGHX15L5PC..GG.1W



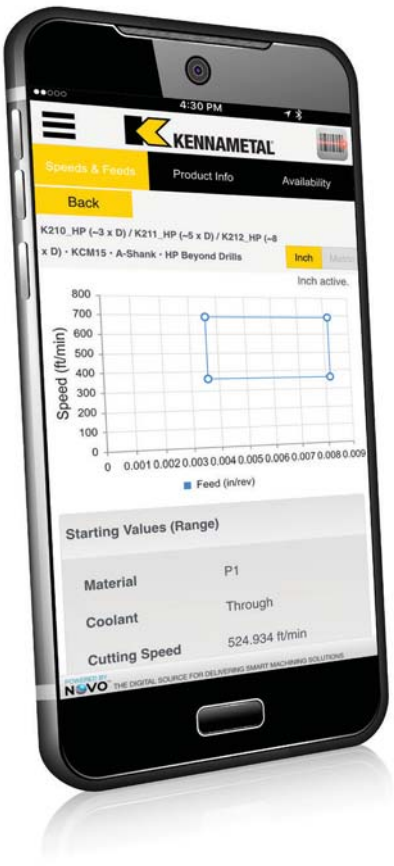


Clean dust, grease, etc., from the insert seat, insert (1), and clamp stud (2).

	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) 44 in. lbs.  ATTENTION: Ensure that the insert is correctly positioned in the insert seat.	Insert the indexable inserts and pre-tighten with the clamping screw (3) 13 in. lbs.  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) 9 in. lbs.  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 4.5 in. -lbs. 	Extract by .0008" 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 .008".	Adjust the finishing indexable insert(s) to the desired projection, preferably .0015" 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 44 in. lbs. 	Clamp the insert by tightening the clamping screw (3) to the specified torque of 44 in. lbs. 

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 catalog number to access complete product information.

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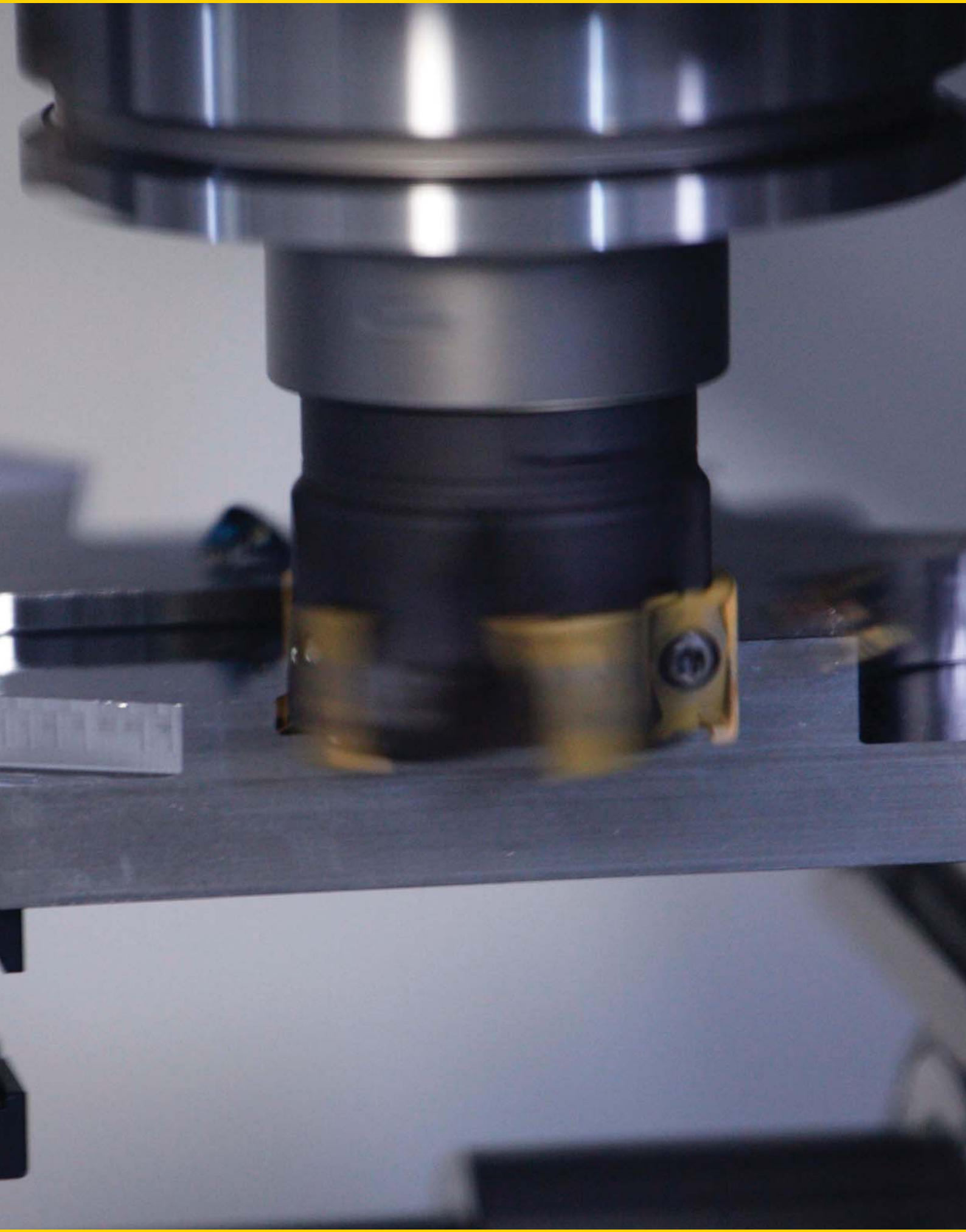


Indexable Milling • Shoulder Milling

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–T93

Mill 1-7 ..... T22–T26

Mill 1-10 ..... T28–T47

Mill 1-14 ..... T48–T73

Mill 1-18 ..... T74–T86

Mill 1-25 ..... T88–T93

Stellram 5720VZ16 Series • High-Speed Aluminum Cutting T94–T104

KSSM • Square Shoulder Milling T106–T117

KSSM-KSSP • Helical Square Shoulder Milling T118–T124

Stellram 5230VS Series T126–T136

Mill 4-11™

One tool for all applications.

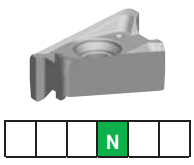
The Mill 4™ series is specially engineered to achieve excellent surface quality and higher metal removal rates in shoulder milling applications. Its unique design allows you to apply the tool in multiple passes (stepping down) with outstanding results.

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

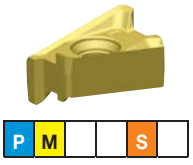
- Double-sided strong insert with 4 cutting edges.
- High positive geometry for lower cutting forces.
- Superior wall and surface finish capabilities.
- “Stepless” solution for multiple-pass operations.
- Comprehensive offering to cover all applications in all material groups.

-ELEJ



For non-ferrous materials.

-EGE



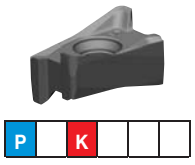
1st choice for stainless steel. Lower cutting forces.

-SGE

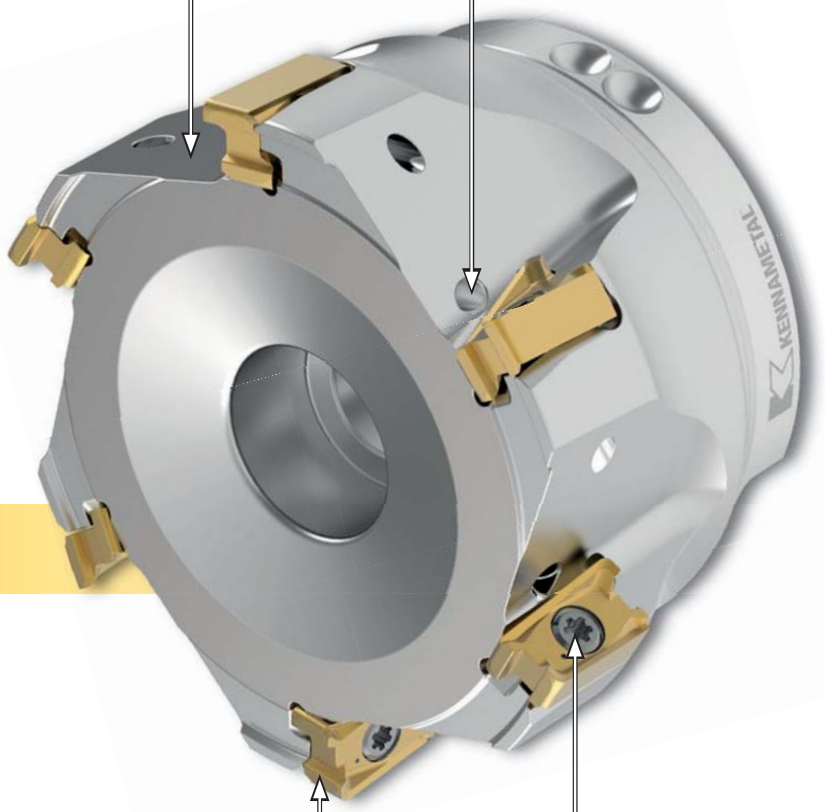


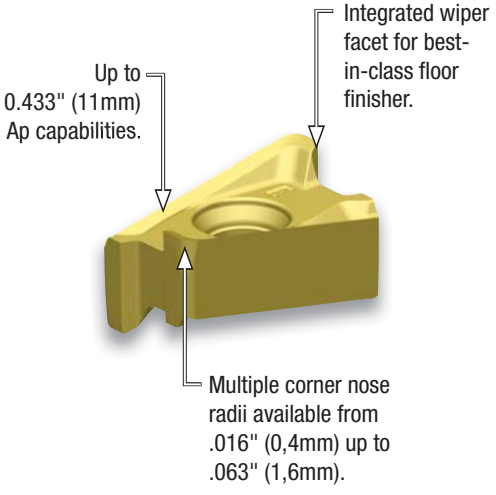
First choice for Mill 4 platform, especially when machining steels.

-SGEM

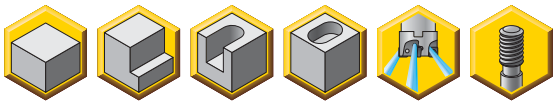


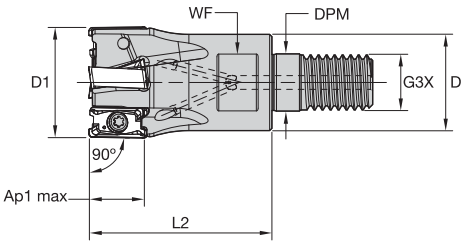
1st choice for cast iron. Strongest cutting edge.


Uneven pocket spacing.
Screw-on, end mills, and shell mill cutter with internal coolant.
KENNAMETAL
TP9 insert screw (M3) to provide higher reliability and safe processes.
Double-sided insert with 4 cutting edges.


Integrated wiper facet for best-in-class floor finisher.
Up to 0.433" (11mm) Ap capabilities.
Multiple corner nose radii available from .016" (0,4mm) up to .063" (1,6mm).

- One tool for all applications: from roughing to finishing.
- Superior wall and surface finish capabilities. Best choice for stepping down operations.
- Up to 0.433" (11mm) depth of cut.
- Screw-on cutters provided 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.







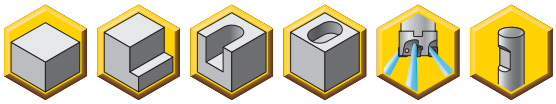
Screw-On End Mills

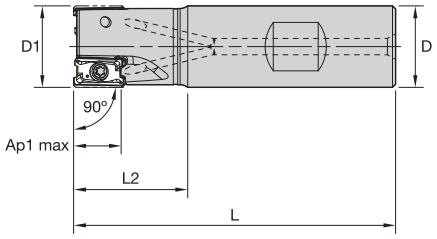
order number	catalog number	D1	D	DPM	G3X	L2	WF (mm)	Ap1 max	Z	lbs	max RPM
6139893	**M4D075L1103M10L110**	.750	.705	.413	M10	1.100	15	.433	3	.01	41700
6139894	**M4D100L1104M12L125**	1.000	.827	.492	M12	1.250	17	.433	4	.19	33900
6139895	**M4D125L1105M16L175**	1.250	1.142	.669	M16	1.750	24	.433	5	.49	29200

Spare Parts

D1	insert screw	in. lbs.	Torx Plus driver
.750	**MS2263**	13.3	**DT9IP**
1.000	**MS2263**	13.3	**DT9IP**
1.250	**MS2263**	13.3	**DT9IP**

- One tool for all applications: from roughing to finishing.
- Superior wall and surface finish capabilities.
- Best choice for stepping down operations.
- Up to 0.433" (11mm) depth of cut.







Weldon End Mills

order number	catalog number	D1	D	L	L2	Ap1 max	Z	lbs	max RPM
6139928	**M4D062L1102W062L100**	.625	.625	2.906	1.000	.433	2	.20	48000
6139929	**M4D075L1102W075L110**	.750	.750	3.130	1.100	.433	2	.32	41700
6139930	**M4D075L1103W075L110**	.750	.750	3.130	1.100	.433	3	.32	41700
6139896	**M4D100L1103W075L175**	1.000	.750	3.780	1.750	.433	3	.45	33900
6140051	**M4D100L1103W100L175**	1.000	1.000	4.030	1.750	.433	3	.77	33900
6140052	**M4D125L1104W125L225**	1.250	1.250	4.530	2.250	.433	4	1.37	29200
6139897	**M4D150L1105W125L225**	1.500	1.250	4.530	2.250	.433	5	1.48	26200

Spare Parts

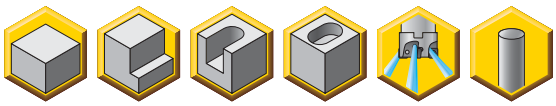


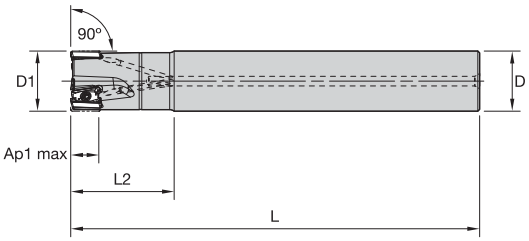




D1	insert screw	in. lbs.	Torx Plus driver
.625	**MS2263**	13.3	**DT9IP**
.750	**MS2263**	13.3	**DT9IP**
1.000	**MS2263**	13.3	**DT9IP**
1.250	**MS2263**	13.3	**DT9IP**
1.500	**MS2263**	13.3	**DT9IP**

- One tool for all applications: from roughing to finishing.
- Superior wall and surface finish capabilities.
- Best choice for stepping down operations.
- Up to 0.433" (11mm) depth of cut.







Cylindrical End Mills

order number	catalog number	D1	D	L	L2	Ap1 max	Z	lbs	max RPM
6140053	**M4D062L1102C062L400**	.625	.625	4.000	1.000	.433	2	.30	48000
6139898	**M4D062L1102C062L600**	.625	.625	6.000	1.000	.433	2	.47	48000
6140055	**M4D075L1102C075L600**	.750	.750	6.000	1.100	.433	2	.67	41700
6140054	**M4D075L1103C075L400**	.750	.750	4.000	1.100	.433	3	.43	41700
6139899	**M4D075L1103C075L600**	.750	.750	6.000	1.100	.433	3	.66	41700
6201903	**M4D100L1104C075L450**	1.000	.750	4.500	1.750	.433	4	.53	33900
6140057	**M4D100L1103C100L700**	1.000	1.000	7.000	1.750	.433	3	1.42	33900
6140056	**M4D100L1104C100L450**	1.000	1.000	4.500	1.750	.433	4	.87	33900
6139900	**M4D100L1104C100L700**	1.000	1.000	7.000	1.750	.433	4	1.41	33900
6201904	**M4D125L1105C100L500**	1.250	1.000	5.000	2.250	.433	5	1.05	29200
6139921	**M4D125L1104C125L800**	1.250	1.250	8.000	2.250	.433	4	2.57	29200
6140058	**M4D125L1105C125L500**	1.250	1.250	5.000	2.250	.433	5	1.55	29200

Spare Parts

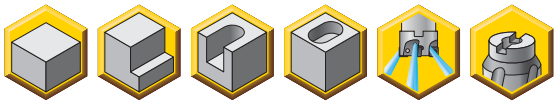


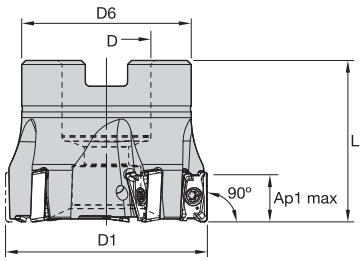


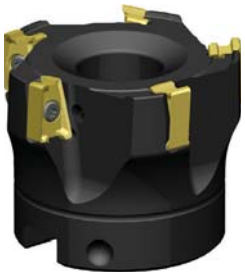


D1	insert screw	in. lbs.	Torx Plus driver
.625	**MS2263**	13.3	**DT9IP**
.750	**MS2263**	13.3	**DT9IP**
1.000	**MS2263**	13.3	**DT9IP**
1.250	**MS2263**	13.3	**DT9IP**

- One tool for all applications: from roughing to finishing.
- Superior wall and surface finish capabilities.
- Best choice for stepping down operations.
- Up to 0.433" (11mm) depth of cut.







Shell Mills

order number	catalog number	D1	D	D6	L	Ap1 max	Z	lbs	max RPM
6140059	**M4D150L1105S050L157**	1.500	.500	1.421	1.575	.433	5	.49	26200
6139922	**M4D150L1106S050L157**	1.500	.500	1.421	1.575	.433	6	.49	26200
6140060	**M4D200L1105S075L157**	2.000	.750	1.750	1.575	.433	5	.80	22100
6140061	**M4D200L1107S075L157**	2.000	.750	1.750	1.575	.433	7	.81	22100
6140062	**M4D250L1107S075L157**	2.500	.750	1.750	1.575	.433	7	1.20	19500
6139923	**M4D250L1107S100L157**	2.500	1.000	2.190	1.575	.433	7	1.28	19500
6140063	**M4D300L1108S100L175**	3.000	1.000	2.190	1.750	.433	8	2.01	17600
6139924	**M4D300L1108S125L175**	3.000	1.250	2.665	1.750	.433	8	2.13	17600

Spare Parts

D1	D	 insert screw	 in. lbs.	 Torx Plus driver	 socket-head cap screw
1.500	.500	**MS2263**	13.3	**DT9IP**	**S424**
2.000	.750	**MS2263**	13.3	**DT9IP**	**S445**
2.500	.750	**MS2263**	13.3	**DT9IP**	**S445**
2.500	1.000	**MS2263**	13.3	**DT9IP**	**S458**
3.000	1.000	**MS2263**	13.3	**DT9IP**	**S458**
3.000	1.250	**MS2263**	13.3	**DT9IP**	**S467**

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	–	–	**–**	**–**	–	–

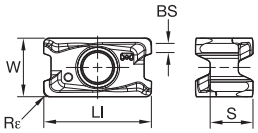
Indexable Inserts • Mill 4-11

● first choice
○ alternate choice

	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P			○	●		●	●		○
M			●	●		○	●	○	●
K		●	○		●	○			
N	●								
S			●	●			○	●	●
H									



LNGU11-ELEJ



LNGU11-ELEJ

LNGU11-ELEJ • For Aluminum and Other Non-Ferrous Alloys

catalog number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU431ERLEJ	.479	.190	.260	.054	.016	.002	4	●	–	–	–	–	–	–	–	–
LNGU432ERLEJ	.479	.190	.260	.039	.031	.002	4	●	–	–	–	–	–	–	–	–

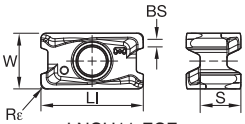
- -EGE is the first choice for stainless steel and high-temp alloys.
- Use -EGE geometry for the highest finishing requirements in light machining for all materials.

● first choice
○ alternate choice

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



LNGU11-EGE



LNGU11-EGE

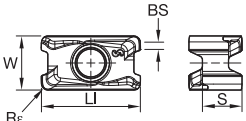
LNGU11-EGE • Precision Ground • For Stainless Steel and High-Temp Alloys

catalog number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU431ERGE	.479	.190	.260	.054	.016	.003	4	–	–	●	●	–	–	●	–	–
LNGU432ERGE	.479	.190	.260	.039	.031	.003	4	–	–	●	●	–	–	●	●	●
LNGU433ERGE	.479	.190	.260	.025	.047	.003	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.



LNGU11-SGE



LNGU11-SGE

LNGU11-SGE • Precision Ground • Universal Geometry • General Purpose for Roughing and Finishing Operations

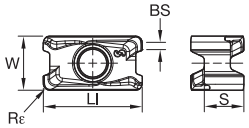
catalog number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU431SRGE	.479	.190	.260	.054	.016	.004	4	–	–	●	–	–	–	●	–	●
LNGU432SRGE	.479	.190	.260	.039	.031	.004	4	–	–	●	●	●	●	●	–	●

- -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.

● first choice
○ alternate choice

		KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○	●		●	●		○
M				●	●		○	●	○	●
K			●	○		●	○			
N		●								
S				●	●			○	●	●
H										


LNPU11-SGE

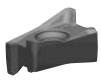


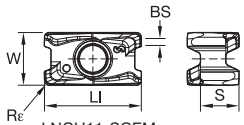
LNPU11-SGE

LNPU11-SGE • Precision Pressed • General Purpose for Roughing and Semi-Finishing Operations

catalog number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNPU432SRGE	.476	.190	.260	.036	.031	.004	4	–	●	●	●	●	●	●	–	–
LNPU433SRGE	.476	.190	.260	.021	.047	.004	4	–	●	●	●	●	●	●	–	–
LNPU434SRGE	.476	.190	.260	.001	.063	.004	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

catalog number	LI	S	W	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU432SRGEM	.479	.190	.260	.036	.031	.004	4	–	●	●	–	●	●	●	–	–
LNGU433SRGEM	.479	.190	.260	.022	.047	.004	4	–	●	–	–	●	●	●	–	–
LNGU434SRGEM	.479	.190	.260	.004	.063	.004	4	–	●	–	–	●	●	●	–	–

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LEJ	.005	**.014**	.023	.004	**.010**	.017	.003	**.008**	.012	.002	**.007**	.011	.002	**.006**	.010	.E..LEJ
.E..GE	.009	**.016**	.022	.007	**.012**	.016	.005	**.009**	.012	.004	**.008**	.010	.004	**.007**	.010	.E..GE
.S..GE	.009	**.018**	.025	.007	**.013**	.018	.005	**.010**	.014	.004	**.009**	.012	.004	**.008**	.011	.S..GE
.S..GEM	.009	**.018**	.028	.007	**.013**	.020	.005	**.010**	.015	.004	**.009**	.013	.004	**.008**	.012	.S..GEM

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

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 • Inch

order number	catalog number	cutter diameter/ flutes	cutter type	material group	application range	content				
						cutter	quantity	insert	grade	quantity
6214774	M4-11KITD062Z2W062SGEKCPM40	0.62z2	Weldon	P	∇/∇∇	M4D062L1102W062L100	1	LNPU110408SRGE	KCPM40	20
6214775	M4-11KITD062Z2C062SGEKCPM40	0.62z2	Cylindrical	P	∇/∇∇	M4D062L1102C062L400	1	LNPU110408SRGE	KCPM40	20
6214776	M4-11KITD075Z2W075SGEKCPM40	0.75z2	Weldon	P	∇/∇∇	M4D075L1102W075L110	1	LNPU110408SRGE	KCPM40	20
6214777	M4-11KITD075Z3W075SGEKCPM40	0.75z3	Weldon	P	∇/∇∇	M4D075L1103W075L110	1	LNPU110408SRGE	KCPM40	20
6214778	M4-11KITD075Z3C075SGEKCPM40	0.75z3	Cylindrical	P	∇/∇∇	M4D075L1103C075L400	1	LNPU110408SRGE	KCPM40	20
6214779	M4-11KITD100Z3W100SGEKCPM40	1.00z3	Weldon	P	∇/∇∇	M4D100L1103W100L175	1	LNPU110408SRGE	KCPM40	20
6214780	M4-11KITD100Z4C100SGEKCPM40	1.00z4	Cylindrical	P	∇/∇∇	M4D100L1104C100L450	1	LNPU110408SRGE	KCPM40	20
6214801	M4-11KITD125Z4W125SGEKCPM40	1.25z4	Weldon	P	∇/∇∇	M4D125L1104W125L225	1	LNPU110408SRGE	KCPM40	20
6214802	M4-11KITD125Z5C125SGEKCPM40	1.25z5	Cylindrical	P	∇/∇∇	M4D125L1105C125L500	1	LNPU110408SRGE	KCPM40	20
6214803	M4-11KITD150Z5S050SGEKCPM40	1.50z5	Shell Mill	P	∇/∇∇	M4D150L1105S050L157	1	LNPU110408SRGE	KCPM40	20
6214804	M4-11KITD200Z5S075SGEKCPM40	2.00z5	Shell Mill	P	∇/∇∇	M4D200L1105S075L157	1	LNPU110408SRGE	KCPM40	20
6214805	M4-11KITD200Z7S075SGEKCPM40	2.00z7	Shell Mill	P	∇/∇∇	M4D200L1107S075L157	1	LNPU110408SRGE	KCPM40	20
6214806	M4-11KITD062Z2W062SGEKC725M	0.62z2	Weldon	M+S	∇∇/∇∇∇	M4D062L1102W062L100	1	LNGU110408ERGE	KC725M	20
6214807	M4-11KITD062Z2C062SGEKC725M	0.62z2	Cylindrical	M+S	∇∇/∇∇∇	M4D062L1102C062L400	1	LNGU110408ERGE	KC725M	20
6214808	M4-11KITD075Z3W075SGEKC725M	0.75z3	Weldon	M+S	∇∇/∇∇∇	M4D075L1103W075L110	1	LNGU110408ERGE	KC725M	20
6214809	M4-11KITD075Z3C075SGEKC725M	0.75z3	Cylindrical	M+S	∇∇/∇∇∇	M4D075L1103C075L400	1	LNGU110408ERGE	KC725M	20
6214810	M4-11KITD100Z3W100SGEKC725M	1.00z3	Weldon	M+S	∇∇/∇∇∇	M4D100L1103W100L175	1	LNGU110408ERGE	KC725M	20
6214821	M4-11KITD100Z4C100SGEKC725M	1.00z4	Cylindrical	M+S	∇∇/∇∇∇	M4D100L1104C100L450	1	LNGU110408ERGE	KC725M	20
6214822	M4-11KITD125Z4W125SGEKC725M	1.25z4	Weldon	M+S	∇∇/∇∇∇	M4D125L1104W125L225	1	LNGU110408ERGE	KC725M	20
6214823	M4-11KITD125Z5C125SGEKC725M	1.25z5	End Mill	M+S	∇∇/∇∇∇	M4D125L1105C125L500	1	LNGU110408ERGE	KC725M	20
6214824	M4-11KITD150Z5S050SGEKC725M	1.50z5	Shell Mill	M+S	∇∇/∇∇∇	M4D150L1105S050L157	1	LNGU110408ERGE	KC725M	20
6214825	M4-11KITD200Z5S075SGEKC725M	2.00z5	Shell Mill	M+S	∇∇/∇∇∇	M4D200L1105S075L157	1	LNGU110408ERGE	KC725M	20
6214826	M4-11KITD200Z7S075SGEKC725M	2.00z7	Shell Mill	M+S	∇∇/∇∇∇	M4D200L1107S075L157	1	LNGU110408ERGE	KC725M	20

∇ Heavy/Roughing
∇∇ Medium
∇∇∇ Light machining/Finishing

Mill 4-15™ • Double-Sided Shoulder Milling

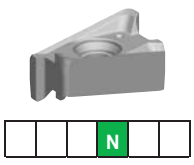
Primary Application

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

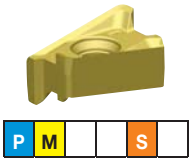
- Double-sided strong insert with 4 cutting edges.
- High positive geometry for lower cutting forces.
- Superior wall and surface finish capabilities.
- "Stepless" solution. No mismatch when machining walls in different steps.

-EGEJ



For non-ferrous materials.

-EGE



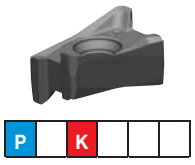
1st choice for stainless steel. Lower cutting forces.

-SGE



First choice for Mill 4 platform, especially when machining steels.

-SGEM



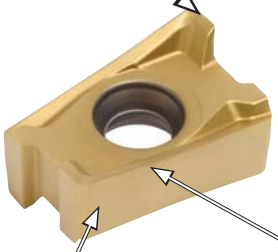
1st choice for cast iron. Strongest cutting edge.

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.

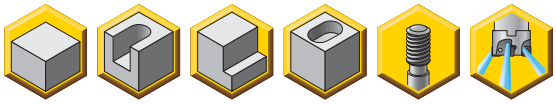


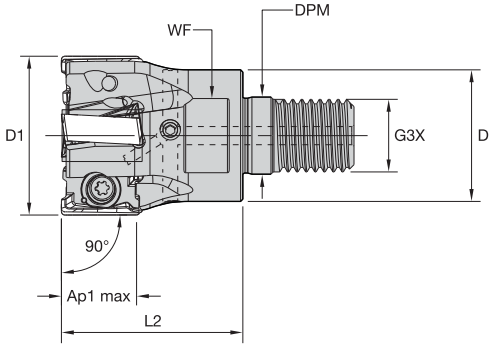
Up to .610" (15,5mm) depth-of-cut capabilities.

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 .610" (15,5mm) depth of cut.
- Effective internal coolant feature, reaching the cutting edge precisely.







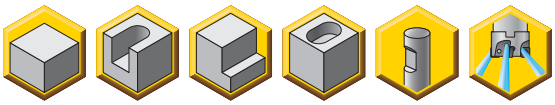
Screw-On End Mills

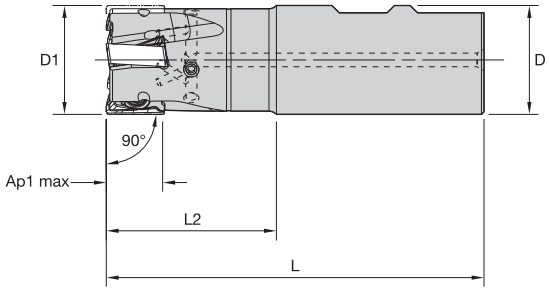
order number	catalog number	D1	D	DPM	G3X	L2	WF (mm)	Ap1 max	Z	lbs	max RPM
5568064	**M4D100L1502M12L125**	1.000	.827	.492	M12	1.250	17	.610	2	.73	26300
5568065	**M4D125L1503M16L175**	1.250	1.142	.669	M16	1.750	24	.610	3	.44	22100
5568066	**M4D150L1504M16L175**	1.500	1.142	.669	M16	1.750	24	.610	4	.52	19500

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
1.000	**MS-2071**	31.0	**DT15IP**
1.250	**MS-2071**	31.0	**DT15IP**
1.500	**MS-2071**	31.0	**DT15IP**

- Superior wall and surface finish capabilities.
- True 90° capabilities. Stepless solution when using multiple steps.
- Engineered to run up to .610" (15,5mm) depth of cut.
- Effective internal coolant feature, reaching the cutting edge precisely.







Weldon® End Mills

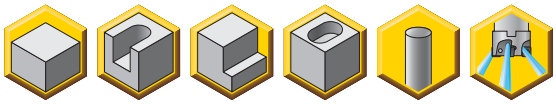
order number	catalog number	D1	D	L	L2	Ap1 max	Z	lbs	max RPM
5568067	**M4D100L1502W075L175**	1.000	.750	3.780	1.750	.610	2	.73	26300
5544366	**M4D100L1502W100L175**	1.000	1.000	4.030	1.750	.610	2	.73	26300
5544367	**M4D125L1503W100L225**	1.250	1.000	4.530	2.250	.610	3	.90	22100
5568068	**M4D125L1503W125L225**	1.250	1.250	4.530	2.250	.610	3	1.30	22100
5568069	**M4D150L1503W125L225**	1.500	1.250	4.530	2.250	.610	3	1.41	19500
5544368	**M4D150L1504W125L225**	1.500	1.250	4.530	2.250	.610	4	1.41	19500

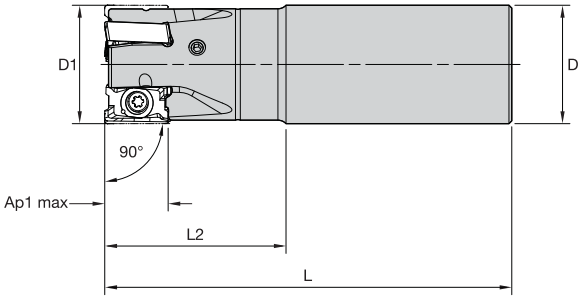
Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
1.000	**MS-2071**	31	**DT15IP**
1.250	**MS-2071**	31	**DT15IP**
1.500	**MS-2071**	31	**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 .610" (15,5mm) depth of cut.
- Effective internal coolant feature, reaching the cutting edge precisely.







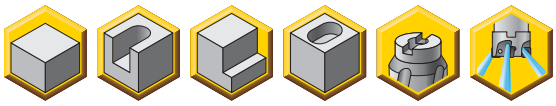
Cylindrical End Mills

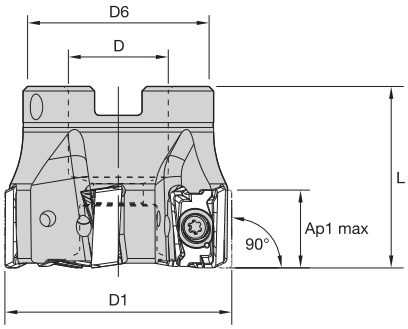
order number	catalog number	D1	D	L	L2	Ap1 max	Z	lbs	max RPM
5544369	**M4D100L1502C100L800**	1.000	1.000	8.000	1.750	.610	2	1.59	26300
5568080	**M4D100L1502C100L1000**	1.000	1.000	10.000	1.750	.610	2	2.03	26300
5544400	**M4D125L1503C125L800**	1.250	1.250	8.000	2.250	.610	3	2.50	22100
5568081	**M4D125L1503C125L1000**	1.250	1.250	10.000	2.250	.610	3	3.18	22100
5544401	**M4D150L1504C125L800**	1.500	1.250	8.000	2.250	.610	4	2.60	19500
5568082	**M4D150L1504C125L1000**	1.500	1.250	10.000	2.250	.610	4	3.29	19500

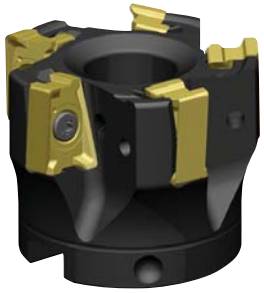
Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
1.000	**MS-2071**	31.0	**DT15IP**
1.250	**MS-2071**	31.0	**DT15IP**
1.500	**MS-2071**	31.0	**DT15IP**

- Superior wall and surface finish capabilities.
- True 90° capabilities. Stepless solution when using multiple steps.
- Engineered to run up to .610" (15,5mm) depth of cut.
- Effective internal coolant feature, reaching the cutting edge precisely.







Shell Mills

order number	catalog number	D1	D	D6	L	Ap1 max	Z	lbs	max RPM
5544402	M4D150L1505S050L157	1.500	.500	1.420	1.575	.610	5	.43	19500
5702499	M4D200L1504S075L175	2.000	.750	1.750	1.575	.610	4	.78	16100
5544403	M4D200L1505S075L157	2.000	.750	1.750	1.575	.610	5	.73	16100
5544404	M4D200L1506S075L157	2.000	.750	1.750	1.575	.610	6	.71	16100
5568083	M4D250L1505S075L157	2.500	.750	1.750	1.575	.610	5	1.09	14100
5544405	M4D250L1506S075L157	2.500	.750	1.750	1.575	.610	6	1.05	14100
5568084	M4D250L1507S100L175	2.500	1.000	2.190	1.750	.610	7	1.31	14100
5702495	M4D300L1505S100L175	3.000	1.000	2.190	1.750	.610	5	1.86	12700
5544406	M4D300L1507S100L175	3.000	1.000	2.190	1.750	.610	7	1.82	12700
5568085	M4D300L1509S100L175	3.000	1.000	2.190	1.750	.610	9	1.85	12700
5544407	M4D300L1508S125L200	3.000	1.250	2.665	2.000	.610	8	2.22	12700
5702496	M4D400L1506S150L200	4.000	1.500	3.380	2.000	.610	6	3.33	10800
5568086	M4D400L1508S150L200	4.000	1.500	3.380	2.000	.610	8	3.31	10800
5544408	M4D400L1511S150L200	4.000	1.500	3.380	2.000	.610	11	3.25	10800
5702500	M4D500L1507S150L238	5.000	1.500	3.907	2.380	.610	7	6.91	9600
5613026	M4D500L1509S150L238	5.000	1.500	3.907	2.380	.610	9	6.84	9660
5613027	M4D500L1512S150L238	5.000	1.500	3.907	2.380	.610	12	6.98	9660
5702497	M4D600L1508S200L238	6.000	2.000	4.880	2.380	.610	8	12.20	8600
5613028	M4D600L1510S200L238	6.000	2.000	4.880	2.380	.610	10	9.55	8600
5702498	M4D600L1512S200L238	6.000	2.000	4.880	2.380	.610	12	12.09	8600

Spare Parts

D1	D	insert screw	in. lbs.	Torx Plus driver	coolant lock screw	coolant lock screw assembly
1.500	.500	MS-2071	31.0	DT15IP	–	–
2.000	.750	MS-2071	31.0	DT15IP	–	–
2.500	.750	MS-2071	31.0	DT15IP	–	–
2.500	1.000	MS-2071	31.0	DT15IP	–	–
3.000	1.000	MS-2071	31.0	DT15IP	–	–
3.000	1.250	MS-2071	31.0	DT15IP	–	–
3.000	1.000	MS-2071	31.0	DT15IP	–	–
4.000	1.500	MS-2071	31.0	DT15IP	420.201	S2165C
5.000	1.500	MS-2071	31.0	DT15IP	420.201	S2165C
6.000	2.000	MS-2071	31.0	DT15IP	420.241	S2192C

NOTE: Coolant lock screw assembly must be ordered separately.

Insert Selection Guide

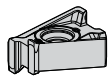
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..GE	KCPM40	**.S..GE**	**KCPM40**	.S..GEM	KCPM40
P3–P4	.E..GE	KCPM40	**.S..GE**	**KCPK30**	.S..GEM	KCPK30
P5–P6	.E..GE	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	–	–	–	–	–	–

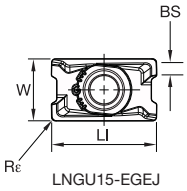
Indexable Inserts • Mill 4-15™

- -EGEJ is the first choice for roughing and finishing of aluminum and other non-ferrous alloys.

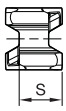
● first choice
○ alternate choice

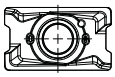
		KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○	●		●	●		○
M				●	●		○	●	○	●
K			●	○		●	○			
N		●								
S				●	●			○	●	●
H										


LNGU15-EGEJ



LNGU15-EGEJ

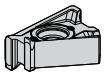


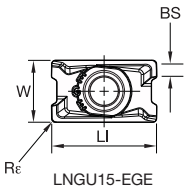

Back view

LNGU15-EGEJ • For Aluminum and Other Non-Ferrous Alloys

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU541ERGEJ	.670	.394	.274	.087	.016	.001	4	●	–	–	–	–	–	–	–	–
LNGU542ERGEJ	.670	.394	.274	.072	.031	.001	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



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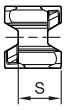


LNGU15-EGE • Precision Ground • For Stainless Steel and High-Temp Alloys

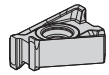
catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU541ERGE	.670	.394	.274	.087	.016	.003	4	–	–	●	●	–	–	●	●	–
LNGU542ERGE	.670	.394	.274	.072	.031	.003	4	–	–	●	●	–	–	●	●	●
LNGU543ERGE	.670	.394	.274	.057	.047	.003	4	–	–	●	●	–	–	●	●	●
LNGU544ERGE	.670	.394	.274	.042	.063	.003	4	–	–	–	●	–	–	●	●	–

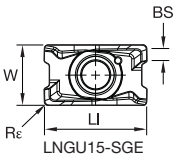
- -SGE is the universal geometry for Mill 4-15.
- First choice when machining steel.
- Suitable for stainless steel and high-temp alloys in medium-heavy applications.

beyond

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

● first choice
○ alternate choice


LNGU15-SGE

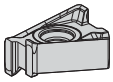


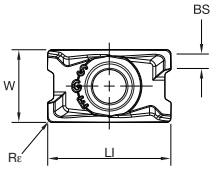
LNGU15-SGE

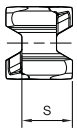
LNGU15-SGE • Precision Ground • For Steel Machining, Finishing, and Light Roughing

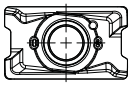
catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU541SRGE	.669	.394	.274	.086	.016	.004	4	–	●	●	●	●	●	–	–	–
LNGU542SRGE	.670	.394	.274	.071	.031	.004	4	–	●	●	●	●	●	–	–	●
LNGU543SRGE	.670	.394	.274	.056	.047	.004	4	–	●	●	●	●	●	–	–	●
LNGU544SRGE	.670	.394	.274	.042	.063	.004	4	–	●	●	●	●	●	–	–	–

- -SGE is the first choice for machining steel, as well as stainless steel and high-temp alloys in heavy applications.


LNPU15-SGE





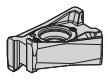

Back View

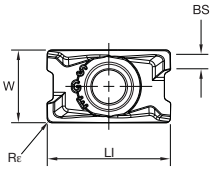
LNPU15-SGE

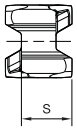
LNPU15-SGE • Precision Pressed • For Steel Machining in Medium-Heavy Roughing

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNPU541SRGE	.665	.394	.274	.085	.016	.004	4	–	●	●	●	●	●	–	–	–
LNPU542SRGE	.665	.394	.274	.070	.031	.004	4	–	●	●	●	●	●	●	–	–
LNPU543SRGE	.665	.394	.274	.058	.047	.004	4	–	●	●	●	–	●	●	–	–
LNPU544SRGE	.666	.394	.274	.042	.063	.004	4	–	●	●	●	●	●	●	–	–
LNPU545SRGE	.666	.394	.274	.028	.078	.004	4	–	–	●	●	●	●	●	–	–

- -SGEM geometry is the first choice for cast iron machining in medium and heavy applications


LNGU15-SGEM





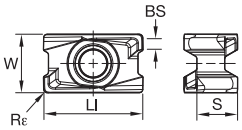
LNGU15-SGEM

LNGU15-SGEM • For Cast Iron Machining

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
LNGU542SRGEM	.670	.394	.274	.067	.031	.004	4	–	●	–	–	●	●	●	–	–
LNGU543SRGEM	.670	.394	.274	.053	.047	.004	4	–	●	–	–	●	–	●	–	–
LNGU544SRGEM	.670	.394	.274	.037	.064	.004	4	–	●	–	–	●	●	●	–	–
LNGU545SRGEM	.670	.394	.274	.013	.078	.004	4	–	●	–	–	●	●	●	–	–

- H stands for helical.
- Insert specially design to fit in helical cutters (porcupine).


LNGU15-SGEH



LNGU15-SGEH

● first choice
○ alternate choice

beyond

	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)

catalog number	LI	W	S	BS	Rε	hm	cutting edges
LNGU542SRGEH	.670	.394	.274	.071	.031	.004	4

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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	.005	**.019**	.034	.003	**.014**	.024	.003	**.010**	.018	.002	**.009**	.016	.002	**.008**	.014	.E..GEJ
.E..GE	.009	**.020**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.009**	.016	.004	**.009**	.015	.E..GE
.S..GE	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GE
.S..GEM	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.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 Inch Starter Kits

material group	order number	catalog number	cutter kit	application range	content				
					cutter	qty	insert	grade	qty
P	5972205	M4KITD100Z02W100SGEKCPM40	D1.00 x z2	∇∇	M4D100L1502W100L175	1	LNPU15T608SRGE	KCPM40	20
P	5972206	M4KITD125Z03W100SGEKCPM40	D1.50 x z3	∇∇	M4D125L1503W100L225	1	LNPU15T608SRGE	KCPM40	20
P	5972207	M4KITD150Z04W125SGEKCPM40	D1.50 x z4	∇∇	M4D150L1504W125L225	1	LNPU15T608SRGE	KCPM40	20
P	5972208	M4KITD150Z05S050SGEKCPM40	D1.50 x z5	∇∇	M4D150L1505S050L157	1	LNPU15T608SRGE	KCPM40	20
P	5972209	M4KITD200Z05S075SGEKCPM40	D2.00 x z5	∇∇	M4D200L1505S075L157	1	LNPU15T608SRGE	KCPM40	20
P	5972210	M4KITD200Z06S075SGEKCPM40	D2.00 x z6	∇∇	M4D200L1506S075L157	1	LNPU15T608SRGE	KCPM40	20
P	5972351	M4KITD250Z06S075SGEKCPM40	D2.50 x z6	∇∇	M4D250L1506S075L157	1	LNPU15T608SRGE	KCPM40	20
P	5972352	M4KITD300Z07S100SGEKCPM40	D3.00 x z7	∇∇	M4D300L1507S100L175	1	LNPU15T608SRGE	KCPM40	20
P	5972353	M4KITD400Z08S150SGEKCPM40	D4.00 x z8	∇∇	M4D400L1508S150L200	1	LNPU15T608SRGE	KCPM40	20
M + S	5972354	M4KITD100Z02C100EGEKC725M	D1.00 x z2	∇∇∇	M4D100L1502C100L800	1	LNGU15T608ERGE	KC725M	20
M + S	5972355	M4KITD125Z03C125EGEKC725M	D1.25 x z3	∇∇∇	M4D125L1503C125L800	1	LNGU15T608ERGE	KC725M	20
M + S	5972356	M4KITD150Z05S050EGEKC725M	D1.50 x z5	∇∇∇	M4D150L1505S050L157	1	LNGU15T608ERGE	KC725M	20
M + S	5972357	M4KITD200Z05S075EGEKC725M	D2.00 x z5	∇∇∇	M4D200L1505S075L157	1	LNGU15T608ERGE	KC725M	20
M + S	5972358	M4KITD200Z06S075EGEKC725M	D2.00 x z6	∇∇∇	M4D200L1506S075L157	1	LNGU15T608ERGE	KC725M	20
M + S	5972359	M4KITD250Z06S075EGEKC725M	D2.50 x z6	∇∇∇	M4D250L1506S075L157	1	LNGU15T608ERGE	KC725M	20
M + S	5972360	M4KITD300Z07S100EGEKC725M	D3.00 x z7	∇∇∇	M4D300L1507S100L175	1	LNGU15T608ERGE	KC725M	20
K	5972371	M4KITD100Z02W100SGEMKC520M	D1.00 x z2	∇	M4D100L1502W100L175	1	LNGU15T608SRGEM	KC520M	20
K	5972372	M4KITD125Z03W100SGEMKC520M	D1.25 x z3	∇	M4D125L1503W100L225	1	LNGU15T608SRGEM	KC520M	20
K	5972373	M4KITD150Z05S050SGEMKC520M	D1.50 x z5	∇	M4D150L1505S050L157	1	LNGU15T608SRGEM	KC520M	20
K	5972374	M4KITD200Z06S075SGEMKC520M	D2.00 x z6	∇	M4D200L1506S075L157	1	LNGU15T608SRGEM	KC520M	20
K	5972375	M4KITD250Z07S075SGEMKC520M	D2.50 x z7	∇	M4D250L1507S100L175	1	LNGU15T608SRGEM	KC520M	20
K	5972376	M4KITD300Z09S100SGEMKC520M	D3.00 x z9	∇	M4D300L1509S100L175	1	LNGU15T608SRGEM	KC520M	20
K	5972377	M4KITD400Z11S150SGEMKC520M	D4.00 x z11	∇	M4D400L1511S150L200	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 optimized 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.

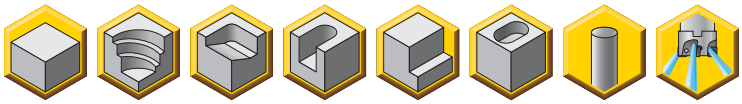
Chip gash designed for excellent chip evacuation.

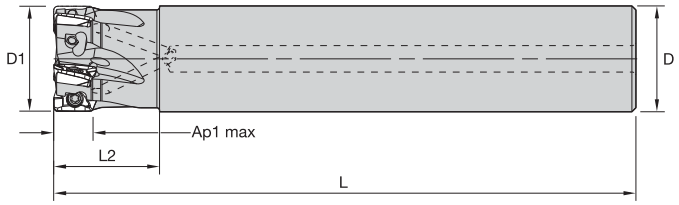
Margin along the main cutting edge and wiper facet for extra strength.

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.







Cylindrical End Mills

order number	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
5190087	**M1D050E0702C050L400**	.500	.500	4.000	.750	.274	2	4.6°	.19	62680
5190088	**M1D062E0703C062L500**	.620	.625	5.000	1.000	.275	3	3.0°	.37	56010
5190089	**M1D075E0705C075L600**	.745	.750	6.000	1.000	.273	5	2.2°	.66	51100

Spare Parts

D1	insert screw	in. lbs.	Torx wrench
.500	**12148006000**	4.4	**FT6**
.620	**12148006000**	4.4	**FT6**
.745	**12148006000**	4.4	**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	–	–	**–**	**–**	–	–

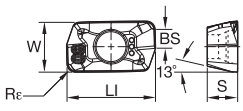
Indexable Inserts

- 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 = .276" (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

catalog number	Ll	W	S	BS	Rε	hm	cutting edges	KC522M	KC725M	KCPK30	KCSM30	KCPM40
EP0708SGE	.322	.185	.110	.067	.031	.003	2	●	●	●	●	●

Recommended Starting Feeds

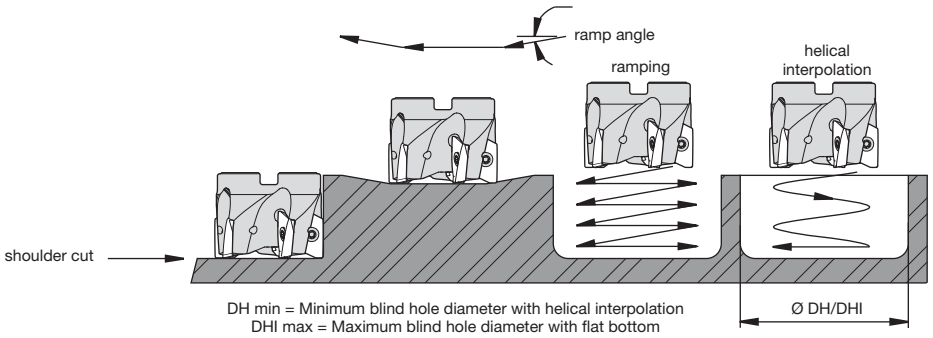
Recommended Starting Feeds [IPT]

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	.009	**.018**	.027	.007	**.013**	.019	.005	**.010**	.014	.004	**.009**	.013	.004	**.008**	.012	.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)
.500	4.56°	.628	.886	1.000
.625	2.97°	.877	1.095	1.250
.750	2.17°	1.126	1.362	1.500

NOTE: Max ramp angle decreases as nose radius increases.

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, minimizing 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 Authorized 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

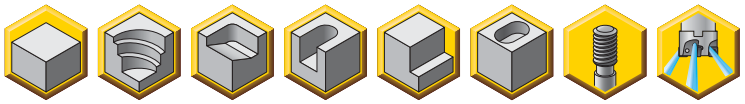
Versatility

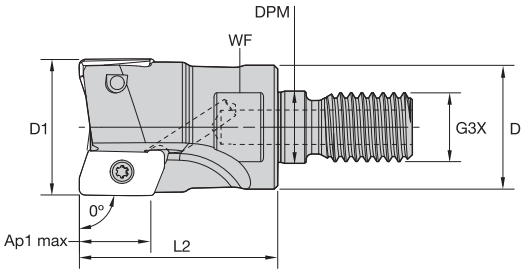
- Works with all tool materials.
- Capable of shoulder, ramp, plunge, and helical milling.
- Internal coolant and air supply.

Advantages

- Optimized soft cutting edge.
- Elliptical edge generates 0° 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.

- Mill 0° walls.
- Ramping capable for all Mill 1-10.
- Generates superior surface finish.
- High RPM capabilities.







Screw-On End Mills

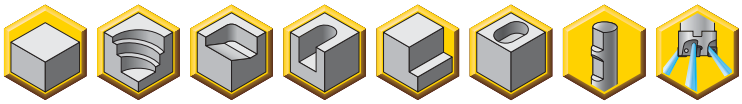
order number	catalog number	D1	D	DPM	G3X	L2	WF (mm)	Ap1 max	Z	max ramp angle	lbs	max RPM
3742470	**M1D062E1002CM08**	.625	.512	.335	M8	1.000	10	.396	2	9.5°	.05	53000
3742471	**M1D075E1002CM10**	.750	.709	.413	M10	1.100	15	.398	2	6.5°	.09	45900
3742472	**M1D075E1003CM10**	.750	.709	.413	M10	1.100	15	.398	3	6.5°	.10	45900
3742513	**M1D100E1003CM12**	1.000	.827	.492	M12	1.250	17	.395	3	4.0°	.19	39700
3742514	**M1D100E1004CM12**	1.000	.827	.492	M12	1.250	17	.395	4	4.0°	.18	39700
3742516	**M1D125E1005CM16**	1.250	1.142	.669	M16	1.500	22	.392	5	2.5°	.38	35500
3742517	**M1D150E1006CM16**	1.500	1.142	.669	M16	1.500	22	.390	6	2.0°	.46	32400

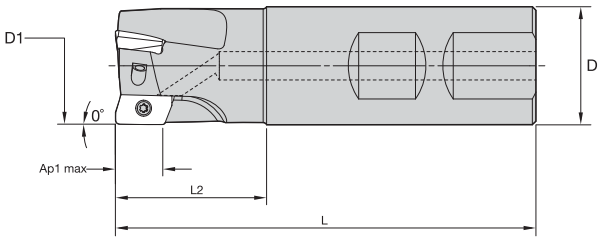
Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus wrench
.625	**MS2205**	9.0	**F7IP**
.750	**MS2205**	9.0	**F7IP**
1.000	**MS2205**	9.0	**F7IP**
1.250	**MS2205**	9.0	**F7IP**
1.500	**MS2205**	9.0	**F7IP**

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

- Mill 0° walls.
- Aggressive ramping rates.
- Generates superior surface finish.
- High RPM capabilities.







Weldon® End Mills

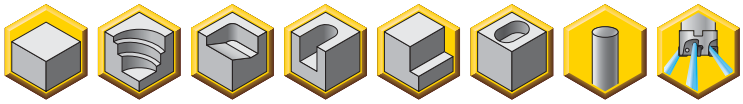
order number	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
3742552	**M1D062E1002W075L100**	.625	.750	3.030	1.000	.396	2	9.5°	.28	50300
3742553	**M1D075E1002W075L110**	.750	.750	3.130	1.100	.398	2	6.5°	.30	45900
3742554	**M1D075E1003W075L110**	.750	.750	3.130	1.100	.398	3	6.5°	.30	45900
3897781	**M1D100E1003W075L125**	1.000	.750	3.280	1.250	.395	3	4.0°	.40	39700
3897782	**M1D100E1004W075L125**	1.000	.750	3.280	1.250	.395	4	4.0°	.40	39700
3742555	**M1D100E1003W100L125**	1.000	1.000	3.530	1.250	.395	3	4.0°	.65	39700
3742556	**M1D100E1004W100L125**	1.000	1.000	3.530	1.250	.395	4	4.0°	.64	39700
3742557	**M1D125E1004W125L160**	1.250	1.250	3.880	1.600	.392	4	2.5°	1.12	35500
3742558	**M1D125E1005W125L160**	1.250	1.250	3.880	1.600	.392	5	2.5°	1.11	35500

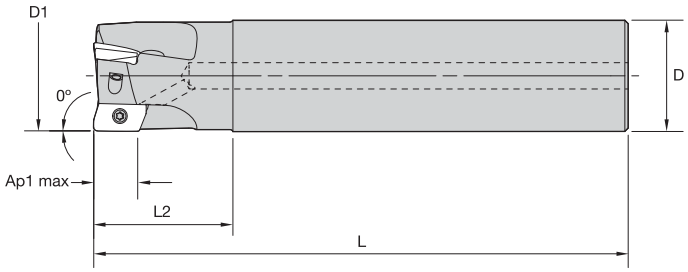
Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
.625	**MS2205**	9.0	**DT7IP**
.750	**MS2205**	9.0	**DT7IP**
1.000	**MS2205**	9.0	**DT7IP**
1.250	**MS2205**	9.0	**DT7IP**

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

- Mill 0° walls.
- Aggressive ramping rates.
- Generates superior surface finish.
- High RPM capabilities.







Cylindrical End Mills

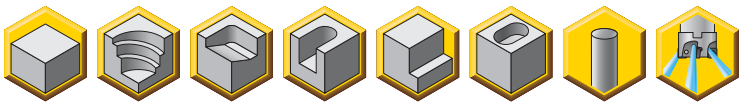
order number	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
3742518	M1D050E1001C062L350	.500	.625	3.500	.800	.404	1	11.5°	.25	56500
3742536	M1D062E1002C062L670	.625	.625	6.700	.999	.396	2	9.5°	.49	50300
3742519	M1D062E1002C075L400	.625	.750	4.000	1.000	.396	2	9.5°	.40	50300
3742520	M1D075E1002C075L450	.750	.750	4.500	1.100	.398	2	6.5°	.46	45900
3742538	M1D075E1002C075L670	.750	.750	6.700	1.250	.398	2	6.5°	.70	45900
3742521	M1D075E1003C075L450	.750	.750	4.500	1.100	.398	3	6.5°	.46	45900
3742540	M1D075E1003C075L670	.750	.750	6.700	1.250	.398	3	6.5°	.71	45900
3742542	M1D088E1003C075L670	.875	.750	6.700	1.250	.396	3	5.0°	.74	42600
3897779	M1D100E1003C075L480	1.000	.750	4.800	1.250	.395	3	4.0°	.58	39700
3897780	M1D100E1004C075L480	1.000	.750	4.800	1.250	.395	4	4.0°	.58	39700
3742522	M1D100E1003C100L480	1.000	1.000	4.800	1.250	.395	3	4.0°	.92	39700
3742543	M1D100E1003C100L800	1.000	1.000	8.000	1.600	.395	3	4.0°	1.59	39700
3742533	M1D100E1004C100L480	1.000	1.000	4.800	1.250	.395	4	4.0°	.92	39700
3742545	M1D100E1004C100L800	1.000	1.000	8.000	1.600	.395	4	4.0°	1.59	39700
3742547	M1D110E1004C100L800	1.100	1.000	8.000	1.600	.394	4	3.3°	1.64	38000
3742534	M1D125E1004C125L520	1.250	1.250	5.200	1.600	.392	4	2.5°	1.57	35500
3742548	M1D125E1004C125L800	1.250	1.250	8.000	1.900	.392	4	2.5°	2.48	35500
3742535	M1D125E1005C125L520	1.250	1.250	5.200	1.600	.392	5	2.5°	1.57	35500
3742550	M1D125E1005C125L800	1.250	1.250	8.000	1.900	.392	5	2.5°	2.48	35500

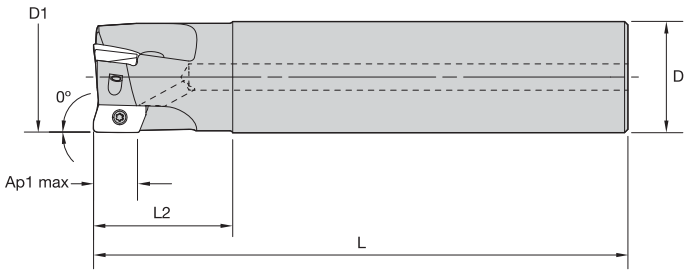
Spare Parts

D1	insert screw	in. lbs.	Torx Plus driver
.500	MS2205	9.0	DT7IP
.625	MS2205	9.0	DT7IP
.750	MS2205	9.0	DT7IP
.875	MS2205	9.0	DT7IP
1.000	MS2205	9.0	DT7IP
1.100	MS2205	9.0	DT7IP
1.250	MS2205	9.0	DT7IP

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

- Mill 0° walls.
- Aggressive ramping rates.
- Generates superior surface finish.
- High RPM capabilities.







Cylindrical End Mills • Long Length

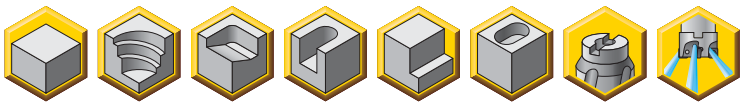
order number	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
3742537	**M1D062E1002C062L670R**	.625	.625	6.688	.987	.384	2	8.0°	.49	50300
3742541	**M1D075E1003C075L670R**	.750	.750	6.689	1.239	.387	3	5.3°	.71	45900
3742544	**M1D100E1003C100L800R**	1.000	1.000	7.989	1.589	.385	3	3.0°	1.59	39700
3742546	**M1D100E1004C100L800R**	1.000	1.000	7.989	1.589	.384	4	3.0°	1.59	39700
3742551	**M1D125E1005C125L800R**	1.250	1.250	7.989	1.889	.382	5	2.0°	2.48	35500

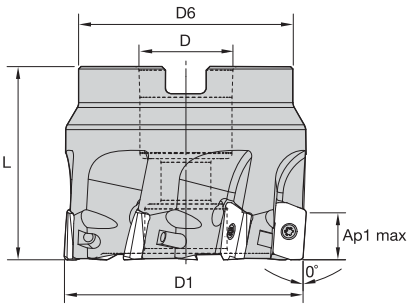
Spare Parts

D1	insert screw	in. lbs.	Torx Plus driver
.625	**MS2205**	9.0	**DT7IP**
.750	**MS2205**	9.0	**DT7IP**
1.000	**MS2205**	9.0	**DT7IP**
1.250	**MS2205**	9.0	**DT7IP**

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.
"R" in catalog number designates factory-relieved tool for insert radii greater than .079".

- Mill 0° walls.
- Aggressive ramping rates.
- Generates superior surface finish.
- High RPM capabilities.







Shell Mills

order number	catalog number	D1	D	D6	L	Ap1 max	Z	max ramp angle	lbs	max RPM
3745039	**M1D150E1004S075L157**	1.500	.750	1.420	1.575	.391	4	2.0°	.46	32400
3745040	**M1D150E1006S075L157**	1.500	.750	1.420	1.575	.391	6	2.0°	.49	32400
3745041	**M1D200E1005S075L157**	2.000	.750	1.750	1.575	.389	5	1.5°	.92	28100
3745042	**M1D200E1008S075L157**	2.000	.750	1.750	1.575	.389	8	1.5°	.89	28100
3745043	**M1D250E1006S075L157**	2.500	.750	1.750	1.575	.389	6	1.0°	1.29	25100
3745045	**M1D250E1009S075L157**	2.500	.750	1.750	1.575	.389	9	1.0°	1.26	25100
3745047	**M1D300E1008S100L175**	3.000	1.000	2.190	1.750	.389	8	.8°	2.08	22900
3745048	**M1D300E1010S100L175**	3.000	1.000	2.190	1.750	.389	10	.8°	2.07	22900
3745049	**M1D400E1008S150L200**	4.000	1.500	3.380	2.000	.389	8	.5°	3.82	19800

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver	 socket-head cap screw
1.500	**MS2205**	9.0	**DT7IP**	**S445**
2.000	**MS2205**	9.0	**DT7IP**	**S445**
2.500	**MS2205**	9.0	**DT7IP**	**S445**
3.000	**MS2205**	9.0	**DT7IP**	**S458**
4.000	**MS2205**	9.0	**DT7IP**	**–**

NOTE: Standard milling cutters will accept insert nose radii up to .079" 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	–	–	–	KC510M

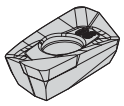
Indexable Inserts

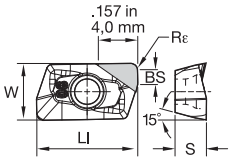
- Roughing and finishing of aluminum and non-ferrous alloys.
- Suitable for wet and dry machining.
- High precision.
- PCD inserts for long tool life.
- Ap1 max = 0.393" (10mm).

● 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

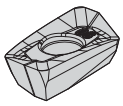
catalog number	LI	W	S	BS	Rε	hm	cutting edges
EC1004FR-PCD	.474	.266	.148	.083	.016	.001	1
EC1008FR-PCD	.474	.265	.148	.067	.031	.001	1

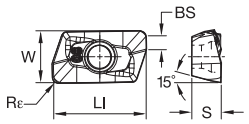
- Periphery ground and polished rake face.
- Roughing and finishing of aluminum alloys.
- Perfect floor surface finish.
- Ap1 max = 0.393" (10mm).

● first choice
○ alternate choice

beyond

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


EDCT-F.LDJ

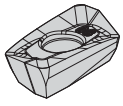


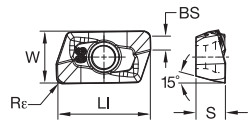
EDCT-F.LDJ

EDCT-F.LDJ

catalog number	LI	W	S	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EC1002FLDJ	.474	.266	.148	.090	.008	.001	2	–	●	–	–	–	–	–	–	–	–	–	–	–
EC1004FLDJ	.474	.266	.148	.078	.016	.001	2	–	●	–	–	–	–	–	–	–	–	–	–	–
EC1008FLDJ	.474	.265	.148	.067	.031	.001	2	–	●	–	–	–	–	–	–	–	–	–	–	–
EC1012FLDJ	.475	.265	.148	.051	.047	.001	2	–	●	–	–	–	–	–	–	–	–	–	–	–
EC1016FLDJ	.475	.265	.148	.036	.062	.001	2	–	●	–	–	–	–	–	–	–	–	–	–	–
EC1020FLDJ	.475	.265	.148	.019	.079	.001	2	–	●	–	–	–	–	–	–	–	–	–	–	–
EC1031FLDJ	.453	.264	.148	—	.122	.001	2	–	●	–	–	–	–	–	–	–	–	–	–	–

- Periphery ground and polished rake face.
- Roughing and finishing of aluminum alloys.
- Perfect floor surface finish.
- Ap1 max = 0.551" (14mm).


EDCT-E.LDJ



EDCT-E.LDJ

EDCT-E.LDJ

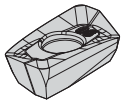
catalog number	LI	W	S	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EC1004ELDJ	.474	.266	.148	.078	.016	.001	2	–	–	●	–	–	–	–	–	–	–	–	–	–
EC1008ELDJ	.474	.265	.148	.067	.031	.001	2	–	–	●	–	–	–	–	–	–	–	–	–	–
EC1016ELDJ	.475	.265	.148	.036	.062	.001	2	–	–	●	–	–	–	–	–	–	–	–	–	–
EC1020ELDJ	.475	.265	.148	.019	.079	.001	2	–	–	●	–	–	–	–	–	–	–	–	–	–
EC1024ELDJ	.475	.265	.148	.004	.094	.001	2	–	–	●	–	–	–	–	–	–	–	–	–	–

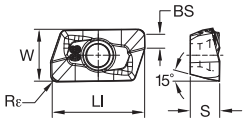
- Finishing and high-precision applications.
- Light machining.
- 15° positive rake angle.
- Perfect floor surface finish.
- Ap1 max = .393" (10mm).

● first choice
○ alternate choice

beyond

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


EDCT-LD

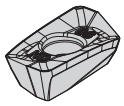


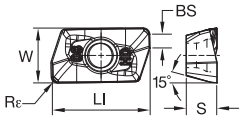
EDCT-LD

EDCT-LD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EC1002ELD	.474	.266	.148	.090	.008	.002	2	–	–	–	–	–	–	●	–	●	–	–	–	–
EC1004ELD	.474	.266	.148	.078	.016	.002	2	–	–	–	–	●	●	●	–	●	–	–	–	–
EC1008ELD	.474	.266	.148	.067	.031	.002	2	–	–	–	●	●	●	●	●	●	●	–	●	–
EC1012ELD	.475	.265	.148	.051	.047	.002	2	–	–	–	–	–	●	●	–	–	–	–	●	–
EC1016ELD	.475	.265	.148	.036	.062	.002	2	–	–	–	–	–	●	●	–	●	–	–	●	–
EC1020ELD	.475	.265	.148	.019	.079	.002	2	–	–	–	–	–	–	●	–	●	–	–	–	–
EC1024ELD	.475	.265	.148	.004	.094	.002	2	–	–	–	–	–	●	●	–	–	–	–	●	–
EC1031ELD	.453	.264	.148	—	.122	.002	2	–	–	–	–	–	–	●	–	●	–	–	●	–

- Medium roughing and semi-finishing.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = .393" (10mm)


EDPT-E.HD



EDPT-E.HD

EDPT-E.HD

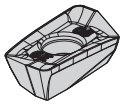
catalog number	LI	W	S	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EP1004EHD	.474	.266	.148	.082	.016	.003	2	–	–	–	–	●	●	●	●	●	●	–	–	–
EP1008EHD	.474	.265	.148	.067	.031	.003	2	–	–	–	–	●	●	●	●	●	●	–	●	–
EP1010EHD	.474	.265	.148	.059	.039	.003	2	–	–	–	–	–	●	●	●	●	–	–	–	–
EP1012EHD	.475	.265	.148	.051	.047	.003	2	–	–	–	–	●	●	●	–	●	●	–	●	–
EP1016EHD	.475	.265	.148	.036	.062	.003	2	–	–	–	–	–	●	●	–	●	●	●	●	–
EP1020EHD	.475	.265	.148	.019	.079	.003	2	–	–	–	–	–	–	●	–	●	●	–	●	–
EP1024EHD	.475	.265	.148	.004	.094	.003	2	–	–	–	–	–	–	●	–	●	–	–	●	–
EP1031EHD	.453	.264	.148	—	.122	.003	2	–	–	–	–	–	●	●	–	●	–	–	●	–

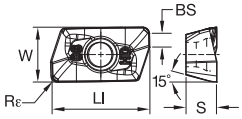
- Medium roughing and semi-finishing.
- Solution for austenitic stainless steel and super alloys.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = .393" (10mm).

● first choice
○ alternate choice

beyond

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


EDPT-S.GE

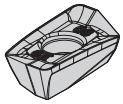


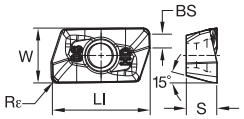
EDPT-S.GE

EDPT-S.GE

catalog number	LI	W	S	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EP1004SGE	.474	.266	.148	.082	.016	.005	2	–	–	–	–	–	●	●	–	●	●	–	–	–
EP1008SGE	.474	.265	.148	.067	.031	.005	2	–	–	–	–	–	●	●	–	●	●	–	●	–
EP1012SGE	.475	.265	.148	.051	.047	.005	2	–	–	–	–	–	●	●	–	●	–	–	●	–
EP1016SGE	.475	.265	.148	.036	.062	.005	2	–	–	–	–	–	●	●	–	●	–	–	●	–
EP1031SGE	.453	.264	.148	—	.122	.005	2	–	–	–	–	–	●	●	–	●	–	–	●	–

- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 0.393" (10mm).


EDPT-S.GD



EDPT-S.GD

EDPT-S.GD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KD1410
EP1004SGD	.474	.266	.148	.082	.016	.005	2	–	–	–	–	–	–	●	●	●	–	–	–	–
EP1008SGD	.474	.265	.148	.067	.031	.005	2	–	–	–	–	●	–	●	●	●	●	–	–	–
EP1012SGD	.475	.265	.148	.051	.047	.005	2	–	–	–	–	●	–	●	●	●	–	–	–	–
EP1016SGD	.475	.265	.148	.036	.062	.005	2	–	–	–	–	–	–	●	–	●	–	–	–	–

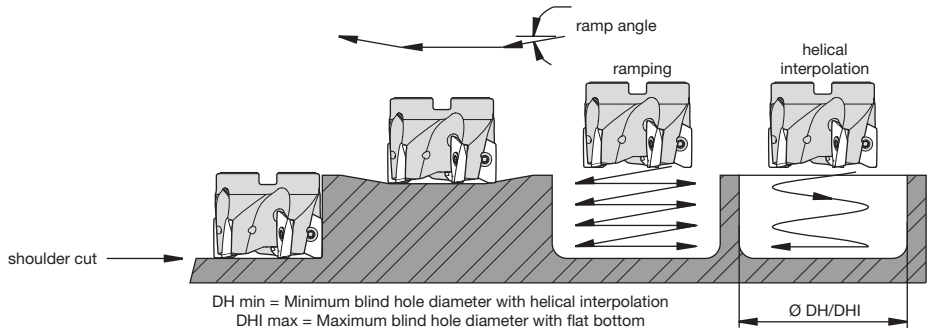
Recommended Starting Feeds [IPT]

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	.005	**.014**	.023	.003	**.010**	.017	.003	**.008**	.013	.002	**.007**	.011	.002	**.006**	.010	.F..LDJ
.F..-PCD	.005	**.014**	.023	.003	**.010**	.017	.003	**.008**	.013	.002	**.007**	.011	.002	**.006**	.010	.F..-PCD
.E..LDJ	.005	**.014**	.023	.003	**.010**	.017	.003	**.008**	.013	.002	**.007**	.011	.002	**.006**	.010	.E..LDJ
.E..LD	.005	**.014**	.023	.004	**.010**	.016	.003	**.008**	.012	.002	**.007**	.011	.002	**.006**	.010	.E..LD
.S..GE	.009	**.018**	.028	.007	**.013**	.020	.005	**.010**	.015	.004	**.009**	.013	.004	**.008**	.012	.S..GE
.S..GD	.009	**.019**	.028	.007	**.013**	.020	.005	**.010**	.015	.004	**.009**	.013	.004	**.008**	.012	.S..GD
.E..HD	.009	**.020**	.032	.007	**.014**	.023	.005	**.011**	.017	.004	**.009**	.015	.004	**.009**	.014	.E..HD

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 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	.500	not recommended	not recommended	not recommended	not recommended	not recommended
Mill-1, 10mm	.625	9.9°	12.5°	.758	1.121	1.250
Mill-1, 10mm	.750	6.8°	9.7°	.998	1.367	1.500
Mill-1, 10mm	.875	5.1°	6.8°	1.248	1.617	1.750
Mill-1, 10mm	1.000	4.1°	5.1°	1.498	1.867	2.000
Mill-1, 10mm	1.100	3.5°	4.3°	1.698	2.067	2.200
Mill-1, 10mm	1.250	2.9°	3.4°	1.999	2.367	2.500
Mill-1, 10mm	1.500	2.2°	2.4°	2.499	2.867	3.000
Mill-1, 10mm	2.000	1.2°	1.6°	3.509	3.876	4.000
Mill-1, 10mm	2.500	1.2°	1.2°	4.509	4.876	5.000
Mill-1, 10mm	3.000	0.9°	1.0°	5.509	5.876	6.000
Mill-1, 10mm	4.000	0.7°	0.7°	7.509	7.876	8.000

NOTE: Max ramp angle decreases as nose radius increases.

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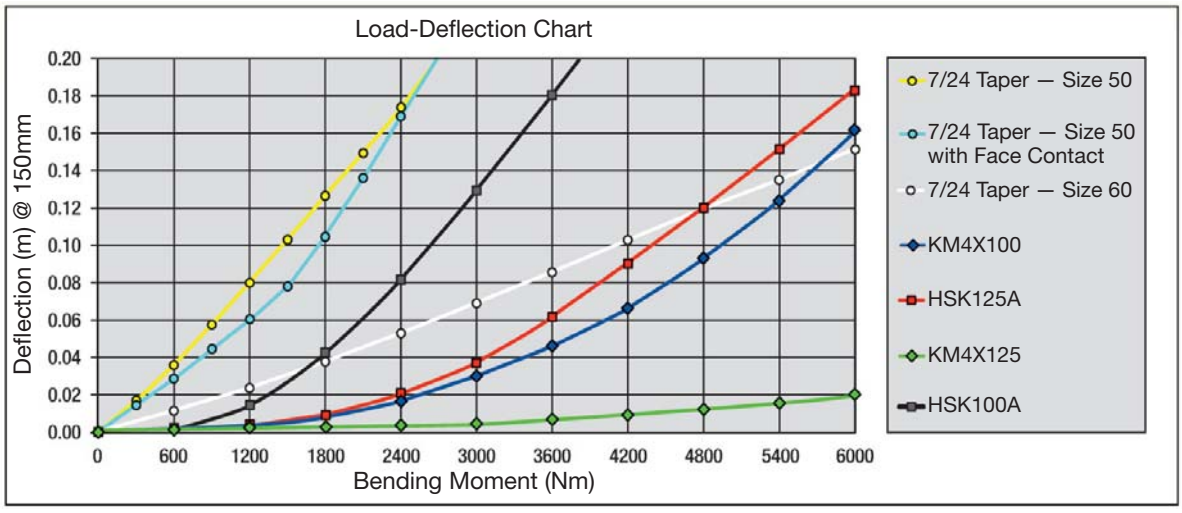
- Achieve lower cost of ownership, increased throughput, and superior results.



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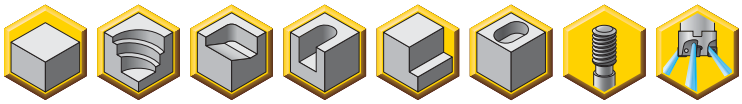
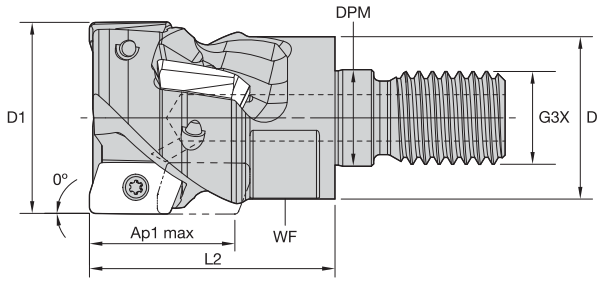
- Mill 0° walls.
- Aggressive ramping rates.
- Generates superior surface finish.







Screw-On Helical Mills

order number	catalog number	D1	D	DPM	G3X	L2	WF (mm)	Ap1 max	Z	Z U	max ramp angle	lbs	max RPM
3746106	**M1HR125ED10M16Z2L160C4**	1.250	1.142	.669	M16	1.614	24	.735	4	2	2.5°	.43	29400
3746107	**M1HR125ED10M16Z3L160C6**	1.250	1.142	.669	M16	1.614	24	.735	6	3	2.5°	.40	29400

Spare Parts



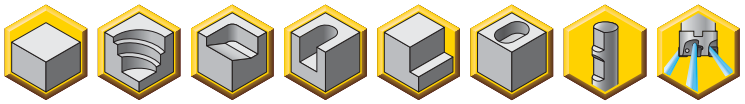


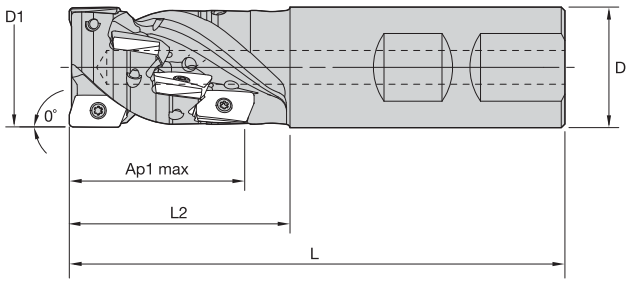


D1	insert screw	in. lbs.	Torx Plus wrench
1.250	**MS2205**	9.0	**F7IP**

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

- Mill 0° walls.
- Aggressive ramping rates.
- Generates superior surface finish.







Weldon® Helical Mills

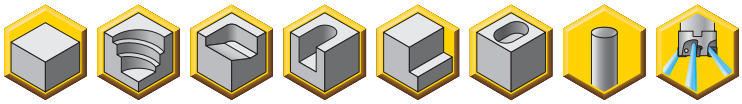
order number	catalog number	D1	D	L	L2	Ap1 max	Z	Z U	max ramp angle	lbs	max RPM
3746093	**M1HR075ED10W075Z2L140C6**	.750	.750	3.422	1.392	1.093	6	2	6.5°	.30	38000
3746097	**M1HR100ED10W100Z2L180C8**	1.000	1.000	4.071	1.790	1.432	8	2	4.0°	.64	32900
3746098	**M1HR125ED10W125Z2L210C10**	1.250	1.250	4.371	2.090	1.764	10	2	2.5°	1.16	29400
3746099	**M1HR125ED10W125Z3L210C15**	1.250	1.250	4.371	2.090	1.764	15	3	2.5°	1.08	29400

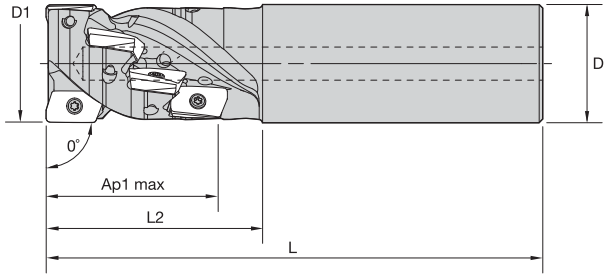
Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
.750	**MS2205**	9.0	**DT7IP**
1.000	**MS2205**	9.0	**DT7IP**
1.250	**MS2205**	9.0	**DT7IP**

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

- Mill 0° walls.
- Aggressive ramping rates.
- Generates superior surface finish.







Cylindrical Helical Mills

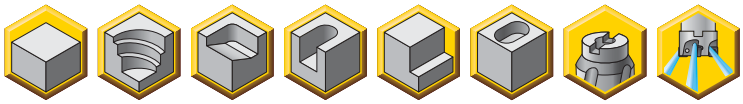
order number	catalog number	D1	D	L	L2	Ap1 max	Z	Z U	max ramp angle	lbs	max RPM
3746100	**M1HR075ED10C075Z2L110C4**	.750	.750	4.406	1.053	.745	4	2	6.5°	.47	38000
3746101	**M1HR100ED10C100Z2L110C4**	1.000	1.000	4.800	1.053	.740	4	2	4.0°	.89	32900

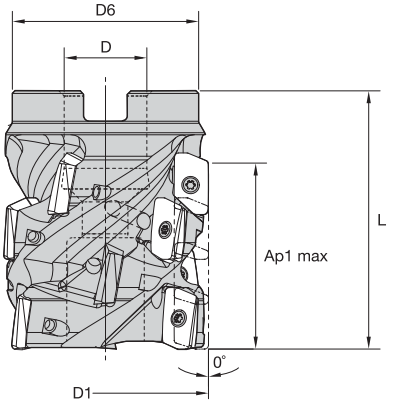
Spare Parts

D1	insert screw	in. lbs.	Torx Plus driver
.750	**MS2205**	9.0	**DT7IP**
1.000	**MS2205**	9.0	**DT7IP**

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

- Mill 0° walls.
- Aggressive ramping rates.
- Generates superior surface finish.







Helical Shell Mills

order number	catalog number	D1	D	D6	L	Ap1 max	Z	Z U	max ramp angle	lbs	max RPM
3746108	**M1HR150ED10S075Z3L200C12**	1.500	.750	1.421	2.000	1.417	12	3	2.0°	.56	26900
3746109	**M1HR150ED10S075Z5L200C20**	1.500	.750	1.420	2.000	1.417	20	5	2.0°	.51	26900
3746110	**M1HR200ED10S075Z3L240C15**	2.000	.750	1.750	2.400	1.745	15	3	1.5°	1.47	23300
3746111	**M1HR200ED10S075Z5L240C25**	2.000	.750	1.750	2.400	1.745	25	5	1.5°	1.31	23300

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
1.500	**MS2205**	9.0	**DT7IP**
2.000	**MS2205**	9.0	**DT7IP**

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

Insert Selection Guide

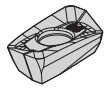
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPM40	**.S..GD**	**KCPM40**	.E..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.E..HD	KCPK30
P5–P6	.E..LD	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	–	–	–	–

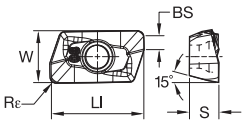
Indexable Inserts

- Periphery ground and polished rake face.
- Roughing and finishing of aluminum alloys.
- Perfect floor surface finish.
- Ap1 max = 0.393" (10mm).

● 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



EDCT-F.LDJ

EDCT-F.LDJ

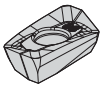
catalog number	Ll	W	S	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1002FLDJ	.474	.266	.148	.090	.008	.001	2	–	●	–	–	–	–	–	–	–	–	–	–
EC1004FLDJ	.474	.266	.148	.078	.016	.001	2	–	●	–	–	–	–	–	–	–	–	–	–
EC1008FLDJ	.474	.265	.148	.067	.031	.001	2	–	●	–	–	–	–	–	–	–	–	–	–
EC1012FLDJ	.475	.265	.148	.051	.047	.001	2	–	●	–	–	–	–	–	–	–	–	–	–
EC1016FLDJ	.475	.265	.148	.036	.062	.001	2	–	●	–	–	–	–	–	–	–	–	–	–
EC1020FLDJ	.475	.265	.148	.019	.079	.001	2	–	●	–	–	–	–	–	–	–	–	–	–
EC1031FLDJ	.453	.264	.148	—	.122	.001	2	–	●	–	–	–	–	–	–	–	–	–	–

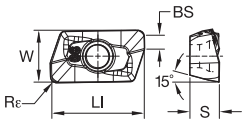
- Perfect floor surface finish.
- Ap1 max = 0.393" (10mm).

beyond

● first choice
○ alternate choice

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


EDCT-E.LDJ

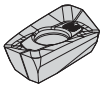


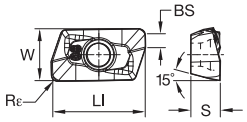
EDCT-E.LDJ

EDCT-E.LDJ

catalog number	LI	W	S	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1004ELDJ	.474	.266	.148	.078	.016	.001	2	–	–	●	–	–	–	–	–	–	–	–	–
EC1008ELDJ	.474	.265	.148	.067	.031	.001	2	–	–	●	–	–	–	–	–	–	–	–	–
EC1016ELDJ	.475	.265	.148	.036	.062	.001	2	–	–	●	–	–	–	–	–	–	–	–	–
EC1020ELDJ	.475	.265	.148	.019	.079	.001	2	–	–	●	–	–	–	–	–	–	–	–	–
EC1024ELDJ	.475	.265	.148	.004	.094	.001	2	–	–	●	–	–	–	–	–	–	–	–	–

- Finishing and high precision applications.
- Light machining.
- 15° positive rake angle.
- Perfect floor surface finish.
- Ap1 max = 0.393" (10mm).


EDCT-LD

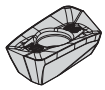


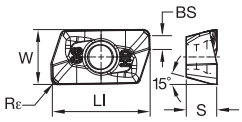
EDCT-LD

EDCT-LD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1002ELD	.474	.266	.148	.090	.008	.002	2	–	–	–	–	–	–	●	–	●	–	–	–
EC1004ELD	.474	.266	.148	.078	.016	.002	2	–	–	–	–	●	●	●	–	●	–	–	–
EC1008ELD	.474	.266	.148	.067	.031	.002	2	–	–	–	●	●	●	●	●	●	–	–	–
EC1012ELD	.475	.265	.148	.051	.047	.002	2	–	–	–	–	–	●	●	–	–	–	–	–
EC1016ELD	.475	.265	.148	.036	.062	.002	2	–	–	–	–	–	●	●	–	●	–	–	–
EC1020ELD	.475	.265	.148	.019	.079	.002	2	–	–	–	–	–	–	●	–	●	–	–	–
EC1024ELD	.475	.265	.148	.004	.094	.002	2	–	–	–	–	–	●	●	–	–	–	–	–
EC1031ELD	.453	.264	.148	—	.122	.002	2	–	–	–	–	–	–	–	–	●	–	–	–

- Medium roughing and semi-finishing.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 0.393" (10mm).


EDPT-E.HD



EDPT-E.HD

● first choice
○ alternate choice

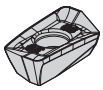
beyond

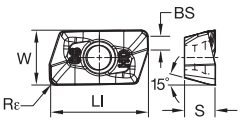
		K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P					○		○	●		●	●		○
M							●	●		○	○	○	●
K					●	●	○		●	○			
N		●	●	●	○								
S							●	●				●	●
H													

EDPT-E.HD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1004EHD	.474	.266	.148	.082	.016	.003	2	–	–	–	–	●	●	●	●	●	–	–	–
EP1008EHD	.474	.265	.148	.067	.031	.003	2	–	–	–	–	●	●	●	●	●	–	–	–
EP1010EHD	.474	.265	.148	.059	.039	.003	2	–	–	–	–	–	●	●	●	●	–	–	–
EP1012EHD	.475	.265	.148	.051	.047	.003	2	–	–	–	–	●	●	●	–	●	–	–	–
EP1016EHD	.475	.265	.148	.036	.062	.003	2	–	–	–	–	–	●	●	–	●	–	–	–
EP1020EHD	.475	.265	.148	.019	.079	.003	2	–	–	–	–	–	–	●	–	●	–	–	–
EP1024EHD	.475	.265	.148	.004	.094	.003	2	–	–	–	–	–	–	●	–	●	–	–	–
EP1031EHD	.453	.264	.148	—	.122	.003	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 = 0.393" (10mm).


EDPT-S.GE



EDPT-S.GE

EDPT-S.GE

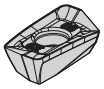
catalog number	LI	W	S	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1004SGE	.474	.266	.148	.082	.016	.005	2	–	–	–	–	–	●	●	–	●	–	–	–
EP1008SGE	.474	.265	.148	.067	.031	.005	2	–	–	–	–	–	●	●	–	●	–	–	–
EP1012SGE	.475	.265	.148	.051	.047	.005	2	–	–	–	–	–	●	●	–	●	–	–	–
EP1016SGE	.475	.265	.148	.036	.062	.005	2	–	–	–	–	–	●	●	–	●	–	–	–
EP1031SGE	.453	.264	.148	—	.122	.005	2	–	–	–	–	–	●	●	–	●	–	–	–

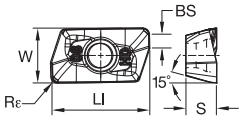
- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 0.393" (10mm).

● first choice
○ alternate choice

beyond

	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○		○	●		●	●		○
M						●	●		○	○	○	●
K				●	●	○		●	○			
N	●	●	●	○								
S						●	●				●	●
H												


EDPT-S.GD



EDPT-S.GD

EDPT-S.GD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	K313	KC410M	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1004SGD	.474	.266	.148	.082	.016	.005	2	–	–	–	–	–	–	●	●	●	–	–	–
EP1008SGD	.474	.265	.148	.067	.031	.005	2	–	–	–	–	●	–	●	●	●	–	–	–
EP1012SGD	.475	.265	.148	.051	.047	.005	2	–	–	–	–	●	–	●	●	●	–	–	–
EP1016SGD	.475	.265	.148	.036	.062	.005	2	–	–	–	–	–	–	●	–	●	–	–	–

Recommended Starting Feeds [IPT]

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	.005	**.014**	.023	.003	**.010**	.017	.003	**.008**	.013	.002	**.007**	.011	.002	**.006**	.010	.F..LDJ
.F..-PCD	.005	**.014**	.023	.003	**.010**	.017	.003	**.008**	.013	.002	**.007**	.011	.002	**.006**	.010	.F..-PCD
.E..LDJ	.005	**.014**	.023	.003	**.010**	.017	.003	**.008**	.013	.002	**.007**	.011	.002	**.006**	.010	.E..LDJ
.E..LD	.005	**.014**	.023	.004	**.010**	.016	.003	**.008**	.012	.002	**.007**	.011	.002	**.006**	.010	.E..LD
.S..GE	.009	**.018**	.028	.007	**.013**	.020	.005	**.010**	.015	.004	**.009**	.013	.004	**.008**	.012	.S..GE
.S..GD	.009	**.019**	.028	.007	**.013**	.020	.005	**.010**	.015	.004	**.009**	.013	.004	**.008**	.012	.S..GD
.E..HD	.009	**.020**	.032	.007	**.014**	.023	.005	**.011**	.017	.004	**.009**	.015	.004	**.009**	.014	.E..HD

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

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 0° walls have proven excellent with the GD2 geometry.





Features and Benefits

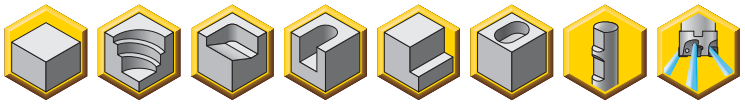
Features

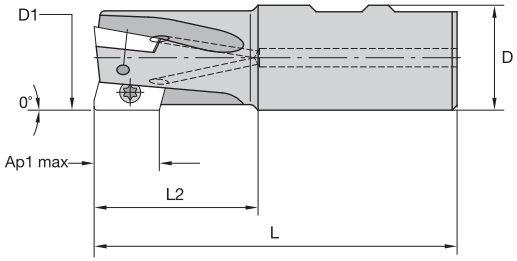
- Insert geometries and grades for most workpiece materials.
- Insert radii from .016" (0,15mm) up to .157" (4mm).
- Axial depth of cut up to .551" (14mm).
- Beyond™ grade technology.

Benefits

- Easy cutting action, even on entry and exiting the workpiece.
- Polished geometry for aluminum machining.
- Slotting, profiling, ramping, helical interpolation, and plunging.

- Mill 0° walls.
- Aggressive ramping angles.
- Generates superior surface finish.
- High RPM capabilities.







Weldon® End Mills

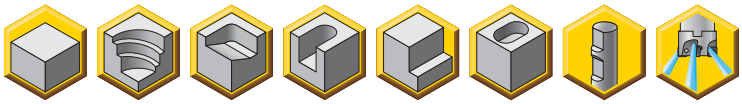
order number	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
2624243	**M1D062E1401W075L150**	.625	.750	3.530	1.500	.580	1	25.0°	.31	8000
2623856	**M1D075E1402W075L175**	.750	.750	3.780	1.750	.580	2	18.0°	.35	49600
2624245	**M1D088E1402W100L175**	.875	1.000	4.030	1.750	.580	2	13.2°	.66	43500
2624189	**M1D097E1403W100L175**	.970	1.000	4.030	1.750	.580	3	10.9°	.69	40100
2623857	**M1D100E1402W100L175**	1.000	1.000	4.030	1.750	.580	2	10.4°	.71	39200
2479508	**M1D100E1403W100L175**	1.000	1.000	4.030	1.750	.580	3	10.2°	.71	39200
2479506	**M1D125E1404W125L225**	1.250	1.250	4.530	2.250	.570	4	7.2°	1.25	33400

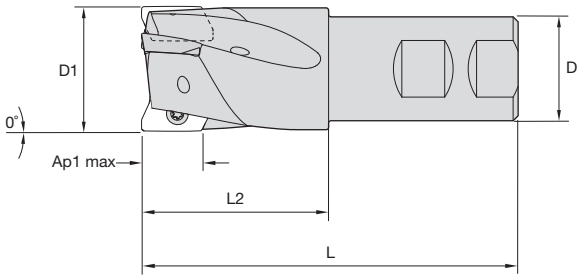
Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
.625	**MS2167**	20.0	**DT9IP**
.750	**MS2167**	20.0	**DT9IP**
.875	**MS2166**	20.0	**DT9IP**
.970	**MS2166**	20.0	**DT9IP**
1.000	**MS2166**	20.0	**DT9IP**
1.250	**MS2166**	20.0	**DT9IP**

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

- Mill 0° walls.
- Aggressive ramping angles.
- Generates superior surface finish.
- High RPM capabilities.







Weldon® End Mills • Reduced Shank

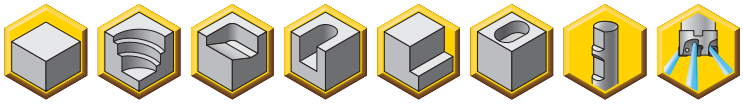
order number	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
2479507	**M1D100E1403W075L175**	1.000	.750	3.780	1.750	.575	3	10.4°	.46	39200
2624199	**M1D100E1403W100L175R**	1.000	1.000	4.010	1.730	.580	3	10.4°	.70	39200
2623858	**M1D125E1403W100L225**	1.250	1.000	4.530	2.250	.571	3	7.2°	.94	33400
2479512	**M1D125E1404W100L225**	1.250	1.000	4.530	2.250	.571	4	7.2°	.97	33400
2624201	**M1D125E1404W125L225R**	1.250	1.250	4.510	2.230	.570	4	7.2°	1.25	33400
2624194	**M1D150E1404W125L225**	1.500	1.250	4.530	2.250	.567	4	5.5°	1.49	29600
2623859	**M1D150E1405W125L225**	1.500	1.250	4.530	2.250	.567	5	5.5°	1.53	29600
2624271	**M1D150E1405W125L225R**	1.500	1.250	4.510	2.230	.555	5	5.5°	1.53	29600

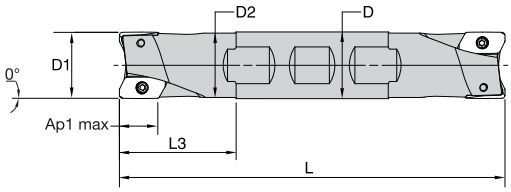
NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.
"R" in catalog number designates factory-relieved tool for insert radii greater than .079".

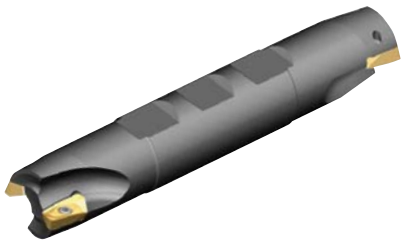
Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
1.000	**MS2166**	20	**DT9IP**
1.250	**MS2166**	20	**DT9IP**
1.500	**MS2166**	20	**DT9IP**

- Mill 0° walls.
- Aggressive ramping angles.
- Generates superior surface finish.
- High RPM capabilities.







Weldon® End Mills • Double Ended

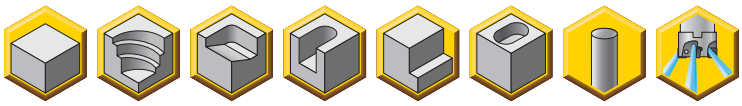
order number	catalog number	D1	D	D2	L	L3	Ap1 max	Z	max ramp angle	lbs	max RPM
2624188	**M1D075E1402W075L175DE**	.750	.750	.681	5.530	1.750	.551	2	18.0°	.53	49600
2624191	**M1D100E1403W100L175DE**	1.000	1.000	.950	5.780	1.750	.580	3	10.2°	1.00	39200

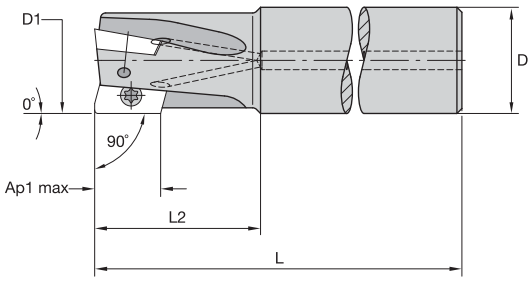
Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
.750	**MS2167**	20	**DT9IP**
1.000	**MS2166**	20	**DT9IP**

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

- Aggressive ramping angles.
- Generates superior surface finish.
- Mill 0° walls.
- High RPM capabilities.







Cylindrical End Mills

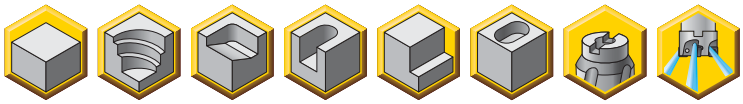
order number	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
2624187	**M1D075E1402C075L650**	.750	.750	6.500	1.750	.570	2	18.5°	.65	49600
2624197	**M1D075E1402C075L800**	.750	.750	8.000	1.750	.570	2	18.5°	.82	49600
2624198	**M1D100E1402C100L1000**	1.000	1.000	10.000	1.750	.570	2	10.2°	1.91	39200
2624190	**M1D100E1403C100L750**	1.000	1.000	7.500	1.750	.570	3	10.2°	1.44	39200
2624200	**M1D125E1403C125L1000**	1.250	1.250	10.000	2.250	.570	3	6.9°	3.09	33400
2624192	**M1D125E1404C125L800**	1.250	1.250	8.000	2.250	.570	4	6.9°	2.44	33400
5903140	**M1D150E1403C125L1000**	1.500	1.250	10.000	2.250	.560	3	5.2°	3.08	29600
2624202	**M1D150E1404C125L1000**	1.500	1.250	10.000	2.250	.560	4	5.2°	3.31	29600
2624250	**M1D150E1405C125L800**	1.500	1.250	8.000	2.250	.560	5	5.2°	2.65	29600

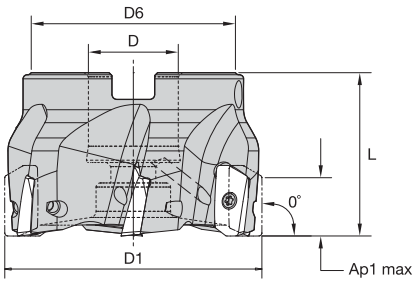
Spare Parts

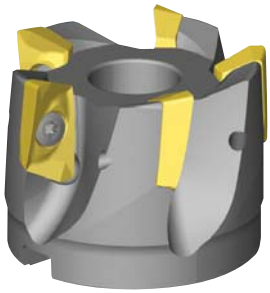
D1	insert screw	in. lbs.	Torx Plus driver
.750	**MS2167**	20	**DT9IP**
1.000	**MS2166**	20	**DT9IP**
1.250	**MS2166**	20	**DT9IP**
1.500	**MS2166**	20	**DT9IP**

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

- Mill 0° walls.
- Aggressive ramping angles.
- Generates superior surface finish.
- High RPM capabilities.







Shell Mills

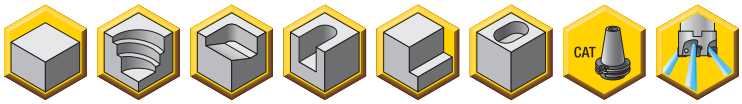
order number	catalog number	D1	D	D6	L	Ap1 max	Z	max ramp angle	lbs	max RPM
2479509	M1D125E1404S050L157	1.250	.500	1.204	1.575	.570	4	6.9°	.28	33400
2624255	M1D150E1405S075L157	1.500	.750	1.414	1.575	.560	5	5.2°	.39	29600
5898598	M1D200E1403S075L157	2.000	.750	1.750	1.575	.560	3	3.4°	.67	24700
2624270	M1D200E1405S075L157	2.000	.750	1.750	1.575	.560	5	3.4°	.72	24700
2479510	M1D200E1406S075L157	2.000	.750	1.750	1.575	.560	6	3.4°	.70	24700
2624274	M1D250E1405S075L157	2.500	.750	1.750	1.575	.560	5	2.5°	1.04	21700
2624254	M1D250E1407S075L157	2.500	.750	1.750	1.575	.560	7	2.5°	1.04	21700
5898597	M1D300E1404S100L175	3.000	1.000	2.188	1.750	.560	4	2.0°	1.56	19600
2624277	M1D300E1406S100L175	3.000	1.000	2.188	1.750	.560	6	2.0°	1.79	19600
2624275	M1D300E1408S100L175	3.000	1.000	2.188	1.750	.560	8	2.0°	1.78	19600
2624279	M1D400E1408S150L200	4.000	1.500	3.625	2.000	.560	8	1.5°	3.97	16700
2624278	M1D400E1410S150L200	4.000	1.500	3.625	2.000	.560	10	1.5°	3.99	16700

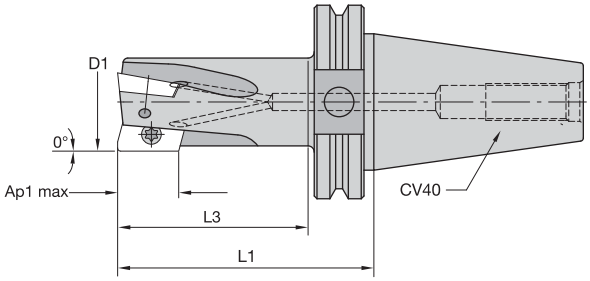
Spare Parts

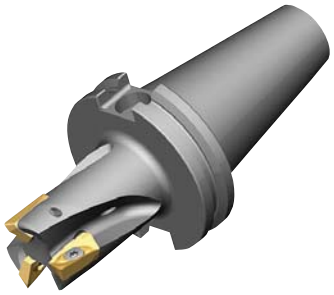
D1	 insert screw	 in. lbs.	 Torx Plus driver	 socket-head cap screw with coolant groove	 coolant screw assembly
1.250	MS2166	20	DT9IP	S422CG	–
1.500	MS2166	20	DT9IP	S445CG	–
2.000	MS2166	20	DT9IP	S445CG	–
2.500	MS2166	20	DT9IP	S445CG	–
3.000	MS2166	20	DT9IP	S2044CG	–
4.000	MS2166	20	DT9IP	–	S2165C

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

- Mill 0° walls.
- Aggressive ramping angles.
- Generates superior surface finish.
- High RPM capabilities.







End Mills • Steep Taper CV40

order number	catalog number	CSMS system size	D1	L1	L3	Ap1 max	Z	max ramp angle	lbs	max RPM
2624246	**M1D100E1403CV40L300**	CV40	1.000	3.000	1.500	.570	3	10.2°	2.40	39200
2624248	**M1D125E1404CV40L300**	CV40	1.250	3.000	1.500	.570	4	6.9°	2.56	33400
2624253	**M1D150E1405CV40L300**	CV40	1.500	3.000	1.625	.560	5	5.2°	2.72	29600

Spare Parts

D1	insert screw	in. lbs.	Torx Plus driver
1.000	**MS2166**	20	**DT9IP**
1.250	**MS2166**	20	**DT9IP**
1.500	**MS2166**	20	**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..GD	KCPM40	**.S..GD2**	**KCPM40**	.E..HD2	KCPM40
P3–P4	.S..GE	KCPK30	**.S..GD2**	**KCPK30**	.E..HD2	KCPK30
P5–P6	.S..GE	KC725M	**.S..GD2**	**KC725M**	.E..HD2	KC725M
M1–M2	.E..LD	KC522M	**.S..GD2**	**KC725M**	.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..GE	KCPM20	**.S..GD2**	**KC520M**	.E..HD2	KC520M
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..GD2**	**KCSM30**	.E..HD2	KCSM30
S3	.E..GD	KCSM40	**.S..GD2**	**KCSM30**	.E..HD2	KCSM30
S4	.S..GE	KCSM40	**.S..GD2**	**KCSM30**	.E..HD2	KCSM30
H1	–	–	**–**	**–**	–	–

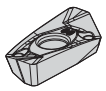
Indexable Inserts

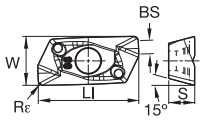
- Roughing and finishing of aluminum alloys.
- Periphery ground and polished rake face.
- Perfect floor surface finish.
- Ap1 max = 0.551" (14mm).

● first choice
○ alternate choice

beyond

	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○	●		●	●		○
M				●	●		○	○	○	●
K			●	○		●	○			
N	●	●								
S				●	●				●	●
H										


EDCT-F.LDJ



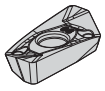
EDCT-F.LDJ

EDCT-F.LDJ

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1402FLDJ	.687	.334	.177	.124	.008	.001	2	●	–	–	–	–	–	–	–	–	–
EC1404FLDJ	.687	.334	.177	.116	.016	.001	2	●	–	–	–	–	–	–	–	–	–
EC1408FLDJ	.688	.334	.177	.101	.031	.001	2	●	–	–	–	–	–	–	–	–	–
EC1412FLDJ	.688	.333	.177	.085	.047	.001	2	●	–	–	–	–	–	–	–	–	–
EC1416FLDJ	.688	.333	.177	.070	.062	.001	2	●	–	–	–	–	–	–	–	–	–
EC1431FLDJ	.689	.331	.177	.010	.122	.001	2	●	–	–	–	–	–	–	–	–	–
EC1440FLDJ	.651	.329	.177	—	.157	.001	2	●	–	–	–	–	–	–	–	–	–

- Roughing and finishing of aluminum alloys.
- Periphery ground and polished rake face.
- Perfect floor surface finish.
- Ap1 max = 0.551" (14mm).

● first choice
○ alternate choice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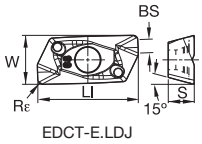
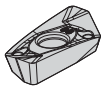


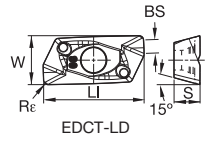
EDCT-E.LDJ

EDCT-E.LDJ

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1404ELDJ	.687	.334	.177	.116	.016	.001	2	–	●	–	–	–	–	–	–	–	–
EC1408ELDJ	.688	.334	.177	.101	.031	.001	2	–	●	–	–	–	–	–	–	–	–
EC1424ELDJ	.689	.332	.177	.039	.094	.001	2	–	●	–	–	–	–	–	–	–	–

- Finishing and high-precision applications.
- Light machining.
- 15° positive rake angle.
- Perfect floor surface finish.
- Ap1 max = 0.551" (14mm).


EDCT-LD

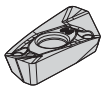


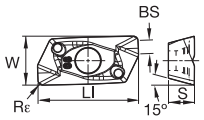
EDCT-LD

EDCT-LD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1404ELD	.687	.334	.177	.116	.016	.002	2	–	–	–	●	–	–	–	–	–	–
EC1408ELD	.688	.334	.177	.101	.031	.002	2	–	–	–	●	–	–	–	–	–	–
EC1412ELD	.688	.333	.177	.085	.047	.002	2	–	–	–	●	–	–	–	–	–	–
EC1416ELD	.688	.333	.177	.070	.062	.002	2	–	–	–	●	–	–	–	–	–	–
EC1431ELD	.689	.331	.177	.010	.122	.002	2	–	–	–	●	–	–	–	–	–	–

- Light machining and finish applications.
- Medium hone for increased edge protection.
- Periphery ground for high-precision machining.
- Ap1 max = .551" (14mm).


EDCT-E.GD



EDCT-E.GD

● first choice
○ alternate choice

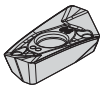
beyond

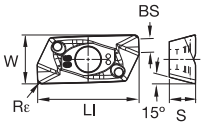
		KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P					○	●		●	●		○
M					●	●		○	○	○	●
K				●	○		●	○			
N		●	●								
S					●	●				●	●
H											

EDCT-E.GD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1404EGD	.687	.334	.177	.116	.016	.002	2	–	–	–	–	●	–	–	●	–	–
EC1408EGD	.688	.334	.177	.101	.031	.002	2	–	–	–	–	●	–	–	●	–	●
EC1412EGD	.688	.333	.177	.085	.047	.002	2	–	–	–	–	●	–	–	–	–	●
EC1416EGD	.688	.333	.177	.070	.062	.002	2	–	–	–	–	●	–	–	–	–	●
EC1431EGD	.689	.331	.177	.010	.122	.002	2	–	–	–	–	●	–	–	–	–	●

- Medium roughing and semi-finishing.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = .551" (14mm).


EDPT-E.HD



EDPT-E.HD

EDPT-E.HD

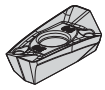
catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1404EHD	.687	.330	.177	.116	.016	.003	2	–	–	●	●	●	●	●	●	–	–
EP1408EHD	.688	.330	.177	.101	.031	.003	2	–	–	●	●	●	●	●	●	–	●
EP1412EHD	.688	.329	.177	.085	.047	.003	2	–	–	●	●	●	●	●	●	–	●
EP1416EHD	.688	.329	.177	.070	.062	.003	2	–	–	–	●	●	●	●	●	●	●
EP1420EHD	.688	.329	.177	.054	.079	.003	2	–	–	–	●	●	–	●	–	–	●
EP1424EHD	.689	.328	.177	.039	.094	.003	2	–	–	–	●	●	–	●	●	–	●
EP1431EHD	.689	.327	.177	.010	.122	.003	2	–	–	–	●	●	–	●	–	●	●
EP1440EHD	.651	.325	.177	—	.157	.003	2	–	–	–	●	●	–	●	–	●	●

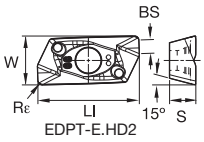
- Medium roughing and semi-finishing.
- Solution for austenitic stainless steel and super alloys.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 0.551" (14mm).

● first choice
○ alternate choice

beyond

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


EDPT-E.HD2

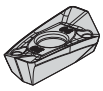


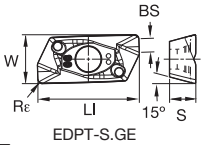
EDPT-E.HD2

EDPT-E.HD2

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1408EHD2	.688	.330	.177	.101	.031	.003	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 = .551" (14mm).


EDPT-S.GE

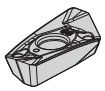


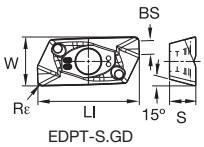
EDPT-S.GE

EDPT-S.GE

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1404SGE	.686	.323	.175	.110	.016	.005	2	–	–	–	●	●	–	●	–	–	–
EP1408SGE	.686	.322	.175	.094	.031	.005	2	–	–	–	●	●	–	●	●	–	●
EP1412SGE	.687	.320	.175	.078	.047	.005	2	–	–	–	●	●	–	●	–	–	●
EP1416SGE	.687	.320	.175	.062	.062	.005	2	–	–	–	●	●	–	●	–	–	●
EP1431SGE	.687	.318	.175	.005	.122	.005	2	–	–	–	–	●	–	●	–	–	●

- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = .551" (14mm).


EDPT-S.GD



EDPT-S.GD

EDPT-S.GD

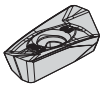
catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1408SGD	.688	.330	.177	.101	.031	.004	2	–	–	●	–	●	–	●	●	–	●
EP1412SGD	.688	.329	.177	.085	.047	.004	2	–	–	●	–	●	–	●	●	–	●
EP1416SGD	.688	.329	.177	.070	.062	.004	2	–	–	●	–	●	–	●	●	–	●

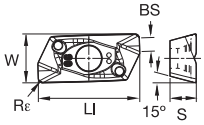
- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = .551" (14mm).

● first choice
○ alternate choice

beyond

		KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P					○	●		●	●		○
M					●	●		○	○	○	●
K				●	○		●	○			
N		●	●								
S					●	●				●	●
H											


EDPT-S.GD2



EDPT-S.GD2

EDPT-S.GD2

catalog number	Ll	W	S	BS	Rε	hm	cutting edges
EP1408SGD2	.688	.330	.177	.103	.031	.004	2

Recommended Starting Feeds

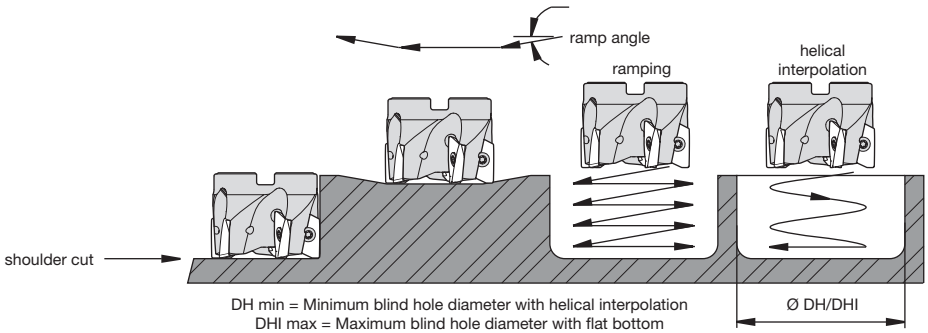
Recommended Starting Feeds [IPT]

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	.005	**.013**	.023	.003	**.009**	.017	.003	**.007**	.013	.002	**.006**	.011	.002	**.006**	.010	.F..LDJ
.E..LDJ	.005	**.017**	.028	.003	**.012**	.020	.003	**.009**	.015	.002	**.008**	.013	.002	**.007**	.012	.E..LDJ
.E..LD	.005	**.016**	.028	.004	**.012**	.020	.003	**.009**	.015	.002	**.008**	.013	.002	**.007**	.012	.E..LD
.E..GD	.007	**.019**	.032	.005	**.013**	.023	.004	**.010**	.017	.003	**.009**	.015	.003	**.008**	.014	.E..GD
.S..GE	.009	**.020**	.032	.007	**.014**	.023	.005	**.011**	.017	.004	**.009**	.015	.004	**.009**	.014	.S..GE
.S..GD	.009	**.020**	.032	.007	**.014**	.023	.005	**.011**	.017	.004	**.009**	.015	.004	**.009**	.014	.S..GD
.S..GD2	.009	**.020**	.032	.007	**.014**	.023	.005	**.011**	.017	.004	**.009**	.015	.004	**.009**	.014	.S..GD2
.E..HD	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.E..HD
.E..HD2	.008	**.023**	.037	.006	**.017**	.027	.004	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.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 (no flat bottom)
Mill-1, 14mm	.625	25°	.625	1.065	1.25
Mill-1, 14mm	.750	18°	.869	1.130	1.50
Mill-1, 14mm	.875	13°	1.113	1.562	1.75
Mill-1, 14mm	.970	11°	1.300	1.752	1.94
Mill-1, 14mm	1.000	10°	1.360	1.812	2.00
Mill-1, 14mm	1.250	7°	1.862	2.312	2.50
Mill-1, 14mm	1.500	6°	2.361	2.812	3.00
Mill-1, 14mm	1.250	7°	1.873	2.322	2.50
Mill-1, 14mm	1.500	5°	2.370	2.822	3.00
Mill-1, 14mm	2.000	4°	3.368	3.822	4.00
Mill-1, 14mm	2.500	3°	4.367	4.822	5.00
Mill-1, 14mm	3.000	2°	5.366	5.822	6.00
Mill-1, 14mm	4.000	2°	7.366	7.822	8.00

NOTE: Max ramp angle decreases as nose radius increases.

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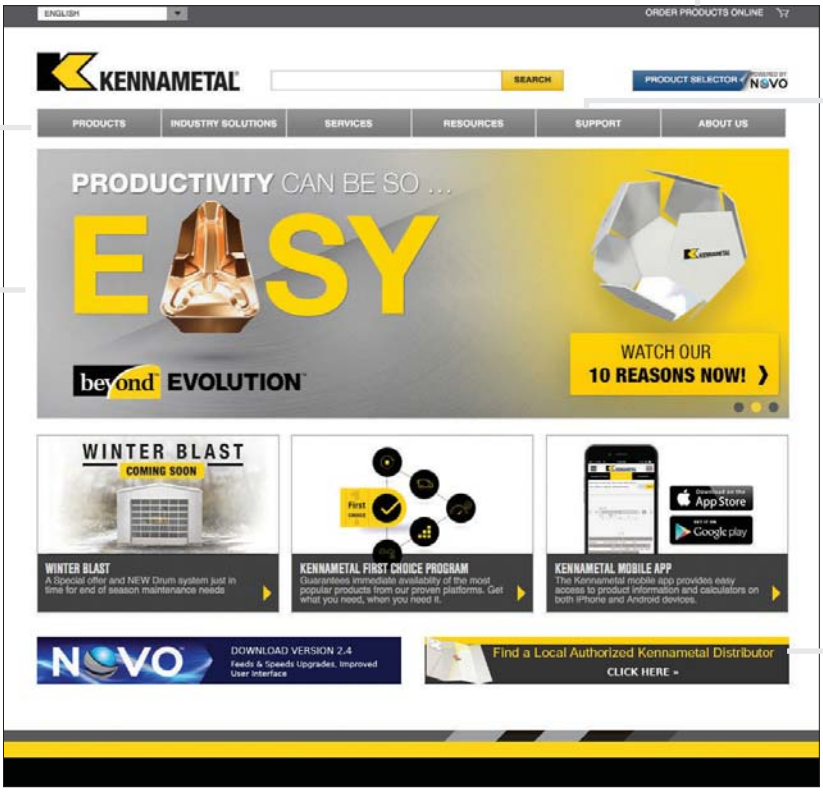

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Mill 1-14™
Helical Cutters

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-Optimized Insert Spacing™ (LOIS) technology. LOIS dramatically minimizes 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

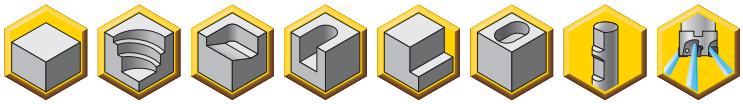
Functions

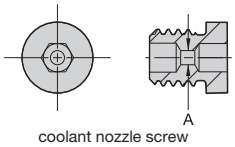
- Improves axial depth of cut better than standard end mills due to the positioning of inserts in helical configuration.
- Up to nine different coolant nozzle diameters tailored to suit each machine tool.
- One tool that offers features common to end mills, but rarely seen on a helical cutter:
  Helical ramping from solid, slotting, contouring, ramping, and plunging.

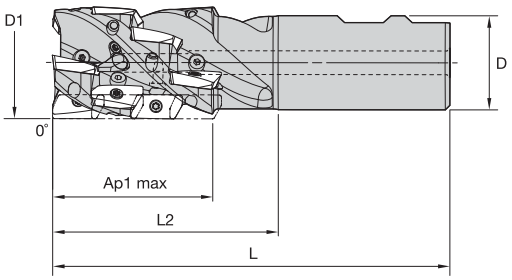
Benefits

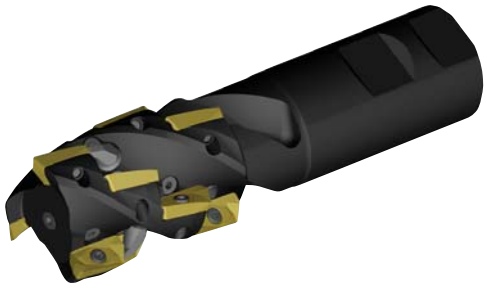
- Increases depth of cut.
- Consistent, focused coolant flow.
- Built for performance, accuracy, and versatility.

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 0° walls.
- Axial support pins.
- Unique coolant nozzles.









Helical Weldon® End Mills • Slot and Profile

order number	catalog number	D1	D	L	L2	Ap1 max	Z	Z U	max ramp angle	lbs	max RPM
3732889	M1HR125E14W125Z2L200C4	1.250	1.250	4.280	2.000	1.100	4	2	6.9°	1.10	31100
3732890	M1HR150E14W125Z3L200C6	1.500	1.250	4.280	2.000	1.090	6	3	5.2°	1.18	28400
3732891	M1HR150E14W125Z3L250C9	1.500	1.250	4.780	2.500	1.612	9	3	5.2°	1.31	28400
3732892	M1HR150E14W125Z3L300C12	1.500	1.250	5.280	3.000	2.130	12	3	5.2°	1.39	28400
3732935	M1HR200E14W150Z3L300C12	2.000	1.500	5.690	3.001	2.104	12	3	3.4°	2.63	24600

Spare Parts

D1	insert screw	in. lbs.	Torx Plus driver	pin	coolant nozzle screw
1.250	MS2148	20	DT9IP	ASPM07001802	MS2191C20
1.500	MS2148	20	DT9IP	ASPM07001802	MS2191C20
2.000	MS2148	20	DT9IP	ASPM07001802	MS2191C20

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

Optional Coolant Nozzle Screws

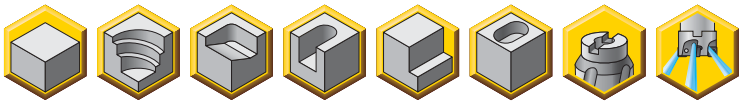
order number	catalog number	A
3400611	MS2191C00	—
3400612	MS2191C06	.024
3400613	MS2191C08	.032
3400616	MS2191C12	.047
3400617	MS2191C14	.055
3400618	MS2191C16	.063
3400619	MS2191C18	.071
3400620	MS2191C20	.079

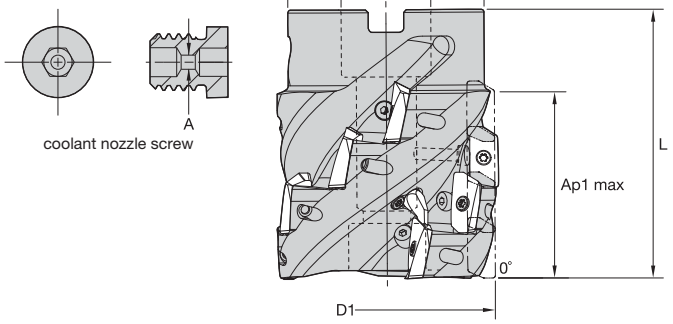
Coolant Nozzle Key

order number	T-handle hex wrench	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 this is a .047" hole.
All coolant nozzles are interchangeable with the original that is supplied with the cutter. This gives flexibility for coolant flow.

- Aggressive ramping rates.
- Generates superior surface finish.
- Mill 0° walls.
- Axial support pins.
- Unique coolant nozzles.







Helical Shell Mills • Slot and Profile

order number	catalog number	D1	D	D6	L	Ap1 max	Z	Z U	max ramp angle	lbs	max RPM
3732933	**M1HR200E14S075Z3L200C6**	2.000	.750	1.750	2.000	1.070	6	3	3.4	.98	24600
3732934	**M1HR200E14S075Z3L250C9**	2.000	.750	1.750	2.500	1.591	9	3	3.4	1.27	24600
3732937	**M1HR250E14S100Z3L250C9**	2.500	1.000	2.188	2.500	1.570	9	3	2.5	2.12	22000
3732938	**M1HR250E14S100Z4L250C12**	2.500	1.000	2.188	2.500	1.570	12	4	2.5	2.05	22000
3732939	**M1HR250E14S100Z3L300C12**	2.500	1.000	2.188	3.000	2.080	12	3	2.5	2.61	22000

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

Spare Parts

order number	D1	L	 insert screw	 in. lbs.	 Torx Plus driver	 pin	 socket-head cap screw	 coolant nozzle screw
3732933	2.000	2.000	**MS2148**	20	**DT9IP**	**ASPM07001802**	**S447**	**MS2191C20**
3732934	2.000	2.500	**MS2148**	20	**DT9IP**	**ASPM07001802**	**S449**	**MS2191C16**
3732937	2.500	2.500	**MS2148**	20	**DT9IP**	**ASPM07001802**	**S462**	**MS2191C20**
3732938	2.500	2.500	**MS2148**	20	**DT9IP**	**ASPM07001802**	**S462**	**MS2191C16**
3732939	2.500	3.000	**MS2148**	20	**DT9IP**	**ASPM07001802**	**S464**	**MS2191C16**

Optional Coolant Nozzle Screws

order number	catalog number	A
3400611	MS2191C00	–
3400612	MS2191C06	.024
3400613	MS2191C08	.032
3400616	MS2191C12	.047
3400617	MS2191C14	.055
3400618	MS2191C16	.063
3400619	MS2191C18	.071
3400620	MS2191C20	.079

Coolant Nozzle Key





order number	catalog number	drive size
1993552	THW2M	2 MM

NOTE: Check the spare parts column 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 this is a .047" (1,20mm) hole. All coolant nozzles are interchangeable with the original that is supplied with the cutter. This gives flexibility with coolant flow.

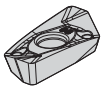
Insert Selection Guide

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 aluminum alloys.
- Periphery ground and polished rake face.
- Perfect floor surface finish.
- Ap1 max = 0.551" (14mm).

● first choice
○ alternate choice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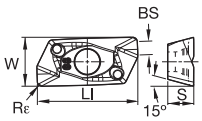


EDCT-F.LDJ

EDCT-F.LDJ

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1402FLDJ	.687	.334	.177	.124	.008	.001	2	●	–	–	–	–	–	–	–	–	–
EC1404FLDJ	.687	.334	.177	.116	.016	.001	2	●	–	–	–	–	–	–	–	–	–
EC1408FLDJ	.688	.334	.177	.101	.031	.001	2	●	–	–	–	–	–	–	–	–	–
EC1412FLDJ	.688	.333	.177	.085	.047	.001	2	●	–	–	–	–	–	–	–	–	–
EC1416FLDJ	.688	.333	.177	.070	.062	.001	2	●	–	–	–	–	–	–	–	–	–
EC1431FLDJ	.689	.331	.177	.010	.122	.001	2	●	–	–	–	–	–	–	–	–	–
EC1440FLDJ	.651	.329	.177	–	.157	.001	2	●	–	–	–	–	–	–	–	–	–

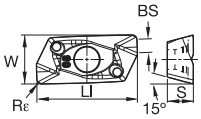
- Roughing and finishing of aluminum alloys.
- Periphery ground and polished rake face.
- Perfect floor surface finish.
- Ap1 max = 0.551" (14mm).

beyond

● first choice
○ alternate choice

		KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P					○	●		●	●		○
M					●	●		○	○	○	●
K				●	○		●	○			
N		●	●								
S					●	●				●	●
H											


EDCT-E.LDJ

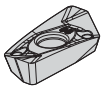


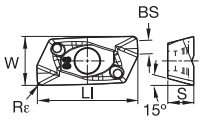
EDCT-E.LDJ

EDCT-E.LDJ

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1404ELDJ	.687	.334	.177	.116	.016	.001	2	–	●	–	–	–	–	–	–	–	–
EC1408ELDJ	.688	.334	.177	.101	.031	.001	2	–	●	–	–	–	–	–	–	–	–
EC1424ELDJ	.689	.332	.177	.039	.094	.001	2	–	●	–	–	–	–	–	–	–	–

- Finishing and high precision applications.
- Light machining.
- 15° positive rake angle.
- Perfect floor surface finish.
- Ap1 max = 0.551" (14mm).


EDCT-LD



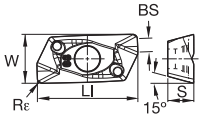
EDCT-LD

EDCT-LD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1404ELD	.687	.334	.177	.116	.016	.002	2	–	–	–	●	–	–	–	–	–	–
EC1408ELD	.688	.334	.177	.101	.031	.002	2	–	–	–	●	–	–	–	–	–	–
EC1412ELD	.688	.333	.177	.085	.047	.002	2	–	–	–	●	–	–	–	–	–	–
EC1416ELD	.688	.333	.177	.070	.062	.002	2	–	–	–	●	–	–	–	–	–	–
EC1431ELD	.689	.331	.177	.010	.122	.002	2	–	–	–	●	–	–	–	–	–	–

- Light machining and finish applications.
- Medium hone for increased edge protection.
- Periphery ground for high precision machining.
- Ap1 max = 0.551" (14mm).


EDCT-E.GD



EDCT-E.GD

● first choice
○ alternate choice

beyond

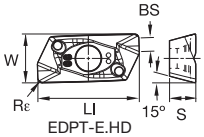
P					○	●		●	●		○
M					●	●		○	○	○	●
K				●	○		●	○			
N	●	●									
S					●	●				●	●
H											

EDCT-E.GD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1404EGD	.687	.334	.177	.116	.016	.002	2	–	–	–	–	●	–	–	●	–	–
EC1408EGD	.688	.334	.177	.101	.031	.002	2	–	–	–	–	●	–	–	●	–	●
EC1412EGD	.688	.333	.177	.085	.047	.002	2	–	–	–	–	●	–	–	–	–	●
EC1416EGD	.688	.333	.177	.070	.062	.002	2	–	–	–	–	●	–	–	–	–	●
EC1431EGD	.689	.331	.177	.010	.122	.002	2	–	–	–	–	●	–	–	–	–	●

- Medium roughing and semi-finishing.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 0.551" (14mm).


EDPT-E.HD



EDPT-E.HD

EDPT-E.HD

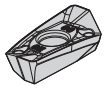
catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1404EHD	.687	.330	.177	.116	.016	.003	2	–	–	●	●	●	●	●	●	–	–
EP1408EHD	.688	.330	.177	.101	.031	.003	2	–	–	●	●	●	●	●	●	–	●
EP1412EHD	.688	.329	.177	.085	.047	.003	2	–	–	●	●	●	●	●	●	–	●
EP1416EHD	.688	.329	.177	.070	.062	.003	2	–	–	–	●	●	●	●	●	●	●
EP1420EHD	.688	.329	.177	.054	.079	.003	2	–	–	–	●	●	–	●	–	–	●
EP1424EHD	.689	.328	.177	.039	.094	.003	2	–	–	–	●	●	–	●	●	–	●
EP1431EHD	.689	.327	.177	.010	.122	.003	2	–	–	–	●	●	–	●	–	●	●
EP1440EHD	.651	.325	.177	—	.157	.003	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 = 0.551" (14mm).

beyond

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

● first choice
○ alternate choice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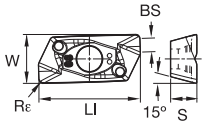
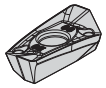


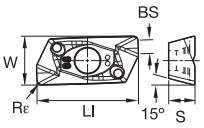
EDPT-E.HD2

EDPT-E.HD2

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1408EHD2	.688	.330	.177	.101	.031	.003	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 = 0.551" (14mm).


EDPT-S.GE



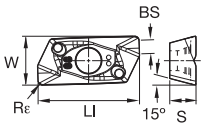
EDPT-S.GE

EDPT-S.GE

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1404SGE	.686	.323	.175	.110	.016	.005	2	–	–	–	●	●	–	●	–	–	–
EP1408SGE	.686	.322	.175	.094	.031	.005	2	–	–	–	●	●	–	●	●	–	●
EP1412SGE	.687	.320	.175	.078	.047	.005	2	–	–	–	●	●	–	●	–	–	●
EP1416SGE	.687	.320	.175	.062	.062	.005	2	–	–	–	●	●	–	●	–	–	●
EP1431SGE	.687	.318	.175	.005	.122	.005	2	–	–	–	–	●	–	●	–	–	●

- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 0.551" (14mm).


EDPT-S.GD

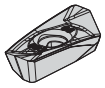


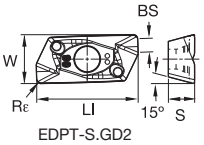
EDPT-S.GD

EDPT-S.GD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1408SGD	.688	.330	.177	.101	.031	.004	2	–	–	●	–	●	–	●	●	–	●
EP1412SGD	.688	.329	.177	.085	.047	.004	2	–	–	●	–	●	–	●	●	–	●
EP1416SGD	.688	.329	.177	.070	.062	.004	2	–	–	●	–	●	–	●	●	–	●

- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = 0.551" (14mm).


EDPT-S.GD2



EDPT-S.GD2

EDPT-S.GD2

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1408SGD2	.688	.330	.177	.103	.031	.004	2	–	–	●	–	●	–	●	●	–	–

● first choice
○ alternate choice

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

Recommended Starting Feeds

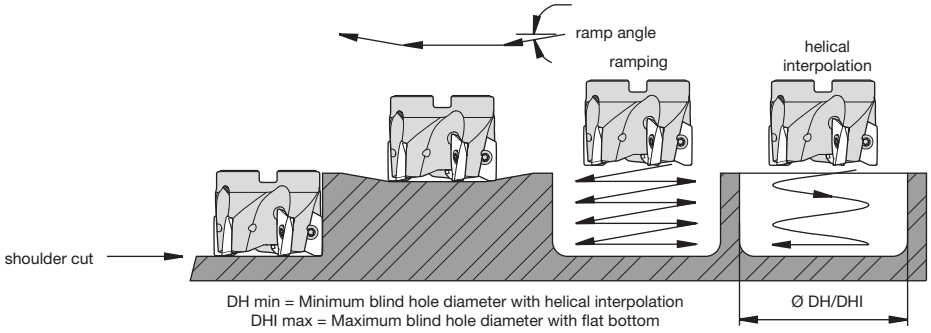
Recommended Starting Feeds [IPT]

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	.005	**.019**	.033	.003	**.013**	.023	.003	**.010**	.018	.002	**.009**	.015	.002	**.008**	.014	.F..LDJ
.E..LDJ	.005	**.019**	.033	.003	**.014**	.024	.003	**.010**	.018	.002	**.009**	.015	.002	**.008**	.014	.E..LDJ
.E..LD	.005	**.018**	.032	.004	**.013**	.023	.003	**.010**	.017	.002	**.009**	.015	.002	**.008**	.014	.E..LD
.E..GD	.007	**.020**	.035	.005	**.015**	.025	.004	**.011**	.019	.003	**.010**	.016	.003	**.009**	.015	.E..GD
.S..GE	.009	**.020**	.035	.007	**.014**	.025	.005	**.011**	.019	.004	**.009**	.017	.004	**.009**	.015	.S..GE
.S..GD	.009	**.020**	.035	.007	**.014**	.025	.005	**.011**	.019	.004	**.009**	.016	.004	**.009**	.015	.S..GD
.S..GD2	.009	**.020**	.035	.007	**.014**	.025	.005	**.011**	.019	.004	**.009**	.016	.004	**.009**	.015	.S..GD2
.E..HD	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.E..HD
.E..HD2	.008	**.023**	.037	.006	**.017**	.027	.004	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.E..HD2

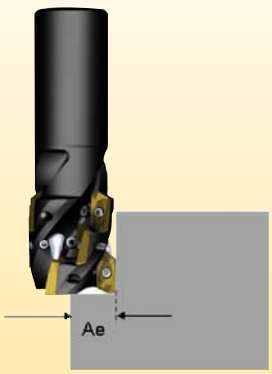
NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Application Examples



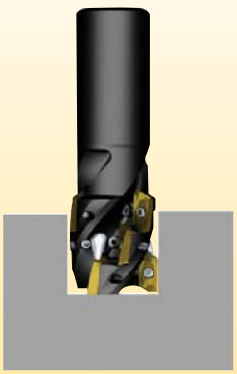
insert style	cutting diameter	max ramp angle	DH min (min hole diameter)	DHI min (min flat-bottomed hole diameter)	max diameter (no flat bottom)
Mill 1-14	1.25	5.4°	1.862	2.312	2.5
Mill 1-14	1.50	4.0°	2.370	2.822	3
Mill 1-14	2.00	2.6°	3.368	3.822	4
Mill 1-14	2.50	1.9°	4.367	4.822	5

Best Machining Practices



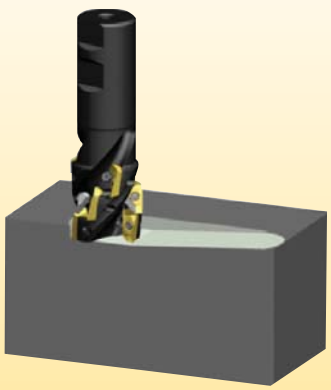
Contouring/Profiling

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.

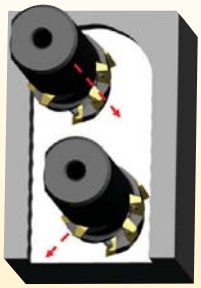


Ramping

Only machine to the depth of the first insert. Observe the ramping angles given in the catalog.

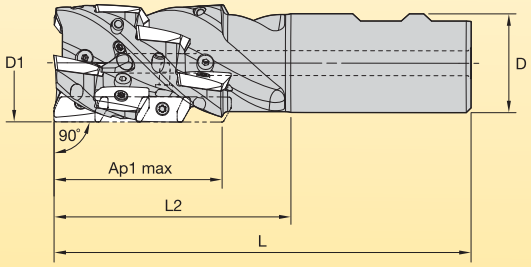
Slotting by Plunging

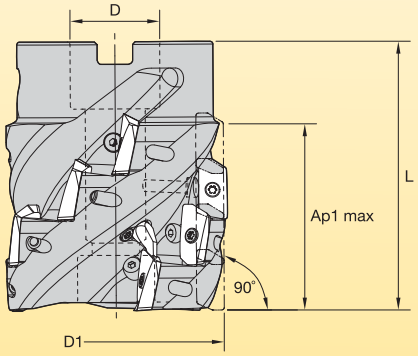
Slot with the alternate side method, alternating the cuts from side to side. This will enable the cutter to move away from the material prior to moving back up in the Z-axis. The cutter will not be in contact with the workpiece. Follow the direction of the arrows. Move 3 axes simultaneously into the center of the slot. Maximum step over 0.315" (8,0mm).



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.







	catalog 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
	M1HR250E14S100Z3L200C6	3732936	2.50	3	6	S	1.00	—	2.00	1.06	1.9°	0.094	22000
	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
	M1HR250E14S100Z3L300C12	3732939	2.50	3	12	S	1.00	—	3.00	2.07	1.9°	0.062	22000
	[5] M1HR250E14S100Z5L300C20	3786638	2.50	5	20	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 0.31" (8mm)
[4] Max insert corner radius allowed in first row without cutter body modification.
[5] Recommended for profiling applications only.

Profile, Slot, and Ramp

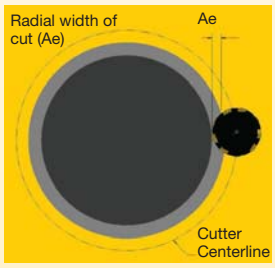
When taking a cut that equals up to 50% of the cutter diameter, you can operate without coolant, unless your material is coolant-dependent. When using more than 50% of the cutter diameter, there is a need to have coolant through the nozzles, or an air blast through the nozzles. This will assist with 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 .130" (3,30mm). 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 .010" (0,25mm).

When machining a conventional slot, you have to move straight up in the Z-axis.

Circular and Helical Interpolation

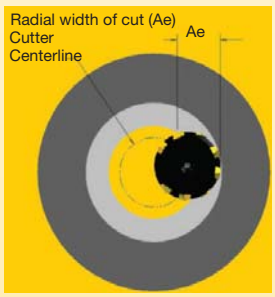
External



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 centerline.

For external profiling, adjust the feed rate for feed at the cutter centerline.
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 centerline, and the feed rate needs to be slower.

For internal profiling, adjust the feed rate for feed at the cutter centerline.
This will effectively reduce the feed rate as the distance traveled is less than the peripheral distance.

Cutting Data

Reference pages X23–X27 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.

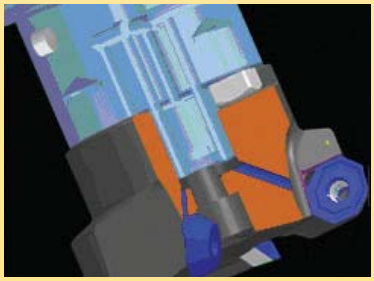
Running too slowly will reduce tool life.

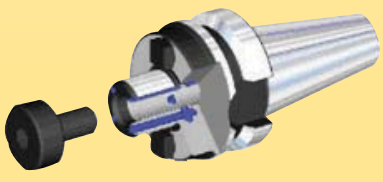
Spare Parts

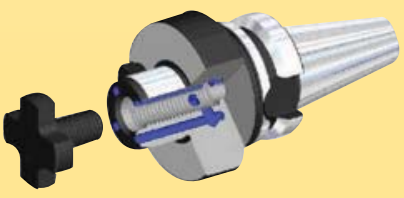
Please make sure all the spare parts in the cutters are fully tightened prior to using the product.

Shell mill cutters no longer have coolant grooved bolts. We now have adapters that will enable the coolant to be fed through the adapter pilot diameter.

True Through Coolant Shell Mill Adapters







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

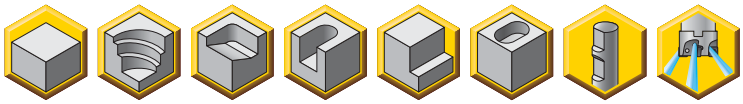
Features

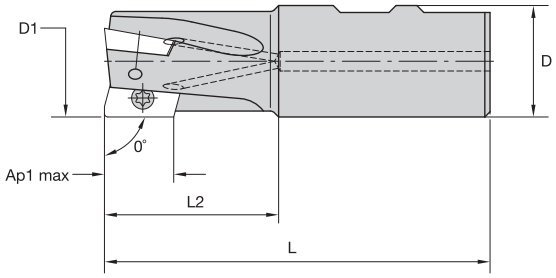
- Inserts for larger axial depth of cut.
- Inserts radii up to .250" (6,35mm).
- Axial depth of cut up to .708" (18mm).
- Cutter diameters up to 8" (160mm).
- Beyond™ grade technology.

Benefits

- Slotting, profiling, ramping, helical interpolation, and plunging.
- Angled screw for insert retention.
- Insert geometries and grades for most workpiece materials.

- Mill 0° walls.
- Aggressive ramping angles.
- Generates superior surface finish.
- High RPM capabilities.







Weldon® End Mills

order number	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
2267545	**M1D097E1802W100L175**	.970	1.000	4.030	1.750	.710	2	17.7°	.66	37710
2267546	**M1D100E1802W100L175**	1.000	1.000	4.030	1.750	.710	2	16.7°	.68	37000
2267550	**M1D100E1802W100L175R**	1.000	1.000	3.968	1.688	.640	2	13.4°	.67	37000
2267547	**M1D100E1802W100L375**	1.000	1.000	6.030	3.750	.710	2	16.7°	1.00	37000
2267552	**M1D100E1802W100L375R**	1.000	1.000	5.968	3.688	.640	2	13.4°	.99	37000
2267623	**M1D125E1803W125L225**	1.250	1.250	4.530	2.250	.710	3	10.9°	1.17	32300
2267624	**M1D125E1803W125L225R**	1.250	1.250	4.469	2.188	.650	3	7.5°	1.16	32300
2267625	**M1D125E1803W125L425**	1.250	1.250	6.530	4.250	.710	3	10.9°	1.71	32300
2267626	**M1D125E1803W125L425R**	1.250	1.250	6.468	4.188	.650	3	7.5°	1.71	32300

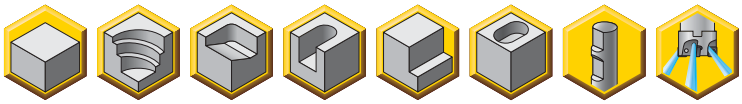
NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.
"R" in catalog number designates factory-relieved tool for insert radii greater than .079". For example: M1D100E1802W100L375**R**.

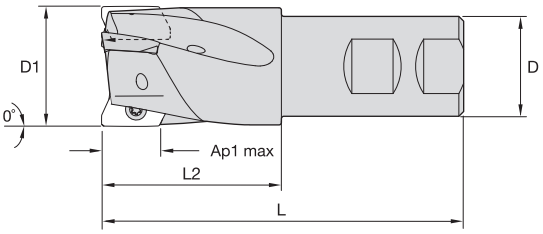
Spare Parts

D1	insert screw	in. lbs.	Torx Plus driver
.970	**MS2126**	35	**DT15IP**
1.000	**MS2126**	35	**DT15IP**
1.250	**MS2126**	35	**DT15IP**

NOTE: Additional insert screws may be ordered in packages of five pieces from catalog number MS2126PKG.

- Mill 0° walls.
- Aggressive ramping angles.
- Generates superior surface finish.
- High RPM capabilities.







Weldon® End Mills • Reduced Shank

order number	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
2452372	**M1D100E1802W075L175**	1.000	.750	3.780	1.750	.710	2	14.0°	.43	37000
2452414	**M1D125E1802W100L225**	1.250	1.000	4.530	2.250	.710	2	10.9°	.95	32300
2635710	**M1D125E1803W100L225**	1.250	1.000	4.530	2.250	.710	3	10.9°	.89	32300
2267627	**M1D150E1803W125L225**	1.500	1.250	4.530	2.250	.710	3	8.2°	1.43	29020
2267651	**M1D150E1803W125L425**	1.500	1.250	6.530	4.250	.710	3	8.2°	2.26	29020
2267631	**M1D150E1803W125L425R**	1.500	1.250	6.468	4.188	.640	3	5.2°	2.25	29020
2267629	**M1D150E1804W125L225**	1.500	1.250	4.530	2.250	.710	4	8.2°	1.38	29020
2267628	**M1D150E1804W125L225R**	1.500	1.250	4.468	2.188	.640	4	5.2°	1.38	29020
2267621	**M1D200E1805W125L225**	2.000	1.250	4.530	2.250	.700	5	5.5°	2.00	24670

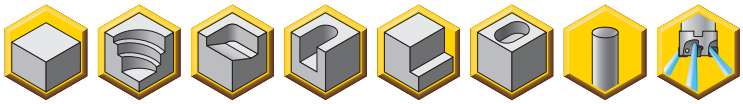
NOTE: "Standard milling cutters will accept insert nose radii up to .079" without modification.
R" in catalog number designates factory-relieved tool for insert radii greater than .079". For example: M1D100E1802W100L375**R**.

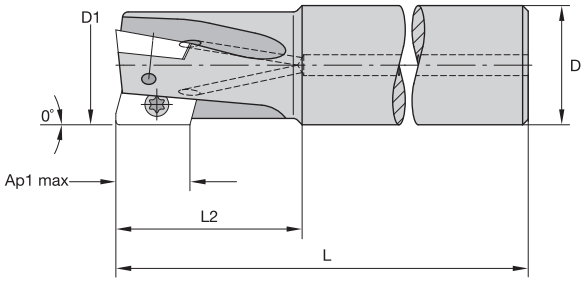
Spare Parts

D1	insert screw	in. lbs.	Torx Plus driver
1.000	**MS2126**	35	**DT15IP**
1.250	**MS2126**	35	**DT15IP**
1.500	**MS2126**	35	**DT15IP**
2.000	**MS2126**	35	**DT15IP**

NOTE: Additional insert screws may be ordered in packages of five pieces from catalog number MS2126PKG.

- Mill 0° walls.
- Aggressive ramping angles.
- Generates superior surface finish.
- High RPM capabilities.







Cylindrical End Mills

order number	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
2267534	**M1D100E1802C100L800**	1.000	1.000	8.000	3.750	.710	2	16.7°	1.41	37000
2267535	**M1D100E1802C100L1000**	1.000	1.000	10.000	3.750	.710	2	16.7°	1.82	37000
2267536	**M1D125E1802C125L800**	1.250	1.250	8.000	4.250	.710	2	10.9°	2.27	32300
2267537	**M1D125E1802C125L1000**	1.250	1.250	10.000	4.250	.710	2	10.9°	2.94	32300
2267538	**M1D150E1803C125L800**	1.500	1.250	8.000	4.250	.710	3	8.2°	2.75	29020
2267539	**M1D150E1803C125L1000**	1.500	1.250	10.000	4.250	.710	3	8.2°	3.42	29020
5194531	**M1D150E1803C125L1000AL**	1.500	1.250	10.000	2.000	.710	3	8.2°	3.11	29020

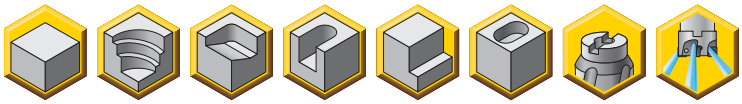
NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.
Cylindrical shank with no through coolant.
Cutters designated with the -AL suffix have relieved flutes for aggressive aluminum machining.

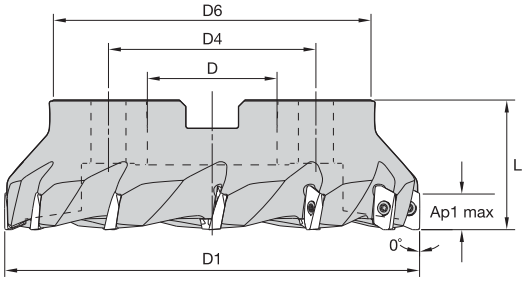
Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
1.000	**MS2126**	35	**DT15IP**
1.250	**MS2126**	35	**DT15IP**
1.500	**MS2126**	35	**DT15IP**

NOTE: Additional insert screws may be ordered in packages of five pieces from catalog number MS2126PKG.

- Mill 0° walls.
- Aggressive ramping angles.
- Generates superior surface finish.
- High RPM capabilities.







Shell Mills

order number	catalog number	D1	D	D4	D6	L	Ap1 max	Z	max ramp angle	lbs	max RPM
2267542	**M1D200E1803S075L157**	2.000	.750	—	1.688	1.575	.700	3	5.2°	.71	24670
5067568	**M1D200E1803S075L157AL**	2.000	.750	—	1.688	1.575	.700	3	5.2°	.60	24670
2267650	**M1D200E1805S075L157**	2.000	.750	—	1.688	1.575	.700	5	5.2°	.69	24670
5067567	**M1D250E1804S075L157AL**	2.500	.750	—	1.750	1.575	.690	4	3.8°	.83	21820
2267632	**M1D250E1806S075L157**	2.500	.750	—	1.750	1.575	.690	6	3.8°	1.00	21820
5135356	**M1D300E1804S100L175AL**	3.000	1.000	—	2.188	1.750	.690	4	3.0°	1.44	19780
2267616	**M1D300E1805S100L175**	3.000	1.000	—	2.188	1.750	.690	5	3.0°	1.72	19780
2267643	**M1D300E1807S100L175**	3.000	1.000	—	2.188	1.750	.690	7	3.0°	1.75	19780
2267617	**M1D400E1806S150L200**	4.000	1.500	—	3.625	2.000	.690	6	2.1°	3.80	16970
2267644	**M1D400E1808S150L200**	4.000	1.500	—	3.625	2.000	.690	8	2.1°	3.83	16970
2267645	**M1D500E1809S150L200**	5.000	1.500	—	3.750	2.000	.690	9	1.6°	5.75	15100
2267646	**M1D600E1808S150L200**	6.000	1.500	—	3.750	2.000	.690	8	1.3°	7.46	13740
2267618	**M1D600E1808S200L200**	6.000	2.000	—	4.875	2.000	.690	8	1.3°	8.77	13740
2267620	**M1D800E1812S250L250**	8.000	2.500	4.000	6.125	2.500	.690	12	1.0°	15.35	11850

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.
"Speed screw" differential lock-up system is identified by the "SS" in the catalog number. For example: M1D200E1803**SS**075L157.
Cutters designated with the -AL suffix have relieved flutes for aggressive aluminum machining.

Spare Parts



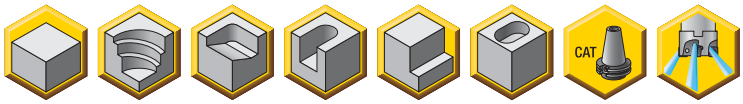


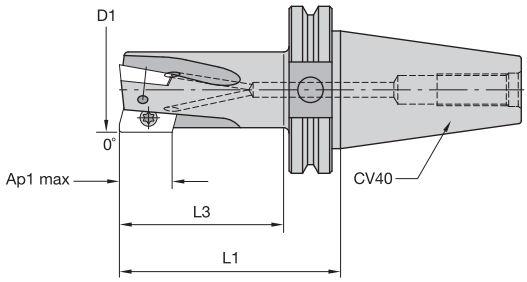


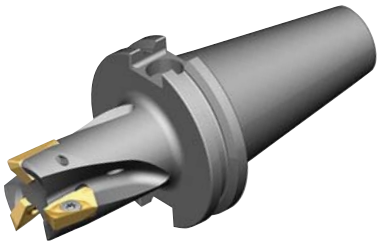

order number	D1	insert screw	in. lbs.	Torx Plus driver	socket-head cap screw with coolant groove	coolant screw assembly	coolant screw assembly
2267542	2.000	**MS2126**	35	**DT15IP**	**S445CG**	—	—
5067568	2.000	**MS2126**	35	**DT15IP**	**S445CG**	—	—
2267650	2.000	**MS2126**	35	**DT15IP**	**S445CG**	—	—
5067567	2.500	**MS2126**	35	**DT15IP**	**S445CG**	—	—
2267632	2.500	**MS2126**	35	**DT15IP**	**S445CG**	—	—
5135356	3.000	**MS2126**	35	**DT15IP**	**S2044CG**	—	—
2267616	3.000	**MS2126**	35	**DT15IP**	**S2044CG**	—	—
2267643	3.000	**MS2126**	35	**DT15IP**	**S2044CG**	—	—
2267617	4.000	**MS2126**	35	**DT15IP**	—	—	**S2165C**
2267644	4.000	**MS2126**	35	**DT15IP**	—	—	**S2165C**
2267645	5.000	**MS2126**	35	**DT15IP**	—	—	**S2165C**
2267646	6.000	**MS2126**	35	**DT15IP**	—	—	**S2165C**
2267618	6.000	**MS2126**	35	**DT15IP**	—	**KLS20C**	—
2267620	8.000	**MS2126**	35	**DT15IP**	—	—	—

NOTE: Additional insert screws may be ordered in packages of five pieces from catalog number MS2126PKG.

- Mill 0° walls.
- Aggressive ramping angles.
- Generates superior surface finish.
- High RPM capabilities.







End Mills • Steep Taper CV40

order number	catalog number	CSMS system size	D1	L1	L3	Ap1 max	Z	max ramp angle	lbs	max RPM
2267549	**M1D100E1802CV40L250**	CV40	1.000	2.500	1.625	.710	2	16.7°	1.98	37000
2541967	**M1D100E1802CV40L450**	CV40	1.000	4.500	2.625	.710	2	16.7°	2.72	37000
2267551	**M1D125E1803CV40L288**	CV40	1.250	2.875	2.000	.710	3	10.9°	2.20	32300
2541970	**M1D125E1803CV40L488**	CV40	1.250	4.875	3.000	.710	3	10.9°	3.03	32300
2267548	**M1D150E1804CV40L288**	CV40	1.500	2.875	2.000	.710	4	8.2°	2.36	29020
2541972	**M1D150E1804CV40L488**	CV40	1.500	4.875	3.000	.710	4	8.2°	3.41	29020

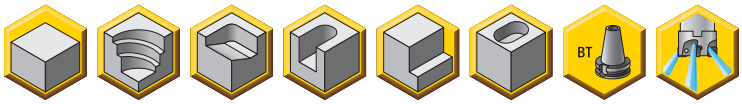
NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

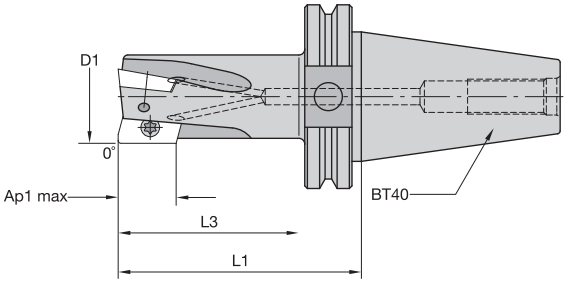
Spare Parts

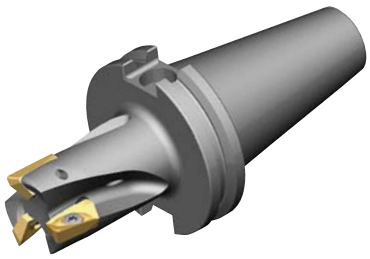
D1	 insert screw	 in. lbs.	 Torx Plus driver
1.000	**MS2126**	35	**DT15IP**
1.250	**MS2126**	35	**DT15IP**
1.500	**MS2126**	35	**DT15IP**

NOTE: Additional insert screws may be ordered in packages of five pieces from catalog number MS2126PKG.

- Mill 0° walls.
- Aggressive ramping angles.
- Generates superior surface finish.
- High RPM capabilities.







End Mills • Steep Taper BT40

order number	catalog number	CSMS system size	D1	L1	L3	Ap1 max	Z	max ramp angle	lbs	max RPM
2541969	**M1D100E1802BT40L450**	BT40	1.000	4.500	2.625	.710	2	16.7°	2.83	37000
2541984	**M1D150E1804BT40L488**	BT40	1.500	4.875	3.000	.710	4	8.2°	3.50	29020

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
1.000	**MS2126**	35.0	**DT15IP**
1.500	**MS2126**	35.0	**DT15IP**

NOTE: Additional insert screws may be ordered in packages of five pieces from catalog number MS2126PKG.

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	–	–	**–**	**–**	–	–

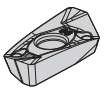
Indexable Inserts

- Roughing and finishing of aluminum alloys.
- Periphery ground and polished rake face.
- Perfect floor surface finish.
- Ap1 max = 0.708" (18mm).

● first choice
○ alternate choice

beyond

	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○		●		●	●		○
M				●	●	●		○	○	○	●
K			●	○			●	○			
N	●	●									
S				●	●	●				●	●
H											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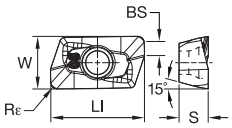


EDCT-F.LDJ

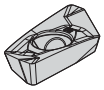
EDCT-F.LDJ

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1804FJ	.856	.432	.217	.121	.016	.001	2	●	–	–	–	–	–	–	–	–	–	–
EC1808FJ	.857	.432	.217	.106	.031	.001	2	●	–	–	–	–	–	–	–	–	–	–
EC1812FJ	.857	.432	.217	.090	.047	.001	2	●	–	–	–	–	–	–	–	–	–	–
EC1816FJ	.858	.431	.217	.075	.062	.001	2	●	–	–	–	–	–	–	–	–	–	–
EC1820FJ	.858	.431	.217	.059	.079	.001	2	●	–	–	–	–	–	–	–	–	–	–
EC1824FJ	.858	.430	.217	.044	.095	.001	2	●	–	–	–	–	–	–	–	–	–	–
EC1832FJ	.858	.430	.217	.013	.125	.001	2	●	–	–	–	–	–	–	–	–	–	–
EC1840FJ	.818	.428	.217	—	.157	.001	2	●	–	–	–	–	–	–	–	–	–	–
EC1848FJ	.795	.426	.217	—	.188	.001	2	●	–	–	–	–	–	–	–	–	–	–
EC1850FJ	.785	.426	.217	—	.197	.001	2	●	–	–	–	–	–	–	–	–	–	–
EC1864FJ	.737	.422	.217	—	.250	.001	2	●	–	–	–	–	–	–	–	–	–	–

- Roughing and finishing of aluminum alloys.
- Periphery ground and polished rake face.
- Perfect floor surface finish.
- Ap1 max = 0.708" (18mm).

● first choice
○ alternate choice

		KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P					○		●		●	●		○
M					●	●	●		○	○	○	●
K				●	○			●	○			
N		●	●									
S					●	●	●				●	●
H												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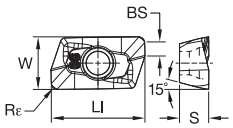
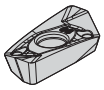


EC-E.LDJ

EDCT-E.LDJ

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1808EJ	.857	.432	.217	.106	.031	.001	2	–	●	–	–	–	–	–	–	–	–	–
EC1812EJ	.857	.432	.217	.090	.047	.001	2	–	●	–	–	–	–	–	–	–	–	–
EC1816EJ	.858	.431	.217	.075	.062	.001	2	–	●	–	–	–	–	–	–	–	–	–
EC1824EJ	.858	.430	.217	.044	.094	.001	2	–	●	–	–	–	–	–	–	–	–	–
EC1832EJ	.858	.430	.217	.013	.125	.001	2	–	●	–	–	–	–	–	–	–	–	–
EC1864EJ	.737	.422	.217	—	.250	.001	2	–	●	–	–	–	–	–	–	–	–	–

- Finishing and high-precision applications.
- Light machining.
- 15° Positive rake angle.
- Perfect floor surface finish.
- Ap1 max = 0.708" (18mm).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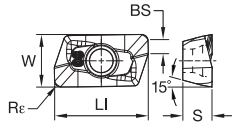
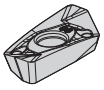


EDCT-LD

EDCT-LD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1808E2	.857	.432	.217	.106	.031	.002	2	–	–	–	●	–	–	–	–	–	–	–
EC1816E	.858	.431	.217	.075	.062	.002	2	–	–	–	●	–	–	–	–	–	–	–
EC1832E	.858	.430	.217	.013	.125	.002	2	–	–	–	●	–	–	–	–	–	–	–
EC1840E	.818	.428	.217	—	.157	.002	2	–	–	–	●	–	–	–	–	–	–	–
EC1848E	.795	.426	.217	—	.188	.002	2	–	–	–	●	–	–	–	–	–	–	–
EC1864E	.737	.422	.217	—	.250	.002	2	–	–	–	●	–	–	–	–	–	–	–

- Light machining and finish applications.
- Periphery ground for high-precision machining.
- Medium hone for increased edge protection.
- Ap1 max = 0.708" (18mm).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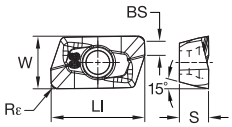


EDCT-EGD

beyond

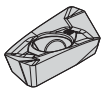
● first choice
○ alternate choice

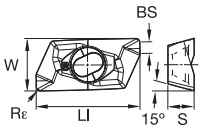
		KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P					○		●		●	●		○
M					●	●	●		○	○	○	●
K				●	○			●	○			
N		●	●									
S					●	●	●				●	●
H												

EDCT-E.GD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EC1804E	.856	.432	.217	.121	.016	.004	2	–	–	–	–	–	●	–	–	●	–	–
EC1808E	.857	.432	.217	.106	.031	.004	2	–	–	–	–	–	●	–	–	●	–	–
EC1812E	.857	.432	.217	.090	.047	.004	2	–	–	–	–	–	●	–	–	●	–	–

- Medium roughing and semi-finishing.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = .708" (18mm).


EDPT-E.GD

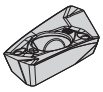


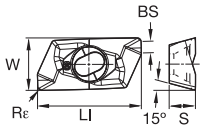
EDPT-E.GD

EDPT-E.GD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1808E	.857	.432	.217	.106	.031	.004	2	–	–	●	–	–	●	–	●	●	–	●
EP1812E	.857	.433	.217	.090	.047	.004	2	–	–	–	–	–	●	–	–	●	–	–
EP1816E	.858	.431	.217	.075	.062	.004	2	–	–	–	●	–	●	–	●	●	–	●
EP1824E	.858	.430	.217	.044	.095	.004	2	–	–	–	–	–	●	–	–	–	–	–
EP1832E	.858	.430	.217	.013	.125	.004	2	–	–	●	●	–	●	–	●	–	–	●
EP1848E	.795	.426	.217	—	.189	.004	2	–	–	–	–	–	●	–	–	–	–	●
EP1864E	.740	.422	.217	—	.250	.004	2	–	–	–	●	–	●	–	●	–	–	●

- Medium roughing and semi-finishing.
- Medium feed rates.
- PSTS — Precision Pressed and Sintered to Size.
- Ap1 max = .708" (18mm).


EDPT-E.HD



EDPT-E.HD

● first choice
○ alternate choice

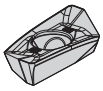
beyond

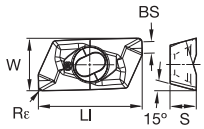
		KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P					○		●		●	●		○
M					●	●	●		○	○	○	●
K				●	○			●	○			
N		●	●									
S					●	●	●				●	●
H												

EDPT-E.HD

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1808EHD	.857	.429	.217	.106	.031	.003	2	–	–	–	–	–	●	–	●	●	–	●
EP1812EHD	.857	.428	.217	.090	.047	.003	2	–	–	–	–	–	●	–	●	–	–	●
EP1816EHD	.857	.428	.217	.075	.062	.003	2	–	–	–	–	–	●	–	●	●	–	●
EP1832EHD	.858	.426	.217	.012	.125	.003	2	–	–	–	–	–	●	–	●	●	–	●
EP1840EHD	.823	.424	.217	—	.157	.003	2	–	–	–	–	–	●	–	–	–	–	●
EP1848EHD	.794	.423	.217	—	.188	.003	2	–	–	–	–	–	●	–	●	–	–	●
EP1864EHD	.740	.420	.217	—	.250	.003	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 = .708" (18mm).


EDPT-S.GE



EDPT-S.GE

EDP T-S.GE

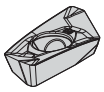
catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1808SGE	.855	.421	.214	.095	.031	.005	2	–	–	–	●	–	●	–	●	–	–	●
EP1812SGE	.856	.420	.214	.079	.047	.005	2	–	–	–	●	–	–	–	●	–	–	●
EP1816SGE	.856	.420	.214	.063	.062	.005	2	–	–	–	–	–	–	–	●	–	–	●
EP1832SGE	.856	.418	.214	.003	.125	.005	2	–	–	–	–	–	–	–	●	–	–	●

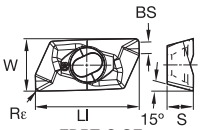
- Heavy roughing applications.
- High feed rates.
- All material groups.
- PSTS – Precision Pressed and Sintered to Size.
- Ap1 max = .708" (18mm).

● first choice
○ alternate choice

beyond

	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P				○		●		●	●		○
M				●	●	●		○	○	○	●
K			●	○			●	○			
N	●	●									
S				●	●	●				●	●
H											


EDPT-S.GE



EDPT-S.GE

EDPT-S.GE

catalog number	LI	W	S	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
EP1808S	.857	.429	.217	.106	.031	.006	2	–	–	–	–	–	●	●	●	●	–	●
EP1812S	.857	.429	.217	.090	.047	.006	2	–	–	–	–	–	●	●	●	●	–	●
EP1816S	.858	.428	.217	.075	.062	.006	2	–	–	–	–	–	●	–	●	●	–	●
EP1832S	.858	.426	.217	.013	.125	.006	2	–	–	–	–	–	●	–	●	–	–	●
EP1848S	.795	.423	.216	—	.189	.005	2	–	–	–	–	–	–	–	–	–	–	●
EP1864S	.739	.419	.217	—	.250	.005	2	–	–	–	–	–	●	–	–	–	–	●

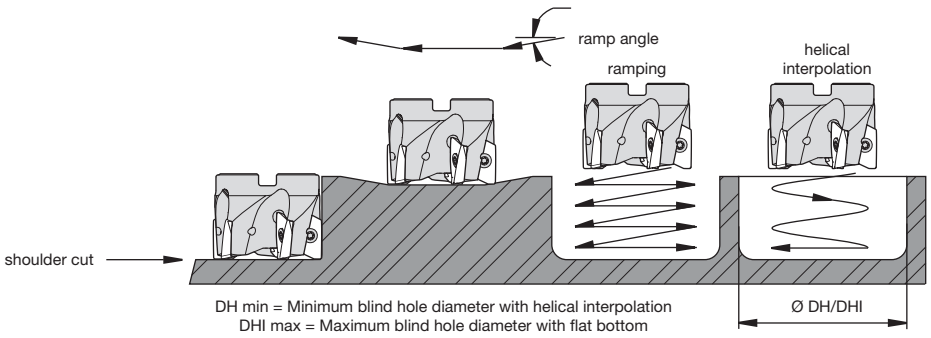
Recommended Starting Feeds [IPT]

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	.005	**.019**	.033	.003	**.013**	.023	.003	**.010**	.018	.002	**.009**	.015	.002	**.008**	.014	.F..LDJ
.E..LDJ	.005	**.018**	.032	.003	**.013**	.023	.003	**.010**	.017	.002	**.009**	.015	.002	**.008**	.014	.E..LDJ
.E..LD	.007	**.019**	.032	.005	**.013**	.023	.004	**.010**	.017	.003	**.009**	.015	.003	**.008**	.014	.E..LD
.E..GD	.009	**.020**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.010**	.016	.004	**.009**	.015	.E..GD
.S..GE	.009	**.020**	.035	.007	**.014**	.025	.005	**.011**	.019	.004	**.009**	.017	.004	**.009**	.015	.S..GE
.S..GD	.009	**.020**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.009**	.016	.004	**.009**	.015	.S..GD
.E..HD	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.E..HD

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 (no flat bottom)
Mill 1–18	.970	18°	1.124	1.776	1.94
Mill 1–18	1.000	17°	1.182	1.836	2.00
Mill 1–18	1.250	11°	1.686	2.336	2.50
Mill 1–18	1.500	8°	2.182	2.836	3.00
Mill 1–18	2.000	5°	3.180	3.836	4.00
Mill 1–18	1.500	8°	2.180	2.836	3.00
Mill 1–18	2.000	5°	3.176	3.862	4.00
Mill 1–18	2.500	4°	4.174	4.862	5.00
Mill 1–18	3.000	3°	5.174	5.862	6.00
Mill 1–18	4.000	2°	7.174	7.862	8.00
Mill 1–18	5.000	2°	9.172	9.862	10.00
Mill 1–18	6.000	1°	11.172	11.862	12.00
Mill 1–18	8.000	1°	15.172	15.862	16.00

Flange Mount Adapters



For HARVI™ Ultra Helical Cutters

HARVI ultra helical cutters can be used with our flange mount adapters to create a powerful combination on nearly all spindle connections on the market.

Our flange mount adapters enable the same cutting tool to be easily adapted to different machine spindle connections.

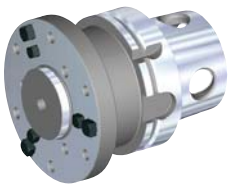
The Portfolio Features:


CV


DV


BT


HSK


KM4X™

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KENNAMETAL®

kennametal.com

Mill 1-25™

Primary Application

Also known as Mill1 Max, the Mill 1-25 cutter is made specifically for aluminum 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 .98" (25mm).



Features and Benefits

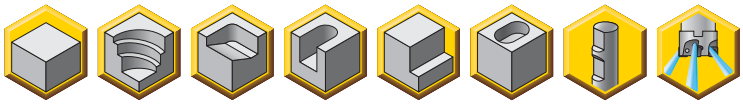
Functions

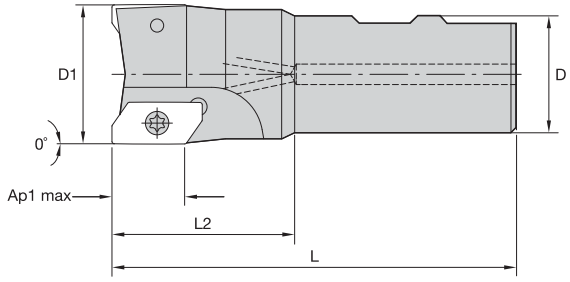
- Strong, thick inserts over .200" (5,2mm) thick.
- Axial depth of cut up to .98" (25mm).
- Cylindrical, monoblock/HSK63A, CV50, and shell mills.

Benefits

- Made for machining aluminum, 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.

- For aluminum machining.
- High-speed capability.
- Insert screws should be changed when inserts are changed.







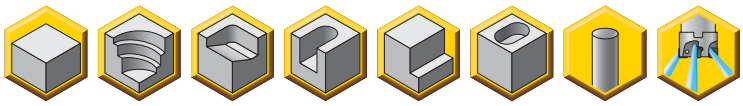
Weldon® End Mills

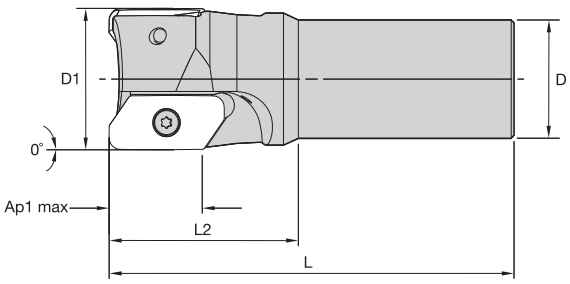
order number	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
2530317	**M1D150K2502W125L200**	1.500	1.250	4.280	2.000	.980	2	16.5°	1.21	25200

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

Spare Parts

D1	insert screw	in. lbs.	Torx driver
1.5000	**MS1374**	35.0	**DT15**







Cylindrical End Mills

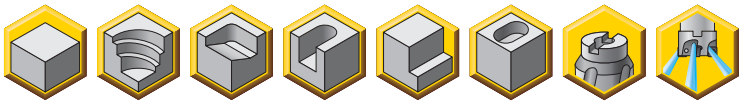
order number	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
2530318	**M1D150K2502C125L200**	1.500	1.250	4.280	2.000	.980	2	16.5°	1.23	25200
2530320	**M1D150K2502C125L400**	1.500	1.250	6.280	4.000	.980	2	16.5°	2.07	25200
2530322	**M1D200K2503C125L200**	2.000	1.250	4.155	2.000	.976	3	10.0°	1.54	20300

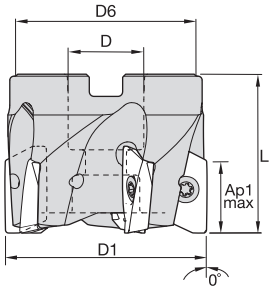
NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

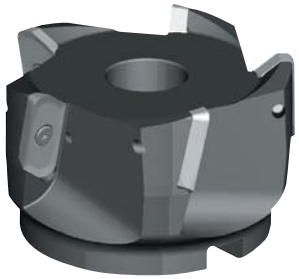
Spare Parts

D1	insert screw	in. lbs.	Torx driver
1.500	**MS1374**	35.0	**DT15**
2.000	**MS1374**	35.0	**DT15**

- For aluminum machining.
- High-speed capability.
- Insert screws should be changed when inserts are changed.
- Ap1 Max 0.985" (25mm).





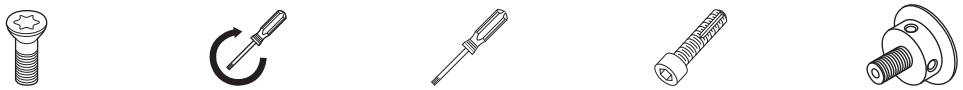


Shell Mills

order number	catalog number	D1	D	D6	L	Ap1 max	Z	max ramp angle	lbs	max RPM
2581445	**M1D200K2502S075L200**	2.000	.750	1.750	2.000	.980	2	10.0°	.87	20300
2581447	**M1D250K2503S100L225**	2.500	1.000	2.190	2.250	.970	3	7.0°	1.49	17500
2496869	**M1D300K2503S100L225**	3.000	1.000	2.190	2.250	.970	3	5.0°	2.33	15600
2581449	**M1D400K2504S125L225**	4.000	1.250	2.880	2.250	.970	4	3.5°	3.05	13100

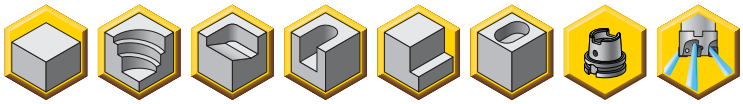
NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

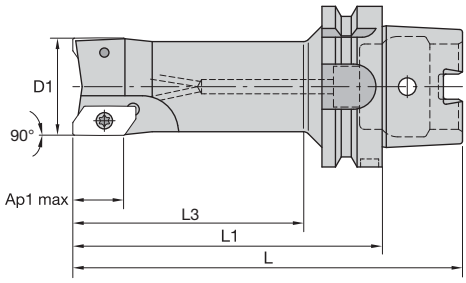
Spare Parts



D1	insert screw	in. lbs.	Torx driver	socket-head cap screw with coolant groove	coolant lock screw assembly
2.000	**MS1374**	35.0	**DT15**	**S445CG**	**—**
2.500	**MS1374**	35.0	**DT15**	**S459CG**	**—**
3.000	**MS1374**	35.0	**DT15**	**S458CG**	**—**
4.000	**MS1374**	35.0	**DT15**	**—**	**S2164C**

- Roughing and finishing of aluminum alloys
- Aggressive ramping angles.
- All integral shank tools are balanced to G2.5 at 10,000 RPM.
- High-speed capability.
- Ap1 Max 0.985" (25mm).
- Replace insert screws when inserts are changed.







Monoblocks • HSK63A

order number	catalog number	shank taper	D1	L	L1	L3	Ap1 max	Z	max ramp angle	lbs	max RPM
2530357	**M1D150K2502HSK63L477**	HSK63A	1.500	6.028	4.772	3.500	.984	2	16.5°	2.60	25200

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

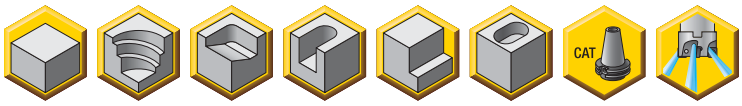
Spare Parts

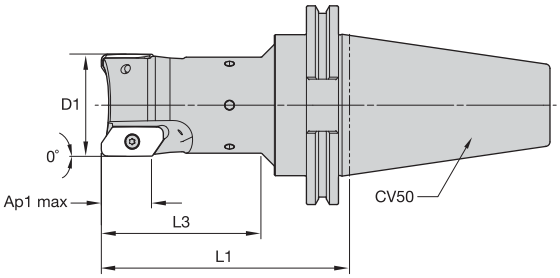





D1	insert screw	in. lbs.	Torx driver	balancing screw
1.500	**MS1374**	35.0	**DT15**	**KUAM27**

- For aluminum machining.
- High-speed capability.
- All integral shank tools are balanced to G2.5 at 10,000 RPM.
- Insert screws should be changed when inserts are changed.







Monoblocks • CV50

order number	catalog number	taper shank	D1	L1	L3	Ap1 max	Z	max ramp angle	lbs	max RPM
2530374	**M1D200K2503CV50L700**	CV50	2.000	7.000	5.375	.976	3	10.0°	10.62	20300

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

Spare Parts

D1	insert screw	in. lbs.	Torx driver	balancing screw
2.000	**MS1374**	35.0	**DT15**	**KUAM27**

Insert Selection Guide

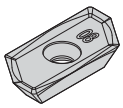
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	.E..LDJ	KC410M	**.E..LDJ**	**KC410M**	.E..LDJ	KC410M
N3	.E..LDJ	KC410M	**.E..LDJ**	**KC410M**	.E..LDJ	KC410M
S1–S2	–	–	–	–	–	–
S3	–	–	–	–	–	–
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

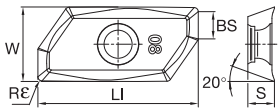
Indexable Inserts • KE..25L5..

- Roughing and finishing of aluminum alloys.
- Periphery ground for accuracy and consistency.
- Radiused cutting edge minimizes lap lines.
- Wiper facet with large radius for better floor surface finish.
- Ap1 max 0.985" (25mm).

● first choice
○ alternate choice

P
M
K
N ●
S
H


KEGT-LDJ



KEGT-LDJ

KEGT-LDJ

catalog number	LI	S	W	BS	Rε	hm	cutting edges	KC410M
KG2508ELDJ	1.236	.205	.575	.210	.031	.001	2	●
KG2512ELDJ	1.239	.205	.575	.195	.047	.001	2	●
KG2516ELDJ	1.239	.205	.575	.179	.063	.001	2	●
KG2520ELDJ	1.239	.205	.575	.164	.079	.001	2	●
KG2531ELDJ	1.239	.205	.575	.120	.122	.001	2	●
KG2540ELDJ	1.239	.205	.575	.085	.157	.001	2	●
KG2550ELDJ	1.239	.205	.575	.045	.197	.001	2	●
KG2564ELDJ	1.181	.205	.575	—	.252	.001	2	●

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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	.005	**.023**	.042	.003	**.017**	.030	.003	**.013**	.023	.002	**.011**	.020	.002	**.010**	.018	.E..LDJ
.E..LDJ2	.005	**.023**	.042	.003	**.017**	.030	.003	**.013**	.023	.002	**.011**	.020	.002	**.010**	.018	.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 aluminum machining to the highest level.

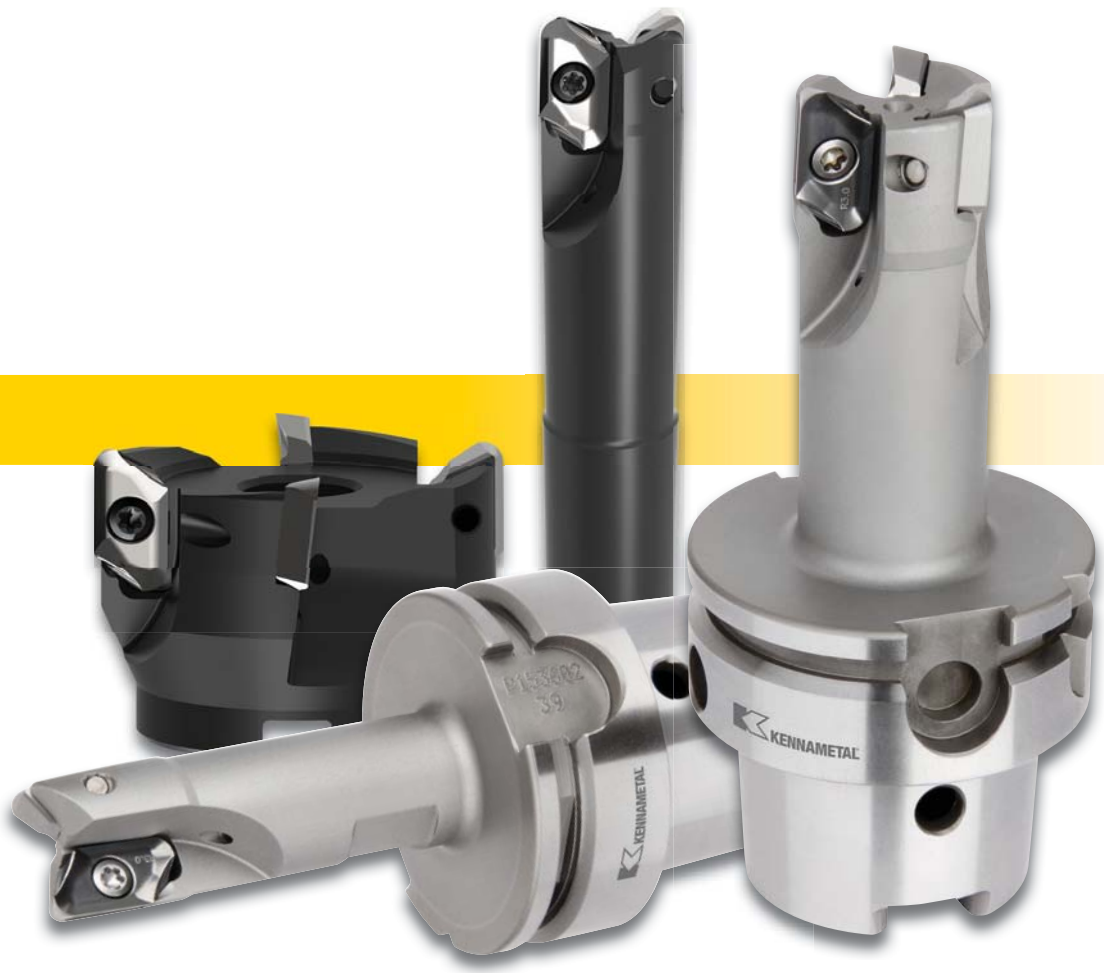


Features and Benefits

- Specially designed for machining pockets and profiles on aluminum and aluminum 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 .630" (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.

Metric monoblock cutters with HSK63A are available as standard in diameters 25, 32, 40, and 50mm.

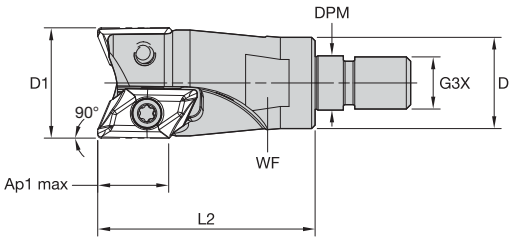
The Stellram® 5720VZ16 cutters are our latest design for high metal removal in aluminum applications.



Maximum ap = .630"
Diameter Range = 1–3"

- High-speed profiling and pocketing aluminum 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	catalog number	D1	D	DPM	G3X	L2	WF (mm)	Ap1 max	Z	max ramp angle	lbs	max RPM
5672512	**A5720VZ16SA1.00Z02R2**	1.000	.827	.492	M12	1.969	18	.630	2	14.7°	.23	50000
5672719	**A5720VZ16SA1.25Z02R2**	1.250	1.142	.669	M16	1.969	24	.630	2	11.5°	.45	41500
5672521	**A5720VZ16SA1.25Z3R2**	1.250	1.142	.669	M16	1.967	24	.630	3	11.5°	.39	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.

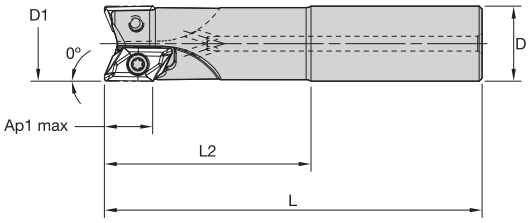
Spare Parts

D1	insert screw	in. lbs.	Torx driver
1.000	**DP5009A**	54.0	**TP20**
1.250	**DP5009A**	54.0	**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 aluminum 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	catalog number	D1	D	L	L2	Ap1 max	Z	max ramp angle	lbs	max RPM
5672718	**C5720VZ16CA1.0Z02R2.7**	1.000	1.000	5.030	2.750	.630	2	14.7°	.87	50000
5673549	**C5720VZ16CA1.25Z2R3.0**	1.250	1.250	5.280	2.997	.630	2	11.5°	1.49	41500
5672885	**C5720VZ16CA1.25Z3R3.0**	1.250	1.250	5.280	3.000	.630	3	11.5°	1.46	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



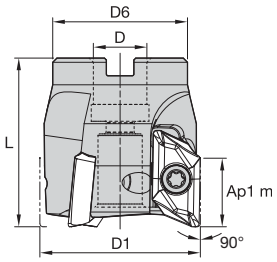


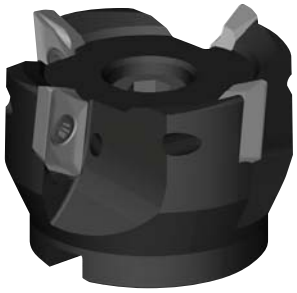
D1	insert screw	in. lbs.	Torx driver
1.000	**DP5009A**	54.0	**TP20**
1.250	**DP5009A**	54.0	**TP20**

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 aluminum 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	catalog number	D1	D	D6	L	Ap1 max	Z	max ramp angle	lbs	max RPM
5681118	**C5720VZ16-A1.50Z03R**	1.500	.500	1.260	1.575	.630	3	8.1°	.34	36500
5672871	**C5720VZ16-A2.00Z04R**	2.000	.750	1.772	1.574	.630	4	7.8°	.55	30000
5673799	**C5720VZ16-A2.00Z03R**	2.000	.750	1.772	1.575	.630	3	7.8°	.65	30000
5673175	**C5720VZ16-A2.50Z04R**	2.500	1.000	1.969	1.969	.630	4	5.8°	1.26	26000
5672872	**C5720VZ16-A2.50Z05R**	2.500	1.000	1.969	1.971	.630	5	5.8°	1.32	26000
5673338	**C5720VZ16-A3.00Z04R**	3.000	1.000	1.969	1.969	.630	4	4.6°	1.91	23000
5673745	**C5720VZ16-A3.00Z05R**	3.000	1.000	1.969	1.969	.630	5	4.6°	1.68	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



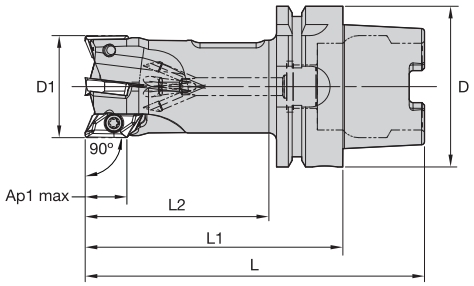



D1	insert screw	in. lbs.	Torx driver	socket-head cap screw
1.500	**DP5009A**	54.0	**TP20**	**#1/4-28X3/4SHCSA**
2.000	**DP5009A**	54.0	**TP20**	**#3/8-24X1SHCSA**
2.500	**DP5009A**	54.0	**TP20**	**#1/2-20X1-1/4SHCSA**
3.000	**DP5009A**	54.0	**TP20**	**#1/2-20X1-1/4SHCSA**

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 aluminum 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	catalog 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**

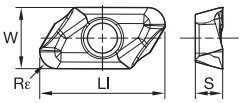
NOTE: Adjustable torque wrench (order number 6197561) and Torx Plus 20 bit (order number 6205891) may be purchased separately in order to ensure proper torque setting.

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-721



ZDET-721

● first choice
○ alternate choice

P		
M		
K		○
N		●
S		
H		

ZDET-721 • Sharp edge preparation for finishing applications

catalog number	LI	W	S	Resultant WorkPiece Radius In	hm	cutting edges	GH1
ZDET16M5PDFR721	.902	.443	.197	.010	.001	2	●
ZDET16M508FR721	.906	.443	.197	.032	.001	2	●
ZDET16M512FR721	.906	.443	.197	.047	.001	2	●
ZDET16M516FR721	.906	.443	.197	.063	.001	2	●
ZDET16M520FR721	.906	.443	.197	.079	.001	2	●
ZDET16M525FR721	.906	.443	.197	.098	.001	2	●
ZDET16M530FR721	.906	.443	.197	.118	.001	2	●
ZDET16M532FR721	.906	.443	.197	.126	.001	2	●
ZDET16M540FR721	.906	.443	.197	.157	.001	2	●
ZDET16M550FR721	.906	.443	.197	.197	.001	2	●
ZDET16M560FR721	.906	.443	.197	.236	.001	2	●
ZDET16M504FR721	.906	.443	.197	.020	.001	2	●

ZDET-ER721 • Honed edge preparation for roughing applications. Apply under unstable conditions.

catalog number	LI	W	S	Resultant WorkPiece Radius In	hm	cutting edges	GH1
ZDET16M525ER721	.906	.443	.197	.098	.001	2	●
ZDET16M530ER721	.906	.443	.197	.118	.001	2	●
ZDET16M540ER721	.906	.443	.197	.157	.001	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

Recommended Starting Feeds [IPT]

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%			40–100%			
.F..721	.001	**.013**	.016	.001	**.010**	.012	.001	**.008**	.011	.001	**.008**	.010	.F..721
.E..721	.003	**.013**	.016	.002	**.010**	.012	.002	**.008**	.011	.002	**.008**	.010	.E..721

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

5720VZ16 Ramp Angle

cutter diameter	Insert ZDET16M5...FR-721								
	Facet 0.047	0.062	0.079	0.098	0.118	0.125	0.157	0.216	0.236
1.000	14.8	16.9	9.2	9.4	18.5	18.5	8.8	10.9	7.0
1.250	11.5	12.1	12.1	12.4	12.7	12.7	13.4	14.0	13.6
1.500	8.1	8.5	8.5	8.7	8.8	8.8	9.1	9.5	9.8
2.000	7.8	7.1	7.2	7.7	7.4	7.4	8.8	8.8	9.0
2.500	5.8	5.3	5.4	5.7	5.5	5.5	6.9	6.5	6.6
3.000	4.6	4.3	4.3	4.6	4.4	4.4	5.4	5.1	5.2

5720VZ16 Possible Maximum ap Slotting

Possible Max ap Slotting		
diameter	number of inserts	ap max
1.000	2	0.300
1.250	2	0.435
1.250	3	0.240
1.500	3	0.350
2.000	3	0.435
2.000	4	0.350
2.500	4	0.435
2.500	5	0.350
3.000	4	0.435
3.000	5	0.435

NOTE: Ap max depends on connection with 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	MRR in^3/min
1.00	2	97
1.25	2	197
1.25	3	182.7
1.50	3	316
2.00	3	483
2.00	4	527
2.50	4	811
2.50	5	830
3.00	4	1030
3.00	5	1288

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 • Aluminum

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 = π x D x n/1000 m/min = mm x RPM

D: Tool diameter, N: RPM, Vc: Cutting speed, π = 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 • Aluminum — continued)

	Typical Tremper	Rm (Mpa)	Machinability Chip Formation	Machinability	Typical Applications	vc SFM min–max	fz IPT max
	H14	105	D	A	• Chemical equipment. • Sheet metal work. • Coiled tube.	2625–9840	0.008
	H14	90	D	A			
	T3	310	A	A	• Screw machine products. • Tuck frame. • Aircraft structure. • Jet engine impellers. • Aircraft engine • Cylinder heads.	1315–8200	0.010
	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.	656–8200	0.008
	T6	379	B	D	• Pistons.	656–3280	0.007
	H14	260	C	A	• Architectural. • Cable sheeting. • Welded pressure vessels. • Hydraulic tubes. • Transportation equipment.	1315–9840	0.010
	–	–	–	–			
	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.	1315–8200	0.008
	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.	1315–9840	0.010
	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:

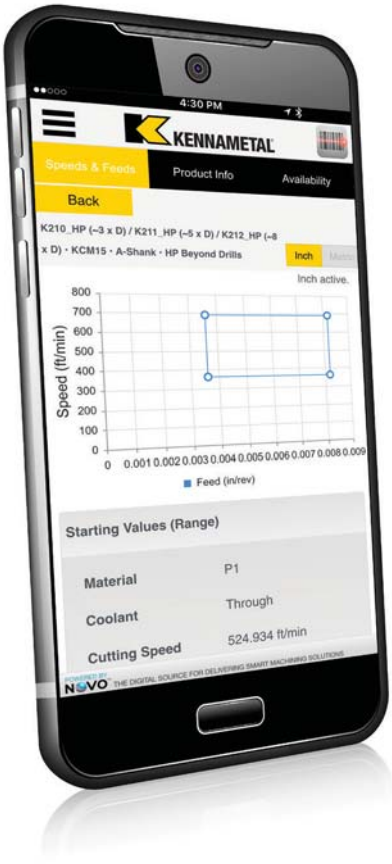
Thread sizes (mm)	Torque Values Ft. Lbs.
M6	7.37
M8	22.12
M10	36.87
M12	59.00
M16	81.13

Tighten the bolt between the shell mill and toolholder; with lubricant, apply the torque value of:

Thread sizes (inch)	Cutter Bore Size (inch)	Torque Values Ft. Lbs.
0.250	0.500	7.37
0.375	0.750	22.12
0.500	1.000	36.87
0.625	1.250	59.00
0.750	1.500	81.13

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 catalog number to access complete product information.

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

View product availability at global locations.

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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

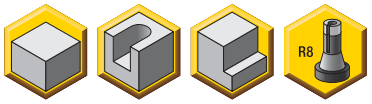
KSSM IC 10 Inserts

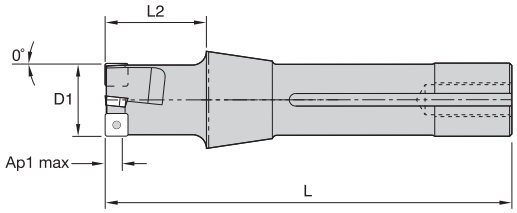
- Four cutting edges.
- Excellent surface finishes.
- Low power requirements.

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.







Bridgeport Shank

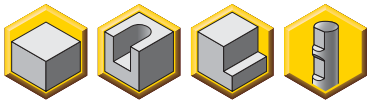
order number	catalog number	D1	L	L2	Ap1 max	Z	lbs	max RPM
1229112	**KISBR150SP10T30F**	1.500	5.180	1.250	.259	4	1.20	30300
1229113	**KISBR200SP10T30F**	2.000	5.180	1.250	.259	5	1.50	26300

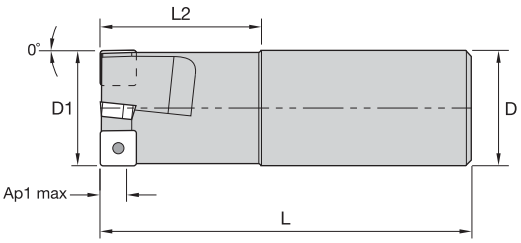
NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
1.500	**MS2148**	10.0	**DT9IP**
2.000	**MS2148**	10.0	**DT9IP**

- Mill 90° walls.
- Excellent surface finishes.
- Low power requirements.
- Four cutting edges per insert.







Weldon® End Mills

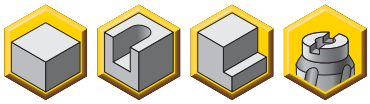
order number	catalog number	D1	D	L	L2	Ap1 max	Z	lbs	max RPM
1229091	**KISR075SP10T30F**	.750	.750	3.500	1.470	.259	1	.40	42900
1229092	**KISR100SP10T30F**	1.000	1.000	3.500	1.220	.259	2	.60	37100
1229095	**KISR125SP10T30F**	1.250	1.250	4.030	1.750	.259	3	1.10	33200
1229096	**KISR150SP10T30F**	1.500	1.500	4.030	1.340	.259	4	1.63	30300

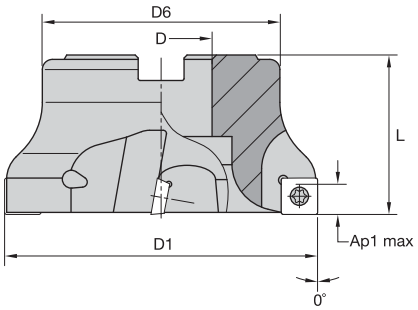
NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

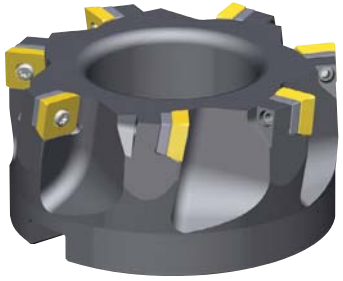
Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
.750	**MS2148**	10.0	**DT9IP**
1.000	**MS2148**	10.0	**DT9IP**
1.250	**MS2148**	10.0	**DT9IP**
1.500	**MS2148**	10.0	**DT9IP**

- Mill 90° walls.
- Excellent surface finishes.
- Low power requirements.
- Four cutting edges per insert.







End Mills • Shell Mills

order number	catalog number	D1	D	D6	L	Ap1 max	Z	lbs	max RPM
1229047	**KSSR150SP10T30F2**	1.500	.500	1.355	1.250	.259	4	.30	30300
1229078	**KSSR200SP10T30F3**	2.000	.750	1.625	1.750	.259	5	.60	26300
1229079	**KSSR250SP10T30F4**	2.500	1.000	2.065	1.750	.259	6	.90	23500
1229080	**KSSR300SP10T30F4**	3.000	1.000	2.065	1.750	.259	8	1.30	21450
1229081	**KSSR400SP10T30F5**	4.000	1.250	2.755	2.000	.259	10	2.50	18600

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.

Spare Parts

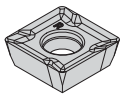
D1	 insert screw	 in. lbs.	 Torx Plus driver	 socket-head cap screw
1.500	**MS2148**	10.0	**DT9IP**	**S422**
2.000	**MS2148**	10.0	**DT9IP**	**S445**
2.500	**MS2148**	10.0	**DT9IP**	**–**
3.000	**MS2148**	10.0	**DT9IP**	**–**
4.000	**MS2148**	10.0	**DT9IP**	**–**

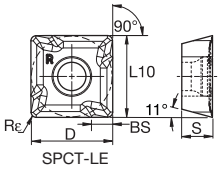
Insert Selection Guide

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

- Aluminum workpiece materials.
- Precision ground.
- 20° rake face.
- Four cutting edges.


SPCT-LE



SPCT-LE

● first choice
○ alternate choice

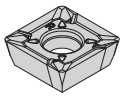
beyond

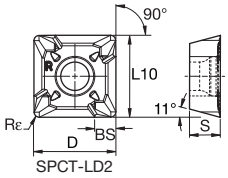
	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	KY3500
P			○	●		●	●		○		
M			●	●		○	○	○	●		
K		●	○		●	○				●	●
N	●		○								
S			●	●				●	●		
H			○								

SPCT-LE

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	KY3500
SPCT31251PPFL8LE	.394	.156	.394	.106	.016	.001	4	●	–	–	–	–	–	–	–	–	–	–
SPCT31251PPFR8LE	.394	.156	.394	.106	.016	.001	4	●	–	–	–	–	–	–	–	–	–	–
SPCT3125PPFL8LE	.394	.156	.394	.106	.031	.001	4	●	–	–	–	–	–	–	–	–	–	–
SPCT3125PPFR8LE	.394	.156	.394	.106	.031	.001	4	●	–	–	–	–	–	–	–	–	–	–
SPCT31253PPFR8LE	.394	.156	.394	.106	.047	.001	4	●	–	–	–	–	–	–	–	–	–	–
SPCT31255FNLE	.394	.156	.394	—	.078	.001	4	●	–	–	–	–	–	–	–	–	–	–

- Light and finish machining.
- Precision ground.
- 75° rake face.
- Four cutting edges.


SPCT-LD2



SPCT-LD2

● first choice
○ alternate choice

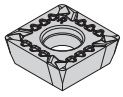
beyond

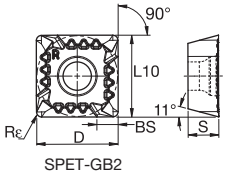
	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	KY3500
P			○	●		●	●		○		
M			●	●		○	○	○	●		
K		●	○		●	○				●	●
N	●		○								
S			●	●				●	●		
H			○								

SPCT-LD2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	KY3500
SPCT31251PPEL8LD2	.394	.156	.394	.106	.016	.002	4	–	–	–	●	–	–	–	–	–	–	–
SPCT31251PPER8LD2	.394	.156	.394	.106	.016	.002	4	–	–	–	●	–	–	–	–	–	–	–
SPCT3125PPEL8LD2	.394	.156	.394	.106	.031	.002	4	–	–	–	●	–	–	–	–	–	–	–
SPCT3125PPER8LD2	.394	.156	.394	.106	.031	.002	4	–	●	–	●	–	–	●	–	–	–	–
SPCT31253PPEL8LD2	.394	.156	.394	.106	.047	.002	4	–	–	–	●	–	–	–	–	–	–	–
SPCT31253PPER8LD2	.394	.156	.394	.106	.047	.002	4	–	–	–	●	–	–	–	–	–	–	–
SPCT31254ENLD2	.394	.156	.394	—	.063	.002	4	–	–	–	●	–	–	–	●	–	–	–
SPCT31255ENLD2	.394	.156	.394	—	.078	.002	4	–	–	–	●	–	–	–	–	–	–	–

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.


SPET-GB2

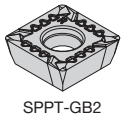


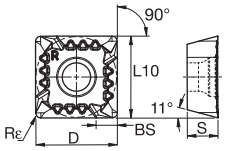
SPET-GB2

SPET-GB2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	KY3500
SPET31251PPEL8GB2	.394	.156	.394	.106	.016	.003	4	–	–	–	●	●	●	–	–	–	–	–
SPET31251PPER8GB2	.394	.156	.394	.106	.016	.003	4	–	–	–	●	●	●	–	–	–	–	–
SPET3125PPEL8GB2	.394	.156	.394	.106	.031	.003	4	–	●	–	●	●	●	–	–	–	–	–
SPET3125PPER8GB2	.394	.156	.394	.106	.031	.003	4	–	●	–	●	●	●	●	–	–	–	–
SPET3125PPSL8GB2	.394	.156	.394	.106	.031	.005	4	–	–	–	●	–	●	–	–	–	–	–
SPET3125PPSR8GB2	.394	.156	.394	.106	.031	.005	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

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	KY3500
SPPT3125PPER8GB2	.394	.156	.394	.106	.031	.003	4	–	–	–	–	●	●	–	–	–	–	–
SPPT3125PPSR8GB2	.394	.156	.394	.106	.031	.005	4	–	–	–	–	●	●	–	–	–	●	–

Recommended Starting Feeds

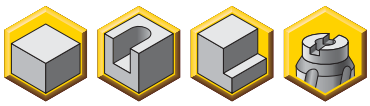
Recommended Starting Feeds [IPT]

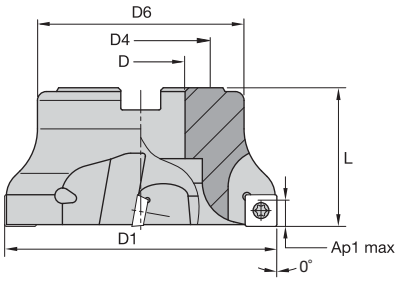
Light Machining	General Purpose	Heavy Machining

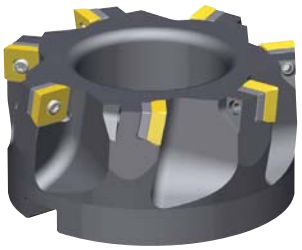
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LE	.005	**.017**	.028	.003	**.012**	.020	.003	**.009**	.015	.002	**.008**	.013	.002	**.007**	.012	.F..LE
.F..LD	.005	**.017**	.028	.003	**.012**	.020	.003	**.009**	.015	.002	**.008**	.013	.002	**.007**	.012	.F..LD
.E..LD2	.005	**.018**	.032	.004	**.013**	.023	.003	**.010**	.017	.002	**.009**	.015	.002	**.008**	.014	.E..LD2
.E..LD	.007	**.019**	.032	.005	**.013**	.023	.004	**.010**	.017	.003	**.009**	.015	.003	**.008**	.014	.E..LD
.E..GB2	.009	**.021**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.010**	.016	.004	**.009**	.015	.E..GB2
.S..GB	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GB
.S..GB2	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GB2
.S..GN	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Mill 0° walls.
- Excellent surface finishes.
- Low power requirements.
- 4 cutting edges per insert.





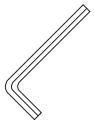


End Mills • Shell Mills

order number	catalog number	D1	D	D4	D6	L	Ap1 max	Z	lbs	max RPM
1024970	KSSISR200SD430C3	2.000	.750	—	1.625	1.750	.361	3	.79	20450
1024994	KSSISR200SD430F3	2.000	.750	—	1.625	1.750	.361	5	.77	20450
1024972	KSSISR200SD430M3	2.000	.750	—	1.625	1.750	.361	4	.75	20450
1025000	KSSISR250SD430F4	2.500	1.000	—	2.065	1.750	.361	6	1.23	18290
1024998	KSSISR250SD430M4	2.500	1.000	—	2.065	1.750	.361	5	1.20	18290
1024930	KSSISR300SD430C4	3.000	1.000	—	2.065	1.750	.361	4	1.42	16700
1024932	KSSISR300SD430F4	3.000	1.000	—	2.065	1.750	.361	7	1.38	16700
1024931	KSSISR300SD430M4	3.000	1.000	—	2.065	1.750	.361	6	1.38	16700
1025025	KSSISR400SD430C5	4.000	1.250	—	2.755	2.000	.361	5	3.05	14460
1025033	KSSISR400SD430F5	4.000	1.250	—	2.755	2.000	.361	8	3.01	14460
1025029	KSSISR400SD430M5	4.000	1.250	—	2.755	2.000	.361	7	3.03	14460
1025027	KSSISR400SD430C6	4.000	1.500	—	3.685	2.000	.361	5	3.58	14460
1025065	KSSISR400SD430F6	4.000	1.500	—	3.685	2.000	.361	8	3.62	14460
1025031	KSSISR400SD430M6	4.000	1.500	—	3.685	2.000	.361	7	3.57	14460
1024933	KSSISR500SD430C6	5.000	1.500	—	3.685	2.380	.361	6	5.82	12940
1024965	KSSISR500SD430F6	5.000	1.500	—	3.685	2.380	.361	10	5.96	12940
1024964	KSSISR500SD430M6	5.000	1.500	—	3.685	2.380	.361	8	5.91	12940
1024966	KSSISR600SD430C6	6.000	1.500	—	3.685	2.380	.361	8	8.52	11800
1024968	KSSISR600SD430F6	6.000	1.500	—	3.685	2.380	.361	12	8.60	11800
1024967	KSSISR600SD430M6	6.000	1.500	—	3.685	2.380	.361	10	8.58	11800
1025071	KSSISR600SD430C8	6.000	2.000	—	4.875	2.380	.361	8	7.37	11800
1025094	KSSISR600SD430M8	6.000	2.000	—	4.875	2.380	.361	10	7.44	11800
1025102	KSSISR800SD430C10	8.000	2.500	4.000	6.125	2.380	.361	10	15.40	10230
1025136	KSSISR800SD430F10	8.000	2.500	4.000	6.125	2.380	.361	14	15.30	10230
1025134	KSSISR800SD430M10	8.000	2.500	4.000	6.125	2.380	.361	12	15.40	10230
1025140	KSSISR1000SD430M10	10.000	2.500	4.000	8.125	2.380	.361	16	25.90	9150

NOTE: Standard milling cutters will accept insert nose radii up to .079" without modification.
2" cutter does not have shims.
2", 2.5", and 3" fine-pitch cutters do not have shims.

Spare Parts

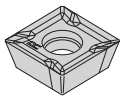
D1	 insert screw	 in. lbs.	 Torx Plus driver	 shim	 shim screw	 in. lbs.	 hex driver	 socket-head cap screw
2.000	MS2078	35.0	DT15IP	—	—	40.0	—	S445
2.500	MS2078	35.0	DT15IP	SM449	SRS3	40.0	DH35M	S458
3.000	MS2078	35.0	DT15IP	SM449	SRS3	40.0	DH35M	—
4.000	MS2078	35.0	DT15IP	SM449	SRS3	40.0	DH35M	—
5.000	MS2078	35.0	DT15IP	SM449	SRS3	40.0	DH35M	—
6.000	MS2078	35.0	DT15IP	SM449	SRS3	40.0	DH35M	—
8.000	MS2078	35.0	DT15IP	SM449	SRS3	40.0	DH35M	—
10.000	MS2078	35.0	DT15IP	SM449	SRS3	40.0	DH35M	—

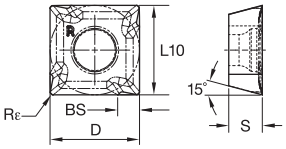
Insert Selection Guide

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

- Aluminum workpiece materials.
- Precision ground.
- 20° rake face.
- Four cutting edges.


SDCT-LE



SDCT-LE

● first choice
○ alternate choice

beyond

	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
P			○	●		●	●		○	
M			●	●		○	○	○	●	
K		●	○		●	○				●
N	●		○							
S			●	●				●	●	
H			○							

SDCT-LE

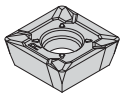
catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCT431PDFL8LE	.500	.188	.500	.106	.016	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT431PDFR8LE	.500	.188	.500	.106	.016	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT43PDFL8LE	.500	.188	.500	.106	.031	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT43PDFR8LE	.500	.188	.500	.106	.031	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT433PDFL8LE	.500	.188	.500	.106	.047	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT433PDFR8LE	.500	.188	.500	.106	.047	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT434FNLE	.500	.188	.500	—	.063	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT435FNLE	.500	.188	.500	—	.078	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT436FNLE	.500	.188	.500	—	.094	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT438FNLE	.500	.188	.500	—	.125	.001	4	●	–	–	–	–	–	–	–	–	–

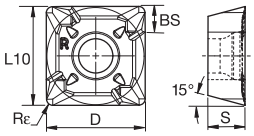
- Light and finish machining.
- Precision ground.
- 15° rake face.
- Four cutting edges.

beyond

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

● first choice
○ alternate choice


SDCT-LD2

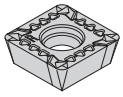


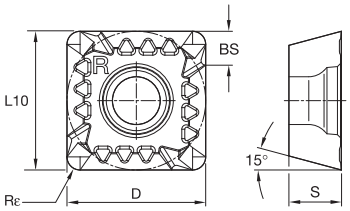
SDCT-LD2

SDCT-LD2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCT431PDEL8LD2	.500	.188	.500	.106	.016	.002	4	–	–	–	●	–	–	–	–	–	–
SDCT431PDER8LD2	.500	.188	.500	.115	.016	.002	4	–	–	–	●	–	–	–	–	–	–
SDCT43PDEL8LD2	.500	.188	.500	.130	.031	.002	4	–	–	–	●	–	–	–	–	–	–
SDCT43PDER8LD2	.500	.188	.500	.130	.031	.002	4	–	●	–	●	–	–	●	–	●	–
SDCT433PDEL8LD2	.500	.188	.500	.120	.047	.002	4	–	–	–	●	–	–	–	–	–	–
SDCT433PDER8LD2	.500	.188	.500	.120	.047	.002	4	–	–	–	●	–	–	–	–	●	–
SDCT434ENLD2	.500	.188	.500	–	.063	.002	4	–	–	–	●	–	–	–	–	●	–
SDCT435ENLD2	.500	.188	.500	–	.078	.002	4	–	–	–	●	–	–	–	–	–	–
SDCT436ENLD2	.500	.188	.500	–	.094	.002	4	–	–	–	●	–	–	–	–	–	–
SDCT438ENLD2	.500	.188	.500	–	.125	.002	4	–	–	●	●	–	–	–	●	●	–
SDCT4316ENLD2	.500	.188	.500	–	.250	.002	2	–	–	–	●	–	–	–	–	●	–

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.


SDET-GB2

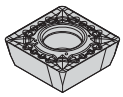


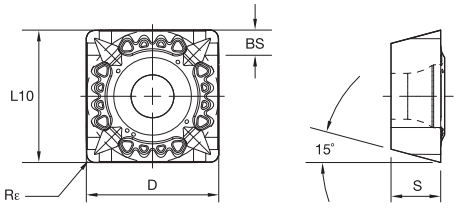
SDET-GB2

SDET-GB2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDET43PDEL8GB2	.500	.188	.500	.130	.031	.003	4	–	●	–	●	●	●	–	–	–	–
SDET43PDER8GB2	.500	.188	.500	.130	.031	.003	4	–	●	–	●	●	●	●	–	●	–
SDET43PDSL8GB2	.500	.188	.500	.130	.031	.005	4	–	–	–	●	–	●	–	–	–	–
SDET43PDSR8GB2	.500	.188	.500	.130	.031	.005	4	–	●	–	●	●	●	●	–	–	–
SDET433PDEL8GB2	.500	.188	.500	.120	.047	.003	4	–	●	–	●	●	–	–	–	–	–
SDET433PDER8GB2	.500	.188	.500	.120	.047	.003	4	–	●	–	●	●	●	●	–	–	–
SDET434SNGB2	.500	.188	.500	–	.063	.005	4	–	●	–	●	●	●	–	–	–	–
SDET435SNGB2	.500	.188	.500	–	.078	.005	4	–	●	–	●	●	●	●	–	–	–
SDET436SNGB2	.500	.188	.500	–	.094	.005	4	–	–	–	●	●	●	–	–	–	–
SDET438SNGB2	.500	.188	.500	–	.125	.005	4	–	●	–	●	●	●	–	–	–	–
SDET438XENGB2	.500	.188	.500	–	.125	.003	2	–	–	–	●	–	–	–	–	–	–
SDET4316SNGB2	.500	.188	.500	–	.250	.005	2	–	–	–	–	–	●	–	–	–	–

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.


SDET-GB



SDET-GB

● first choice
○ alternate choice

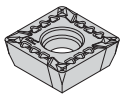
beyond

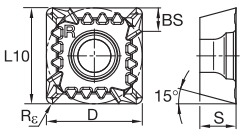
P				○	●		●	●		○			
M				●	●		○	○	○	●			
K			●	○		●	○				●		
N		●		○									
S				●	●				●	●			
H				○									

SDET-GB

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDET43PDER8GB	.500	.188	.500	.101	.031	.003	4	–	●	–	–	–	–	–	–	●	–
SDET43PDSR8GB	.500	.188	.500	.101	.031	.006	4	–	–	–	●	–	●	●	●	●	–
SDET433PDER8GB	.500	.188	.500	.086	.047	.003	4	–	–	–	●	–	–	●	–	●	–
SDET433PDSR8GB	.500	.188	.500	.085	.047	.006	4	–	–	–	●	–	–	–	–	●	–
SDET434ENGB	.500	.188	.500	—	.062	.003	4	–	–	–	–	–	–	–	–	●	–
SDET434SNGB	.500	.188	.500	—	.062	.006	4	–	–	–	●	–	–	–	–	●	–
SDET436ENGB	.500	.188	.500	—	.094	.003	4	–	–	–	●	–	–	–	–	●	–
SDET436SNGB	.500	.188	.500	—	.094	.006	4	–	–	–	●	–	–	–	–	●	–
SDET438ENGB	.500	.188	.500	—	.125	.003	4	–	–	–	●	–	–	–	–	●	–
SDET438SNGB	.500	.188	.500	—	.125	.006	4	–	–	–	–	–	–	–	–	●	–
SDET4312ENGB	.500	.188	.500	—	.188	.003	2	–	–	–	●	–	–	–	–	●	–
SDET4312SNGB	.500	.188	.500	—	.188	.006	2	–	–	–	●	–	–	–	–	●	–
SDET4316ENGB	.500	.188	.500	—	.250	.003	2	–	–	–	●	–	–	–	–	●	–
SDET4316SNGB	.500	.188	.500	—	.250	.006	2	–	–	–	●	–	●	–	●	●	–

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.


SDPT-GB2

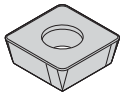


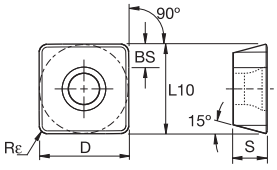
SDPT-GB2

SDPT-GB2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDPT43PDER8GB2	.500	.188	.500	.106	.031	.003	4	–	–	–	●	●	●	●	–	●	–
SDPT43PDSR8GB2	.500	.188	.500	.106	.031	.005	4	–	–	–	●	●	●	●	–	●	–

- Heavy machining.
- Precision ground.
- 0° rake face flat top.
- Four cutting edges.


SDCW-GN



SDCW-GN

● first choice
○ alternate choice

beyond

	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
P			○	●		●	●		○	
M			●	●		○	○	○	●	
K		●	○		●	○				●
N	●		○							
S			●	●				●	●	
H			○							

SDCW-GN

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCW43EDSR8GN	.500	.188	.500	.132	.031	.006	4	–	–	–	–	–	–	–	–	–	●
SDCW43PDSR8GN	.500	.188	.500	.099	.031	.006	4	–	–	–	–	–	–	–	–	–	●
SDCW433PDSR8GN	.500	.188	.500	.120	.047	.006	4	–	–	–	–	–	–	–	–	–	●

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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	.005	**.017**	.030	.003	**.012**	.021	.003	**.009**	.016	.002	**.008**	.014	.002	**.007**	.013	.F..LE
.E..LD	.007	**.019**	.032	.005	**.013**	.023	.004	**.010**	.017	.003	**.009**	.015	.003	**.008**	.014	.E..LD
.E..LD2	.005	**.018**	.032	.004	**.013**	.023	.003	**.010**	.017	.002	**.009**	.015	.002	**.008**	.014	.E..LD2
.E..GB	.009	**.021**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.010**	.016	.004	**.009**	.015	.E..GB
.E..GB2	.009	**.021**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.010**	.016	.004	**.009**	.015	.E..GB2
.S..GB	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GB
.S..GB2	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GB2
.S..GN	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

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 minimizes vibration and chatter.



Features and Benefits

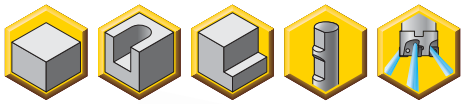
Features

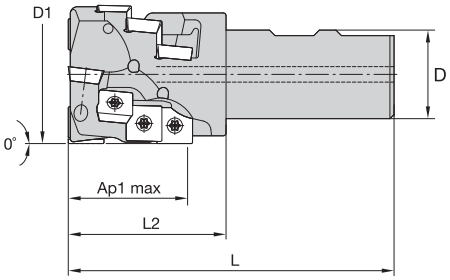
- Patented HARVI™ technology.
- Progressive helical rakes.
- Unique coolant supply.

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.







Weldon® End Mills

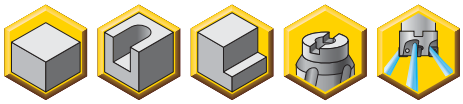
order number	catalog number	D1	D	L	L2	Ap1 max	Z	Z U	lbs	max RPM
2528269	**KSSP200R3SD43W125L169**	2.000	1.250	4.530	2.250	1.691	12	3	1.73	16300

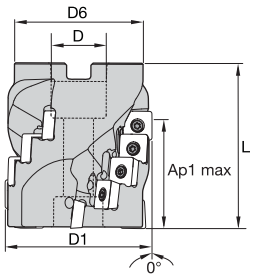
NOTE: Maximum nose radii of lead insert is .094" for a 2" diameter cutter.
All subsequent inserts up the flute should have a maximum nose radius of .031" to avoid lap lines.

Spare Parts

D1	 insert screw	 in. lbs.	 Torx wrench
2.000	**MS1273**	35.0	**TT15**

- Patented HARVI™ technology.
- Progressive helical rakes.
- Increased Metal Removal Rates (MRR).
- Excellent surface finishes.
- Low power requirements.
- Four cutting edges.







Shell Mills

order number	catalog number	D1	D	D6	L	Ap1 max	Z	Z U	lbs	max RPM
2601012	**KSSP200R3SD43L125**	2.000	.750	1.750	1.875	1.275	9	3.0	.87	16300
2400680	**KSSP200R3SD43L168**	2.000	.750	1.750	2.250	1.691	12	3.0	1.02	16300
3045090	**KSSP200R3SD43L200HC**	2.000	.750	1.913	3.000	2.072	15	3.0	1.42	16300
2400681	**KSSP250R3SD43L200**	2.500	1.000	2.190	2.750	2.005	15	3.0	2.34	14550
2400682	**KSSP300R4SD43L240**	3.000	1.250	2.750	3.250	2.427	24	4.0	4.07	13300
2977923	**KSSP300R5SD43L400HC**	3.000	1.250	2.900	5.000	4.114	55	5.0	5.95	13300

NOTE: ZU = Effective number of flutes.
Maximum nose radii of lead insert is .094" for 2" diameter cutters and .125" for 2.50" diameter cutters and above.
All subsequent inserts up the flutes should have a maximum nose radius of .031" to avoid lap lines.

Spare Parts

order number	D1	insert screw	in. lbs.	Torx Plus wrench	Torx wrench
2601012	2.000	**MS1273**	35.0	**–**	**TT15**
2400680	2.000	**MS1273**	35.0	**–**	**TT15**
3045090	2.000	**MS2085**	35.0	**TTP15**	**–**
2400681	2.500	**MS1273**	35.0	**–**	**TT15**
2400682	3.000	**MS1273**	35.0	**–**	**TT15**
2977923	3.000	**MS2085**	35.0	**TTP15**	**–**

Insert Selection Guide

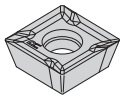
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KCPM40
P3–P4	.E..LD2	KCPM40	**.E..GB2**	**KCPK30**	.S..GB2	KCPK30
P5–P6	.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	–	–	**–**	**–**	–	–

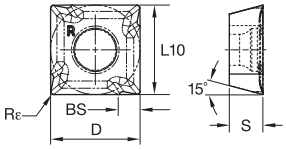
- Aluminum workpiece materials.
- Precision ground.
- 20° rake face.
- Four cutting edges.

beyond

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

● first choice
○ alternate choice


SDCT-LE

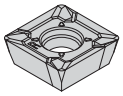


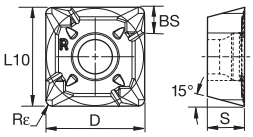
SDCT-LE

SDCT-LE

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCT431PDFL8LE	.500	.188	.500	.106	.016	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT431PDFR8LE	.500	.188	.500	.106	.016	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT43PDFL8LE	.500	.188	.500	.106	.031	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT43PDFR8LE	.500	.188	.500	.106	.031	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT433PDFL8LE	.500	.188	.500	.106	.047	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT433PDFR8LE	.500	.188	.500	.106	.047	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT434FNLE	.500	.188	.500	—	.063	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT435FNLE	.500	.188	.500	—	.078	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT436FNLE	.500	.188	.500	—	.094	.001	4	●	–	–	–	–	–	–	–	–	–
SDCT438FNLE	.500	.188	.500	—	.125	.001	4	●	–	–	–	–	–	–	–	–	–

- Light and finish machining.
- Precision ground.
- 15° rake face.
- Four cutting edges.


SDCT-LD2



SDCT-LD2

● first choice
○ alternate choice

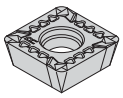
beyond

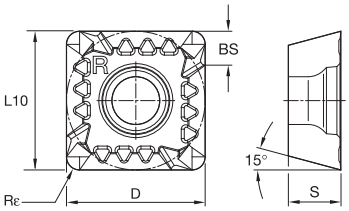
		KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
P				○	●		●	●		○	
M				●	●		○	○	○	●	
K			●	○		●	○				●
N		●		○							
S				●	●				●	●	
H				○							

SDCT-LD2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCT431PDEL8LD2	.500	.188	.500	.106	.016	.002	4	–	–	–	●	–	–	–	–	–	–
SDCT431PDER8LD2	.500	.188	.500	.115	.016	.002	4	–	–	–	●	–	–	–	–	–	–
SDCT43PDEL8LD2	.500	.188	.500	.130	.031	.002	4	–	–	–	●	–	–	–	–	–	–
SDCT43PDER8LD2	.500	.188	.500	.130	.031	.002	4	–	●	–	●	–	–	●	–	●	–
SDCT433PDEL8LD2	.500	.188	.500	.120	.047	.002	4	–	–	–	●	–	–	–	–	–	–
SDCT433PDER8LD2	.500	.188	.500	.120	.047	.002	4	–	–	–	●	–	–	–	–	●	–
SDCT434ENLD2	.500	.188	.500	–	.063	.002	4	–	–	–	●	–	–	–	–	●	–
SDCT435ENLD2	.500	.188	.500	–	.078	.002	4	–	–	–	●	–	–	–	–	–	–
SDCT436ENLD2	.500	.188	.500	–	.094	.002	4	–	–	–	●	–	–	–	–	–	–
SDCT438ENLD2	.500	.188	.500	–	.125	.002	4	–	–	●	●	–	–	–	●	●	–
SDCT4316ENLD2	.500	.188	.500	–	.250	.002	2	–	–	–	●	–	–	–	–	●	–

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.


SDET-GB2

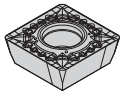


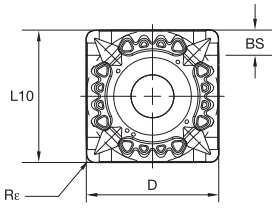
SDET-GB2

SDET-GB2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDET43PDEL8GB2	.500	.188	.500	.130	.031	.003	4	–	●	–	●	●	●	–	–	–	–
SDET43PDER8GB2	.500	.188	.500	.130	.031	.003	4	–	●	–	●	●	●	●	–	●	–
SDET43PDSL8GB2	.500	.188	.500	.130	.031	.005	4	–	–	–	●	–	●	–	–	–	–
SDET43PDSR8GB2	.500	.188	.500	.130	.031	.005	4	–	●	–	●	●	●	●	–	–	–
SDET433PDEL8GB2	.500	.188	.500	.120	.047	.003	4	–	●	–	●	●	–	–	–	–	–
SDET433PDER8GB2	.500	.188	.500	.120	.047	.003	4	–	●	–	●	●	●	●	–	–	–
SDET434SNGB2	.500	.188	.500	–	.063	.005	4	–	●	–	●	●	●	–	–	–	–
SDET435SNGB2	.500	.188	.500	–	.078	.005	4	–	●	–	●	●	●	●	–	–	–
SDET436SNGB2	.500	.188	.500	–	.094	.005	4	–	–	–	●	●	●	–	–	–	–
SDET438SNGB2	.500	.188	.500	–	.125	.005	4	–	●	–	●	●	●	–	–	–	–
SDET438XENGB2	.500	.188	.500	–	.125	.003	2	–	–	–	●	–	–	–	–	–	–
SDET4316SNGB2	.500	.188	.500	–	.250	.005	2	–	–	–	–	–	●	–	–	–	–

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.


SDET-GB



SDET-GB

● first choice
○ alternate choice

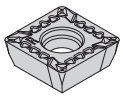
beyond

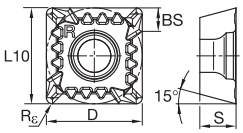
P			○	●		●	●		○		
M			●	●		○	○	○	●		
K		●	○		●	○				●	
N	●		○								
S			●	●				●	●		
H			○								

SDET-GB

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDET43PDER8GB	.500	.188	.500	.101	.031	.003	4	–	●	–	–	–	–	–	–	●	–
SDET43PDSR8GB	.500	.188	.500	.101	.031	.006	4	–	–	–	●	–	●	●	●	●	–
SDET433PDER8GB	.500	.188	.500	.086	.047	.003	4	–	–	–	●	–	–	●	–	●	–
SDET433PDSR8GB	.500	.188	.500	.085	.047	.006	4	–	–	–	●	–	–	–	–	●	–
SDET434ENGB	.500	.188	.500	–	.062	.003	4	–	–	–	–	–	–	–	–	●	–
SDET434SNGB	.500	.188	.500	–	.062	.006	4	–	–	–	●	–	–	–	–	●	–
SDET436ENGB	.500	.188	.500	–	.094	.003	4	–	–	–	●	–	–	–	–	●	–
SDET436SNGB	.500	.188	.500	–	.094	.006	4	–	–	–	●	–	–	–	–	●	–
SDET438ENGB	.500	.188	.500	–	.125	.003	4	–	–	–	●	–	–	–	–	●	–
SDET438SNGB	.500	.188	.500	–	.125	.006	4	–	–	–	–	–	–	–	–	●	–
SDET4312ENGB	.500	.188	.500	–	.188	.003	2	–	–	–	●	–	–	–	–	●	–
SDET4312SNGB	.500	.188	.500	–	.188	.006	2	–	–	–	●	–	–	–	–	●	–
SDET4316ENGB	.500	.188	.500	–	.250	.003	2	–	–	–	●	–	–	–	–	●	–
SDET4316SNGB	.500	.188	.500	–	.250	.006	2	–	–	–	●	–	●	–	●	●	–

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.


SDPT-GB2

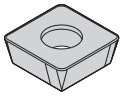


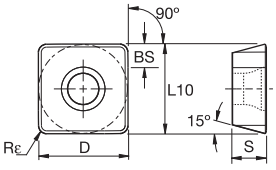
SDPT-GB2

SDPT-GB2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDPT43PDER8GB2	.500	.188	.500	.106	.031	.003	4	–	–	–	●	●	●	●	–	●	–
SDPT43PDSR8GB2	.500	.188	.500	.106	.031	.005	4	–	–	–	●	●	●	●	–	●	–

- Heavy machining.
- Precision ground.
- 0° rake face flat top.
- Four cutting edges.


SDCW-GN



SDCW-GN

● first choice
○ alternate choice

beyond

	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
P			○	●		●	●		○	
M			●	●		○	○	○	●	
K		●	○		●	○				●
N	●		○							
S			●	●				●	●	
H			○							

SDCW-GN

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCW43EDSR8GN	.500	.188	.500	.132	.031	.006	4	–	–	–	–	–	–	–	–	–	●
SDCW43PDSR8GN	.500	.188	.500	.099	.031	.006	4	–	–	–	–	–	–	–	–	–	●
SDCW433PDSR8GN	.500	.188	.500	.120	.047	.006	4	–	–	–	–	–	–	–	–	–	●

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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	.005	**.017**	.030	.003	**.012**	.021	.003	**.009**	.016	.002	**.008**	.014	.002	**.007**	.013	.F..LE
.E..LD	.007	**.019**	.032	.005	**.013**	.023	.004	**.010**	.017	.003	**.009**	.015	.003	**.008**	.014	.E..LD
.E..LD2	.005	**.018**	.032	.004	**.013**	.023	.003	**.010**	.017	.002	**.009**	.015	.002	**.008**	.014	.E..LD2
.E..GB	.009	**.021**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.010**	.016	.004	**.009**	.015	.E..GB
.E..GB2	.009	**.021**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.010**	.016	.004	**.009**	.015	.E..GB2
.S..GB	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GB
.S..GB2	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GB2
.S..GN	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GN

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

NOVO KNOWS CAD/CAM

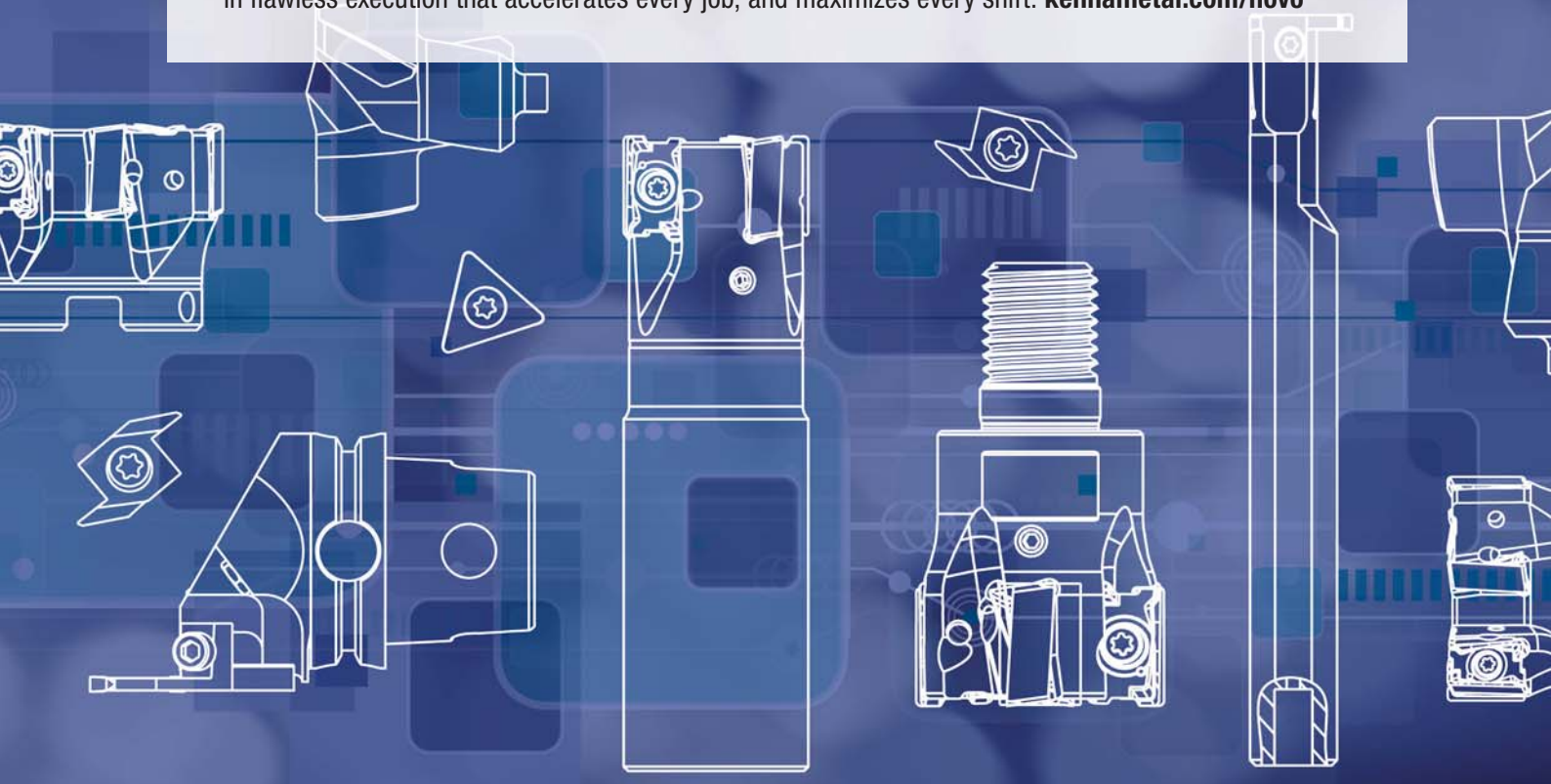
With the addition of NOVO™ applications to your team, your CAD/CAM capabilities become much more accurate, streamlined, and productive.

Before NOVO: The programmer would be in their CAD/CAM software, programming a part. Using the tedious method of finding a tool in a catalog, and then manually inputting the tooling information from the catalog 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 maximizes every shift. **kennametal.com/novo**



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

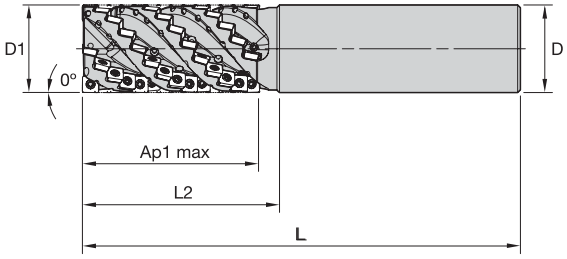
5230VS09:
(a_p max is determined by selection of cutter diameter)
Diameter range and maximum a_p= 2.000" diameter with a_p 2.010", 3.150" or 4.000"

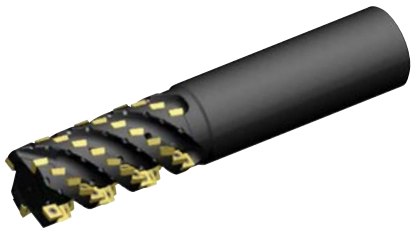
5230VS12:

(a_p max is determined by selection of cutter diameter)
Diameter range and maximum a_p= 2.500" diameter with a_p 2.244" or 3.700"
3.000" diameter with a_p 2.560" or 4.433"
4.000" diameter with a_p 3.000" or 5.236"

- 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 provide constant chip evacuation and temperature stability in the cutting zone.







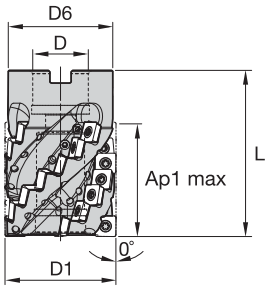
Cylindrical End Mills

order number	catalog number	D1	D	L	L2	Ap1 max	Z	Z U
5673041	C5230VS09CA2.0Z04R4.0	2.000	2.000	10.000	4.500	4.000	56	4

Spare Parts

D1	insert screw	in. lbs.	Torx driver	coolant control screw	Torx driver
2.000	F3508T	18.6	T15	F3006T	T9

- 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 provide constant chip evacuation and temperature stability in the cutting zone.





Shell Mills

order number	catalog number	D1	D	D6	L	Ap1 max	Ap2 max	Z	Z U
5673176	**C5230VS09-A2.0Z4R2.0**	2.000	1.000	1.882	2.990	2.010	1.750	28	4
5673530	**C5230VS09-A2.0Z04R3.1**	2.000	1.000	1.882	4.173	3.150	—	44	4

NOTE: Ap2 max is the max Ap for slotting.

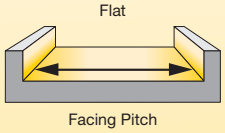
Spare Parts

order number	D1	 insert screw	 in. lbs.	 Torx driver	 coolant control screw	 Torx driver	 steel coolant plug	 nord lock washer	 socket-head cap screw
5673530	2.000	**F3508T**	18.6	**T15**	**F3006T**	**T9**	**SB3621**	**NLW-0.375**	**#1/2-20X1-1/4SHCSA**
5673176	2.000	**F3508T**	18.6	**T15**	**F3006T**	**T9**	**SB3413**	**NLW-0.375**	**#1/2-20X1-1/4SHCSA**

NOTE: Tighten mounting bolt to 59–74 ft. lbs.
Tighten steel coolant plug to 25 ft. lbs.

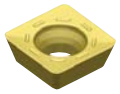
5230VS09 Technical Information (Inch)

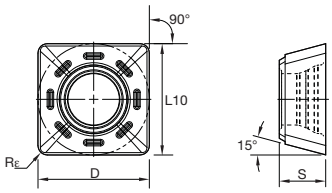
Product		Dimension					
EDP	**Item Description**	Facing Pitch	Ramping Angle°	Helical Hole min. – max.		a_p max Helical/Linear	Max RPM
033073	**C5230VS09-CA2.0Z4R4.0**	2.000	-	–	–	–	32,500
031430	**C5230VS09-A2.0Z4R2.0**	2.000	–	–	–	–	32,500
031581	**C5230VS09-A2.0Z4R3.1**	2.000	–	–	–	–	32,500



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	–	–	–	–	–	–


SDHT09-422



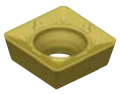
SDHT09-422

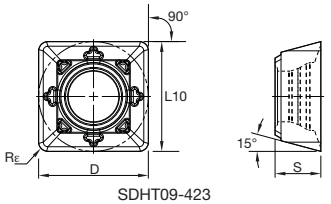
● first choice
○ alternate choice

		KCSM40	MP91M	SP6519	X500
P		○	●	○	○
M		●		●	●
K			●	○	
N					
S		●		●	●
H			○		

SDHT09-422

catalog number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDHT09T308EN422	.375	.375	.156	.031	.001	4	●	–	●	●
SDHT09T3AEEN422	.375	.375	.156	—	.002	4	–	–	●	–


SDHT09-423

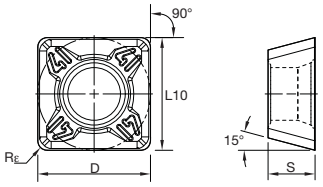


SDHT09-423

SDHT09-423

catalog number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDHT09T308EN423	.375	.375	.156	.031	.002	4	●	–	●	●


SDMT09-41



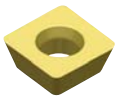
SDMT09-41

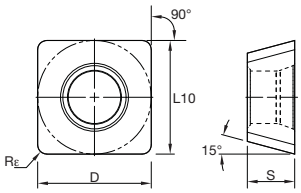
● first choice
○ alternate choice

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

SDMT09-41

catalog number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDMT09T308EN41	.375	.375	.156	.032	.002	4	●	●	●	●


SDMW09-TN



SDMW09-TN

SDMW09-TN

catalog number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDMW09T308TN	.375	.375	.156	.031	.004	4	●	–	–	–

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

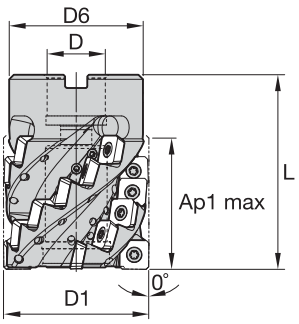
Light Machining	General Purpose	Heavy Machining

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	.005	**.019**	.030	.003	**.014**	.022	.003	**.010**	.016	.002	**.009**	.014	.002	**.008**	.013	.E..422
.E..423	.005	**.019**	.030	.004	**.013**	.021	.003	**.010**	.016	.002	**.009**	.014	.002	**.008**	.013	.E..423
.E..41	.007	**.021**	.033	.005	**.015**	.023	.004	**.011**	.018	.003	**.010**	.015	.003	**.009**	.014	.E..41
...TN	.009	**.023**	.035	.007	**.017**	.025	.005	**.013**	.019	.004	**.011**	.016	.004	**.010**	.015	...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 provide constant chip evacuation and temperature stability in the cutting zone.







Shell Mills

order number	catalog number	D1	D	D6	L	Ap1 max	Ap2 max	Z	Z U
5673797	C5230VS12-A2.5Z4R2.24	2.500	1.000	2.303	3.347	2.244	2.000	24	4
5672481	C5230VS12-A2.5Z4R3.70	2.500	1.000	2.283	4.882	3.701	—	40	4
5673747	C5230VS12-A3.0Z5R2.56	3.000	1.250	2.764	3.740	2.559	2.360	35	5
5673617	C5230VS12-A3.0Z5R4.33	3.000	1.250	2.764	5.630	4.331	—	60	5

NOTE: Ap2 max is the max Ap for slotting.

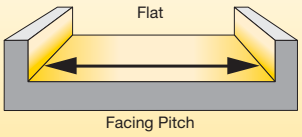
Spare Parts

D1	Z	insert screw	in. lbs.	Torx driver	coolant control screw	Torx driver	steel coolant plug	nord lock washer	socket-head cap screw
2.500	24	F4011T	27.4	T20	F3006T	T9	—	NLW-0.375	#1/2-20X1-1/4SHCSA
2.500	40	F4011T	27.4	T20	F3006T	T9	SB3230	NLW-0.375	#1/2-20X1-1/4SHCSA
3.000	35	F4011T	27.4	T20	F3006T	T9	—	NLW12SP	#5/8-18X1-1/2SHCSA
3.000	60	F4011T	27.4	T20	F3006T	T9	SB3232	NLW12SP	#5/8-18X1-1/2SHCSA

NOTE: Tighten mounting bolt on 2.5" cutters to 59–74 ft. lbs, 3" cutters to 81–110 ft. lbs, and 4" cutters to 89–132 ft. lbs.
Tighten steel coolant plug to 25 ft. lbs for 2.5" cutters and 45 ft. lbs for 3" and 4" cutters.

5230VS12 Technical Information (inch)

Product		Dimension					
EDP	Item Description	Facing Pitch	Ramping Angle°	Helical Hole min.–max.		a_p max Helical/Linear	Max RPM
031234	C5230VS12-A2.5Z4R2.24	2.500	–	–	–	–	21,000
031133	C5230VS12-A2.5Z4R3.70	2.500	–	–	–	–	21,000
031606	C5230VS12-A3.0Z5R2.56	3.000	–	–	–	–	18,500
031607	C5230VS12-A3.0Z5R4.33	3.000	–	–	–	–	18,500
031237	C5230VS12-A4.0Z6R5.23	4.000	–	–	–	–	16,000



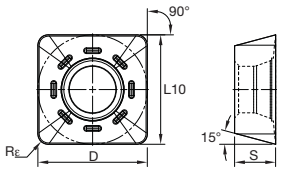
Insert Selection Guide

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	–	–	–	–	–	–

Milling Inserts



SDHT12-422



SDHT12-422

● first choice
○ alternate choice

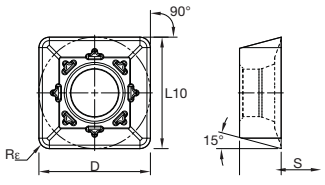
P		○	●	○	○	
M		●		●	●	
K			●	○		
N						
S		●		●	●	
H			○			

SDHT12-422

catalog number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDHT120412EN422	.500	.500	.187	.047	.002	4	●	–	●	●



SDHT12-423

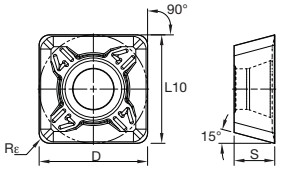


SDHT12-423

SDHT12-423

catalog number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDHT120412EN423	.500	.500	.187	.047	.002	4	●	–	●	●


SDMT12-41



SDMT12-41

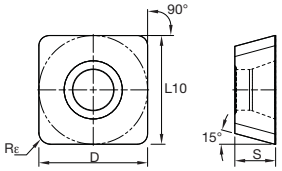
● first choice
○ alternate choice

		KCSM40	MP91M	SP6519	X500
P		○	●	○	○
M		●		●	●
K			●	○	
N					
S		●		●	●
H			○		

SDMT12-41

catalog number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDMT120412EN41	.500	.500	.187	.047	.002	4	●	●	●	●


SDMW12-TN



SDMW12-TN

SDMW12-TN

catalog number	D	L10	S	Rε	hm	cutting edges	KCSM40	MP91M	SP6519	X500
SDMW120412TN	.500	.500	.187	.047	.002	4	●	–	●	–

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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	.007	**.021**	.035	.005	**.015**	.025	.004	**.011**	.019	.003	**.010**	.016	.003	**.009**	.015	.E..422
.E..41	.007	**.021**	.035	.005	**.015**	.025	.004	**.011**	.019	.003	**.010**	.016	.003	**.009**	.015	.E..41
.E..423	.008	**.023**	.037	.006	**.017**	.027	.004	**.013**	.020	.004	**.011**	.017	.003	**.010**	.016	.E..423
...TN	.008	**.023**	.037	.006	**.017**	.027	.004	**.013**	.020	.004	**.011**	.017	.003	**.010**	.016	...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: Program 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

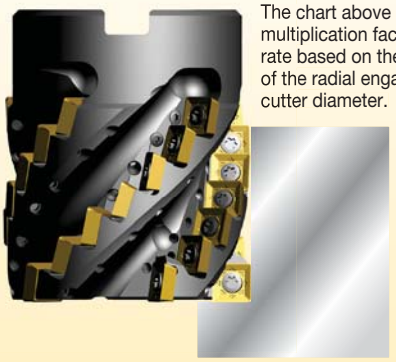
Formula: Average Chip Thickness (h_m)

$$h_m = f_z \times \sqrt{\frac{a_e}{d}}$$

h_m Correction Coefficient Chart

Cutter Ø 2.000"			Cutter Ø 2.500"			Cutter Ø 3.000"			Cutter Ø 4.000"		
ae%	ae (Inch)	Coefficient Factor	ae%	ae (Inch)	Coefficient Factor	ae%	ae (Inch)	Coefficient Factor	ae%	ae (Inch)	Coefficient Factor
5	0.100	2.294	5	0.125	2.329	5	0.150	2.294	5	0.200	2.294
10	0.200	1.667	10	0.250	1.667	10	0.300	1.667	10	0.400	1.667
15	0.300	1.400	15	0.375	1.425	15	0.450	1.407	15	0.600	1.407
20	0.400	1.250	20	0.500	1.250	20	0.600	1.250	20	0.800	1.250
25	0.500	1.155	25	0.625	1.160	25	0.750	1.155	25	1.000	1.155
35	0.700	1.048	35	0.875	1.056	35	1.050	1.048	35	1.400	1.056
50–100	1.000–2.000	1.000	50–100	1.250–2.500	1.000	50–100	1.500–3.000	1.000	50–100	2.000–4.000	1.000

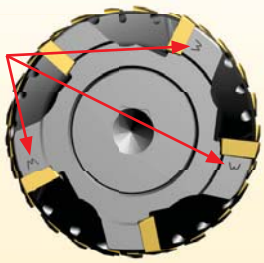
Example: A 3.000" diameter cutter using a 0.300" radial engagement (ae) = 10% of the cutter diameter. At 10%, your coefficient is 1.667 (see above table); therefore you must multiply your feed rate by 1.667 for correcting the feed for profiling.



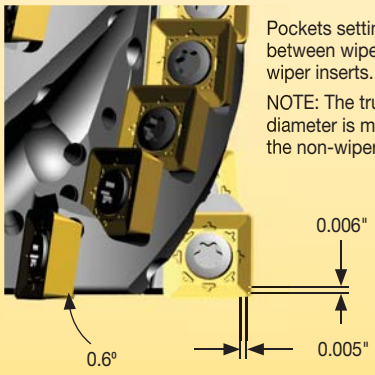
The chart above shows the multiplication factor for the feed rate based on the percentage of the radial engagement of the cutter diameter.



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 utilized 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 (inch)	Number of Wiper Inserts
2.000	2
2.500	2
3.000	3
4.000	3

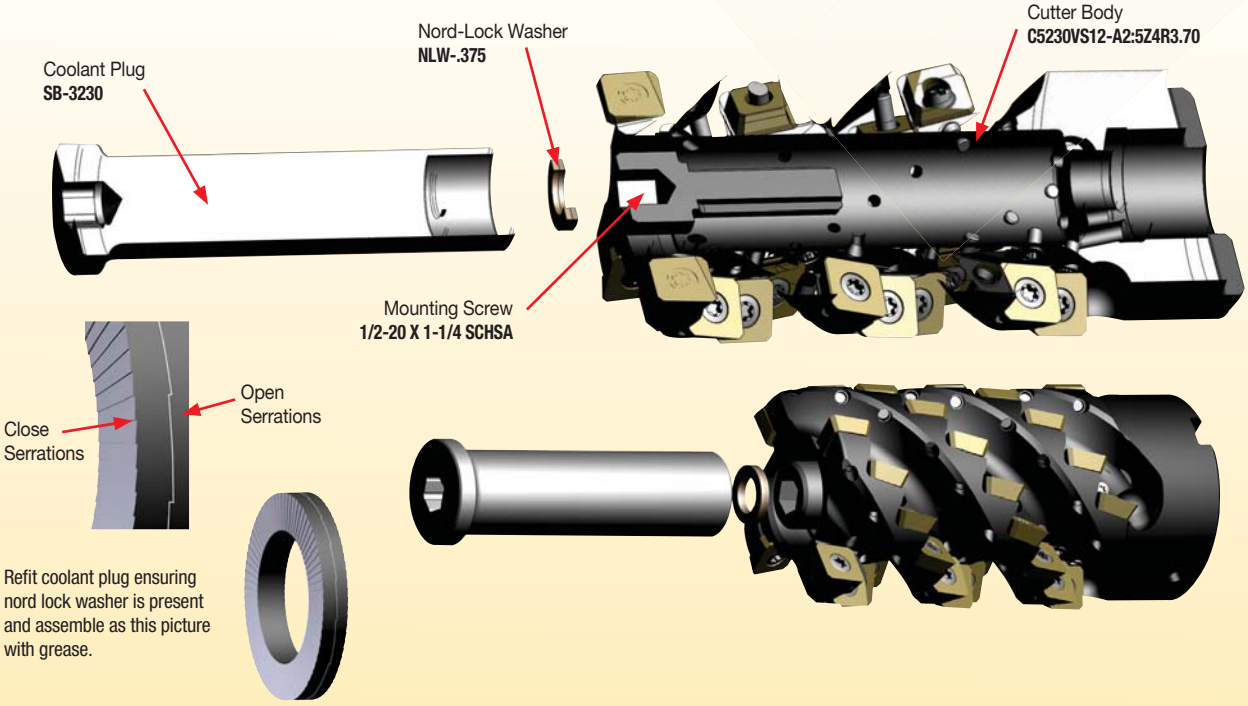
5230VS09 and 5230VS12 Fitting Instructions for Shell Mill Cutters

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 adapter, 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: C5230VS12-A2.5Z4R3.70 assembly



Refit coolant plug ensuring nord lock washer is present and assemble as this picture with grease.

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 adapter 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 T136.
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 T136.
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 ft lbs. for Mounting Bolt		Coolant Plug Description	Coolant Plug Tightening ft lbs.
		Normal Condition	Excessive Condition		
C5230VS09-A2.0Z4R2.0	1/2-20 x 1-1/4 SHCSA	59	74	SB-3413	25
C5230VS09-A2.0Z4R3.1				SB-3621	

5230VS12	Detail 1			Detail 2	
Cutter	Mounting Bolt Description	Torque Values in ft lbs. for Mounting Bolt		Coolant Plug Description	Coolant Plug Tightening ft lbs.
		Normal Condition	Excessive Condition		
C5230VS12-A2.5Z4R2.24	1/2-20 x 1-1/4 SHCSA	59	74	SB-3229	25
C5230VS12-A2.5Z4R3.70				SB-3230	
C5230VS12-A3.0Z5R2.56	5/8-18 x 1-1/2 SHCSA	81.1	110.6	SB-3231	45
C5230VS12-A3.0Z5R4.33				SB-3232	
C5230VS12-A4.0Z6R3.00	3/4-16 x 1-3/4 SHCSA	88.5	132.76	SB-3233	45
C5230VS12-A4.0Z6R5.23				SB-3234	

Mounting Bolt Hex Keys

M12 = Hex Key Size 10
M16 = Hex Key Size 14
M20 = Hex Key Size 17



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It's easy for your company to be environmentally conscious with the Kennametal Carbide Recycling Program.

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- 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.

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For more information, please visit **kennametal.com/carbiderecycling**.

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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–U31

KSSM12 • Neutral, Right-, and Left-Hand Cutters, 12mm IC U32–U41

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.

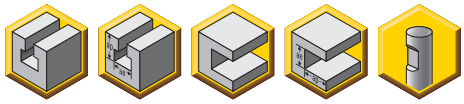
Please note that all of these cutters have metric diameters, speeds, and feeds.

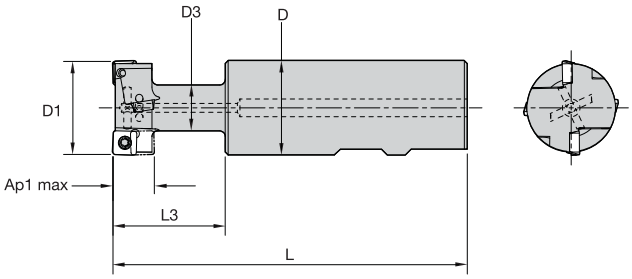


Features and Benefits

- 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	catalog 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

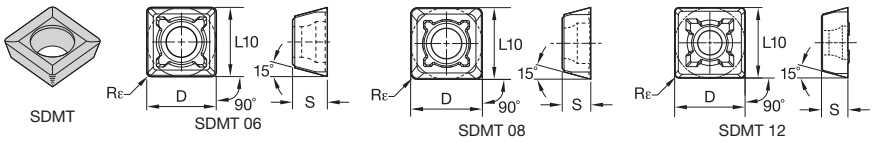
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	..EGG	KC735M	**..EGG**	**KC735M**	..EGG	KC735M
P3–P4	..EGG	KC735M	**..EGG**	**KC735M**	..EGG	KC735M
P5–P6	..EGG	KC735M	**..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

catalog 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.

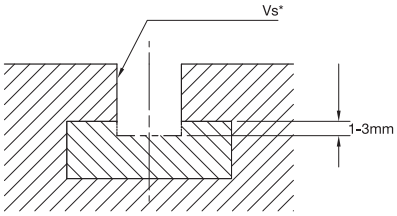


Fig. 1

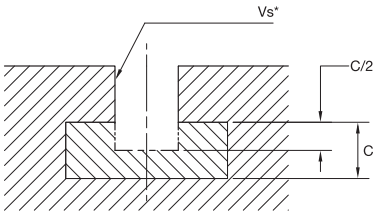


Fig. 2

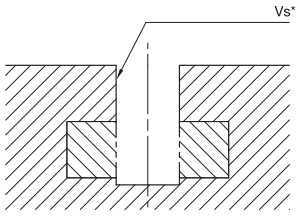
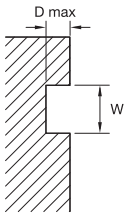


Fig. 3



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	catalog 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	0,15	Figure 2,3
		KTMS50S32SD12H	120	0,15	Figure 3

* Vs = Vertical Slot Preparation for T-slot.

Side Slot Machining

side slot dimension / catalog number	(unit: mm) W -0.1 / -0. (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.

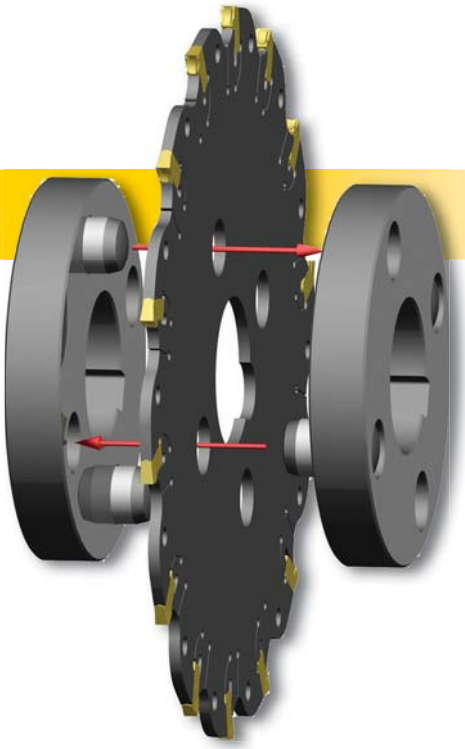
Cutting Data Table • Side Machining

	material type	catalog 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

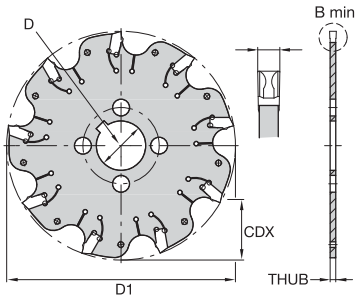
The KVNS slotting cutter enables diameters from 2.50–10" and insert widths from .063–.245". It is a perfect solution for small groove widths, grades, and geometries and suits most materials. Drive rings and support rings are available; use these items to get the maximum support for the cutter body.

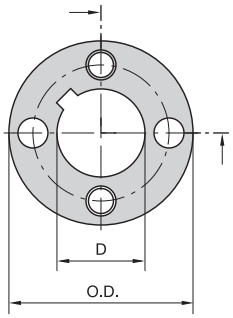


Features and Benefits

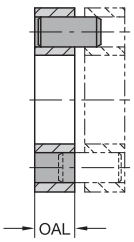
- Slot widths from .063–.245".
- Grades and geometries to suit most workpiece materials.
- Self-clamping inserts.
- Positive chipforming inserts are standard.
- Self-clamping insert seat with fixed stop.
- Excellent for all flat-bottom slotting and cut-off operations.
- Two drive hubs required for each cutter body, except when using two drive supports.
- Drive rings and support rings available, must be ordered separately (in pairs).

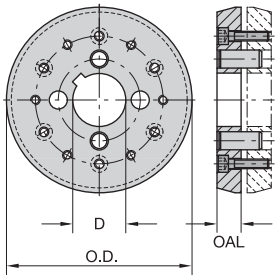
- .063–.245" slot width range.
- Positive chipforming inserts are standard.
- Self-clamping insert seat with fixed stop.
- Excellent for all flat-bottom slotting and cut-off operations.
- Two drive rings required for each cutter body, except when using two drive supports (must be ordered separately, in pairs).





Drive Ring





Support Ring



KVNS • Cutting Width .063"

order number	catalog number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	lbs
1247698	**KVNS02063OD**	2.500	.625	.063	.625	.051	5	5100	OD_1063__	**1247652**	<2.00
1247710	**KVNS03063OD**	3.000	.625	.063	.875	.051	7	4000	OD_1063__	**1247675**	<2.00
1247725	**KVNS04063OD**	4.000	1.000	.063	1.063	.051	9	3200	OD_1063__	**1247660**	<2.00
1247738	**KVNS05063OD**	5.000	1.250	.063	1.375	.051	11	2600	OD_1063__	**1247663**	<2.00

KVNS • Cutting Width .087"

order number	catalog number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	lbs
1247712	**KVNS03087OD**	3.000	.625	.089	.875	.071	7	4000	OD_2087__	1247675	<2.00
1247727	**KVNS04087OD**	4.000	1.000	.089	1.063	.071	9	3200	OD_2087__	1247660	<2.00
1247740	**KVNS05087OD**	5.000	1.250	.089	1.375	.071	11	2600	OD_2087__	1247663	<2.00
1247753	**KVNS06087OD** *	6.000	1.250	.089	1.438	.071	14	2000	OD_2087__	1247666	<2.00

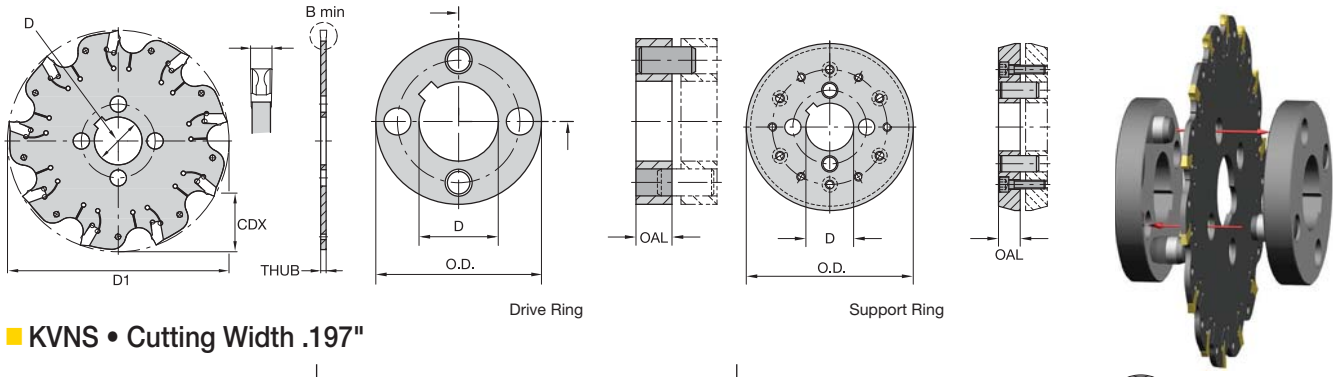
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

KVNS • Cutting Width .118"

order number	catalog number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	lbs
1247704	**KVNS02118OD**	2.500	.625	.126	.625	.095	4	5100	OD_3125_	**1247650**	<2.00
1247716	**KVNS03118OD**	3.000	.625	.126	.875	.095	6	4000	OD_3125_	**1247675**	<2.00
1247730	**KVNS04118OD**	4.000	1.000	.126	1.063	.095	9	3200	OD_3125_	**1247660**	<2.00
1247742	**KVNS05118OD**	5.000	1.250	.126	1.375	.095	11	2600	OD_3125_	**1247663**	<2.00
1247757	**KVNS06118OD**	6.000	1.250	.126	1.438	.095	14	2000	OD_3125_	**1247666**	<2.00
1247768	**KVNS08118OD**	8.000	2.000	.126	2.250	.095	19	1600	OD_3125_	**1247668**	<2.00
1247778	**KVNS10118OD**	10.000	2.000	.126	3.250	.095	24	1300	OD_3125_	**1247668**	<2.00

KVNS • Cutting Width .158"

order number	catalog number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	lbs
1247718	**KVNS03158OD**	3.000	.625	.164	.875	.134	6	4000	OD_4158__	1247675	<2.00
1247732	**KVNS04158OD**	4.000	1.000	.164	1.063	.134	9	3200	OD_4158__	1247660	<2.00
1247746	**KVNS05158OD**	5.000	1.250	.164	1.375	.134	11	2600	OD_4158__	1247663	<2.00



Drive Ring Support Ring

KVNS • Cutting Width .197"

order number	catalog number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	lbs
1247721	**KVNS03197OD** *	3.000	.625	.206	.875	.173	5	4000	OD_5197__	1247675	<2.00

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

KVNS • Cutting Width .236"

order number	catalog number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	lbs
1247722	**KVNS03236OD**	3.000	.625	.245	.875	.213	5	4000	OD_6236__	**1247675**	<2.00
1247735	**KVNS04236OD**	4.000	1.000	.245	1.063	.213	8	3200	OD_6236__	**1247660**	<2.00
1247785	**KVNS102360D**	10.000	2.000	.245	3.250	.213	24	1300	OD_6236__	**1247668**	<2.00

NOTE: Insert wrench 170.183 (order number 1124601) must be ordered separately.

Drive Rings

order number	D1	O.D.	OAL	bore size	drive ring	lbs
1247650	2.500	1.250	.315	.625	**KAP1250632**	.07
1247652	2.500	1.250	.315	.625	**KAP1250634**	.08
1247675	3.000	1.250	.315	.625	**KAP1250764**	.11
1247660	4.000	1.875	.394	1.000	**KAP1871004**	.20
1247663	5.000	2.250	.394	1.250	**KAP2251254**	.26
1247666	6.000	3.125	.472	1.250	**KAP3121254**	.75
1247668	8.000	3.500	.472	2.000	**KAP3502004**	.75
1247668	10.000	3.500	.472	2.000	**KAP3502004**	.75

NOTE: KAP1250634 is for use with KVNS020630D.
KAP1250632 is for use with KVNS021180D.

Support Rings

order number	catalog number	D1	O.D.	OAL	clamp screw	Allen key	bore size	lbs
1247669	**KAP5502004**	8.000	5.500	.472	**125.616**	**170.005**	2.000	2.53
1247669	**KAP5502004**	10.000	5.500	.472	**125.616**	**170.005**	2.000	2.53

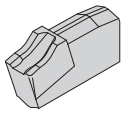
Spare Parts

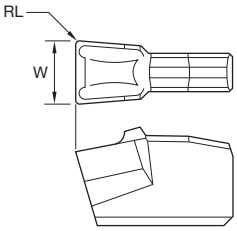
D1	support ring screw
8.000	**125.616**
10.000	**125.616**

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	–	–	–	–	–	–

- Positive chipforming insert geometry.
- Very narrow slotting/slitting operations.





● first choice
○ alternate choice

P	○	●	
M	●	○	
K		○	
N			●
S	●		●
H			

.063"

catalog number	W	RL	hm	KC735M	KCPK30	KMF
ODG1063ISGD	.063	.006	.003	●	●	–
ODG1063ISGB	.063	.006	.003	●	●	–
ODC1063IEGD	.063	.006	.003	–	–	●

.087"

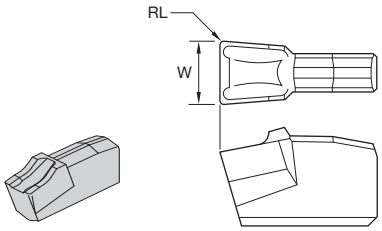
catalog number	W	RL	hm	KC735M	KCPK30	KMF
ODG2087ISGD	.087	.008	.003	●	●	–
ODG2087ISGB	.087	.008	.003	●	●	–
ODC2087IEGD	.087	.008	.003	–	–	●

.118"

catalog number	W	RL	hm	KC735M	KCPK30	KMF
ODG3125ISGD	.120	.008	.003	●	●	–
ODG3125ISGB	.120	.008	.003	●	●	–
ODC3125IEGD	.119	.008	.003	–	–	●

.158"

catalog number	W	RL	hm	KC735M	KCPK30	KMF
ODG4158ISGD	.160	.008	.003	●	●	–
ODG4158ISGB	.160	.008	.003	●	●	–
ODC4158IEGD	.159	.008	.003	–	–	●



● first choice
○ alternate choice

P		○	●
M		●	○
K			○
N			
S		●	
H			

.197"

catalog number	W	RL	hm	KC735M	KCPK30	KMF
ODG5197ISGB	.199	.012	.003	●	–	–

.236"

catalog number	W	RL	hm	KC735M	KCPK30	KMF
ODG6236ISGB	.238	.012	.003	●	●	–

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

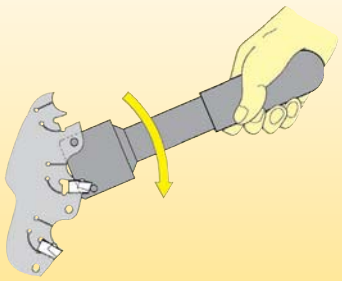
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..GD	.009	**.015**	.024	.007	**.011**	.017	.005	**.008**	.013	.004	**.007**	.011	.004	**.007**	.010	.E..GD
.S..GD	.009	**.017**	.026	.007	**.013**	.019	.005	**.009**	.014	.004	**.008**	.012	.004	**.008**	.011	.S..GD
.S..GB	.009	**.017**	.028	.007	**.013**	.020	.005	**.009**	.015	.004	**.008**	.013	.004	**.008**	.012	.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.

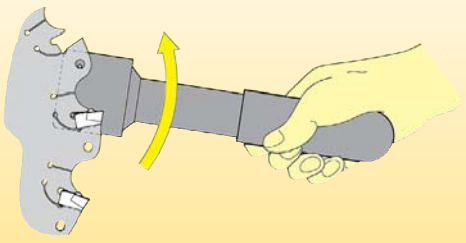
Slotting Cutters • Technical Information

Slot Milling

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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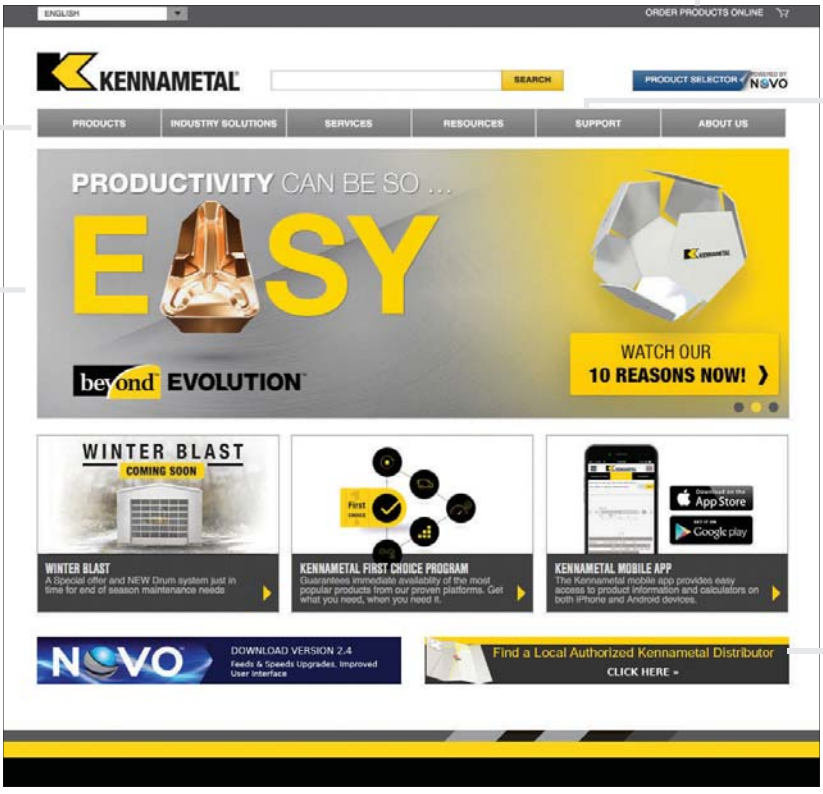

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SN Slotting Cutter

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 .161–.187" and cutter diameters from 4–6" as well as an economical way to achieve balanced cutting.

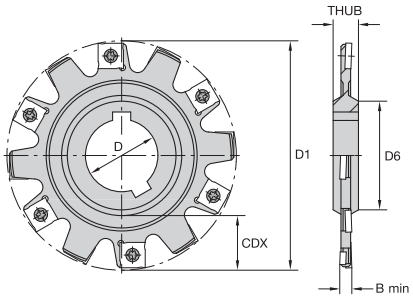


Features and Benefits

- Cutters available in arbor mount.
- Inserts with four indexes.
- Staggered key ways in mounting bore, used for multiple ganged cutters.
- Slot width .161–.187".
- Three insert geometries available: -GP, -GE, and -T.
- Requires only one spare part.

- .161–.187" slotting width range.
- Four indexes per insert.
- Three chipformers available.
- Two keyways for staggered mounting.
- Requires only one spare part.







SN • Cutting Width .161"

order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z U	max RPM	insert 1	lbs
1247681	**KS426SNH1102**	4.000	1.000	1.620	.161	1.120	.500	12	6	9530	SNHX1102T	<2.00
1247684	**KS526SNH1102**	5.000	1.250	1.880	.161	1.500	.500	14	7	8520	SNHX1102T	<2.00

SN • Cutting Width .187"

order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z U	max RPM	insert 1	lbs
1247686	**KS33SNH1103**	3.000	1.000	1.620	.187	.620	.500	10	5	10000	SNHX1103T	<2.00
1247688	**KS43SNH1103**	4.000	1.000	1.620	.187	1.120	.500	12	6	8660	SNHX1103T	<2.00
1247691	**KS53SNH1103**	5.000	1.250	1.880	.187	1.500	.500	14	7	7745	SNHX1103T	<2.00
1247694	**KS63SNH1103**	6.000	1.250	1.880	.187	2.000	.500	18	9	7070	SNHX1103T	2.00

Spare Parts

D1	 insert screw	 in. lbs.	 Torx driver
3.000	**192.530**	10	**DT7**
4.000	**192.530**	10	**DT7**
5.000	**192.530**	10	**DT7**
6.000	**192.530**	10	**DT7**

NOTE: Slot width tolerance is +/-.003" over standard insert.
Bottom slot angle is 2°.

Insert Selection Guide

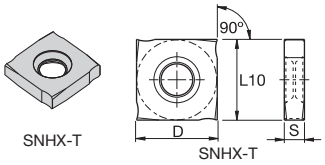
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.T..GP	KCPM40	**.T..GP**	**KCPM40**	..T	KCPM40
P3–P4	.T..GP	KCPK30	**.T..GP**	**KCPM40**	..T	KCPM40
P5–P6	.T..GP	KCPK30	**..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

		K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
P			●		●	●	●
M					●	○	○
K		○	●	●		○	
N		●	○				
S					●		
H							

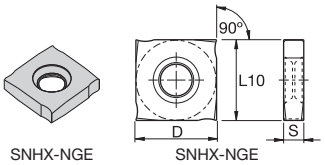


SNHX-T

catalog number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
SNHX1102T	.433	.091	.433	.006	4	–	–	–	●	–	●
SNHX1103T	.433	.106	.433	.006	4	–	–	–	●	●	●
SNHX1203T	.500	.126	.500	.006	4	–	–	–	●	–	●
SNHX1204T	.500	.157	.500	.004	4	–	–	–	●	–	–
SNHX12045T	.500	.177	.500	.004	4	–	–	–	●	–	–
SNHX1205T	.500	.213	.500	.004	4	–	–	–	●	–	–

NOTE: Inch cutter bodies for SNHX12* inserts are available upon request.

- Positive geometry for lighter machining.
- Four cutting edges.



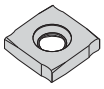
SNHX-NGE

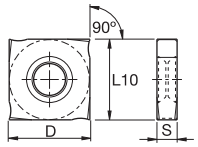
catalog number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
SNHX11T3PZFNGE	.433	.106	.433	.002	4	–	●	–	–	–	–
SNHX1203PZFNGE	.500	.126	.500	.002	4	–	●	–	–	–	–
SNHX12L5PZFNGE	.500	.213	.500	.002	4	●	●	–	–	–	–

NOTE: Inch cutter bodies for SNHX12* inserts are available upon request.

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

catalog number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
SNHX1102PZTNGP	.433	.091	.433	.006	4	●	–	–	●	●	●
SNHX11T3PZTNGP	.433	.106	.433	.006	4	–	–	–	●	–	●
SNHX1203PZTNGP	.500	.126	.500	.006	4	●	–	–	●	●	●
SNHX12L4PZTNGP	.500	.177	.500	.006	4	–	–	–	–	●	–
SNHX12L5PZTNGP	.500	.213	.500	.006	4	●	–	–	●	●	–

NOTE: Inch cutter bodies for SNHX12* inserts are available upon request.

Recommended Starting Feeds [IPT]

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	.005	**.017**	.028	.004	**.012**	.020	.003	**.009**	.015	.002	**.008**	.013	.002	**.007**	.012	.F..GE
.T..GP	.009	**.018**	.027	.007	**.013**	.020	.005	**.010**	.015	.004	**.009**	.013	.004	**.008**	.012	.T..GP
..T	.009	**.022**	.032	.007	**.016**	.023	.005	**.012**	.017	.004	**.010**	.015	.004	**.009**	.014	..T

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

LN Slotting Cutter

Primary Application

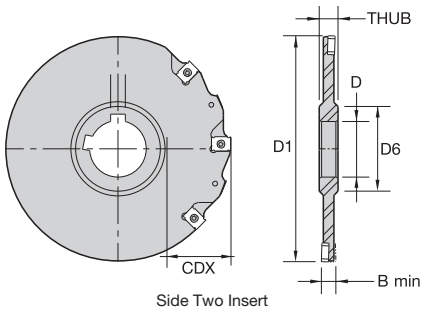
LN slotting cutters offer arbor and shell mill cutter options, groove widths from .250–.539", and cutter diameters from 3–8". Easy to adjust radially in .020" increments.



Features and Benefits

- Cutter available in arbor and shell mounts.
- Groove width .250–.500".
- Groove width can be increased by .020" or .040". Please consult the charts “Technical Information: Possible Insert Combinations”. NOTE: This involves changing the insert and insert screw.
- 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.

- .250–.500" 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: +/- 0,001".



Side Two Insert



LN • Cutting Width .250"



order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	insert 1	lbs
1025930	KS34LNE1240	3.000	1.000	1.500	.250	.594	.500	8	4	9470	MS1281	TT15	35	LNE_1240___	.36
1025931	KS44LNE1240	4.000	1.250	1.880	.250	.904	.500	10	5	8200	MS1281	TT15	35	LNE_1240___	.66
1025895	KS54LNE1240	5.000	1.250	1.880	.250	1.404	.500	12	6	7300	MS1281	TT15	35	LNE_1240___	1.08
1025932	KS64LNE1240	6.000	1.500	2.250	.250	1.747	.500	16	8	6700	MS1281	TT15	35	LNE_1240___	1.54
1025933	KS84LNE1240	8.000	1.500	2.250	.250	2.719	.500	18	9	5800	MS1281	TT15	35	LNE_1240___	2.87

LN • Cutting Width .312"



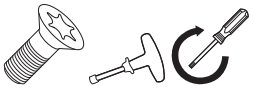
order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	insert 1	lbs
1025964	KS45LNE1245	4.000	1.250	1.880	.312	.935	.500	10	5	7400	MS1282	TT15	35	LNE_1245___	.81
1025896	KS55LNE1245	5.000	1.250	1.880	.312	1.435	.500	12	6	6600	MS1282	TT15	35	LNE_1245___	1.33
1025965	KS65LNE1245	6.000	1.500	2.250	.312	1.750	.500	16	8	6000	MS1282	TT15	35	LNE_1245___	1.93
1025897	KS85LNE1245	8.000	1.500	2.250	.312	2.750	.500	18	9	5200	MS1282	TT15	35	LNE_1245___	3.62

LN • Cutting Width .375"



order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	insert 1	lbs
1025966	KS46LNE1245	4.000	1.250	1.880	.375	.966	.500	9	3	7400	MS1282	TT15	35	LNE_1245___	.96
1025898	KS56LNE1245	5.000	1.250	1.880	.375	1.466	.500	12	4	6600	MS1282	TT15	35	LNE_1245___	1.57
1025967	KS66LNE1245	6.000	1.500	2.250	.375	1.809	.500	15	5	8000	MS1282	TT15	35	LNE_1245___	1.56
1025968	KS86LNE1245	8.000	1.500	2.250	.375	2.781	.500	18	6	5200	MS1282	TT15	35	LNE_1245___	1.56

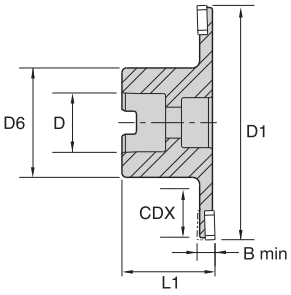
LN • Cutting Width .500"

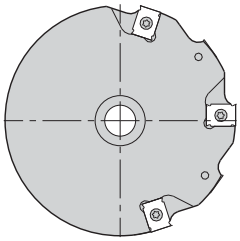


order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	insert 1	lbs
1025969	KS48LNE1255	4.000	1.250	1.880	.500	1.060	.500	9	3	4900	MS1284	TT15	35	LNE_1255___	1.23
1025899	KS58LNE1255	5.000	1.250	1.880	.500	1.560	.500	12	4	4400	MS1284	TT15	35	LNE_1255___	2.07
1025970	KS68LNE1255	6.000	1.500	2.250	.500	1.844	.500	15	5	4000	MS1284	TT15	35	LNE_1255___	3.04
1025971	KS88LNE1255	8.000	1.500	2.250	.500	2.875	.500	18	6	3500	MS1284	TT15	35	LNE_1255___	5.83

NOTE: Slot width tolerance is +/-.003" over standard insert.

- .250–.500" slot width range.
- Easy width adjustment through insert thickness.
- Full side cutting.
- 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: +/- 0,001".







LN • Cutting Width .250"



order number	catalog number	D1	D	D6	B min	CDX	L1	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	flat-head cap screw	socket-head cap screw	insert 1
1067765	**KS254BLNE1240**	2.500	.750	1.580	.250	.560	1.875	6	3	10400	**MS1281**	**TT15**	35	**S1903**	**–**	LNE_1240___
1025861	**KS44BLNE1240**	4.000	1.000	1.880	.250	.940	1.570	10	5	8200	**MS1281**	**TT15**	35	**–**	**S458**	LNE_1240___

LN • Cutting Width .312"



order number	catalog number	D1	D	D6	B min	CDX	L1	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	flat-head cap screw	socket-head cap screw	insert 1
1067766	**KS255BLNE1245**	2.500	.750	1.580	.312	.560	1.875	6	3	9400	**MS1282**	**TT15**	35	**S1903**	**–**	LNE_1245___
1025862	**KS45BLNE1245**	4.000	1.000	1.880	.312	.942	1.570	10	5	7400	**MS1282**	**TT15**	35	**–**	**S458**	LNE_1245___

LN • Cutting Width .375"



order number	catalog number	D1	D	D6	B min	CDX	L1	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	socket-head cap screw	insert 1
1025863	**KS46BLNE1245**	4.000	1.000	1.880	.375	.942	1.570	9	3	7400	**MS1282**	**TT15**	35	**S458**	LNE_1245___

LN • Cutting Width .500"



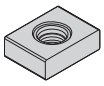
order number	catalog number	D1	D	D6	B min	CDX	L1	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	socket-head cap screw	insert 1
1025894	**KS48BLNE1255**	4.000	1.000	1.880	.500	.940	2.000	9	3	4900	**MS1284**	**TT15**	35	**S458**	LNE_1255___

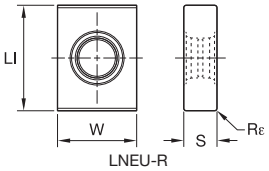
NOTE: Slot width tolerance is +/-.003" over standard insert.

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	**–**	**–**	–	–	–	–

- Light machining.
- Four cutting edges.


LNEU-R



LNEU-R

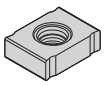
● first choice
○ alternate choice

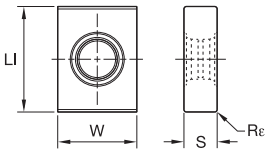
P			●		●	●
M			●		○	○
K	●			●	○	
N						
S			●			
H						

LNEU-R

catalog number	LI	W	S	Rε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40
LNEU1235R03 4	.500	.375	.138	.012	.002	4	●	●	–	–	●
LNEU1240R03 4	.500	.375	.157	.012	.002	4	●	●	–	–	●
LNEU1245R04	.500	.375	.177	.016	.002	4	●	●	–	●	●
LNEU1250R04	.500	.375	.197	.016	.002	4	–	●	–	–	●
LNEU1255R04	.500	.375	.217	.016	.002	4	–	●	–	–	●
LNEU1260R04	.500	.375	.236	.016	.002	4	–	●	–	–	●
LNEU1240R08 4	.500	.375	.157	.031	.002	4	●	●	–	–	●
LNEU1245R08	.500	.375	.177	.031	.002	4	●	●	–	–	●
LNEU1250R08	.500	.375	.197	.031	.002	4	–	●	–	–	●
LNEU1255R08	.500	.375	.217	.031	.002	4	●	●	–	–	●
LNEU1240R16 4	.500	.375	.157	.062	.002	4	–	●	–	–	–
LNEU1245R16	.500	.375	.177	.062	.002	4	●	●	–	–	–
LNEU1255R16	.500	.375	.217	.062	.002	4	–	●	–	–	–
LNEU1245R32	.500	.375	.177	.125	.002	4	●	●	–	–	–
LNEU1255R32	.500	.375	.217	.125	.002	4	–	●	–	–	–

- Medium machining with chip groover.
- Four cutting edges.


LNEU-SGP



LNEU-SGP

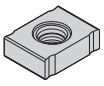
● first choice
○ alternate choice

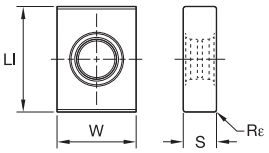
P			●		●	●
M			●		○	○
K		●		●	○	
N						
S			●			
H						

LNEU-SGP

catalog number	LI	W	S	Rε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40
LNEU1235R03SGP 4	.500	.375	.138	.012	.004	4	–	●	–	–	–
LNEU1240R03SGP 4	.500	.375	.157	.012	.004	4	–	●	–	–	–
LNEU1245R04SGP	.500	.375	.177	.016	.004	4	–	●	–	–	–
LNEU1250R04SGP	.500	.375	.197	.016	.004	4	–	●	–	–	–
LNEU1245R08SGP	.500	.375	.177	.031	.004	4	–	●	–	–	●
LNEU1250R08SGP	.500	.375	.197	.031	.004	4	–	●	–	–	–
LNEU1245R16SGP	.500	.375	.177	.063	.004	4	–	●	–	–	–

- Very strong geometry for roughing application.
- Four cutting edges.


LNEQ

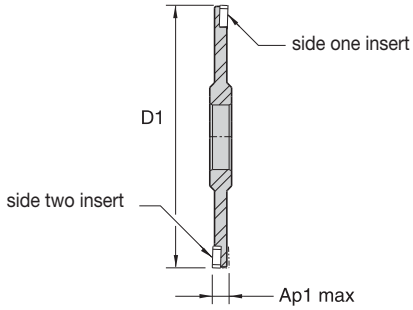


LNEQ

LNEQ

catalog number	LI	W	S	Rε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40
LNEQ1235R03 4	.500	.375	.138	.012	.002	4	–	●	●	–	–
LNEQ1240R03 4	.500	.375	.157	.012	.002	4	–	●	–	●	–
LNEQ1245R04	.500	.375	.177	.016	.002	4	●	●	●	●	–
LNEQ1250R04	.500	.375	.197	.016	.002	4	–	–	●	–	–
LNEQ1255R04	.500	.375	.217	.016	.002	4	–	●	●	–	–
LNEQ1260R04	.500	.375	.236	.016	.002	4	–	●	●	–	●

- Utilizes wider inserts in standard cutter bodies.
- Cutting width of the unique LNE insert style for narrow slotting cutters can be varied by using an insert one size thicker.
- The width can be increased in .020" or .040" increments.
- Refer to the insert combination in the table “LN Slotting Cutter Widths” for insert and screw selection.



LN Slotting Cutter Widths: Adjust Width by Changing Inserts and Screws • Arbor Mount

cutter catalog number	D1	Ap1 max	Ap1 max (new)	side one insert*	screw**	side two insert*	screw**
KS34LNE	3.000	.250	.270	LNE1240	MS-1281	LNE1245	MS-1282
KS44LNE	4.000	.250	.270	LNE1240	MS-1281	LNE1245	MS-1282
KS54LNE	5.000	.250	.289	LNE1245	MS-1282	LNE1245	MS-1282
KS64LNE	6.000	.250	.289	LNE1245	MS-1282	LNE1245	MS-1282
KS84LNE	8.000	.250	.289	LNE1245	MS-1282	LNE1245	MS-1282
KS45LNE	4.000	.312	.332	LNE1245	MS-1282	LNE1250	MS-1283
KS55LNE	5.000	.312	.332	LNE1245	MS-1282	LNE1250	MS-1283
KS65LNE	6.000	.312	.351	LNE1250	MS-1283	LNE1250	MS-1283
KS85LNE	8.000	.312	.351	LNE1250	MS-1283	LNE1250	MS-1283
KS46LNE	4.000	.375	.395	LNE1245	MS-1282	LNE1250	MS-1283
KS56LNE	5.000	.375	.395	LNE1245	MS-1282	LNE1250	MS-1283
KS66LNE	6.000	.375	.414	LNE1250	MS-1283	LNE1250	MS-1283
KS86LNE	8.000	.375	.414	LNE1250	MS-1283	LNE1250	MS-1283
KS48LNE	4.000	.500	.520	LNE1255	MS-1284	LNE1260	MS-1285
KS58LNE	5.000	.500	.520	LNE1255	MS-1284	LNE1260	MS-1285
KS68LNE	6.000	.500	.539	LNE1260	MS-1285	LNE1260	MS-1285
KS88LNE	8.000	.500	.539	LNE1260	MS-1285	LNE1260	MS-1285

Example: Cutting Width of .289"

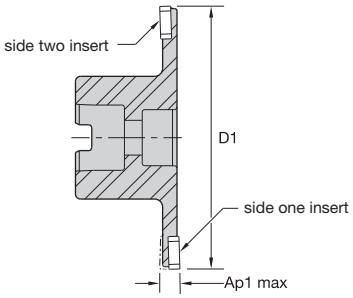
cutter catalog number	D1	Ap1 max (new)	side one insert*	screw**	side two insert*	screw**
KS34LNE	3.000	.289	LNE1245	MS-1282	LNE1245	MS-1282

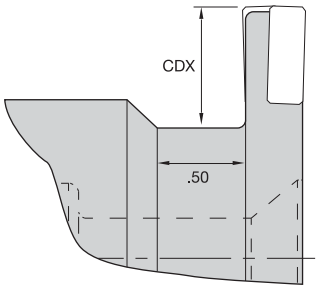
*Caution variation in cutting width range is limited to one size (thickness) greater than the standard insert thickness.

**When changing to wider insert thickness, use the necessary longer screw.

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 that employ a radius of .094" or .125", the corner radius under the insert on the cutter body must be modified to a .10" radius or an optional .10" x 45° chamfer; see chart for detail.

- Utilizes wider inserts in standard cutter bodies.
- Cutting width of the unique LNE insert style for narrow slotting cutters can be varied by using an insert one size thicker.
- The width can be increased in .020" or .040" increments.
- Refer to the insert combination table below for insert selection.





LN Slotting Cutter Widths: Adjust Width by Changing Inserts and Screws • Shell Mill

cutter catalog number	D1	Ap1 max	Ap1 max (new)	side one insert*	screw**	side two insert*	screw**
KS254BLNE1240	2.500	.250	.270	LNE1240	MS-1281	LNE1245	MS-1282
KS44BLNE1240	4.000	.250	.289	LNE1245	MS-1282	LNE1245	MS-1282
KS255BLNE1245	2.500	.312	.332	LNE1245	MS-1282	LNE1250	MS-1283
KS45BLNE1245	4.000	.312	.351	LNE1250	MS-1283	LNE1250	MS-1283
KS46BLNE1245	4.000	.375	.395	LNE1245	MS-1282	LNE1250	MS-1283
KS46BLNE1245	4.000	.375	.414	LNE1250	MS-1283	LNE1250	MS-1283
KS48BLNE1255	4.000	.500	.520	LNE1255	MS-1284	LNE1260	MS-1285
KS48BLNE1255	4.000	.500	.539	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 wider insert thickness, use the necessary longer screw.
NOTE: When using inserts with a radius of .094" or .125", the corner radius under the insert on the cutter body must be modified to a .10" radius or an optional .10" x 45° chamfer.

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

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%			
...	.007	**.019**	.027	.005	**.013**	.020	.004	**.010**	.015	.003	**.009**	.013	.003	**.008**	.012	...
.S..GP	.009	**.020**	.032	.007	**.015**	.023	.005	**.011**	.017	.004	**.010**	.015	.004	**.009**	.014	.S..GP

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

NOVO KNOWS CAD/CAM

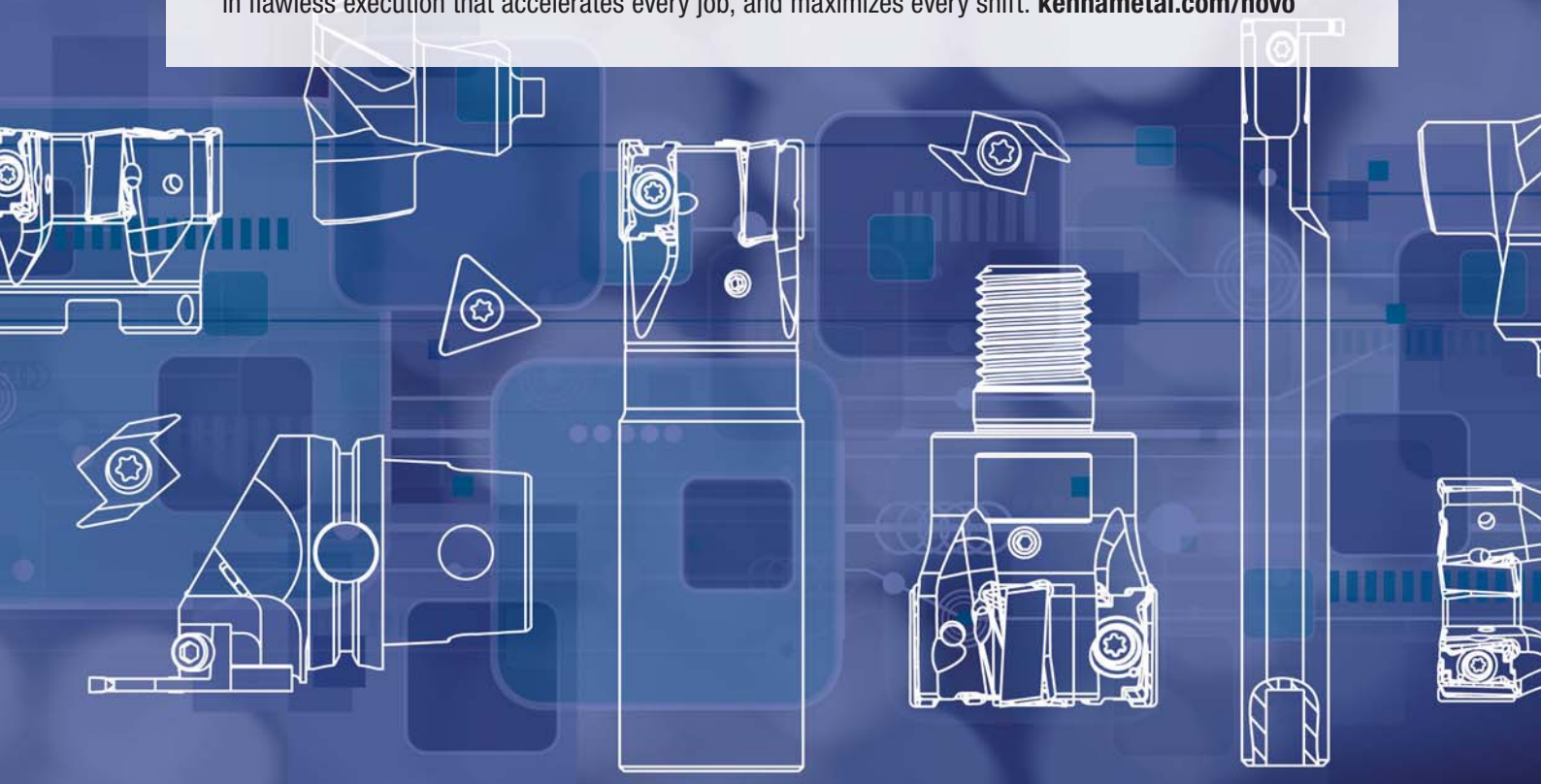
With the addition of NOVO™ applications to your team, your CAD/CAM capabilities become much more accurate, streamlined, and productive.

Before NOVO: The programmer would be in their CAD/CAM software, programming a part. Using the tedious method of finding a tool in a catalog, and then manually inputting the tooling information from the catalog 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 maximizes every shift. **kennametal.com/novo**

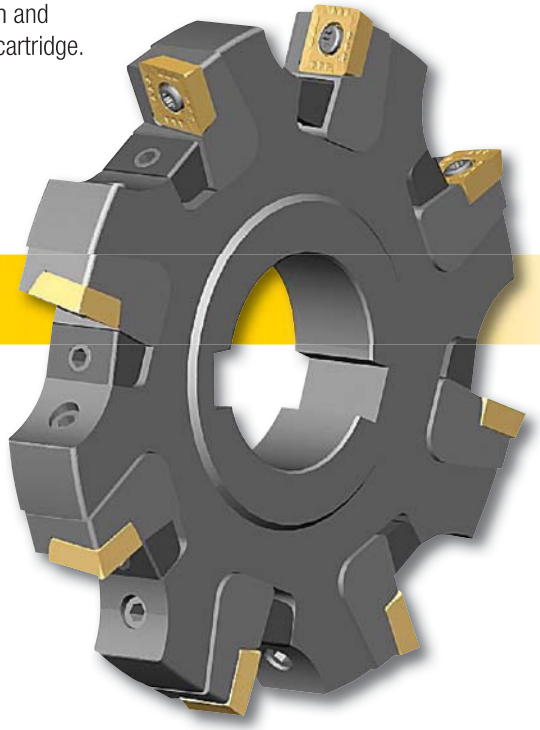


KSSM™ Slotting Cutter

Primary Application

Cutters available in fixed and adjustable groove widths:

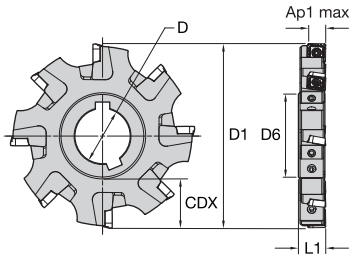
Cutters available in arbor and shell mounts, as well as in fixed and adjustable groove widths, with insert grades and geometries for most materials, KSSM fixed-width slotting cutters are a cost effective solution for the general engineering market. Very precise adjustments to achieve consistent widths 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 arbor and shell mounts, as well as in fixed and adjustable groove widths.
- Maximum groove widths:
  - — Fixed cutters IC 10: .359" and .614".
  - — Fixed cutters 1/2" IC: .461" and .739".
  - — Adjustable cutters IC 10: .551–.709".
  - — Adjustable cutters 1/2" IC: .709–.917".
- 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 4–12".
- Insert corner radii from 0.016–0.125".

- Right-hand and left-hand cutters with .359" width of cut.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Insert radii available.
- Faceted inserts for superior surface finishes.





Arbor Mount • 10mm IC • Right Hand

order number	catalog number	D1	D	D6	B min	CDX	L1	Ap1 max	Z	Z S	max RPM	lbs
3330528	**100G10RP90SP10 ***	3.937	1.260	1.841	.359	1.035	.630	.359	10	10	17200	1.20
2629770	**KSSS400ASP10R625**	4.000	1.250	1.880	—	1.038	.625	.359	10	10	17100	1.22
3330531	**125H11RP90SP10 ***	4.921	1.575	2.156	.359	1.370	.630	.359	11	11	15400	1.89

NOTE: For superior surface finish, use right-hand inserts.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Arbor Mount • 10mm IC • Left Hand

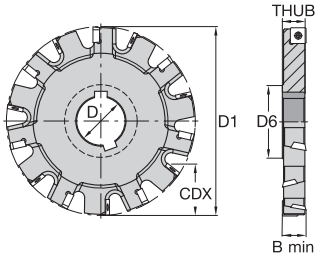
order number	catalog number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	lbs
2629769	**KSSS400ASP10L625**	4.000	1.250	1.880	1.038	.625	.359	10	10	17100	1.22
2629772	**KSSS500ASP10L625 ***	5.000	1.500	2.250	1.353	.625	.359	11	11	15300	1.98

NOTE: For superior surface finish, use left-hand inserts.
Insert radii ≥ .062" (1,6mm) has no facet.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
4.000	**MS2148**	17	**DT9IP**
5.000	**MS2148**	17	**DT9IP**

- Neutral slot width (B min) is .614" + .010".
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide selection of insert radii.
- Faceted inserts for superior surface finishes.





Arbor Mount • 10mm IC • Neutral (Full Slotting)

order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z S	max RPM	lbs
2629768	**KSSS400ASP10N625**	4.000	1.250	1.880	.614	1.042	.542	10	5	17100	1.05
2629794	**KSSS500ASP10N625**	5.000	1.500	2.250	.614	1.357	.542	12	6	15300	1.75
2629774	**KSSS600ASP10N625**	6.000	1.500	2.250	.614	1.857	.542	12	6	14000	2.78

NOTE: For superior surface finish, use right- and left-hand inserts.
Insert radii ≥.062" (1,6mm) has no facet.

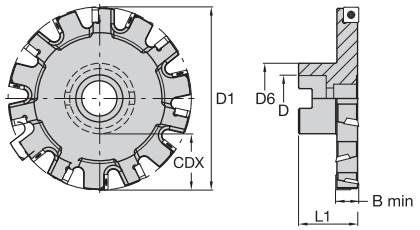
Spare Parts





D1	insert screw	in. lbs.	Torx Plus driver
4.000	**MS2148**	17	**DT9IP**
5.000	**MS2148**	17	**DT9IP**
6.000	**MS2148**	17	**DT9IP**

- Neutral slot width (B min) is .614" + .010".
- Neutral cutting.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide selection of insert radii.
- Faceted inserts for superior surface finishes.





Shell Mount • 10mm IC • Neutral (Full Slotting)

order number	catalog number	D1	D	D6	B min	CDX	L1	Z	Z S	max RPM	lbs
2629780	**KSSS400BSP10N625**	4.000	1.000	2.132	.614	.887	1.500	10	5	17100	2.12
2629781	**KSSS500BSP10N625**	5.000	1.250	2.880	.614	.995	1.750	12	6	15300	3.89
2629783	**KSSS800BSP10N625**	8.000	1.500	3.810	.614	2.030	2.000	14	7	12100	8.80

NOTE: For superior surface finish, use right- and left-hand inserts.
Insert radii ≥.062" (1,6mm) has no facet.

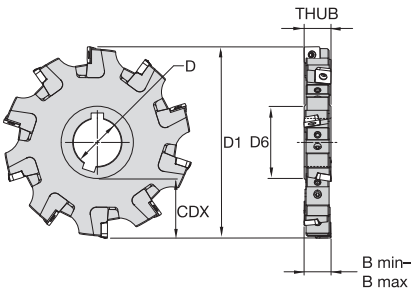
Spare Parts






D1	insert screw	in. lbs.	Torx Plus driver	socket-head cap screw
4.000	**MS2148**	17	**DT9IP**	**S2044**
5.000	**MS2148**	17	**DT9IP**	**S467**
8.000	**MS2148**	17	**DT9IP**	**–**

- 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.
- Large selection of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.

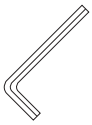




Arbor Mount • Slotting Cutter • .551–.630" Adjustment Range

order number	catalog number	D1	D	D6	B min	B max	CDX	L1	THUB	Z	Z S	max RPM	lbs
2268052	**KSSS400ASP10N551-630**	4.000	1.250	1.880	.551	.630	1.030	.548	.545	6	3	17100	1.17
2268640	**KSSS600ASP10N551-630**	6.000	1.500	2.250	.551	.630	1.845	.548	.545	10	5	14000	2.97
2268652	**KSSS800ASP10N551-630**	8.000	2.000	2.880	.551	.630	2.530	.548	.545	14	7	12100	5.53

Spare Parts

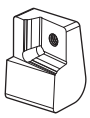
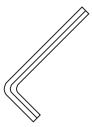
D1	 cartridge right-hand	 cartridge left-hand	 wedge	 cam pin wrench	 insert screw	 in. lbs.	 Torx Plus wrench	 cam pin	 wedge wrench	 wedge screw
4.000	**KSSC551-630R**	**KSSC551-630L**	**KSSW551-630**	**MW25**	**MS2148**	17	**TTP9**	**KSSCP551-709**	**THW3M**	**STCM32**
6.000	**KSSC551-630R**	**KSSC551-630L**	**KSSW551-630**	**MW25**	**MS2148**	17	**TTP9**	**KSSCP551-709**	**THW3M**	**STCM11**
8.000	**KSSC551-630R**	**KSSC551-630L**	**KSSW551-630**	**MW25**	**MS2148**	17	**TTP9**	**KSSCP551-709**	**THW3M**	**STCM11**

Arbor Mount • Slotting Cutter • .630–.709" Adjustment Range

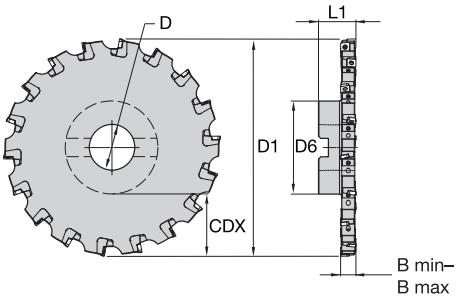
order number	catalog number	D1	D	D6	B min	B max	CDX	L1	THUB	Z	Z S	max RPM	lbs
2268634	**KSSS500ASP10N630-709 ***	5.000	1.500	2.250	.630	.709	1.345	.627	.624	8	4	15300	2.27
2268670	**KSSS1200ASP10N630-709 ***	12.000	2.000	2.880	.630	.709	4.530	.627	.624	20	10	9900	15.96

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

Spare Parts

D1	 cartridge right-hand	 cartridge left-hand	 wedge	 cam pin wrench	 insert screw	 in. lbs.	 Torx Plus wrench	 cam pin	 wedge wrench	 wedge screw
12.000	**KSSC630-709R**	**KSSC630-709L**	**KSSW630-709**	**MW25**	**MS2148**	17	**TTP9**	**KSSCP551-709**	**THW3M**	**STCM11**
5.000	**KSSC630-709R**	**KSSC630-709L**	**KSSW630-709**	**MW25**	**MS2148**	17	**TTP9**	**KSSCP551-709**	**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.
- Large selection of insert radii.
- Wiper insert facets for superior surface finishes.





Shell Mount • Slotting Cutting • .551–.630" Adjustment Range

order number	catalog number	D1	D	D6	B min	B max	CDX	L1	Z	Z S	max RPM	lbs
2268625	KSSS400BSP10N551-630	4.000	1.000	2.132	.551	.630	.872	2.072	6	3	17100	2.49

Spare Parts

D1	cartridge right-hand	cartridge left-hand	wedge	cam pin wrench	insert screw	in. lbs.	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
4.000	KSSC551-630R	KSSC551-630L	KSSW551-630	MW25	MS2148	17	TTP9	KSSCP551-709	THW3M	STCM11	S458

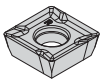
Insert Selection Guide

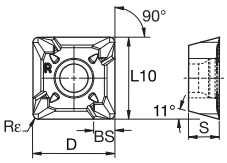
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD2	KCPM40	**.E..GB2**	**KCPM40**	.S..GB2	KCPK30
P3–P4	.E..LD2	KCPM40	**.E..GB2**	**KCPK30**	.S..GB2	KCPK30
P5–P6	.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

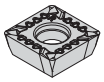
catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
SPCT31251PPEL8LD2	.394	.156	.394	.106	.016	.002	4	–	–	●	–	–	–	–	–
SPCT31251PPER8LD2	.394	.156	.394	.106	.016	.002	4	–	–	●	–	–	–	–	–
SPCT3125PPEL8LD2	.394	.156	.394	.106	.031	.002	4	–	–	●	–	–	–	–	–
SPCT3125PPER8LD2	.394	.156	.394	.106	.031	.002	4	–	●	●	–	–	●	–	–
SPCT31253PPEL8LD2	.394	.156	.394	.106	.047	.002	4	–	–	●	–	–	–	–	–
SPCT31253PPER8LD2	.394	.156	.394	.106	.047	.002	4	–	–	●	–	–	–	–	–
SPCT31254ENLD2	.394	.156	.394	–	.063	.002	4	–	–	●	–	–	–	●	–
SPCT31255ENLD2	.394	.156	.394	–	.078	.002	4	–	–	●	–	–	–	–	–

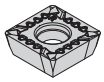
- Light-duty Insert.
- Four cutting edges.

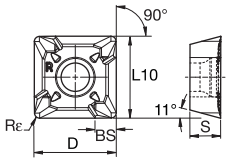
SPCT-LE

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
SPCT31251PPFL8LE	.394	.156	.394	.106	.016	.001	4	●	–	–	–	–	–	–	–
SPCT31251PPFR8LE	.394	.156	.394	.106	.016	.001	4	●	–	–	–	–	–	–	–
SPCT3125PPFL8LE	.394	.156	.394	.106	.031	.001	4	●	–	–	–	–	–	–	–
SPCT3125PPFR8LE	.394	.156	.394	.106	.031	.001	4	●	–	–	–	–	–	–	–
SPCT31253PPFR8LE	.394	.156	.394	.106	.047	.001	4	●	–	–	–	–	–	–	–
SPCT31255FNLE	.394	.156	.394	–	.078	.001	4	●	–	–	–	–	–	–	–

- Light-duty Insert.
- 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

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
SPET31251PPEL8GB2	.394	.156	.394	.106	.016	.003	4	–	–	●	●	●	–	–	–
SPET31251PPER8GB2	.394	.156	.394	.106	.016	.003	4	–	–	●	●	●	–	–	–
SPET3125PPEL8GB2	.394	.156	.394	.106	.031	.003	4	–	●	●	●	●	–	–	–
SPET3125PPER8GB2	.394	.156	.394	.106	.031	.003	4	–	●	●	●	●	●	–	–
SPET3125PPSL8GB2	.394	.156	.394	.106	.031	.005	4	–	–	●	–	●	–	–	–
SPET3125PPSR8GB2	.394	.156	.394	.106	.031	.005	4	–	●	●	●	●	–	–	–

SPPT-GB2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
SPPT3125PPER8GB2	.394	.156	.394	.106	.031	.003	4	–	–	–	●	●	–	–	–
SPPT3125PPSR8GB2	.394	.156	.394	.106	.031	.005	4	–	–	–	●	●	–	–	●

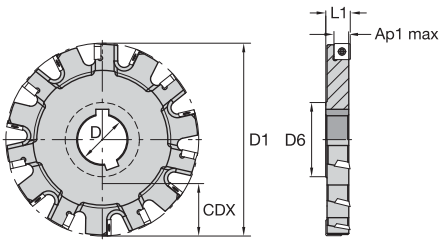
Recommended Starting Feeds [IPT]

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	.005	**.017**	.028	.003	**.012**	.020	.003	**.009**	.015	.002	**.008**	.013	.002	**.007**	.012	.F..LE
.F..LD	.005	**.017**	.028	.003	**.012**	.020	.003	**.009**	.015	.002	**.008**	.013	.002	**.007**	.012	.F..LD
.E..LD2	.005	**.018**	.032	.004	**.013**	.023	.003	**.010**	.017	.002	**.009**	.015	.002	**.008**	.014	.E..LD2
.E..LD	.007	**.019**	.032	.005	**.013**	.023	.004	**.010**	.017	.003	**.009**	.015	.003	**.008**	.014	.E..LD
.E..GB2	.009	**.021**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.010**	.016	.004	**.009**	.015	.E..GB2
.S..GB	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GB
.S..GB2	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GB2
.S..GN	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.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 available.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Large selection of insert radii.
- Faceted inserts for superior surface finishes.





Arbor Mount • 1/2" IC • Right Hand

order number	catalog number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	lbs
2618969	**KSSS600ASD43R750**	6.000	1.500	2.250	1.851	.750	.461	12	12	9400	3.73
2629787	**KSSS800ASD43R750**	8.000	2.000	2.880	2.536	.750	.461	14	14	8150	6.86
2629790	**KSSS1000ASD43R750 ***	10.000	2.000	2.880	3.536	.750	.461	16	16	7250	11.44

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

Arbor Mount • 1/2" IC • Left Hand

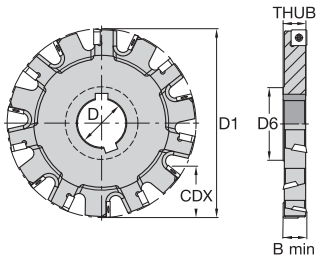
order number	catalog number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	lbs
2629784	**KSSS600ASD43L750**	6.000	1.500	2.250	1.851	.750	.461	12	12	9400	3.73
2629786	**KSSS800ASD43L750**	8.000	2.000	2.880	2.536	.750	.461	14	14	8150	6.86

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
6.000	**MS2078**	35	**DT15IP**
8.000	**MS2078**	35	**DT15IP**
10.000	**MS2078**	35	**DT15IP**

NOTE: For superior surface finish, use right- and left-hand inserts.

- Neutral slot width (B min) is .739" + .010" wide.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Large selection of insert radii.
- Faceted inserts for superior surface finishes.





Arbor Mount • 1/2" IC • Neutral (Full Slotting)

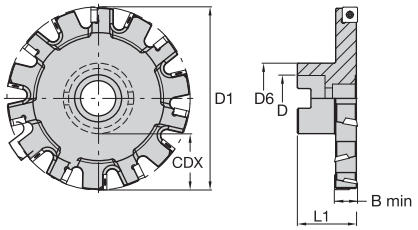
order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z S	max RPM	lbs
2618967	**KSSS600ASD43N750**	6.000	1.500	2.250	.744	1.857	.666	14	7	9400	3.49
2629785	**KSSS800ASD43N750**	8.000	2.000	2.880	.739	2.542	.666	18	9	8150	6.58
2629788	**KSSS1000ASD43N750**	10.000	2.000	2.880	.739	3.542	.666	22	11	7250	11.02

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
6.000	**MS2078**	35	**DT15IP**
8.000	**MS2078**	35	**DT15IP**
10.000	**MS2078**	35	**DT15IP**

NOTE: For superior surface finish, use right-hand and left-hand inserts.

- Neutral slot width (B min) is .739" + .010" wide.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Large selection of insert radii.
- Faceted inserts for superior surface finishes.





Shell Mount • 1/2" IC • Neutral (Full Slotting)

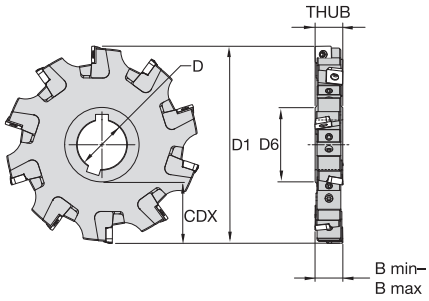
order number	catalog number	D1	D	D6	B min	CDX	L1	Z	Z S	max RPM	lbs
2629791	**KSSS600BSD43N750**	6.000	1.500	3.810	.739	1.029	2.000	14	7	9400	6.28
2629792	**KSSS800BSD43N750**	8.000	1.500	3.810	.739	2.029	2.000	18	9	8150	9.90

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
6.000	**MS2078**	35	**DT15IP**
8.000	**MS2078**	35	**DT15IP**

NOTE: For superior surface finish, use right-hand and left-hand inserts.

- 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.
- Large selection of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.





Arbor Mount • Slotting Cutter • .709–.813" Adjustment Range

order number	catalog number	D1	D	D6	B min	B max	CDX	THUB	Z	Z S	max RPM	lbs
2268676	KSSS500ASD43N709-813	5.000	1.500	2.250	.709	.813	1.331	.716	8	4	10300	2.33
2268688	KSSS600ASD43N709-813 *	6.000	1.500	2.250	.709	.813	1.831	.716	10	5	9400	3.62
2268712	KSSS1000ASD43N709-813	10.000	2.000	2.880	.709	.813	3.516	.716	16	8	7250	11.51
2268724	KSSS1200ASD43N709-813	12.000	2.000	2.880	.709	.813	4.516	.716	18	9	6650	17.30

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

Spare Parts

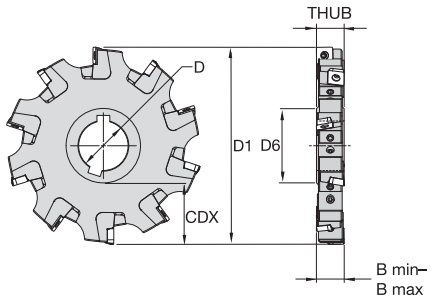
D1	cartridge right-hand	cartridge left-hand	wedge	cam pin wrench	insert screw	in. lbs.	Torx Plus wrench	cam pin	wedge wrench	wedge screw
5.000	KSSC709-813R	KSSC709-813L	KSSW709-813	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	STCM11
6.000	KSSC709-813R	KSSC709-813L	KSSW709-813	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	STCM11
10.000	KSSC709-813R	KSSC709-813L	KSSW709-813	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	STCM11
12.000	KSSC709-813R	KSSC709-813L	KSSW709-813	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	STCM11

Cartridges • Larger Insert Radii

order number	catalog number
3663324	KSSC709813RX
3663325	KSSC709813LX

NOTE: Use left- or right-hand cartridges for neutral cutters. Fits all larger radii inserts.

- 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.
- Large selection of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.





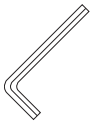
Arbor Mount • Slotting Cutter • .813–.917" Adjustment Range

order number	catalog number	D1	D	D6	B min	B max	CDX	THUB	Z	Z S	max RPM	lbs
2268694	**KSSS600ASD43N813-917**	6.000	1.500	2.250	.813	.917	1.831	.820	10	5	9400	4.23
2268706	**KSSS800ASD43N813-917 ***	8.000	2.000	2.880	.813	.917	2.516	.820	14	7	8150	7.99
2268730	**KSSS1200ASD43N813-917 ***	12.000	2.000	2.880	.813	.917	4.516	.820	18	9	6650	20.20

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

Spare Parts









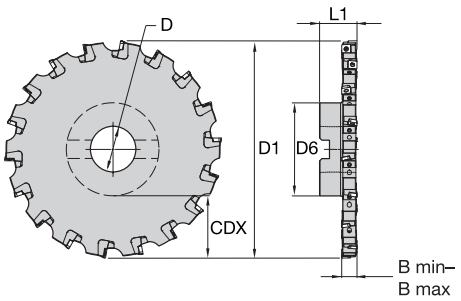
D1	cartridge right-hand	cartridge left-hand	wedge	cam pin wrench	insert screw	in. lbs.	Torx Plus wrench	cam pin	wedge wrench	wedge screw
6.000	**KSSC813-917R**	**KSSC813-917L**	**KSSW813-917**	**MW3**	**MS2077**	35	**TTP15**	**KSSCP709-917**	**THW3M**	**STCM11**
8.000	**KSSC813-917R**	**KSSC813-917L**	**KSSW813-917**	**MW3**	**MS2077**	35	**TTP15**	**KSSCP709-917**	**THW3M**	**STCM11**
12.000	**KSSC813-917R**	**KSSC813-917L**	**KSSW813-917**	**MW3**	**MS2077**	35	**TTP15**	**KSSCP709-917**	**THW3M**	**STCM11**

Cartridges • Larger Insert Radii

order number	catalog number
3663326	**KSSC813917RX**
3663327	**KSSC813917LX**

NOTE: Use left- or right-hand cartridges for neutral cutters. Fits all larger radii inserts.

- 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.
- Large selection of insert radii.
- Wiper insert facets for superior surface finishes.

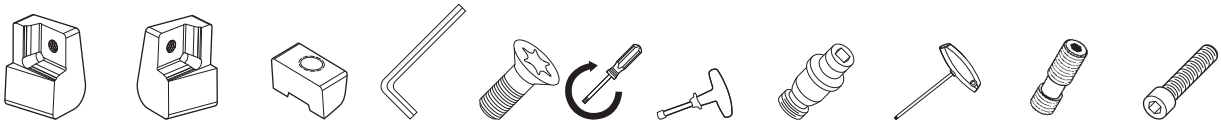




Shell Mount • Slotting Cutting • .709–.813" Adjustment Range

order number	catalog number	D1	D	D6	B min	B max	CDX	L1	Z	Z S	max RPM	lbs
2268679	**KSSS500BSD43N709-813**	5.000	1.250	2.880	.709	.813	.997	2.093	8	4	10300	4.55
2268727	**KSSS1200BSD43N709-813**	12.000	2.500	5.250	.709	.813	3.312	2.093	18	9	6650	19.83

Spare Parts



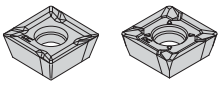
D1	cartridge right-hand	cartridge left-hand	wedge	cam pin wrench	insert screw	in. lbs.	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
5.000	**KSSC709-813R**	**KSSC709-813L**	**KSSW709-813**	**MW3**	**MS2077**	35	**TTP15**	**KSSCP709-917**	**THW3M**	**KSSW709-813**	**S467**
12.000	**KSSC709-813R**	**KSSC709-813L**	**KSSW709-813**	**MW3**	**MS2077**	35	**TTP15**	**KSSCP709-917**	**THW3M**	**KSSW709-813**	**—**

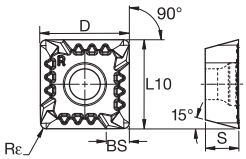
Insert Selection Guide

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-LD2



SDCT-LE
SDCT-LD2

● first choice
○ alternate choice

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

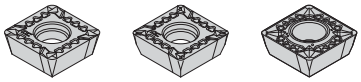
SDCT-LE (Ground) 20° Rake Face

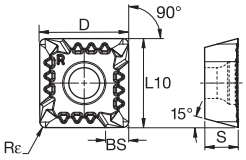
catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDCT431PDFL8LE	.500	.188	.500	.106	.016	.001	4	●	–	–	–	–	–	–	–	–
SDCT431PDFR8LE	.500	.188	.500	.106	.016	.001	4	●	–	–	–	–	–	–	–	–
SDCT43PDFL8LE	.500	.188	.500	.106	.031	.001	4	●	–	–	–	–	–	–	–	–
SDCT43PDFR8LE	.500	.188	.500	.106	.031	.001	4	●	–	–	–	–	–	–	–	–
SDCT433PDFL8LE	.500	.188	.500	.106	.047	.001	4	●	–	–	–	–	–	–	–	–
SDCT433PDFR8LE	.500	.188	.500	.106	.047	.001	4	●	–	–	–	–	–	–	–	–
SDCT434FNLE	.500	.188	.500	–	.063	.001	4	●	–	–	–	–	–	–	–	–
SDCT435FNLE	.500	.188	.500	–	.078	.001	4	●	–	–	–	–	–	–	–	–
SDCT436FNLE	.500	.188	.500	–	.094	.001	4	●	–	–	–	–	–	–	–	–
SDCT438FNLE	.500	.188	.500	–	.125	.001	4	●	–	–	–	–	–	–	–	–

SDCT-LD2 (Ground) 15° Rake Face

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDCT431PDEL8LD2	.500	.188	.500	.106	.016	.002	4	–	–	–	●	–	–	–	–	–
SDCT431PDER8LD2	.500	.188	.500	.115	.016	.002	4	–	–	–	●	–	–	–	–	–
SDCT43PDEL8LD2	.500	.188	.500	.130	.031	.002	4	–	–	–	●	–	–	–	–	–
SDCT43PDER8LD2	.500	.188	.500	.130	.031	.002	4	–	●	–	●	–	–	●	–	●
SDCT433PDEL8LD2	.500	.188	.500	.120	.047	.002	4	–	–	–	●	–	–	–	–	–
SDCT433PDER8LD2	.500	.188	.500	.120	.047	.002	4	–	–	–	●	–	–	–	–	–
SDCT434ENLD2	.500	.188	.500	–	.063	.002	4	–	–	–	●	–	–	–	–	●
SDCT435ENLD2	.500	.188	.500	–	.078	.002	4	–	–	–	●	–	–	–	–	–
SDCT436ENLD2	.500	.188	.500	–	.094	.002	4	–	–	–	●	–	–	–	–	–
SDCT438ENLD2	.500	.188	.500	–	.125	.002	4	–	–	●	●	–	–	–	–	–
SDCT4316ENLD2	.500	.188	.500	–	.250	.002	2	–	–	–	●	–	–	–	–	●

- Heavy machining.
- Four cutting edges.


SDET-GB2 SDPT-GB2 SDET-GB



SDET-GB2
SDPT-GB2
SDET-GB

● first choice
○ alternate choice

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

SDET-GB (Ground) 5° Rake Face

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDET43PDER8GB	.500	.188	.500	.101	.031	.003	4	–	●	–	–	–	–	–	–	●
SDET43PDSR8GB	.500	.188	.500	.101	.031	.006	4	–	–	–	●	–	●	●	●	●
SDET433PDER8GB	.500	.188	.500	.086	.047	.003	4	–	–	–	●	–	–	●	–	●
SDET433PDSR8GB	.500	.188	.500	.085	.047	.006	4	–	–	–	●	–	–	–	–	●
SDET434ENGB	.500	.188	.500	–	.062	.003	4	–	–	–	–	–	–	–	–	●
SDET434SNGB	.500	.188	.500	–	.062	.006	4	–	–	–	●	–	–	–	–	●
SDET436ENGB	.500	.188	.500	–	.094	.003	4	–	–	–	●	–	–	–	–	●
SDET436SNGB	.500	.188	.500	–	.094	.006	4	–	–	–	●	–	–	–	–	●
SDET438ENGB	.500	.188	.500	–	.125	.003	4	–	–	–	●	–	–	–	–	●
SDET438SNGB	.500	.188	.500	–	.125	.006	4	–	–	–	–	–	–	–	–	●
SDET4312ENGB	.500	.188	.500	–	.188	.003	2	–	–	–	●	–	–	–	–	●
SDET4312SNGB	.500	.188	.500	–	.188	.006	2	–	–	–	●	–	–	–	–	●
SDET4316SNGB	.500	.188	.500	–	.250	.006	2	–	–	–	●	–	●	–	●	●
SDET4316ENGB	.500	.188	.500	–	.250	.003	2	–	–	–	●	–	–	–	–	●

SDET-GB2 (Ground) 5° Rake Face

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDET43PDEL8GB2	.500	.188	.500	.130	.031	.003	4	–	●	–	●	●	●	–	–	–
SDET43PDER8GB2	.500	.188	.500	.130	.031	.003	4	–	●	–	●	●	●	●	–	●
SDET43PDSL8GB2	.500	.188	.500	.130	.031	.005	4	–	–	–	●	–	●	–	–	–
SDET43PDSR8GB2	.500	.188	.500	.130	.031	.005	4	–	●	–	●	●	●	●	–	–
SDET433PDEL8GB2	.500	.188	.500	.120	.047	.003	4	–	●	–	●	●	–	–	–	–
SDET433PDER8GB2	.500	.188	.500	.120	.047	.003	4	–	●	–	●	●	●	●	–	–
SDET434SNGB2	.500	.188	.500	–	.063	.005	4	–	●	–	●	●	●	–	–	–
SDET435SNGB2	.500	.188	.500	–	.078	.005	4	–	●	–	●	●	●	●	–	–
SDET436SNGB2	.500	.188	.500	–	.094	.005	4	–	–	–	●	●	●	–	–	–
SDET438XENGB2	.500	.188	.500	–	.125	.003	2	–	–	–	●	–	–	–	–	–
SDET438SNGB2	.500	.188	.500	–	.125	.005	4	–	●	–	●	●	●	–	–	–
SDET4316SNGB2	.500	.188	.500	–	.250	.005	2	–	–	–	–	–	●	–	–	–

SDPT-GB2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDPT43PDER8GB2	.500	.188	.500	.106	.031	.003	4	–	–	–	●	●	●	●	–	●
SDPT43PDSR8GB2	.500	.188	.500	.106	.031	.005	4	–	–	–	●	●	●	●	–	●

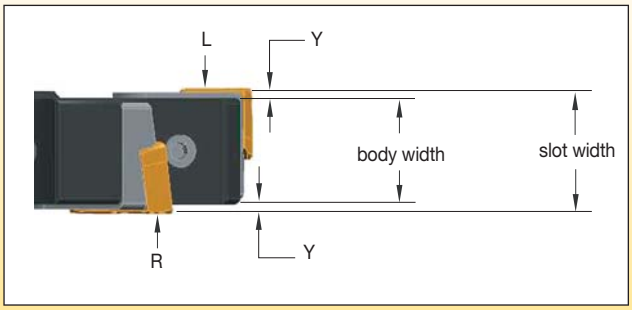
Recommended Starting Feeds [IPT]

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	.005	**.017**	.030	.003	**.012**	.021	.003	**.009**	.016	.002	**.008**	.014	.002	**.007**	.013	.F..LE
.E..LD	.007	**.019**	.032	.005	**.013**	.023	.004	**.010**	.017	.003	**.009**	.015	.003	**.008**	.014	.E..LD
.E..LD2	.005	**.018**	.032	.004	**.013**	.023	.003	**.010**	.017	.002	**.009**	.015	.002	**.008**	.014	.E..LD2
.E..GB	.009	**.021**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.010**	.016	.004	**.009**	.015	.E..GB
.E..GB2	.009	**.021**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.010**	.016	.004	**.009**	.015	.E..GB2
.S..GB	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GB
.S..GB2	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GB2
.S..GN	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..GN

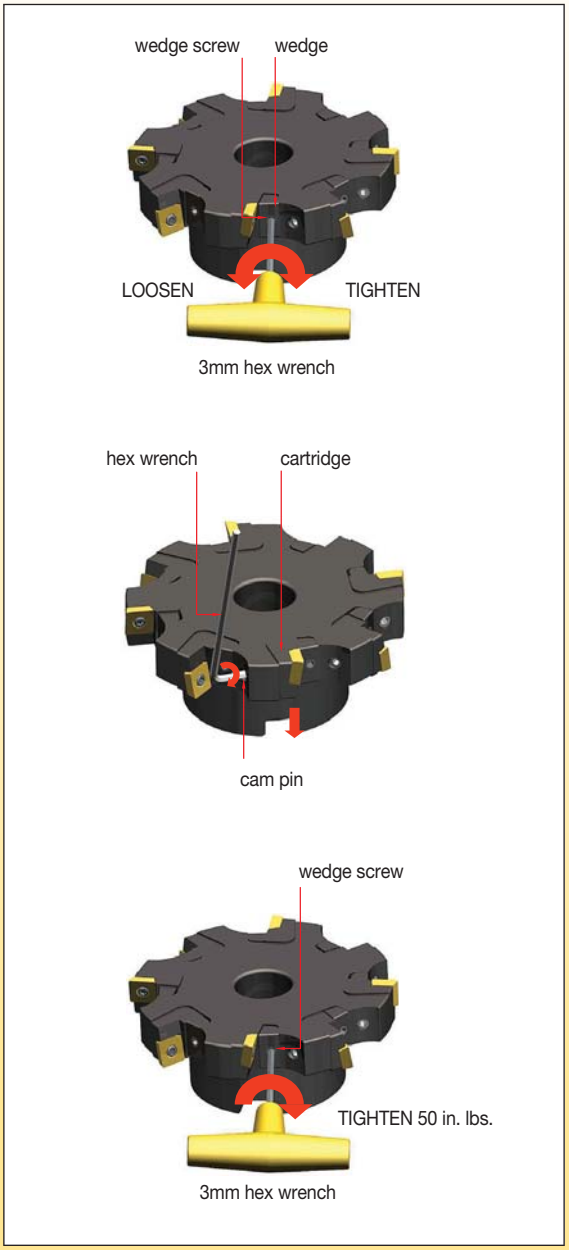
NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

KSSM Slot Width Adjustment Instructions

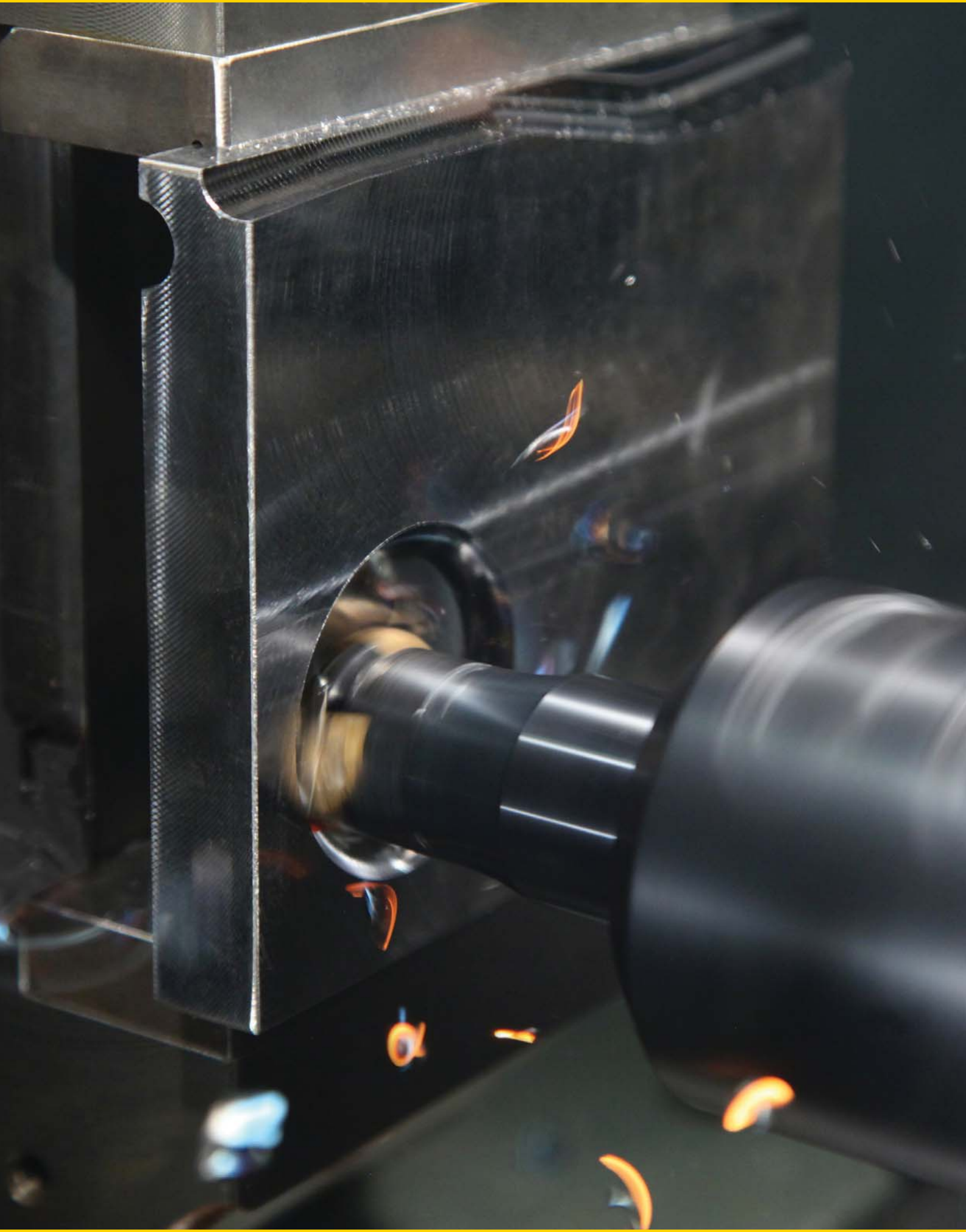


1. Measure body width at pocket 1 (per stamp on tool body) behind cartridge.
2. Zero tool presetter at pocket 1 behind cartridge.
3. Move presetter over the insert and set distance Y. Y= (Desired Slot Width-Body Width)/2
4. Zero over insert at starting pocket (pocket 1).
5. Adjust remaining cartridges 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 counter-clockwise to loosen wedge.
3. Rotate 3mm hex wrench clockwise to lightly tighten STCM screw to approximately 9 in. lbs., so the wedge is touching the cartridge and cutter body. 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 55 in. lbs. 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–V32

KenFeed 2X • Double-Sided High-Feed Milling Cutters V34–V41

Rodeka • Double-Sided Round Inserts V42–V64

Rodeka 10 ..... V44–V50

Rodeka 12 ..... V51–V57

Rodeka 16 ..... V58–V60

Rodeka 12X V61–V64

KSRM • Round Inserts, Specially Developed for Titanium and Stainless Steel V66–V94

Stellram 7713VR • Round Inserts V96–V108

Stellram 7713VR10 ..... V97–V101

Stellram 7713VR12 ..... V102–V108

Stellram 5505VX V110–V118

KDMB and KDMT V120–V137

Z-Axis V138–V145

KCRA • Double-Sided Ceramic Round Inserts V146–V152

KIPR V154–V159

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 aluminum 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 <0.020 in/z.



7792VXP06:
Maximum ap = 0.035"
Diameter Range = 0.625–1.250"

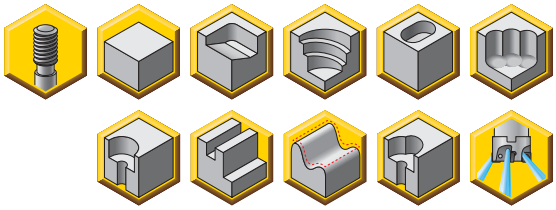
7792VXD09:
Maximum ap = 0.059"
Diameter Range = 1.000–2.000"

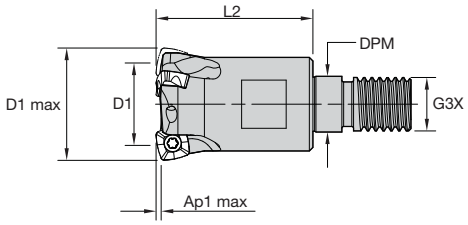
7792VXD12:
Maximum ap = 0.098"
Diameter Range = 1.250–6.300"

7792VXE16:
Maximum ap = 0.138"
Diameter Range = 2.000–6.000"

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

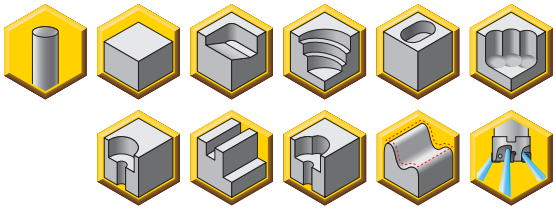
order number	catalog number	D1 max	D1	L2	G3X	DPM	Ap1 max	Z U
5661213	A7792VXP06SA.625Z2R1	.625	.255	1.000	M8	.335	.035	2
5660060	A7792VXP06SA.75Z2R1.4	.750	.380	1.377	M10	.413	.035	2
5661214	A7792VXP06SA.75Z3R1.4	.750	.380	1.377	M10	.413	.035	3
5667958	A7792VXP06SA1.0Z3R1.4	1.000	.630	1.377	M12	.492	.035	3
5661215	A7792VXP06SA1.0Z4R1.4	1.000	.630	1.377	M12	.492	.035	4
5681114	A7792VXP06SA1.25Z5R2	1.250	.880	1.693	M16	.669	.035	5

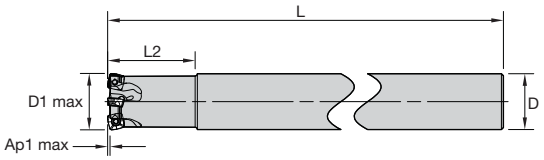
Spare Parts

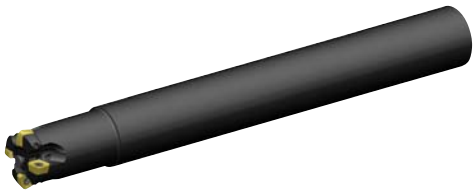
catalog number	insert screw	in. lbs.	Torx driver
A7792VXP06SA.625Z2R1	FP2506T	7.1	TP7
A7792VXP06SA.75Z2R1.4	FP2506T	7.1	TP7
A7792VXP06SA.75Z3R1.4	FP2506T	7.1	TP7
A7792VXP06SA1.0Z3R1.4	FP2507T	7.1	TP7
A7792VXP06SA1.0Z4R1.4	FP2507T	7.1	TP7
A7792VXP06SA1.25Z5R2	FP2507T	7.1	TP7

NOTE: For further application recommendation, please see technical information on pages V30–V32.

- 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	catalog number	D1 max	D	L	L2	Ap1 max	Z U
5667588	C7792VXP06CA.62Z2R5.5	.625	.625	7.402	.980	.035	2
5658507	C7792VXP06CA.75Z3R6.1	.750	.750	7.874	1.259	.035	3
5661212	C7792VXP06CA1.0Z4R6.1	1.000	1.000	8.344	1.575	.035	4
5681117	C7792VXP06CA1.25Z5R8	1.250	1.250	9.761	1.575	.035	5

Spare Parts

catalog number	insert screw	in. lbs.	Torx driver
C7792VXP06CA.62Z2R5.5	FP2506T	7.1	TP7
C7792VXP06CA.75Z3R6.1	FP2506T	7.1	TP7
C7792VXP06CA1.0Z4R6.1	FP2507T	7.1	TP7
C7792VXP06CA1.25Z5R8	FP2507T	7.1	TP7

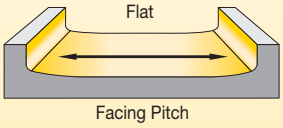
NOTE: For further application recommendation, please see technical information on pages V30–V32.

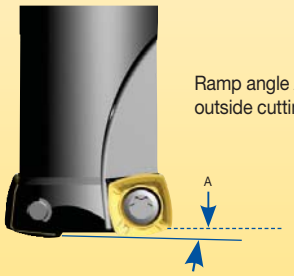
Technical Information (in)

		dimension						
order number	catalog number	facing pitch	ramping angle	helical hole min–max		ap max helical/ linear	a_e max plunging	max RPM
5667588	C7792VXP06CA.62Z2R5.5	6.090	8.20	0.850	1.170	0.024	0.118	65,000
5658507	C7792VXP06CA.75Z3R6.1	3.860	6.74	1.100	1.420	0.024	0.118	57,000
5661212	C7792VXP06CA1.0Z4R6.1	2.110	4.34	1.600	1.920	0.024	0.118	49,000
5681117	C7792VXP06CA1.25Z5R8	1.430	2.69	2.100	2.420	0.024	0.118	41,500
5661213	A7792VXP06SA.625Z2R1	6.090	8.20	0.850	1.170	0.024	0.118	65,000
5660060	A7792VXP06SA.75Z2R1.4	3.860	6.74	1.100	1.420	0.024	0.118	57,000
5661214	A7792VXP06SA.75Z3R1.4	3.860	6.74	1.100	1.420	0.024	0.118	57,000
5667958	A7792VXP06SA1.0Z3R1.4	2.110	4.34	1.600	1.920	0.024	0.118	49,000
5661215	A7792VXP06SA1.0Z4R1.4	2.110	4.34	1.600	1.920	0.024	0.118	49,000
5681114	A7792VXP06SA1.25Z5R2	1.430	2.69	2.100	2.420	0.024	0.118	41,500


Helical Interpolation


Plunging





Ramp angle A uses one outside cutting edge only.

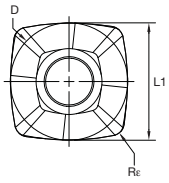
A = max ramp angle utilizing full-face contact.

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


XPLT06-D41



XPLT06-D41

● first choice
○ alternate choice

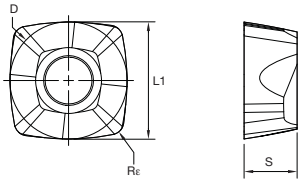
		KC510M	KC522M	KCPK30	KCPM40	KCSM40	SC6525	SP6519	X400	X500
P		○	○	●	●	○	●	○	●	○
M			●	○	○	●		●		●
K		●	○	○			●	○		
N		○								
S			●			●		●		●
H									○	

XPLT06-D41 • First choice for machining stainless steel and high-temp alloys

catalog number	D	LI	S	Rε	hm	RT	KC510M	KC522M	KCPK30	KCPM40	KCSM40	SC6525	SP6519	X400	X500
XPLT060308ERD41	.276	.276	.125	.031	.002	.054	–	–	–	–	–	●	●	●	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XPPT-D41

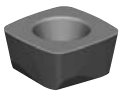


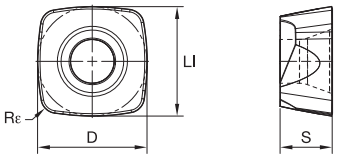
XPPT-D41

XPPT-D41 • Precision pressed insert. General purpose in soft steels, stainless steels, and high-temp alloys.

catalog number	D	LI	S	Rε	hm	RT	KC510M	KC522M	KCPK30	KCPM40	KCSM40	SC6525	SP6519	X400	X500
XPPT060308ERD41	.276	.276	.125	.031	.002	.054	–	–	–	–	●	–	–	–	–

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.

catalog number	D	LI	S	Rε	hm	RT	KC510M	KC522M	KCPK30	KCPM40	KCSM40	SC6525	SP6519	X400	X500
XPPW060310SRD	.276	.276	.125	.039	.006	.061	●	●	●	●	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

Recommended Starting Feeds [IPT] • High-Feed

Light Machining	General Purpose	Heavy Machining

At .035 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	.015	**.043**	.076	.011	**.029**	.050	.008	**.022**	.036	.007	**.019**	.031	.006	**.017**	.028	.E..D41
.S..D	.027	**.058**	.093	.019	**.039**	.059	.014	**.028**	.042	.012	**.024**	.036	.011	**.022**	.033	.S..D

At .025 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	.018	**.051**	.094	.013	**.035**	.059	.009	**.025**	.042	.008	**.022**	.037	.007	**.020**	.033	.E..D41
.S..D	.032	**.070**	.118	.023	**.046**	.071	.017	**.033**	.050	.014	**.029**	.043	.013	**.026**	.039	.S..D

At .020 Axial Depth of Cut (ap)

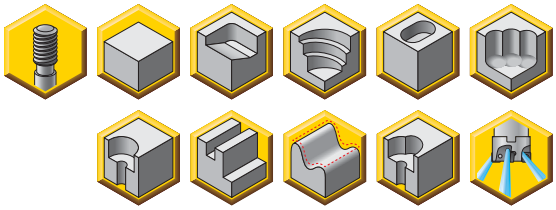
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D41	.020	**.058**	.109	.014	**.039**	.067	.010	**.028**	.047	.009	**.025**	.041	.008	**.022**	.037	.E..D41
.S..D	.036	**.080**	.141	.025	**.052**	.080	.019	**.037**	.056	.016	**.032**	.048	.015	**.029**	.043	.S..D

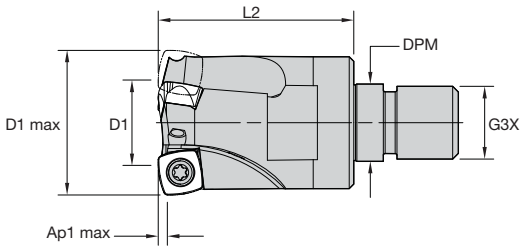
Feed Rate Guide • Plunging • IC 06 • fz [in/tooth]

Insert Geometry	Programmed Feed per Tooth (fz) Max .118" insert engagement (ae radial engagement)			Insert Geometry
.E..D41	.002	**.006**	.010	.E..D41
.S..D	.004	**.008**	.012	.S..D

NOTE: For further details about using the 7792VX series in plunging operations, please see page V30.
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	catalog number	D1 max	D1	L2	G3X	DPM	Ap1 max	Z U
5659840	A7792VXD09SA1.0Z2R1.4	1.000	.487	1.378	M12	.492	.059	2
5660449	A7792VXD09SA1.25Z3R2	1.250	.738	1.692	M16	.669	.059	3

Spare Parts

catalog number	 insert screw	 in. lbs.	 Torx driver
A7792VXD09SA1.0Z2R1.4	F3508T	18.6	T15
A7792VXD09SA1.25Z3R2	F3510T	18.6	T15

NOTE: For further application recommendation, please see technical information on pages V30–V32.

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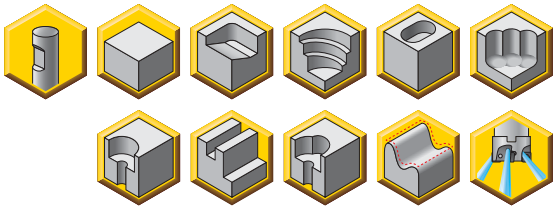
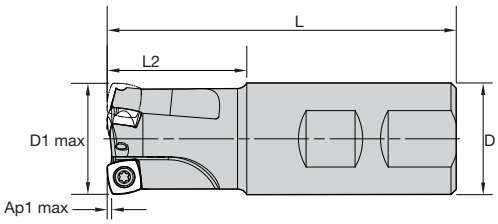
- Positive design to support lower cutting forces and long overhang usage.
- Ramping and plunge milling capabilities.







7792VXD09 Weldon® Shank

order number	catalog number	D1 max	D	L	L2	Ap1 max	Z U
5658075	**C7792VXD09WA1.00Z2R**	1.000	1.000	3.856	1.575	.059	2
5666067	**C7792VXD09WA1.25Z3R**	1.250	1.250	3.855	1.574	.059	3

Spare Parts

catalog number	 insert screw	 in. lbs.	 Torx driver
C7792VXD09WA1.00Z2R	**F3508T**	18.6	**T15**
C7792VXD09WA1.25Z3R	**F3510T**	18.6	**T15**

NOTE: For further application recommendation, please see technical information on pages V30–V32.

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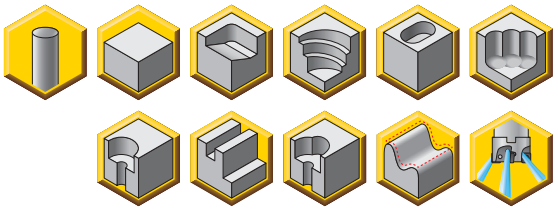

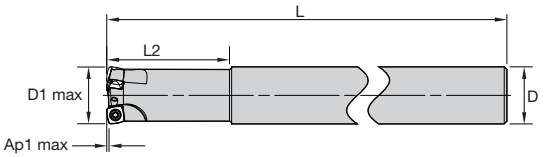



7792VXD09 Cylindrical Shank

order number	catalog number	D1 max	D	L	L2	Ap1 max	Z U
5667564	C7792VXD09CA1.00Z2R2	1.000	1.000	7.874	1.969	.059	2
6025590	C7792VXD09CA1.00Z3R2	1.000	1.000	8.000	2.000	.059	3
5659948	C7792VXD09CA1.25Z3R3	1.250	1.250	9.843	2.756	.059	3
6025611	C7792VXD09CA1.25Z4R3	1.251	1.250	10.000	3.000	.059	4

Spare Parts

catalog number	 insert screw	 in. lbs.	 Torx driver
C7792VXD09CA1.00Z2R2	F3508T	18.6	T15
C7792VXD09CA1.00Z3R2	F3508T	18.6	T15
C7792VXD09CA1.25Z3R3	F3510T	18.6	T15
C7792VXD09CA1.25Z4R3	F3510T	18.6	T15

NOTE: For further application recommendation, please see technical information on pages V30–V32.

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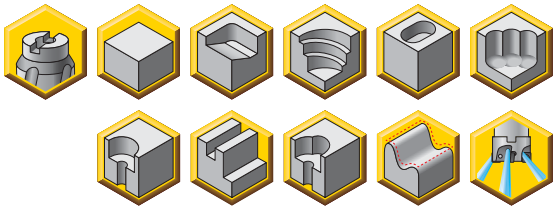
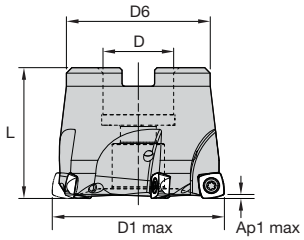






7792VXD09 Shell Mill

order number	catalog number	D1 max	D	D6	L	Ap1 max	Z U
5656731	C7792VXD09-A1.50Z4R	1.500	.500	1.339	1.260	.059	4
5658170	C7792VXD09-A1.50Z5R	1.500	.500	1.339	1.260	.059	5
5667832	C7792VXD09-A2.00Z5R	2.000	.750	1.811	1.575	.059	5
5665795	C7792VXD09-A2.00Z6R	2.000	.750	1.811	1.575	.059	6
6025612	C7792VXD09-A2.00Z7R	2.000	.750	1.772	1.575	.059	7

Spare Parts

catalog number	 insert screw	 in. lbs.	 Torx driver	 mounting screw
C7792VXD09-A1.50Z4R	F3510T	18.6	T15	#1/4-28X3/4SHCSA
C7792VXD09-A1.50Z5R	F3510T	18.6	T15	#1/4-28X3/4SHCSA
C7792VXD09-A2.00Z5R	F3510T	18.6	T15	#3/8-24X1SHCSA
C7792VXD09-A2.00Z6R	F3510T	18.6	T15	#3/8-24X1SHCSA
C7792VXD09-A2.00Z7R	F3510T	18.6	TB15	#3/8-24X1SHCSA

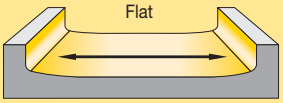
NOTE: For further application recommendation, please see technical information on pages V30–V32.

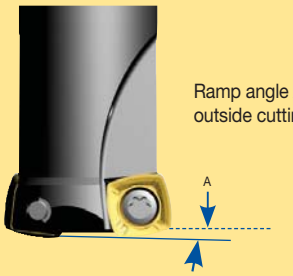
Technical Information (in)

order number	catalog number	dimension						max RPM
		facing pitch	ramping angle	helical hole min–max		ap max helical/ linear	a_e max plunging	
5658075	C7792VXD09WA1.00Z2R	0.478	2.70	1.370	1.920	0.039	0.236	48,000
5666067	C7792VXD09WA1.25Z3R	0.728	1.50	1.870	2.420	0.039	0.236	40,500
5667564	C7792VXD09CA1.00Z2R2	0.478	2.70	1.370	1.920	0.039	0.236	48,000
6025590	C7792VXD09CA1.00Z3R2	0.478	2.70	1.370	1.920	0.039	0.236	48,000
5659948	C7792VXD09CA1.25Z3R3	0.728	1.50	1.870	2.420	0.039	0.236	40,500
6025611	C7792VXD09CA1.25Z4R3	0.728	1.50	1.870	2.420	0.039	0.236	40,500
5656731	C7792VXD09-A1.50Z4R	0.980	1.10	2.370	2.920	0.039	0.236	36,000
5658170	C7792VXD09-A1.50Z5R	0.980	1.10	2.370	2.920	0.039	0.236	36,000
5667832	C7792VXD09-A2.00Z5R	1.478	0.70	3.370	3.920	0.039	0.236	30,000
5665795	C7792VXD09-A2.00Z6R	1.478	0.70	3.370	3.920	0.039	0.236	30,000
6025612	C7792VXD09-A2.00Z7R	1.478	0.70	3.370	3.920	0.039	0.236	30,000
5659840	A7792VXD09SA1.0Z2R1.4	0.480	2.70	1.370	1.920	0.039	0.236	48,000
5660449	A7792VXD09SA1.25Z3R2	0.730	1.50	1.870	2.420	0.039	0.236	40,500


Helical Interpolation


Plunging





Ramp angle A uses one outside cutting edge only.

A = max ramp angle utilizing full face contact.

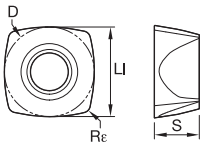
Insert Selection Guide • IC 09

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

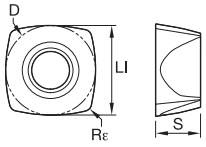
catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLT090408ERD721	.375	.375	.187	.031	.002	.079	●	–	–	–	–	–	–	–	–	–	–	–	–

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

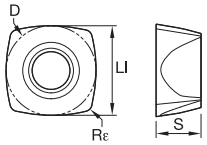
catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLT090408ERD41	.375	.375	.187	.031	.002	.079	–	–	–	–	–	–	–	–	–	●	●	–	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

Copy Milling

- First choice for machining stainless steel and high-temp alloys.


XDPT09...D41



XDPT09...D41

● first choice
○ alternate choice

		GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P			○	○	●		●	●	○		●	○	●	○
M				●	●		○	○	●			●		●
K		○	●	○		●	○			●	●	○		
N		●	○											
S				●	●				●			●		●
H													○	

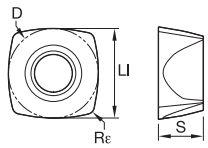
XDPT09-D41 • Precision pressed. General purpose in soft steels. Best fit for face milling, slotting operation

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPT090408ERD41	.375	.375	.187	.031	.002	.079	–	–	–	–	–	–	–	●	–	●	●	–	●

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



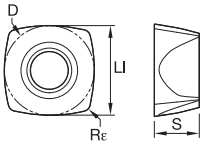
XDLT09...D411

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

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLT090412ERD411	.375	.375	.187	.047	.002	.089	–	–	–	–	–	–	–	–	–	–	●	–	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XDPT-D411



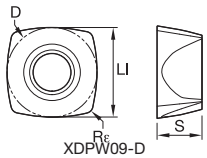
XDPT-D411

XDPT-D411 • Precision pressed. General purpose in stainless steel and high-temp alloys. Best fit for pocketing and profiling operations in general, also in combination with long overhangs

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPT090412ERD411	.375	.375	.187	.047	.002	.089	–	–	–	–	–	–	–	●	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XDPW09-D



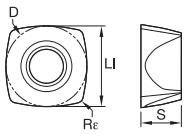
XDPW09-D

XDPW09-D • Precision pressed. First choice for roughing alloyed steel and cast iron

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPW090412SRD	.375	.375	.187	.047	.004	.089	–	●	●	–	●	●	●	–	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XDLW09-D



XDLW09-D

● first choice
○ alternate choice

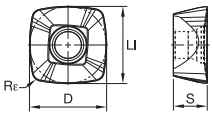
		GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P			○	○	●		●	●	○		●	○	●	○
M				●	●		○	○	●			●		●
K		○	●	○		●	○			●	●	○		
N		●	○											
S				●	●				●			●		●
H													○	

■ XDLW09-D • First choice for roughing alloyed steel and cast iron

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLW090408SRD	.375	.375	.187	.031	.004	.079	–	–	–	–	–	–	–	–	●	●	–	●	●

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.

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPT090412SRGP	.375	.375	.187	.047	.009	.026	–	–	●	●	–	●	●	–	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

Recommended Starting Feeds • High-Feed and Plunging Applications • fz [in/tooth]

■ Recommended Starting Feeds [IPT] • High-Feed

Light Machining	General Purpose	Heavy Machining

At .060 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	.012	**.038**	.067	.009	**.027**	.047	.006	**.020**	.034	.006	**.018**	.030	.005	**.016**	.027	.E..D721
.E..D41	.015	**.044**	.067	.011	**.031**	.047	.008	**.023**	.034	.007	**.020**	.030	.006	**.018**	.027	.E..D41
.E..D411	.015	**.044**	.067	.011	**.031**	.047	.008	**.023**	.034	.007	**.020**	.030	.006	**.018**	.027	.E..D411
.S..D	.021	**.048**	.079	.015	**.034**	.055	.011	**.025**	.040	.010	**.022**	.035	.009	**.020**	.032	.S..D
.S..GP	.021	**.048**	.079	.015	**.034**	.054	.011	**.025**	.040	.010	**.022**	.035	.009	**.020**	.032	.S..GP

At .040 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	.015	**.047**	.083	.010	**.033**	.057	.008	**.024**	.042	.007	**.021**	.036	.006	**.019**	.033	.E..D721
.E..D41	.018	**.053**	.083	.013	**.038**	.057	.010	**.028**	.042	.009	**.024**	.036	.008	**.022**	.033	.E..D41
.E..D411	.018	**.053**	.083	.013	**.038**	.057	.010	**.028**	.042	.009	**.024**	.036	.008	**.022**	.033	.E..D411
.S..D	.026	**.059**	.098	.019	**.041**	.067	.014	**.031**	.049	.012	**.027**	.042	.011	**.024**	.039	.S..D
.S..GP	.026	**.058**	.097	.019	**.041**	.067	.014	**.030**	.049	.012	**.026**	.042	.011	**.024**	.038	.S..GP

At .030 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	.017	**.054**	.097	.012	**.038**	.066	.009	**.028**	.048	.008	**.024**	.042	.007	**.022**	.038	.E..D721
.E..D41	.021	**.062**	.097	.015	**.043**	.066	.011	**.032**	.048	.010	**.028**	.042	.009	**.025**	.038	.E..D41
.E..D411	.021	**.062**	.097	.015	**.043**	.066	.011	**.032**	.048	.010	**.028**	.042	.009	**.025**	.038	.E..D411
.S..D	.030	**.069**	.115	.021	**.048**	.078	.016	**.035**	.056	.014	**.031**	.049	.013	**.028**	.044	.S..D
.S..GP	.030	**.068**	.114	.021	**.047**	.077	.016	**.035**	.056	.014	**.030**	.048	.013	**.028**	.044	.S..GP

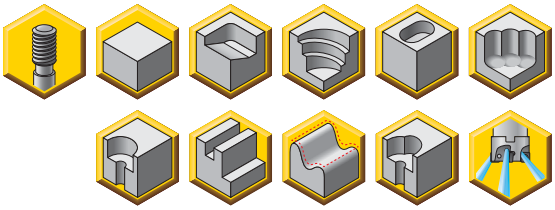
■ Feed Rate Guide • Plunging • IC 09 • fz [in/tooth]

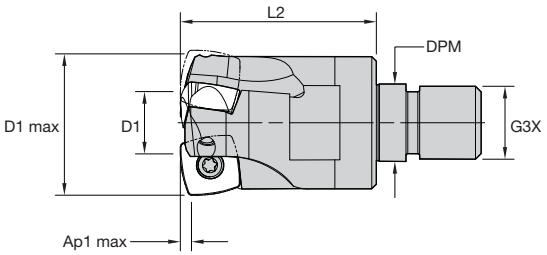
Insert Geometry	Programmed Feed per Tooth (fz) Max .236" insert engagement (ae radial engagement)			Insert Geometry
.E..D721	.002	**.007**	.012	.E..D721
.E..D41	.003	**.008**	.012	.E..D41
.E..D411	.003	**.008**	.012	.E..D411
.S..D	.004	**.009**	.014	.S..D
.S..GP	.004	**.009**	.014	.S..GP

NOTE: For further details about using the 7792VX series in plunging operations, please see page V30.
Use "Light Machining" values as starting feed rate
Please see pages X22–X37 for recommended starting speeds.

Copy Milling

- 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

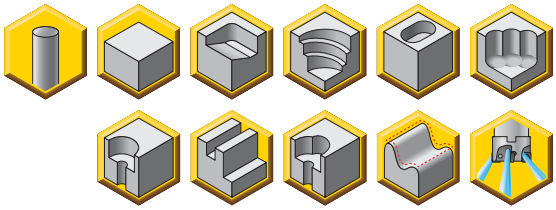
order number	catalog number	D1 max	D1	L2	G3X	DPM	Ap1 max	Z U
5659929	A7792VXD12SA1.25Z2R2	1.250	.520	1.693	M16	.669	.098	2
5667487	A7792VXD12SA1.5Z3R1.7	1.500	.785	1.750	M16	.669	.098	3

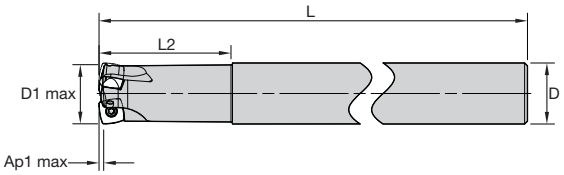
Spare Parts

catalog number	insert screw	in. lbs.	Torx driver
A7792VXD12SA1.25Z2R2	D4010T	27.4	T15
A7792VXD12SA1.5Z3R1.7	D4010T	27.4	T15

NOTE: For further application recommendation, please see technical information on pages V30–V32.

- 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

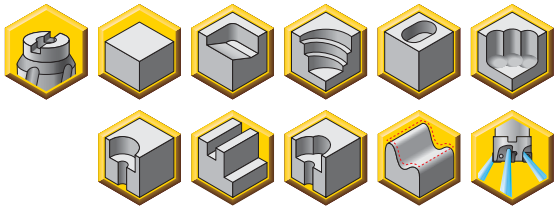
order number	catalog number	D1 max	D	L	L2	Ap1 max	Z U
5666596	C7792VXD12CA1.25Z2R3	1.250	1.250	9.843	2.756	.098	2
6025588	C7792VXD12CA1.25Z3R3	1.250	1.250	10.000	3.000	.098	3
5665832	C7792VXD12CA1.2/1.5Z3	1.500	1.250	9.843	2.755	.098	3
6025589	C7792VXD12CA1.50Z4R3	1.500	1.500	10.000	3.000	.098	4

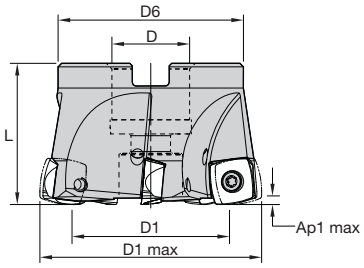
Spare Parts

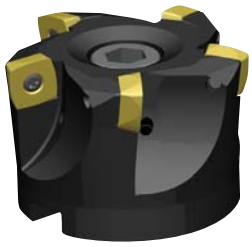
catalog number	 insert screw	 in. lbs.	 Torx driver
C7792VXD12CA1.25Z2R3	D4010T	27.4	T15
C7792VXD12CA1.25Z3R3	D4010T	27.4	T15
C7792VXD12CA1.2/1.5Z3	D4010T	27.4	T15
C7792VXD12CA1.50Z4R3	D4010T	27.4	T15

NOTE: For further application recommendation, please see technical information on pages V30–V32.

- 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	catalog number	D1 max	D	D6	L	Ap1 max	Z U
6025581	C7792VXD12-A1.50Z4R	1.500	.750	1.417	1.575	.098	4
5657237	C7792VXD12-A2.00Z3R	2.000	.750	1.811	1.575	.098	3
5667404	C7792VXD12-A2.00Z4R	2.000	.750	1.772	1.575	.098	4
5656382	C7792VXD12-A2.00Z5R	2.000	.750	1.811	1.575	.098	5
6025582	C7792VXD12-A2.00Z6R	2.000	.750	1.772	1.575	.098	6
5667809	C7792VXD12-A2.50Z4R	2.500	1.000	1.969	1.575	.098	4
5656732	C7792VXD12-A2.50Z5R	2.500	1.000	1.969	1.575	.098	5
6025583	C7792VXD12-A2.50Z7R	2.500	1.000	2.087	1.575	.098	7
5665708	C7792VXD12-A3.00Z5R	3.000	1.000	2.087	1.969	.098	5
5656919	C7792VXD12-A3.00Z8R	3.000	1.000	1.969	1.969	.098	8
6025584	C7792VXD12-A3.00Z9R	3.000	1.000	2.087	1.969	.098	9
5667833	C7792VXD12-A4.00Z6R	4.000	1.250	2.559	1.969	.098	6
5656378	C7792VXD12-A4.00Z9R	4.000	1.250	2.559	1.969	.098	9
6025585	C7792VXD12-A4.00Z11R	4.000	1.250	2.559	1.969	.098	11
5667476	C7792VXD12-A5.00Z8R	5.000	1.500	3.244	2.480	.098	8
5658171	C7792VXD12-A5.00Z11R	5.000	1.500	3.244	2.480	.098	11
6025586	C7792VXD12-A5.00Z13R	5.000	1.500	3.189	2.480	.098	13
5656915	C7792VXD12-6.00Z12R	6.000	1.500	3.953	2.480	.098	12
6025587	C7792VXD12-6.00Z15R	6.000	1.500	4.323	2.480	.098	15
5659736	C7792VXD12-6.30Z8R	6.300	1.500	3.945	2.480	.098	8

NOTE: No through coolant for cutters where D1 max = 6.00".

Spare Parts

catalog number	insert screw	in. lbs.	Torx driver	mounting screw	mounting screw
C7792VXD12-A1.50Z4R	D4010T	27.4	T15	–	KLSS0714C
C7792VXD12-A2.00Z3R	D4012T	27.4	T15	#3/8-24X1SHCSA	–
C7792VXD12-A2.00Z4R	D4012T	27.4	T15	#3/8-24X1SHCSA	–
C7792VXD12-A2.00Z5R	D4010T	27.4	T15	#3/8-24X1SHCSA	–
C7792VXD12-A2.00Z6R	D4010T	27.4	TB15	#3/8-24X1SHCSA	–
C7792VXD12-A2.50Z4R	D4012T	27.4	T15	#1/2-20X1-1/4 LHCSA	–
C7792VXD12-A2.50Z5R	D4012T	27.4	T15	#1/2-20X1-1/4 LHCSA	–
C7792VXD12-A2.50Z7R	D4012T	27.4	TB15	#1/2-20X1-1/4 LHCSA	–
C7792VXD12-A3.00Z5R	D4012T	27.4	T15	#1/2-20X1-1/4SHCSA	–
C7792VXD12-A3.00Z8R	D4012T	27.4	T15	#1/2-20X1-1/4SHCSA	–
C7792VXD12-A3.00Z9R	D4012T	27.4	TB15	#1/2-20X1-1/4SHCSA	–
C7792VXD12-A4.00Z6R	D4012T	27.4	T15	#5/8-18X1-1/2SHCSA	–
C7792VXD12-A4.00Z9R	D4012T	27.4	T15	#5/8-18X1-1/2SHCSA	–
C7792VXD12-A4.00Z11R	D4012T	27.4	TB15	#5/8-18X1-1/2SHCSA	–
C7792VXD12-A5.00Z8R	D4012T	27.4	T15	#3/4-16X1-3/4SHCSA	–
C7792VXD12-A5.00Z11R	D4012T	27.4	T15	#3/4-16X1-3/4SHCSA	–
C7792VXD12-A5.00Z13R	D4012T	27.4	TB15	#3/4-16X1-3/4SHCSA	–
C7792VXD12-6.00Z12R	D4012T	27.4	T15	–	–
C7792VXD12-6.00Z15R	D4010T	27.4	TB15	–	–
C7792VXD12-6.30Z8R	D4012T	27.4	T15	–	–

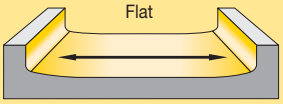
NOTE: For further application recommendation, please see technical information on pages V30–V32.

Technical Information (in)

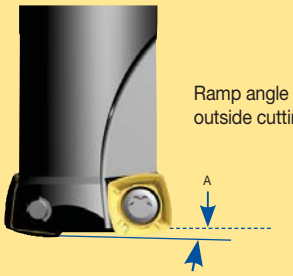
order number	catalog number	dimension						max RPM
		facing pitch	ramping angle	helical hole min–max		ap max helical/ linear	a_e max plunging	
5666596	C7792VXD12CA1.25Z2R3	0.526	1.85	1.630	2.420	0.070	0.354	31,500
5665832	C7792VXD12CA1.2/1.5Z3	0.770	0.95	2.130	2.920	0.070	0.354	27,500
6025581	C7792VXD12-A1.50Z4R	0.770	0.95	2.130	2.920	0.070	0.354	27,500
5657237	C7792VXD12-A2.00Z3R	1.276	0.90	3.130	3.920	0.070	0.354	22,500
5667404	C7792VXD12-A2.00Z4R	1.276	0.90	3.130	3.920	0.070	0.354	22,500
5656382	C7792VXD12-A2.00Z5R	1.276	0.90	3.370	3.920	0.070	0.354	22,500
6025582	C7792VXD12-A2.00Z6R	1.276	0.90	3.130	3.920	0.070	0.354	22,500
5667809	C7792VXD12-A2.50Z4R	1.776	0.60	4.130	4.920	0.070	0.354	22,500
5656732	C7792VXD12-A2.50Z5R	1.776	0.60	4.130	4.920	0.070	0.354	22,500
6025583	C7792VXD12-A2.50Z7R	1.776	0.60	4.130	4.920	0.070	0.354	19,500
5665708	C7792VXD12-A3.00Z5R	2.276	0.45	5.130	5.920	0.070	0.354	17,500
5656919	C7792VXD12-A3.00Z8R	2.276	0.45	5.130	5.920	0.070	0.354	17,500
6025584	C7792VXD12-A3.00Z9R	2.276	0.45	5.130	5.920	0.070	0.354	17,500
5667833	C7792VXD12-A4.00Z6R	3.270	0.31	7.130	7.920	0.070	0.354	14,500
5656378	C7792VXD12-A4.00Z9R	3.270	0.31	7.130	7.920	0.070	0.354	14,500
6025585	C7792VXD12-A4.00Z11R	3.270	0.31	7.130	7.920	0.070	0.354	14,500
5667476	C7792VXD12-A5.00Z8R	4.270	0.24	9.130	9.920	0.070	0.354	13,000
5658171	C7792VXD12-A5.00Z11R	4.270	0.24	9.130	9.920	0.070	0.354	13,000
6025586	C7792VXD12-A5.00Z13R	4.270	0.24	9.130	9.920	0.070	0.354	13,000
5656915	C7792VXD12-6.00Z12R	5.270	0.19	11.130	11.920	0.070	0.354	11,500
6025587	C7792VXD12-6.00Z15R	5.270	0.19	11.130	11.920	0.070	0.354	11,500
5659736	C7792VXD12-6.30Z8R	5.570	0.18	11.130	11.920	0.070	0.354	11,000
5659929	A7792VXD12SA1.25Z2R2	0.520	2.60	1.630	2.420	0.070	0.354	31,500
6025588	C7792VXD12CA1.25Z3R3	0.520	2.60	1.630	2.420	0.070	0.354	31,500
5667487	A7792VXD12SA1.5Z3R1.7	0.770	1.60	2.130	2.920	0.070	0.354	27,500
6025589	C7792VXD12CA1.50Z4R3	0.770	1.60	2.130	2.920	0.070	0.354	27,500


Helical Interpolation


Plunging



Facing Pitch



Ramp angle A uses one outside cutting edge only.

A = max ramp angle utilizing full face contact.

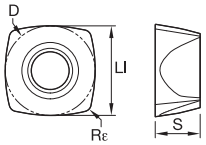
Insert Selection Guide • IC 12

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

Milling Inserts



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

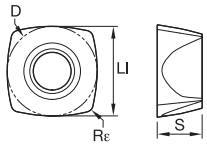
catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLT120508ERD721	.500	.500	.219	.031	.002	.098	●	–	–	–	–	–	–	–	–	–	–	–	–

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

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLT120508ERD41	.500	.500	.219	.031	.002	.098	–	–	–	–	–	–	–	●	–	●	●	–	●

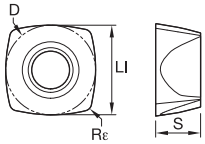
NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

- 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														○	


XDPT12-D41



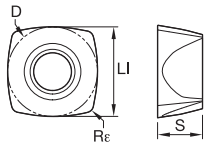
XDPT12-D41

XDPT12-D41 • Precision-pressed insert; improved cost per edge. General purpose in soft steels. Best fit for face milling, slotting operation

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPT120508ERD41	.500	.500	.219	.031	.002	.098	–	–	–	–	–	–	–	●	–	●	●	–	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XDPT12-D411



XDPT12-D411

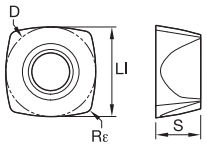
XDPT12-D411 • Precision pressed. General purpose in stainless steel and high-temp alloys. Best fit for pocketing and profiling operations in general, also in combination with long overhangs.

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPT120512ERD411	.500	.500	.219	.047	.002	.107	–	–	–	–	–	–	–	●	–	–	–	–	–

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

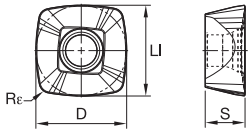
XDLT12-D411 • General purpose in stainless steel and high-temp alloys. Best fit for pocketing and profiling operations in general

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLT120512ERD411	.500	.500	.219	.047	.002	.107	–	–	–	–	–	–	–	●	–	–	●	–	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.



XDPT12-GP



XDPT12-GP

● first choice
○ alternate choice

		GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P			○	○	●		●	●	○		●	○	●	○
M				●	●		○	○	●			●		●
K		○	●	○		●	○			●	●	○		
N		●	○											
S				●	●				●			●		●
H													○	

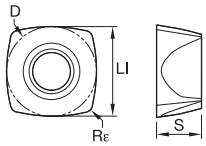
XDPT12-GP • Precision-pressed insert; improved cost per edge. General use on alloyed steels. Good balance across all machining situations

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPT120515SRGP	.500	.500	.219	.059	.009	.109	–	–	●	●	–	●	●	–	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.



XDLW12-D



XDLW12-D

XDLW12-D • First choice for roughing alloyed steel and cast iron

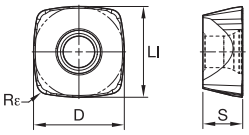
catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLW120508SRD	.500	.500	.219	.031	.010	.098	–	–	–	–	–	–	–	–	●	–	–	●	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

- Particularly suitable for high strength steels, hardened materials, and cast iron.



XDPW12-D



XDPW12-D

XDPW12-D • Precision Pressed with Reinforced Geometry • First Choice for Hardened Materials and Cast Iron

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPW120515SRD	.500	.500	.219	.058	.010	.109	–	●	●	–	●	●	●	–	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

Recommended Starting Feeds [IPT] • High-Feed

Light Machining	General Purpose	Heavy Machining

At .100 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	.011	**.041**	.066	.008	**.029**	.047	.006	**.022**	.035	.005	**.019**	.030	.005	**.017**	.028	.E..D721
.E..D41	.014	**.046**	.072	.010	**.033**	.051	.008	**.024**	.038	.007	**.021**	.033	.006	**.019**	.030	.E..D41
.E..D411	.014	**.046**	.072	.010	**.033**	.051	.008	**.024**	.038	.007	**.021**	.033	.006	**.019**	.030	.E..D411
.S..GP	.020	**.051**	.077	.015	**.036**	.055	.011	**.027**	.041	.009	**.024**	.035	.009	**.022**	.032	.S..GP
.S..D	.020	**.051**	.077	.015	**.036**	.055	.011	**.027**	.041	.009	**.024**	.036	.009	**.022**	.032	.S..D

At .070 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	.013	**.048**	.078	.010	**.035**	.056	.007	**.026**	.041	.006	**.022**	.036	.006	**.021**	.033	.E..D721
.E..D41	.017	**.054**	.086	.012	**.039**	.061	.009	**.029**	.045	.008	**.025**	.039	.007	**.023**	.036	.E..D41
.E..D411	.017	**.054**	.086	.012	**.039**	.061	.009	**.029**	.045	.008	**.025**	.039	.007	**.023**	.036	.E..D411
.S..GP	.024	**.061**	.092	.017	**.043**	.065	.013	**.032**	.048	.011	**.028**	.042	.010	**.026**	.038	.S..GP
.S..D	.024	**.061**	.092	.017	**.043**	.065	.013	**.032**	.048	.011	**.028**	.042	.010	**.026**	.038	.S..D

At .055 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	.015	**.054**	.088	.011	**.039**	.063	.008	**.029**	.046	.007	**.025**	.040	.007	**.023**	.037	.E..D721
.E..D41	.019	**.061**	.097	.014	**.044**	.069	.010	**.033**	.051	.009	**.028**	.044	.008	**.026**	.040	.E..D41
.E..D411	.019	**.061**	.097	.014	**.044**	.069	.010	**.033**	.051	.009	**.028**	.044	.008	**.026**	.040	.E..D411
.S..GP	.027	**.068**	.104	.019	**.049**	.073	.014	**.036**	.054	.013	**.031**	.047	.012	**.029**	.043	.S..GP
.S..D	.027	**.068**	.104	.019	**.049**	.074	.014	**.036**	.054	.013	**.031**	.047	.012	**.029**	.043	.S..D

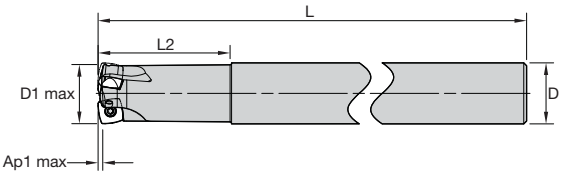
Feed Rate Guide • Plunging • IC 12 • fz [in/tooth]

Insert Geometry	Programmed Feed per Tooth (fz) Max .354" insert engagement (ae radial engagement)			Insert Geometry
.E..D721	.002	**.008**	.013	.E..D721
.E..D41	.003	**.009**	.014	.E..D41
.E..D411	.003	**.009**	.014	.E..D411
.S..GP	.004	**.010**	.015	.S..GP
.S..D	.004	**.010**	.015	.S..D

NOTE: For further details about using the 7792VX series in plunging operations, please see page V30.
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

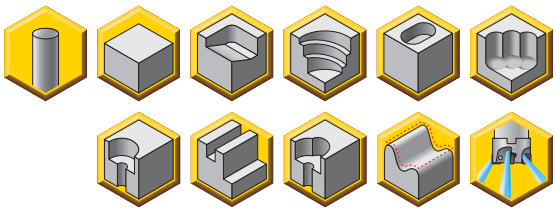
order number	catalog number	D1 max	D	L	L2	Ap1 max	Z U
5659564	C7792VXE16CA1.50Z2R4	1.500	1.500	6.703	4.016	.138	2
5666415	C7792VXE16CA2.00Z3R4	2.000	1.500	6.703	4.016	.138	3

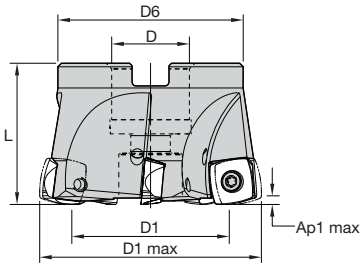
Spare Parts

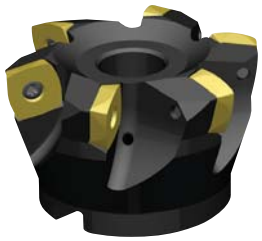
catalog number	 insert screw	 in. lbs.	 Torx driver
C7792VXE16CA1.50Z2R4	DP5013T	54.0	TP20
C7792VXE16CA2.00Z3R4	DP5013T	53.9	TP20

NOTE: For further application recommendation, please see technical information on pages V30–V32.

- 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	catalog number	D1 max	D	D6	L	Ap1 max	Z U
6025564	C7792VXE16-A2.00Z4R	2.000	.750	1.772	1.772	.138	4
5665812	C7792VXE16-A2.50Z5R	2.500	1.000	2.055	1.575	.138	5
6025565	C7792VXE16-A2.50Z6R	2.500	1.000	1.969	1.575	.138	6
5661029	C7792VXE16-A3.00Z6R	3.000	1.000	2.087	1.969	.138	6
6025566	C7792VXE16-A3.00Z7R	3.000	1.000	1.969	1.969	.138	7
6160743	C7792VXE16-A1.5/4.00Z7R	4.000	1.500	3.189	2.480	.138	7
5667941	C7792VXE16-A4.00Z8R	4.000	1.250	2.559	1.969	.138	8
6160744	C7792VXE16-A1.5/4.00Z9R	4.000	1.500	3.189	2.480	.138	9
6025567	C7792VXE16-A4.00Z9R	4.000	1.250	2.559	1.969	.138	9
5661030	C7792VXE16-A5.00Z10R	5.000	1.500	3.307	2.480	.138	10
6025568	C7792VXE16-A5.00Z11R	5.000	1.500	3.189	2.480	.138	11
5667570	C7792VXE16-6.00Z12R	6.000	1.500	4.291	2.480	.138	12
6025569	C7792VXE16-6.00Z13R	6.000	1.500	4.323	2.480	.138	13

NOTE: No through coolant for cutters where D1 max = 6.00".

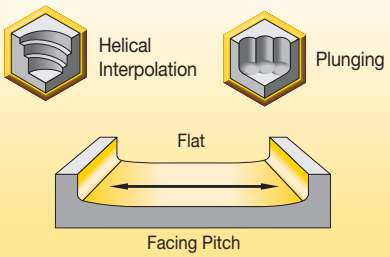
Spare Parts

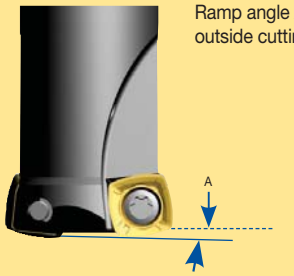
catalog number	insert screw	in. lbs.	Torx driver	mounting screw	mounting screw
C7792VXE16-A2.00Z4R	DP5013T	54.0	TP20	–	KLSS0714C
C7792VXE16-A2.50Z5R	DP5013T	54.0	TP20	#1/2-20X1-1/4 LHCSA	–
C7792VXE16-A2.50Z6R	DP5013T	54.0	TB20	#1/2-20X1-1/4 LHCSA	–
C7792VXE16-A3.00Z6R	DP5013T	54.0	TP20	#1/2-20X1-1/4SHCSA	–
C7792VXE16-A3.00Z7R	DP5013T	54.0	TB20	#1/2-20X1-1/4SHCSA	–
C7792VXE16-A1.5/4.00Z7R	DP5013T	54.0	TP20	#3/4-16X1-3/4SHCSA	–
C7792VXE16-A4.00Z8R	DP5013T	54.0	TP20	#5/8-18X1-1/2SHCSA	–
C7792VXE16-A1.5/4.00Z9R	DP5013T	54.0	TB20	#3/4-16X1-3/4SHCSA	–
C7792VXE16-A4.00Z9R	DP5013T	54.0	TB20	#5/8-18X1-1/2SHCSA	–
C7792VXE16-A5.00Z10R	DP5013T	67.3	TP20	#3/4-16X1-3/4SHCSA	–
C7792VXE16-A5.00Z11R	DP5013T	54.0	TB20	#3/4-16X1-3/4SHCSA	–
C7792VXE16-6.00Z12R	DP5013T	54.0	TP20	–	–
C7792VXE16-6.00Z13R	DP5013T	54.0	TB20	–	–

NOTE: For further application recommendation, please see technical information on pages V30–V32.

Technical Information (in)

order number	catalog number	dimension						max RPM
		facing pitch	ramping angle	helical hole min–max		ap max helical/ linear	a_e max plunging	
5666415	C7792VXE16CA2.0Z3R4	1.05	2.85	3	4	0.098	0.512	27,000
6025564	C7792VXE16-A2.00Z4R	1.05	2.85	3	4	0.098	0.512	27,000
5665812	C7792VXE16-A2.5Z5R	1.46	1.00	4	5	0.098	0.512	22,000
6025565	C7792VXE16-A2.50Z6R	1.56	0.86	3.82	5	0.098	0.512	27,500
5661029	C7792VXE16-A3.00Z6R	1.96	0.65	5	6	0.098	0.512	19,500
6025566	C7792VXE16-A3.00Z7R	2.06	0.58	5	6	0.098	0.512	27,500
5667941	C7792VXE16-A4.00Z8R	2.96	0.51	7	8	0.098	0.512	16,500
6025567	C7792VXE16-A4.00Z9R	3.06	0.42	7	8	0.098	0.512	27,500
5661030	C7792VXE16-A5.00Z10R	3.96	0.37	8.82	9.92	0.098	0.512	14,500
6025568	C7792VXE16-A5.00Z11R	4.06	0.32	8.82	9.92	0.098	0.512	27,500
5667570	C7792VXE16-6.00Z12R	4.96	0.27	10.82	11.92	0.098	0.512	13,000
6025569	C7792VXE16-6.00Z13R	5.06	0.23	10.82	11.92	0.098	0.512	27,500





Ramp angle A uses one outside cutting edge only.

A = max ramp angle utilizing full-face contact.

Insert Selection Guide • IC 16

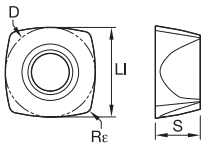
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		← →		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	...D41	SC6525	**...D41**	**KCPM40**	...D41	KCPM40
P3–P4	...D41	SC6525	**...D**	**KCPM40**	...D	KCPM40
P5–P6	...D41	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

- First choice for machining stainless steel and high-temp alloys.

● first choice
○ alternate choice

		KC522M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P		○		●	●	○		●	○	●	○
M		●		○	○	●			●		●
K		○	●	○			●	●	○		
N											
S		●				●			●		●
H										○	


XELT16-D41



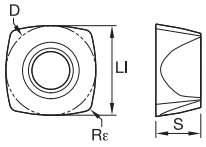
XELT16-D41

XELT16-D41 • Best fit for face milling and slotting operation. General purpose in soft steels.

catalog number	D	LI	S	Rε	hm	RT
XELT160512ERD41	.661	.661	.219	.047	.002	.165

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XEPT-D41



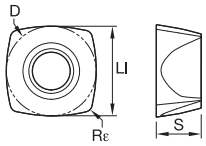
XEPT-D41

XEPT16-D41 • Precision pressed insert • Best fit for face milling and slotting operation. General purpose in soft steels.

catalog number	D	LI	S	Rε	hm	RT
XEPT160512ERD41	.661	.661	.219	.047	.002	.165
XEPT160516ERD41	.661	.661	.219	.063	.002	.175

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XEPW16-D



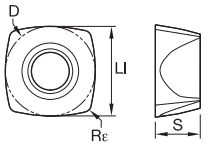
XEPW16-D

XEPW16-D • Precision pressed insert. First Choice for machining steel and cast iron

catalog number	D	LI	S	Rε	hm	RT
XEPW160520SRD	.661	.661	.219	.079	.005	.187

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

catalog number	D	LI	S	Rε	hm	RT
XELW160512SRD	.661	.661	.219	.047	.005	.165

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

Recommended Starting Feeds [IPT] • High-Feed

Light Machining	General Purpose	Heavy Machining

At .140 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	.012	**.039**	.066	.009	**.028**	.047	.007	**.021**	.035	.006	**.018**	.030	.005	**.017**	.028	.E..D41
.S..D	.017	**.043**	.070	.012	**.031**	.050	.009	**.023**	.037	.008	**.020**	.032	.007	**.019**	.030	.S..D

At .100 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	.014	**.046**	.077	.010	**.033**	.055	.008	**.024**	.041	.007	**.021**	.036	.006	**.019**	.032	.E..D41
.S..D	.020	**.051**	.083	.015	**.036**	.059	.011	**.027**	.044	.009	**.024**	.038	.009	**.022**	.035	.S..D

At .080 Axial Depth of Cut (ap)

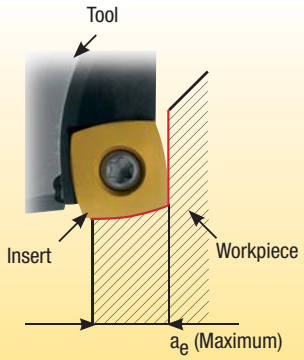
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D41	.016	**.051**	.086	.011	**.036**	.061	.009	**.027**	.045	.007	**.024**	.039	.007	**.022**	.036	.E..D41
.S..D	.022	**.057**	.092	.016	**.041**	.065	.012	**.030**	.048	.011	**.026**	.042	.010	**.024**	.039	.S..D

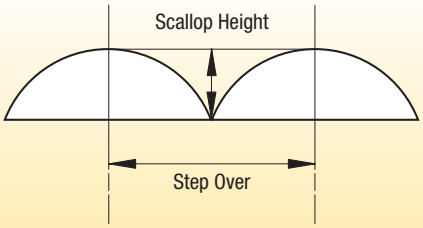
Feed Rate Guide • Plunging • IC 16 • fz [in/tooth]

Insert Geometry	Programmed Feed per Tooth (fz) Max .512" insert engagement (ae radial engagement)			Insert Geometry
.E..D41	.003	**.009**	.015	.E..D41
.S..D	.004	**.010**	.016	.S..D

NOTE: For further details about using the 7792VX series in plunging operations, please see page V30.
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.

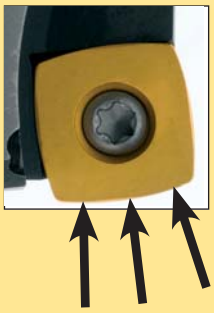
The maximum radial engagement is directly in relation to insert cutting edge length.

For insert type:
XP…06 the ae max is .118"
XD…09 the ae max is .236"
XD…12 the ae max is .354"
XE…16 the ae max is .512"

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.

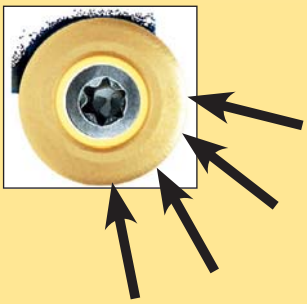
7792VX

- 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

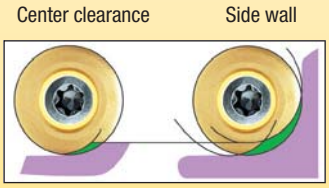
- Constant cutting section (chip volume) irrespective of position in cavity.
- Producing a close to profile side wall.
- Near-square side walls possible.



Round insert tools have increasing chip volume through the process.

Round insert

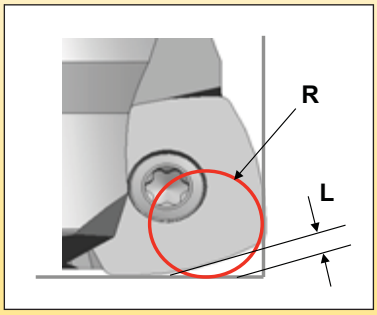
- Greater surface contact.
- Increased chip section for side wall machining.
- Vibration in corners.
- Undulating side wall cusps.



CNC Program • 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 0.031"

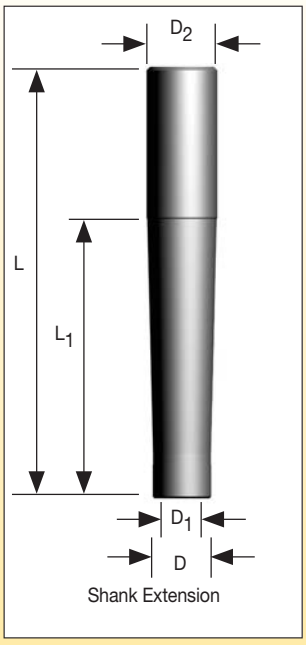


Programming Data (inch)			
Insert corner nose size (IC)	Rε	R	L
06	0.750	1.100	1.420
09	0.031	0.079	0.028
	0.047	0.089	0.026
12	0.031	0.098	0.040
	0.047	0.107	0.038
16	0.047	0.164	0.057

Cylindrical Shank Extensions for Modular Heads

order number	catalog number	dimension					
			ramping angle		helical hole		
		L	L1	D_2	D	D1	M
5673704	**M-13-M8-CA.625-3.543**	3.543	1.600	0.625	0.512	0.335	M8
5673705	**M-13-M8-CA.625-4.331**	4.331	2.500	0.625	0.512	0.335	M8
5672469	**M-13-M8-CA.625-5.118**	5.118	3.000	0.625	0.512	0.335	M8
5672833	**M-13-M8-CA.625-6.693**	6.693	4.750	0.625	0.512	0.335	M8
5672470	**M-18-M10-CA.750-4.331**	4.331	2.500	0.750	0.709	0.413	M10
5672834	**M-18-M10-CA.750-5.118**	5.118	3.000	0.750	0.709	0.413	M10
5672990	**M-18-M10-CA.750-6.693**	6.693	4.750	0.750	0.709	0.413	M10
5672835	**M-21-M12-CA1-5.157**	5.157	3.000	1.000	0.827	0.492	M12
5672991	**M-21-M12-CA1-6.142**	6.142	4.000	1.000	0.827	0.492	M12
5673353	**M-21-M12-CA1-7.126**	7.126	5.000	1.000	0.827	0.492	M12
5673588	**M-21-M12-CA1-8.110**	8.110	6.000	1.000	0.827	0.492	M12
5672471	**M-21-M12-CA1-9.094**	9.094	7.000	1.000	0.827	0.492	M12
5672992	**M-29-M16-CA1.25-6.3**	6.300	4.000	1.250	1.141	0.669	M16
5672836	**M-29-M16-CA1.25-8.27**	8.268	6.000	1.250	1.141	0.669	M16
5672993	**M-29-M16-CA1.25-10.2**	10.236	8.000	1.250	1.141	0.669	M16
5673706	**M-29-M16-CA1.25-12.2**	12.205	10.000	1.250	1.141	0.669	M16

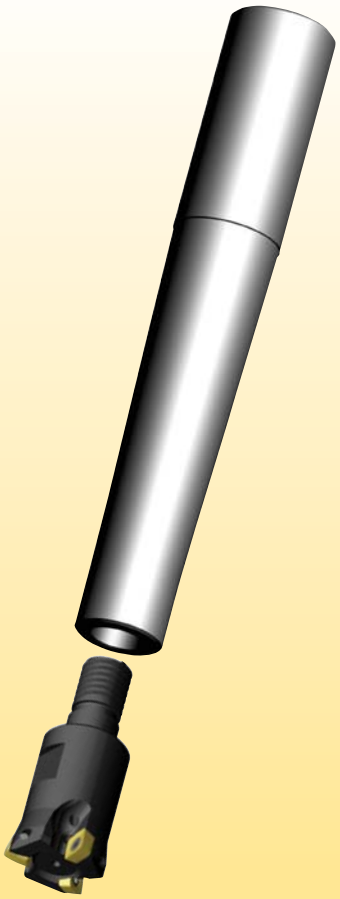
NOTE: Order example with cylindrical shank: M-13-M8-CA.625-3.543.



Shank Extension

Cylindrical shank extensions can be used with all modular heads found in several product family series within this catalog.

These extensions have the industry standard of metric threads.



Technical Advice

M	Modular adapter
13	Diameter in front of the modular shank (D) = 0.512" (13mm)
M8	Metric Thread (M)
CA.625	Cylindrical shank diameter 0.625" with through coolant
3.543	Total length of the body in Inches

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 catalog 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 maximizes every shift. **kennametal.com/novo**

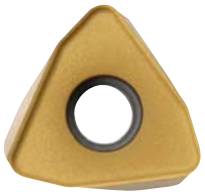
KenFeed™ 2X Series

Primary Application

KenFeed 2X is a double-sided trigon 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

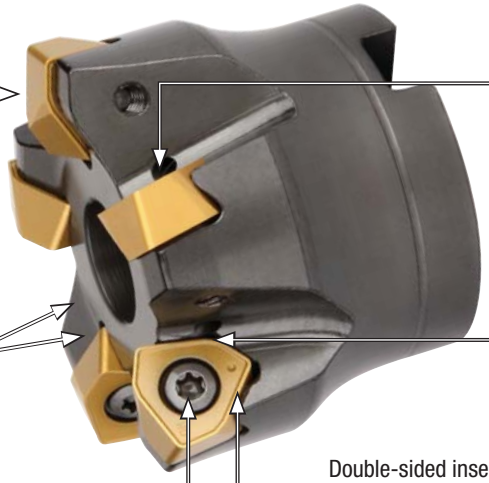
- Six cutting edges per insert. Double-sided solution with unique design.
- Two different topography styles cover any type of material, component, and application.
- KenFeed 2X inserts are specially suitable for long, deep applications, up to 10 x L/D ratio.



9mm IC Insert WOEJ094....
Up to 0.059" Ap max.
Diameter 1.000–3.000"

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.

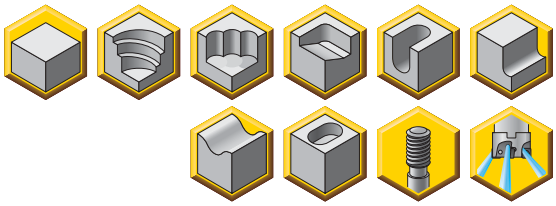
Platform designed for pocketing, ramping, and helical interpolations.

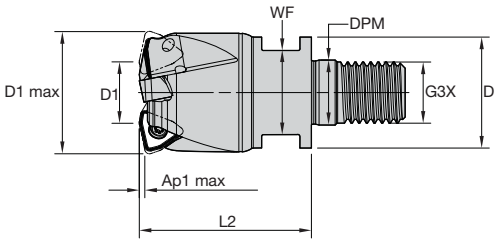
Just two topographies to cover all applications with easy selection.

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 0,1 IPT.
- Ideal for pocketing, ramping, and helical interpolations. Z-plunge capabilities.
- First choice for deep cavities or from 3 x D.







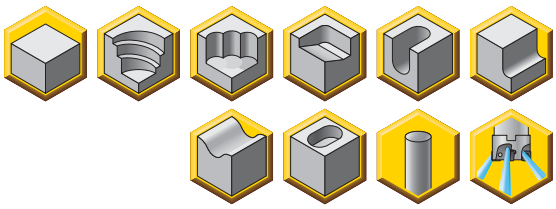
Screw-On End Mills

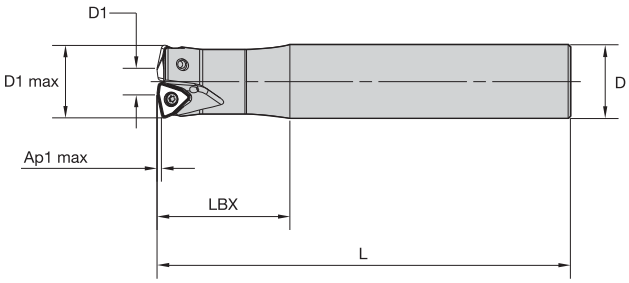
order number	catalog number	D1 max	D1	D	DPM	WF (mm)	G3X	L2	Ap1 max	Z	lbs	max RPM	insert 1
4109575	**KF2X100W0902M12L138**	1.000	.350	.827	.492	17	M12	1.380	.059	2	.20	36600	**WOEJ090512__**
4109577	**KF2X125W0903M16L169**	1.250	.622	1.142	.669	22	M16	1.690	.059	3	.45	31000	**WOEJ090512__**
4109579	**KF2X150W0904M16L169**	1.500	.869	1.142	.669	22	M16	1.691	.059	4	.51	27400	**WOEJ090512__**

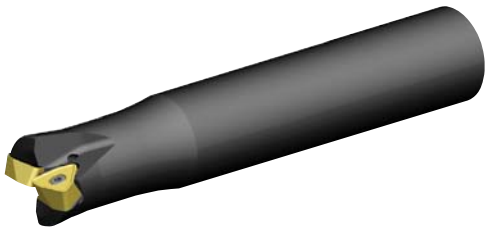
Spare Parts

D1 max	 insert screw	 in. lbs.	 Torx Plus driver
1.000	**MS2219**	16	**DT9IP**
1.250	**MS2219**	16	**DT9IP**
1.500	**MS2219**	16	**DT9IP**

- Dramatically improves MRR using the latest milling strategies.
- Engineered to run up to 0,1 IPT.
- Ideal for pocketing, ramping, and helical interpolations. Z-plunge capabilities.
- First choice for deep cavities or from 3 x D.







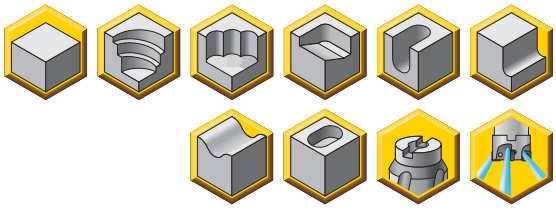
End Mills

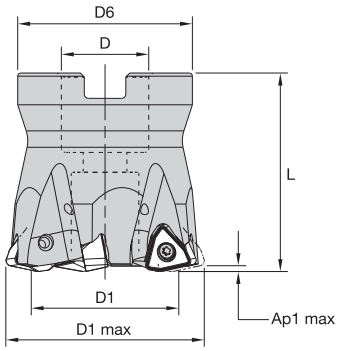
order number	catalog number	D1 max	D1	D	L	LBX	Ap1 max	Z	max RPM	insert 1	lbs
4109580	**KF2X100W0902C100L600**	1.000	.350	1.000	6.000	1.780	.059	2	36600	WOEJ090512__	1.15
4109581	**KF2X100W0902C100L800**	1.000	.350	1.000	8.000	1.780	.059	2	36600	WOEJ090512__	1.58
4109582	**KF2X125W0903C125L600**	1.250	.619	1.250	6.000	1.690	.059	3	31000	WOEJ090512__	1.84
4109593	**KF2X125W0903C125L800**	1.250	.622	1.250	8.000	1.690	.059	3	31000	WOEJ090512__	2.53
4109594	**KF2X150W0903C125L600**	1.500	.869	1.250	6.000	1.691	.059	3	27400	WOEJ090512__	1.94
4109595	**KF2X150W0903C125L800**	1.500	.869	1.250	8.000	1.691	.059	3	27400	WOEJ090512__	2.61

Spare Parts

D1 max	insert screw	in. lbs.	Torx Plus driver
1.000	**MS2219**	15	**DT9IP**
1.250	**MS2219**	15	**DT9IP**
1.500	**MS2219**	15	**DT9IP**

- Dramatically improves MRR using the latest milling strategies.
- Engineered to run up to 0,1 IPT.
- Ideal for pocketing, ramping, and helical interpolations. Z-plunge capabilities.
- First choice for deep cavities or from 3 x D.







Face Mills

order number	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z	max RPM	insert 1	lbs
4109596	**KF2X150W0904S050L157**	1.500	.869	.500	1.417	1.571	.059	4	27400	WOEJ090512__	.40
4109597	**KF2X200W0905S075L157**	2.000	1.366	.750	1.772	1.575	.059	5	22900	WOEJ090512__	.71
4109598	**KF2X200W0906S075L157**	2.000	1.366	.750	1.732	1.570	.059	6	22900	WOEJ090512__	.69
4109599	**KF2X250W0906S075L175**	2.500	1.864	.750	1.732	1.750	.059	6	20000	WOEJ090512__	1.16
4109600	**KF2X300W0907S100L175**	3.000	2.362	1.000	2.189	1.750	.059	7	18000	WOEJ090512__	1.77

Spare Parts

D1 max	insert screw	in. lbs.	Torx Plus driver	socket-head cap screw
1.500	**MS2219**	15.00	**DT9IP**	**S424**
2.000	**MS2219**	15.00	**DT9IP**	**S445**
2.500	**MS2219**	15.00	**DT9IP**	**S445**
3.000	**MS2219**	15.00	**DT9IP**	**S458**

Insert Selection Guide

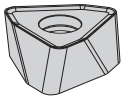
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.S..GD	KCPK30	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.S..GD	KCPK30	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P5–P6	.S..GD	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	–	–	**–**	**–**	–	–

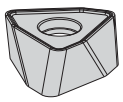
Indexable Inserts • WOEJ09...

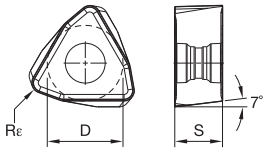
- Double-sided insert with six cutting edges.
- Unique and strong insert design that enables high-feed conditions, up to 0.1 IPT.
- -GD provides lower cutting forces; first choice for soft materials.

● 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

catalog number	D	S	Rε	cutting edges	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30
WOEJ090512SRGD	.350	.213	.048	6	–	●	●	–	●	●	●

- Double-sided insert with six cutting edges.
- Unique and strong insert design that enables high-feed conditions, up to 0,1 IPT.
- -HD geometry is the first choice for steels, high-strength steels, and cast iron.

WOEJ-HD

catalog number	D	S	Rε	cutting edges	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30
WOEJ090512SRHD	.351	.215	.048	6	–	●	●	–	●	●	–

Recommended Starting Feeds [IPT]

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	.045	**.089**	.141	.032	**.063**	.098	.024	**.047**	.072	.021	**.040**	.063	.019	**.037**	.057	.S..GD
.S..HD	.045	**.109**	.168	.032	**.077**	.116	.024	**.057**	.085	.021	**.049**	.074	.019	**.045**	.067	.S..HD

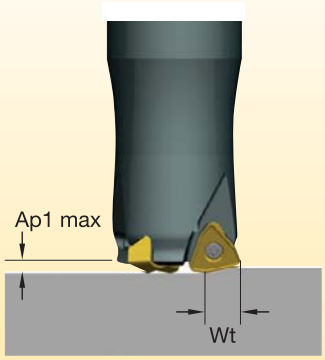
Feed Rate Guide • Plunging • IC09 • fz [in/tooth]

Insert Geometry	Programmed Feed per Tooth (fz) Max .118" insert engagement (ae radial engagement)			Insert Geometry
.S..GD	.004	**.008**	.012	.S..GD
.S..HD	.004	**.009**	.014	.S..HD

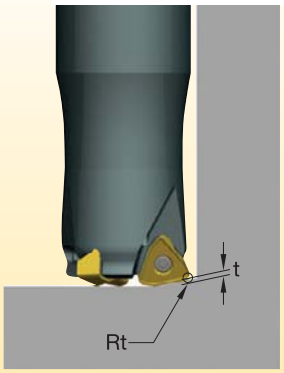
NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

General Programming Information for Applying KenFeed 2X • IC 09

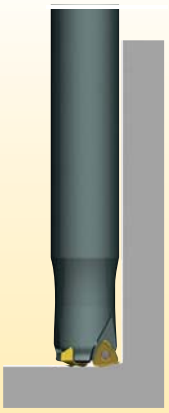
Rt	Wt	t
.110	.312	.045



Small Ap1 values and higher feed rates generate lower cutting forces versus traditional milling strategies.

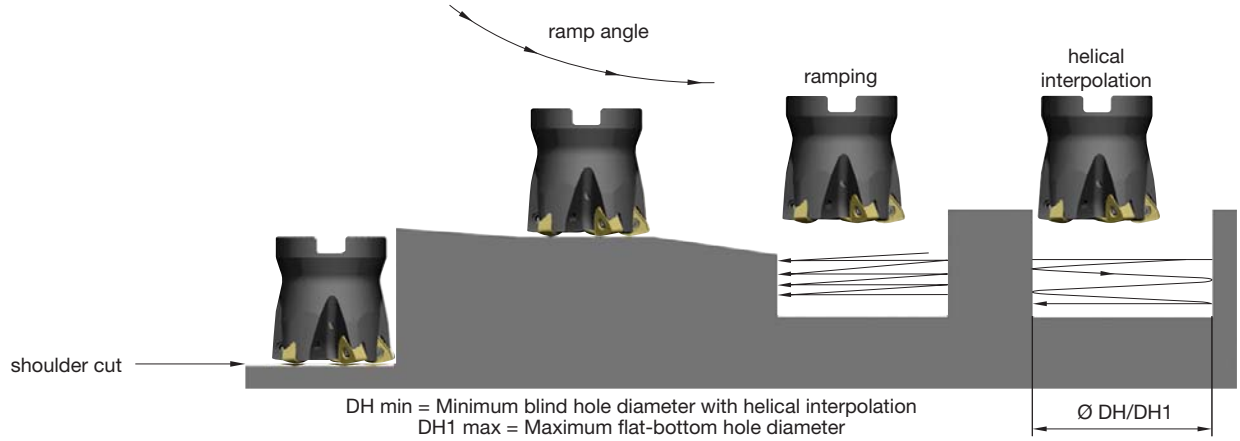


For CAM programming, the loads can be programmed as a toroidal tool type by using the Rt value as the insert radius.



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 • Inch



cutter type	catalog 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	**KF2X100W0902M12L138**	3.5°	5.2°	3.1°	1.291	1.35	2.0
	KF2X125W0902M16L169	1.9°	2.8°	1.7°	1.813	1.87	2.5
	KF2X125W0903M16L169	1.9°	2.8°	1.7°	1.813	1.87	2.5
	KF2X150W0903M16L169	1.4°	2.1°	1.2°	2.310	2.37	3.0
	KF2X150W0904M16L169	1.4°	2.1°	1.2°	2.310	2.37	3.0
End Mills	**KF2X100W0902C100L600**	3.5°	5.2°	3.1°	1.291	1.35	2.0
	KF2X100W0902C100L800	3.5°	5.2°	3.1°	1.291	1.35	2.0
	KF2X125W0903C125L600	1.9°	2.8°	1.7°	1.813	1.87	2.5
	KF2X125W0903C125L800	1.9°	2.8°	1.7°	1.813	1.87	2.5
	KF2X150W0903C125L600	1.4°	2.1°	1.2°	2.310	2.37	3.0
	KF2X150W0903C125L800	1.4°	2.1°	1.2°	2.310	2.37	3.0
Face Mills	**KF2X150W0904S050L157**	1.4°	2.1°	1.2°	2.310	2.37	3.0
	KF2X200W0905S075L157	1.0°	1.4°	0.8°	3.307	3.37	4.0
	KF2X200W0906S075L157	1.0°	1.4°	0.8°	3.307	3.37	4.0
	KF2X250W0906S075L175	0.7°	1.1°	0.6°	4.305	4.36	5.0
	KF2X300W0907S100L175	0.6°	1.0°	0.5°	5.303	5.36	6.0
	KF2X300W0907S125L200	0.6°	1.0°	0.5°	5.303	5.36	6.0

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

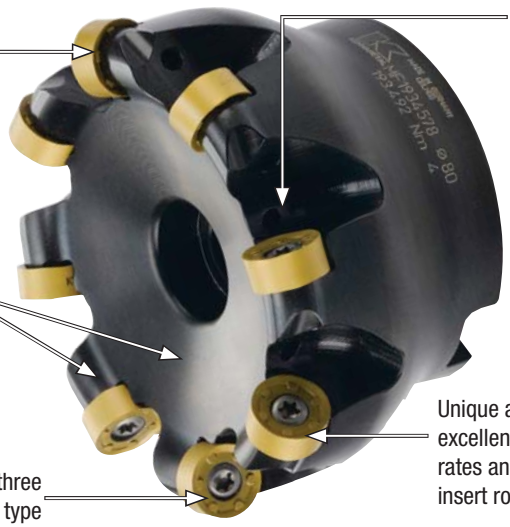


Rodeka 12
12mm IC insert
12 cutting edges



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.

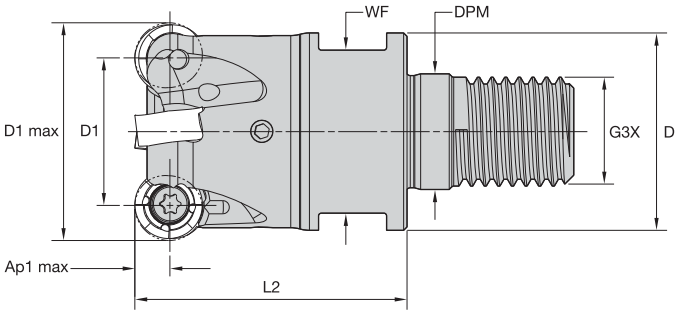
Higher clearance in bodies to permit pocketing, profiling, and 5-axis machining.

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 insert with eight indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.







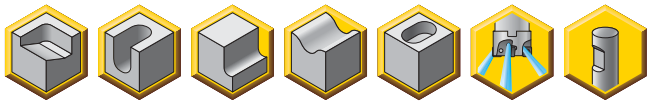
Screw-On End Mills

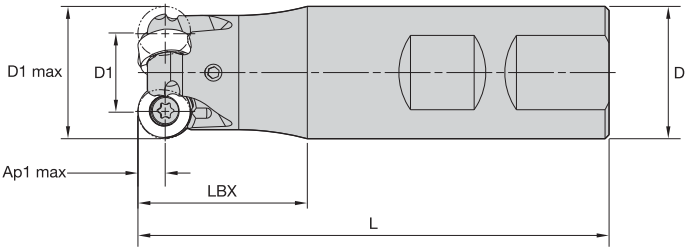
order number	catalog number	D1 max	D1	D	WF (mm)	G3X	DPM	L2	Ap1 max	Z	max ramp angle	lbs	max RPM	insert 1
5154366	**KDR100R1003M12L125**	1.00	.606	.827	17	M12	.490	1.250	.200	3	.6°	.17	54200	RN_J10T3M0_N__

Spare Parts

D1 max	insert screw	in. lbs.	Torx Plus driver
1.000	**191.848**	18	**170.025**

- Double-sided round insert with eight indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing, profiling, ramping, and helical interpolation capabilities.







Weldon End Mills

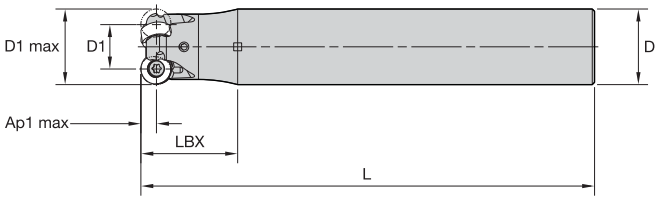
order number	catalog number	D1 max	D1	D	L	LBX	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
5154400	**KDR100R1003W100L200**	1.000	.606	1.000	4.280	2.000	.200	3	.6°	54200	RN_J10T3M0_N__	.74

Spare Parts

D1 max	insert screw	in. lbs.	Torx Plus driver
1.000	**191.848**	18	**170.025**

- Double-sided round insert with eight indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.







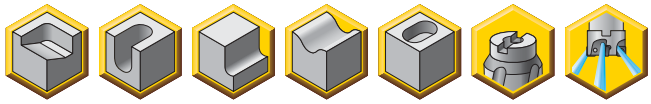
Cylindrical End Mills

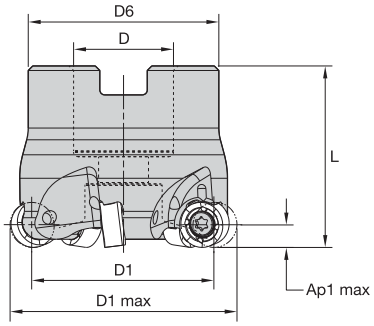
order number	catalog number	D1 max	D1	D	L	LBX	Ap1 max	Z	max ramp angle	lbs	max RPM	insert 1
5154402	**KDR100R1003C100L600**	1.000	.606	1.000	6.000	1.500	.200	3	.6°	1.15	54200	RN_J10T3M0_N__

Spare Parts

D1 max	insert screw	in. lbs.	Torx Plus driver
1.000	**191.848**	18	**170.025**

- Double-sided round insert with eight indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.







Shell Mills

order number	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
5154406	**KDR150R1005S050L157**	1.500	1.106	.500	1.300	1.570	.200	5	.4°	44300	RN_J10T3M0_N__	.43
5154408	**KDR200R1006S075L200**	2.000	1.606	.750	1.654	2.000	.200	6	.3°	38300	RN_J10T3M0_N__	1.02

Spare Parts

D1 max	 insert screw	 in. lbs.	 socket-head cap screw	 Torx Plus driver
1.500	**191.848**	18	**S422**	**–**
2.000	**191.848**	18	**S445**	**170.025**

Insert Selection Guide

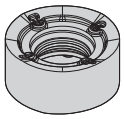
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄——►		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LDJ	KC725M	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.S..GD	KCPK30	**.S..HD**	**KCPK30**	.S..HD	KCPM40
P5–P6	.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**	–	–

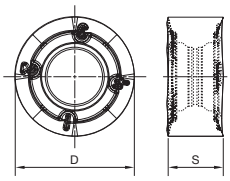
Indexable Inserts RN.J10..

- -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



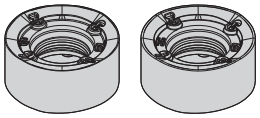
RNGJ10-LD

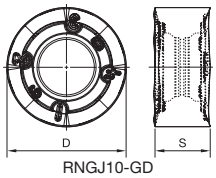
RNGJ10-LD

catalog number	D	S	hm	cutting edges	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ10T3M0ELDJ	.394	.187	.002	8	–	–	–	–	●	–	–	–	–	●
RNGJ10T3M0FLDJ	.394	.187	.002	8	●	–	–	–	–	–	–	–	–	–

Copy Milling

- -GD geometry is for general use in steel and stainless steel.


RNGJ10-GD RNPJ10-HD



RNGJ10-GD

● first choice
○ alternate choice

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

RNGJ10-GD

catalog number	D	S	hm	cutting edges	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ10T3M0SGDJ	.394	.187	.003	8	–	–	–	–	–	–	–	–	●	–

RNGJ10-GDJ

catalog number	D	S	hm	cutting edges	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ10T3M0SGDJ	.394	.187	.003	8	–	–	–	–	●	–	–	–	–	–

RNPJ10-GD

catalog number	D	S	hm	cutting edges	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNPJ10T3M0SGD	.394	.188	.003	8	–	–	–	●	–	–	●	●	–	–

- -HD geometry is the first choice for heavy machining high-strength steel and cast iron.

RNPJ10-HD

catalog number	D	S	hm	cutting edges	KC422M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNPJ10T3M0SHD	.394	.188	.007	8	–	–	–	–	●	●	●	●	–	–

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .200 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	.005	**.016**	.028	.004	**.011**	.020	.003	**.008**	.015	.002	**.007**	.013	.002	**.007**	.012	.F..LDJ
.E..LDJ	.005	**.017**	.030	.004	**.013**	.021	.003	**.009**	.016	.002	**.008**	.014	.002	**.008**	.013	.E..LDJ
.E..LD	.005	**.017**	.030	.004	**.013**	.021	.003	**.009**	.016	.002	**.008**	.014	.002	**.008**	.013	.E..LD
.S..GDJ	.009	**.021**	.032	.007	**.015**	.023	.005	**.011**	.017	.004	**.010**	.015	.004	**.009**	.014	.S..GDJ
.S..GD	.009	**.021**	.032	.007	**.015**	.023	.005	**.011**	.017	.004	**.010**	.015	.004	**.009**	.014	.S..GD
.S..HD	.009	**.021**	.033	.007	**.015**	.023	.005	**.011**	.017	.004	**.010**	.015	.004	**.009**	.014	.S..HD

At .070 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	.006	**.021**	.037	.005	**.015**	.027	.003	**.011**	.020	.003	**.010**	.017	.003	**.009**	.016	.F..LDJ
.E..LDJ	.006	**.023**	.040	.005	**.016**	.028	.003	**.012**	.021	.003	**.011**	.018	.003	**.010**	.017	.E..LDJ
.E..LD	.006	**.023**	.040	.005	**.016**	.028	.003	**.012**	.021	.003	**.011**	.018	.003	**.010**	.017	.E..LD
.S..GDJ	.012	**.027**	.043	.009	**.019**	.030	.007	**.014**	.022	.006	**.013**	.019	.005	**.012**	.018	.S..GDJ
.S..GD	.012	**.027**	.043	.009	**.019**	.030	.007	**.014**	.022	.006	**.013**	.019	.005	**.012**	.018	.S..GD
.S..HD	.012	**.028**	.043	.009	**.020**	.031	.007	**.015**	.023	.006	**.013**	.020	.005	**.012**	.018	.S..HD

At .040 Axial Depth of Cut (ap)

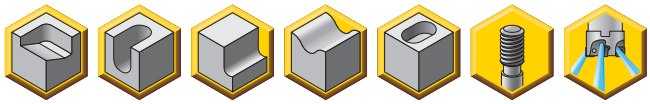
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LDJ	.008	**.026**	.048	.006	**.019**	.034	.004	**.014**	.025	.004	**.012**	.022	.004	**.011**	.020	.F..LDJ
.E..LDJ	.008	**.029**	.051	.006	**.021**	.036	.004	**.016**	.027	.004	**.014**	.023	.004	**.012**	.021	.E..LDJ
.E..LD	.008	**.029**	.051	.006	**.021**	.036	.004	**.016**	.027	.004	**.014**	.023	.004	**.012**	.021	.E..LD
.S..GDJ	.015	**.035**	.054	.011	**.025**	.038	.008	**.018**	.028	.007	**.016**	.025	.007	**.015**	.023	.S..GDJ
.S..GD	.015	**.035**	.054	.011	**.025**	.038	.008	**.018**	.028	.007	**.016**	.025	.007	**.015**	.023	.S..GD
.S..HD	.015	**.035**	.055	.011	**.025**	.039	.008	**.019**	.029	.007	**.016**	.025	.007	**.015**	.023	.S..HD

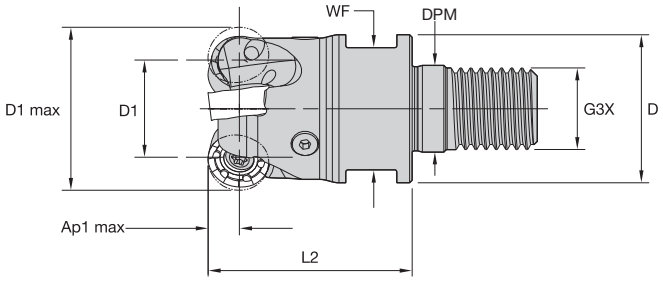
At .020 Axial Depth of Cut (ap)

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	.011	**.037**	.067	.008	**.026**	.047	.006	**.019**	.034	.005	**.017**	.030	.005	**.015**	.027	.F..LDJ
.E..LDJ	.011	**.041**	.072	.008	**.029**	.050	.006	**.021**	.037	.005	**.019**	.032	.005	**.017**	.029	.E..LDJ
.E..LD	.011	**.041**	.072	.008	**.029**	.050	.006	**.021**	.037	.005	**.019**	.032	.005	**.017**	.029	.E..LD
.S..GDJ	.021	**.048**	.077	.015	**.034**	.053	.011	**.025**	.039	.010	**.022**	.034	.009	**.020**	.031	.S..GDJ
.S..GD	.021	**.048**	.077	.015	**.034**	.053	.011	**.025**	.039	.010	**.022**	.034	.009	**.020**	.031	.S..GD
.S..HD	.021	**.049**	.078	.015	**.035**	.054	.011	**.026**	.040	.010	**.022**	.034	.009	**.020**	.031	.S..HD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Double-sided round insert with 12 indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.







Screw-On End Mills

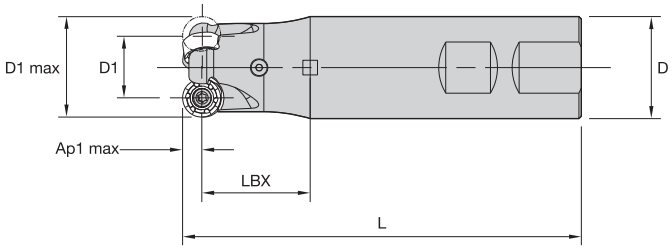
order number	catalog number	D1 max	D1	D	WF (mm)	G3X	DPM	L2	Ap1 max	Z	max ramp angle	lbs	max RPM	insert 1
4178116	**KDR150R1204M16L150**	1.50	1.028	1.142	24	M16	.670	1.50	.117	4	.5°	.42	35890	RN_J1204M0__

Spare Parts

D1 max	 insert screw	 in. lbs.	 Torx Plus driver
1.500	**193.492**	35	**170.025**

- Double-sided round insert with 12 indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing, profiling, ramping, and helical interpolation capabilities.







Weldon End Mills

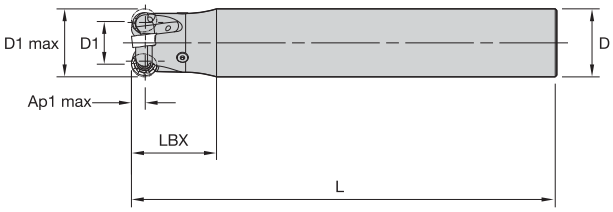
order number	catalog number	D1 max	D1	D	L	LBX	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
4178119	**KDR125R1202W100L200**	1.250	.778	1.000	4.280	2.000	.117	2	1.0°	39310	RN_J1204M0__	.85

Spare Parts

D1 max	insert screw	in. lbs.	Torx Plus driver
1.250	**193.492**	35	**170.025**

- Double-sided round insert with 12 indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.







Cylindrical End Mills

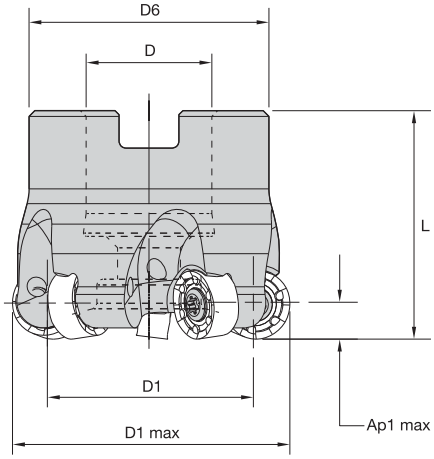
order number	catalog number	D1 max	D1	D	L	LBX	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
4178120	**KDR125R1202C125L900**	1.250	.778	1.250	9.000	1.500	.117	2	.9°	39310	RN_J1204M0__	2.79

Spare Parts

D1 max	insert screw	in. lbs.	Torx Plus driver
1.250	**193.492**	35	**170.025**

- Double-sided round insert with 12 indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.







Shell Mills

order number	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
4178122	**KDR150R1204S050L157**	1.500	1.028	.500	1.300	1.570	.117	4	.5°	35890	RN_J1204M0__	.39
4178123	**KDR200R1204S075L200**	2.000	1.528	.750	1.750	2.000	.117	4	.4°	31080	RN_J1204M0__	1.00
4178124	**KDR200R1205S075L200**	2.000	1.528	.750	1.750	2.000	.117	5	.4°	31080	RN_J1204M0__	.96
4178125	**KDR250R1207S075L200**	2.500	2.028	.750	1.750	2.000	.117	7	.3°	27800	RN_J1204M0__	1.41
4178126	**KDR300R1208S100L200**	3.000	2.528	1.000	2.189	2.000	.117	8	.2°	25370	RN_J1204M0__	2.01
5360215	**KDR300R1208S125L200**	3.000	2.528	1.250	2.875	2.000	.117	8	.5°	25370	RN_J1204M0__	2.60

Spare Parts

order number	D1 max	 insert screw	 in. lbs.	 socket-head cap screw	 socket-head cap screw with coolant groove	 low head cap screw with coolant groove	 wrench
4178122	1.500	**193.492**	35	**S422**	**S422CG**	**–**	**170.025**
4178123	2.000	**193.492**	35	**S445**	**S445CG**	**–**	**170.025**
4178124	2.000	**193.492**	35	**S445**	**S445CG**	**–**	**170.025**
4178125	2.500	**193.492**	35	**S445**	**S445CG**	**–**	**170.025**
4178126	3.000	**193.492**	35	**S458**	**S458CG**	**–**	**170.025**
5360215	3.000	**193.492**	35	**S467**	**–**	**S2172CG**	**170.025**

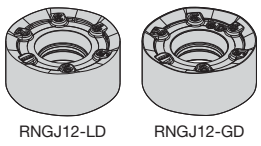
Insert Selection Guide

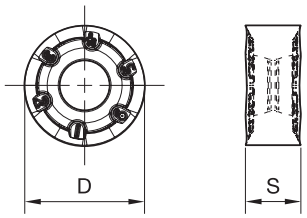
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LD	KCPK30	**.S..GD**	**KCPM40**	.S..HD	KCPM40
P3–P4	.E..LD	KCPK30	**.S..GD**	**KCPK30**	.S..HD	KCPM40
P5–P6	.E..LD	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 for 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

catalog number	D	S	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ1204M0ELD	.472	.187	.002	12	–	–	●	●	–	●	–	–	–
RNGJ1204M0ELDJ	.472	.187	.002	12	–	–	–	–	–	–	–	●	–
RNGJ1204M0FLDJ	.472	.187	.002	12	●	–	–	–	–	–	–	–	–

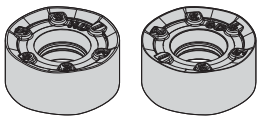
RNGJ12-GD

catalog number	D	S	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ1204M0SGD	.472	.187	.003	12	–	–	●	●	–	●	–	–	–
RNGJ1204M0SGDJ	.472	.187	.003	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.

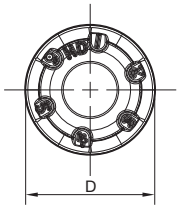
● first choice
○ alternate choice

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



RNGJ12-HD
RNPJ12-HD

RNPJ12-GD



RNGJ12-HD
RNPJ12-HD



RNGJ12-HD

catalog number	D	S	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ1204M0SHD	.472	.187	.007	12	–	–	–	●	–	●	–	–	–

RNPJ12-GD

catalog number	D	S	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNPJ1204M0SGD	.472	.187	.003	12	–	–	●	●	–	●	●	–	–

RNPJ12-HD

catalog number	D	S	hm	cutting edges	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNPJ1204M0SHD	.472	.187	.007	12	–	–	–	●	–	●	●	–	–

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .240 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	.005	**.016**	.030	.004	**.011**	.021	.003	**.008**	.016	.002	**.007**	.014	.002	**.007**	.013	.F..LDJ
.E..LDJ	.005	**.017**	.032	.004	**.013**	.023	.003	**.009**	.017	.002	**.008**	.015	.002	**.008**	.014	.E..LDJ
.E..LD	.005	**.017**	.032	.004	**.013**	.023	.003	**.009**	.017	.002	**.008**	.015	.002	**.008**	.014	.E..LD
.S..GDJ	.009	**.023**	.035	.007	**.017**	.025	.005	**.013**	.019	.004	**.011**	.016	.004	**.010**	.015	.S..GDJ
.S..GD	.009	**.023**	.035	.007	**.017**	.025	.005	**.013**	.019	.004	**.011**	.016	.004	**.010**	.015	.S..GD
.S..HD	.009	**.023**	.035	.007	**.017**	.025	.005	**.013**	.019	.004	**.011**	.016	.004	**.010**	.015	.S..HD

At .080 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	.007	**.021**	.040	.005	**.015**	.029	.004	**.011**	.021	.003	**.010**	.019	.003	**.009**	.017	.F..LDJ
.E..LDJ	.007	**.023**	.043	.005	**.017**	.030	.004	**.013**	.023	.003	**.011**	.020	.003	**.010**	.018	.E..LDJ
.E..LD	.007	**.023**	.043	.005	**.017**	.030	.004	**.013**	.023	.003	**.011**	.020	.003	**.010**	.018	.E..LD
.S..GDJ	.012	**.031**	.048	.009	**.022**	.034	.007	**.017**	.025	.006	**.015**	.022	.005	**.013**	.020	.S..GDJ
.S..GD	.012	**.031**	.048	.009	**.022**	.034	.007	**.017**	.025	.006	**.015**	.022	.005	**.013**	.020	.S..GD
.S..HD	.012	**.031**	.048	.009	**.022**	.034	.007	**.017**	.025	.006	**.015**	.022	.005	**.013**	.020	.S..HD

At .050 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	.008	**.026**	.049	.006	**.018**	.035	.004	**.014**	.026	.004	**.012**	.023	.003	**.011**	.021	.F..LDJ
.E..LDJ	.008	**.029**	.052	.006	**.020**	.037	.004	**.015**	.028	.004	**.013**	.024	.003	**.012**	.022	.E..LDJ
.E..LD	.008	**.029**	.052	.006	**.020**	.037	.004	**.015**	.028	.004	**.013**	.024	.003	**.012**	.022	.E..LD
.S..GDJ	.015	**.038**	.059	.011	**.027**	.041	.008	**.020**	.031	.007	**.018**	.027	.007	**.016**	.024	.S..GDJ
.S..GD	.015	**.038**	.059	.011	**.027**	.041	.008	**.020**	.031	.007	**.018**	.027	.007	**.016**	.024	.S..GD
.S..HD	.015	**.038**	.059	.011	**.027**	.041	.008	**.020**	.031	.007	**.018**	.027	.007	**.016**	.024	.S..HD

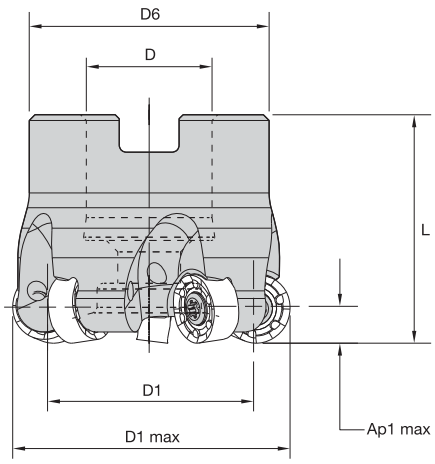
At .030 Axial Depth of Cut (ap)

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	.010	**.033**	.063	.007	**.023**	.044	.005	**.017**	.033	.005	**.015**	.029	.004	**.014**	.026	.F..LDJ
.E..LDJ	.010	**.036**	.067	.007	**.026**	.047	.005	**.019**	.035	.005	**.017**	.030	.004	**.015**	.028	.E..LDJ
.E..LD	.010	**.036**	.067	.007	**.026**	.047	.005	**.019**	.035	.005	**.017**	.030	.004	**.015**	.028	.E..LD
.S..GDJ	.019	**.049**	.075	.014	**.035**	.052	.010	**.026**	.039	.009	**.022**	.034	.008	**.021**	.031	.S..GDJ
.S..GD	.019	**.049**	.075	.014	**.035**	.052	.010	**.026**	.039	.009	**.022**	.034	.008	**.021**	.031	.S..GD
.S..HD	.019	**.049**	.075	.014	**.035**	.052	.010	**.026**	.039	.009	**.022**	.034	.008	**.021**	.031	.S..HD

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Double-sided round insert with 12 indexable positions.
- Anti-rotation features enable higher cutting data and extra stability.
- Pocketing and profiling capabilities.







Shell Mills

order number	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
5154910	**KDR200R1604S075L200**	2.000	1.370	.750	1.752	2.000	.156	4	.5°	26400	RN_J1605M0__	.93
5154913	**KDR300R1607S100L200**	3.000	2.370	1.000	2.189	2.000	.156	7	.3°	20100	RN_J1605M0__	1.92
5360214	**KDR300R1607S125L200**	3.000	2.370	1.250	2.875	2.000	.156	7	.5°	20100	RN_J1605M0__	2.33
5154914	**KDR400R1606S150L200**	4.000	3.370	1.500	3.812	2.000	.156	6	.4°	16800	RNGJ1605M0__	3.99
5154915	**KDR400R1608S150L200**	4.000	3.370	1.500	3.812	2.000	.156	8	.4°	16800	RNGJ1605M0__	4.04
5154916	**KDR500R1608S150L200**	5.000	4.370	1.500	3.380	2.000	.156	8	.2°	14800	RN_J1605M0__	5.08

Spare Parts

D1 max	 insert screw	 in. lbs.	 socket-head cap screw	 wrench	 coolant screw assembly
2.000	**192.932**	35	**S446**	**170.026**	**–**
3.000	**192.932**	35	**S458**	**170.026**	**–**
3.000	**MS2260**	35	**S467**	**170.026**	**S2172CG**
4.000	**MS2260**	35	**–**	**170.026**	**–**
5.000	**MS2260**	35	**–**	**170.026**	**–**

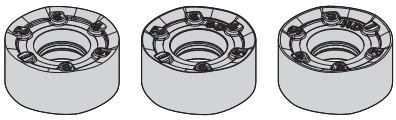
Insert Selection Guide

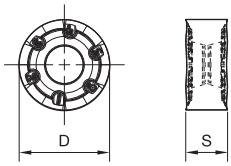
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LDJ	KC725M	.S..GD	KCPM40	.S..HD	KCPM40
P3–P4	.E..LDJ	KC522M	.S..GD	KCPK30	.S..HD	KCPM40
P5–P6	.E..LDJ	KC725M	.S..GD	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	–	–	–	–	–	–

- -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.
- -HD geometry is the first choice for heavy machining high-strength steel and cast iron.

● first choice
○ alternate choice

		KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
P			○	●		●	●		○
M			●	●		○	○	○	●
K		●	○		●	○			
N									
S			●	●				●	●
H									


RNGJ16-LD RNPJ16-GD RNPJ16-HD



RNGJ16-LD

RNGJ16-LD

catalog number	D	S	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNGJ1605M0ELDJ	.630	.217	.002	12	–	●	●	–	–	–	–	–

RNPJ16-GD

catalog number	D	S	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNPJ1605M0SGD	.630	.217	.003	12	–	●	●	–	●	●	–	●

RNPJ16-HD

catalog number	D	S	hm	cutting edges	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
RNPJ1605M0SHD	.630	.217	.009	12	●	–	●	●	●	●	–	–

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .320 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	.005	**.017**	.031	.004	**.013**	.023	.003	**.009**	.017	.002	**.008**	.015	.002	**.008**	.014	.E..LDJ
.E..LD	.005	**.017**	.031	.004	**.013**	.023	.003	**.009**	.017	.002	**.008**	.015	.002	**.008**	.014	.E..LD
.S..GD	.009	**.020**	.035	.007	**.014**	.025	.005	**.011**	.019	.004	**.009**	.016	.004	**.009**	.015	.S..GD
.S..HD	.009	**.023**	.037	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..HD

At .100 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	.007	**.024**	.043	.005	**.017**	.031	.004	**.013**	.023	.003	**.011**	.020	.003	**.010**	.018	.E..LDJ
.E..LD	.007	**.024**	.043	.005	**.017**	.031	.004	**.013**	.023	.003	**.011**	.020	.003	**.010**	.018	.E..LD
.S..GD	.013	**.027**	.048	.009	**.019**	.034	.007	**.015**	.026	.006	**.013**	.022	.005	**.012**	.020	.S..GD
.S..HD	.013	**.032**	.051	.009	**.023**	.037	.007	**.017**	.027	.006	**.015**	.024	.005	**.014**	.022	.S..HD

At .060 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	.008	**.030**	.054	.006	**.021**	.039	.005	**.016**	.029	.004	**.014**	.025	.004	**.013**	.023	.E..LDJ
.E..LD	.008	**.030**	.054	.006	**.021**	.039	.005	**.016**	.029	.004	**.014**	.025	.004	**.013**	.023	.E..LD
.S..GD	.016	**.034**	.060	.011	**.024**	.043	.009	**.018**	.032	.007	**.016**	.028	.007	**.014**	.025	.S..GD
.S..HD	.016	**.040**	.064	.011	**.029**	.046	.009	**.021**	.034	.007	**.019**	.030	.007	**.017**	.027	.S..HD

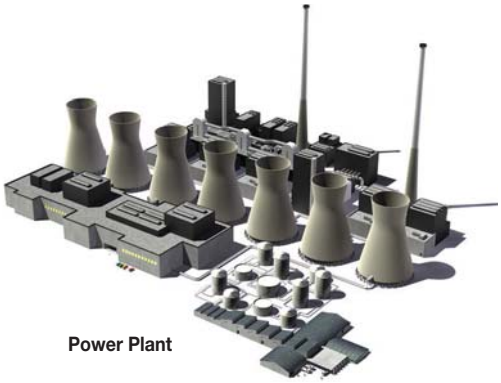
At .040 Axial Depth of Cut (ap)

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	.010	**.036**	.066	.007	**.026**	.047	.005	**.019**	.035	.005	**.017**	.030	.004	**.015**	.028	.E..LDJ
.E..LD	.010	**.036**	.066	.007	**.026**	.047	.005	**.019**	.035	.005	**.017**	.030	.004	**.015**	.028	.E..LD
.S..GD	.019	**.041**	.073	.014	**.029**	.052	.010	**.022**	.039	.009	**.019**	.034	.008	**.017**	.031	.S..GD
.S..HD	.019	**.048**	.078	.014	**.034**	.056	.010	**.026**	.041	.009	**.022**	.036	.008	**.021**	.033	.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.



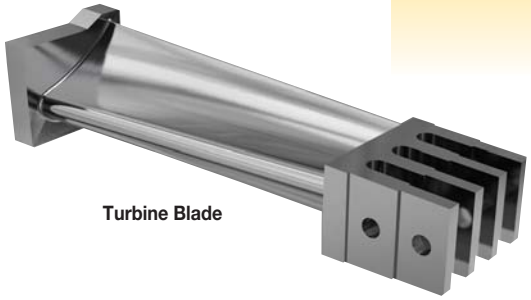
Power Plant



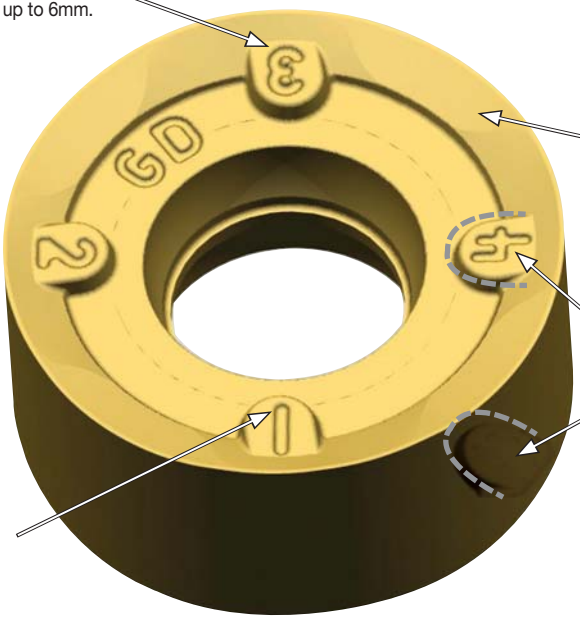
Steam Turbine



Rodeka 12X



Turbine Blade



Four indexes per side, in total eight cutting edges. With higher Ap capabilities, up to 6mm.

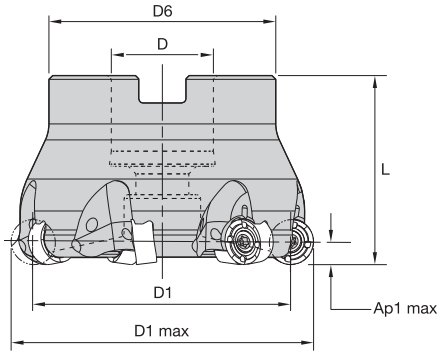
Specific high positive geometries with improved chip forming and higher tool life.

Insert location twisted by 45° between top and bottom side for equal performance over all eight cutting edges.

Unique anti-rotation feature with higher contact area for excellent stability, allowing higher feed rates.

- 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 • Inch

order number	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
5104420	**KDR40Z04S16RN12X**	1.575	1.102	.630	1.496	1.575	.236	4	.5°	35020	RN_J1204M0___	.51
5104421	**KDR50Z05S22RN12X**	1.970	1.496	.866	1.650	1.570	.236	5	.7°	31330	RN_J1204M0___	.67
5104424	**KDR63Z06S22RN12X**	2.480	2.008	.866	1.930	1.570	.236	6	.5°	27910	RN_J1204M0___	1.06
5104426	**KDR80Z07S27RN12X**	3.150	2.677	1.063	2.360	1.970	.236	7	.3°	24760	RN_J1204M0___	2.31

Spare Parts

D1 max	insert screw	in. lbs.	socket-head cap screw	socket-head cap screw with coolant groove	wrench
1.575	**193.492**	35	**–**	**MS1294CG**	**170.025**
1.970	**193.492**	35	**–**	**MS1234CG**	**170.025**
2.480	**193.492**	35	**–**	**MS1234CG**	**170.025**
3.150	**193.492**	35	**MS2038**	**MS2038CG**	**170.025**

NOTE: Socket-head cap screws with coolant groove need to be purchased separately.

Insert Selection Guide

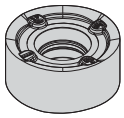
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LDJX	KC522M	**.E..LDJX**	**KC725M**	.S..GDJX	KC725M
P3–P4	.E..LDJX	KC522M	**.E..LDJX**	**KC725M**	.S..GDJX	KC522M
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	–	–	**–**	**–**	–	–

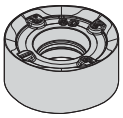
Indexable Inserts

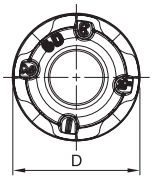
- -LD geometry is for general use on blades from a solid block.
- -LD geometry is the first choice for stainless steel and titanium machining at lower cutting forces.
- -GD geometry is the first choice for forged blades.
- -GD geometry is for general use in steel and stainless steel.

● first choice
○ alternate choice

		KC522M	KC725M	KCSM30
P		○	●	
M		●	●	○
K		○		
N				
S		●	●	●
H		○		


RNGJ12-LDX


RNGJ12-GDX



RNGJ12-GDX

RNGJ12-LDX

catalog number	D	S	hm	cutting edges	KC522M	KC725M	KCSM30
RNGJ1204M0ENLDJX	.472	.187	.001	8	●	–	–

RNGJ12-GDX

catalog number	D	S	hm	cutting edges	KC522M	KC725M	KCSM30
RNGJ1204M0SNGDJX	.472	.187	.003	8	–	●	–

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .240 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	.005	**.019**	.034	.003	**.014**	.024	.003	**.011**	.018	.002	**.009**	.016	.002	**.008**	.014	.E..LDJX
.S..GDJX	.009	**.023**	.035	.007	**.017**	.025	.005	**.013**	.019	.004	**.011**	.016	.004	**.010**	.015	.S..GDJX

At .080 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	.006	**.026**	.045	.004	**.019**	.032	.003	**.014**	.024	.003	**.012**	.021	.003	**.011**	.019	.E..LDJX
.S..GDJX	.012	**.031**	.047	.009	**.022**	.034	.007	**.017**	.025	.006	**.015**	.022	.005	**.013**	.020	.S..GDJX

At .050 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	.007	**.032**	.055	.005	**.023**	.039	.004	**.017**	.029	.004	**.015**	.026	.003	**.014**	.023	.E..LDJX
.S..GDJX	.015	**.038**	.057	.011	**.027**	.041	.008	**.020**	.031	.007	**.018**	.027	.007	**.016**	.024	.S..GDJX

At .030 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	.009	**.040**	.070	.007	**.029**	.050	.005	**.022**	.037	.004	**.019**	.032	.004	**.017**	.030	.E..LDJX
.S..GDJX	.019	**.048**	.073	.014	**.034**	.052	.010	**.026**	.039	.009	**.022**	.034	.008	**.021**	.031	.S..GDJX

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

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KM4X is designed to take on your most aggressive machining jobs. This next generation KM™ spindle interface should be your first choice for heavy-duty machining applications. It's especially suited for large structural components, like titanium aerospace components.

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Primary Application

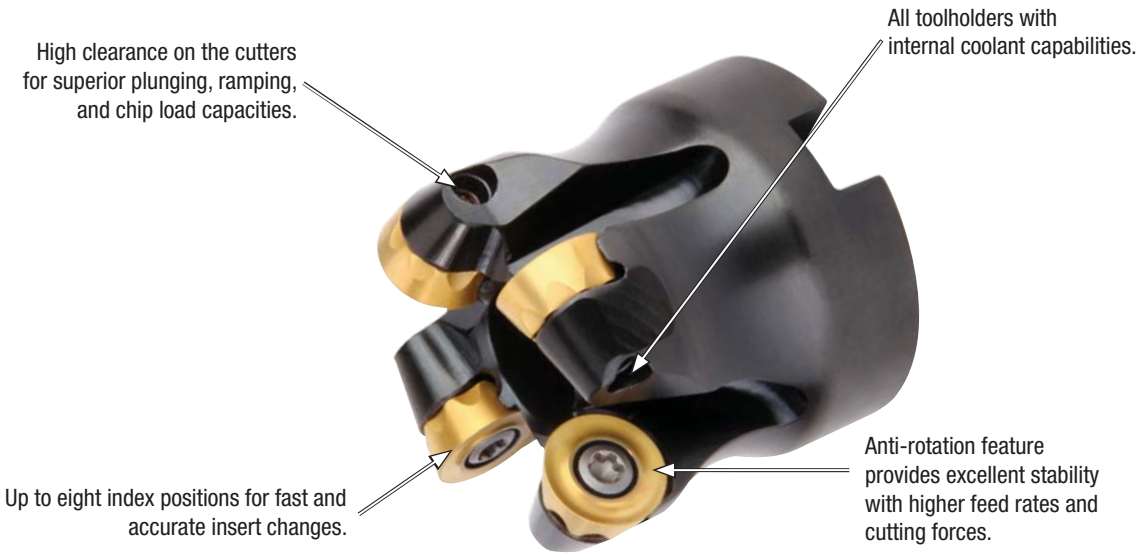
Specially developed for machining titanium and stainless steel. KSRM platform enables you to pocket, profile, ramp, and plunge with consistent performance and outstanding metal removal rates with the lowest cutting forces.

Features and Benefits

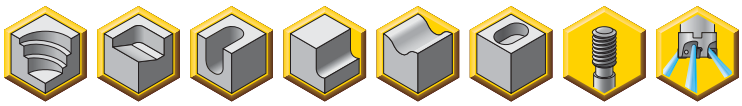
- Up to eight cutting edges per insert.
- Anti-rotation feature achieves excellent stability.
- Engineered to provide longer tool life in titanium and stainless steel.
- Roughing and semi-finishing operations with lower cutting forces.

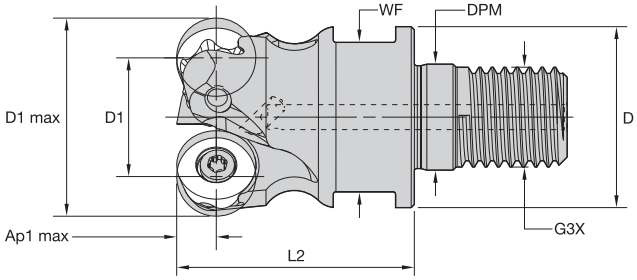





High clearance on the cutters for superior plunging, ramping, and chip load capacities.
All toolholders with internal coolant capabilities.
Up to eight index positions for fast and accurate insert changes.
Anti-rotation feature provides excellent stability with higher feed rates and cutting forces.

- Engineered for titanium and stainless steel machining.
- Anti-rotation components feature eight indexable positions.
- Pocketing, ramping, plunging, and helical interpolation capabilities.





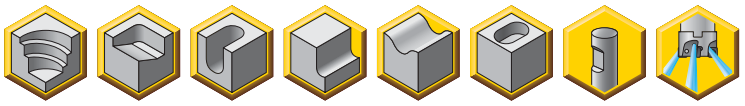


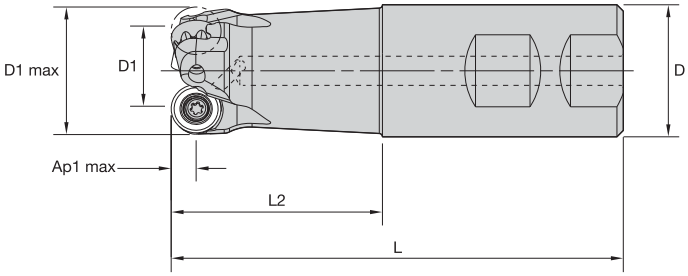
Screw-On End Mills

order number	catalog number	D1 max	D1	D	DPM	G3X	L2	WF (mm)	Ap1 max	Z	max ramp angle	max RPM	lbs	insert 1
4042688	**BMD125R1203M16L150**	1.250	.778	1.142	.670	M16	1.500	22	.236	3	5.7°	43500	.35	RP..T1204M0..
4042690	**BMD150R1204M16L150**	1.500	1.028	1.142	.670	M16	1.500	22	.236	4	9.2°	39700	.41	RP..T1204M0..

Spare Parts

D1 max	insert screw	in. lbs.	Torx Plus driver
1.250	**MS2077**	20	**DT15IP**
1.500	**MS2077**	20	**DT15IP**







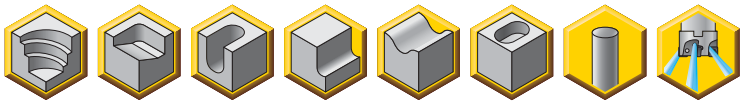
Weldon End Mills

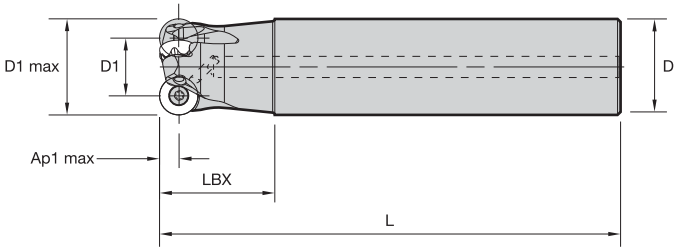
order number	catalog number	D1 max	D1	D	L	L2	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
4042691	**BMD125R1203W125L200**	1.250	.778	1.250	4.280	2.000	.236	3	5.7°	43500	RP..T1204M0..	1.17
3891915	**BMD150R1204W150L200**	1.500	1.028	1.500	4.690	2.000	.236	4	9.2°	39700	RP..T1204M0..	1.94

Spare Parts

D1 max	insert screw	in. lbs.	Torx Plus driver
1.250	**MS2077**	20	**DT15IP**
1.500	**MS2077**	20	**DT15IP**

- Engineered for titanium and stainless steel machining.
- Anti-rotation components feature eight indexable positions.
- Pocketing, ramping, plunging, and helical interpolation capabilities.







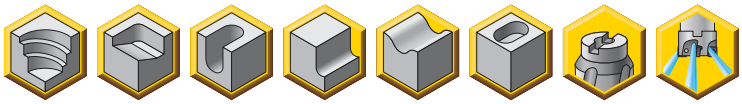
Cylindrical End Mills

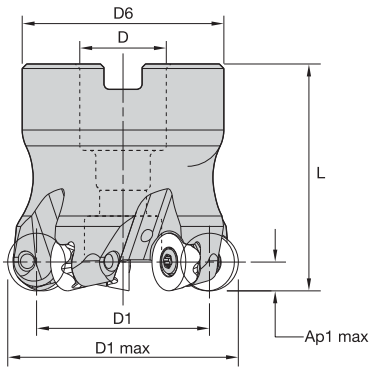
order number	catalog number	D1 max	D1	D	L	L2	LBX	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
4042692	**BMD125R1203C125L700**	1.250	.778	1.250	7.000	1.575	1.575	.236	3	5.7°	43500	RP..T1204M0..	2.11
4042713	**BMD150R1203C125L800**	1.500	1.028	1.250	8.000	1.575	1.575	.236	3	9.8°	39700	RP..T1204M0..	2.54

Spare Parts

D1 max	 insert screw	 in. lbs.	 Torx Plus driver
1.250	**MS2077**	20	**DT15IP**
1.500	**MS2077**	20	**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	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
3891882	**BMD150R1204S050L158**	1.500	1.028	.500	1.440	1.575	.236	4	9.2°	39700	RP..T1204M0#	.47
4042714	**BMD200R1203S075L200**	2.000	1.528	.750	1.752	2.000	.236	3	10.5°	34400	RP..T1204M0#	1.02
4042715	**BMD200R1205S075L200**	2.000	1.528	.750	1.752	2.000	.236	5	7.7°	34400	RP..T1204M0#	1.01
4042716	**BMD250R1207S100L200**	2.500	2.028	1.000	2.190	2.000	.236	7	4.1°	30800	RP..T1204M0#	1.61
3885499	**BMD300R1206S100L200**	3.000	2.528	1.000	2.752	2.000	.236	6	5.7°	28100	RP..T1204M0#	2.54
4042717	**BMD300R1208S100L200**	3.000	2.528	1.000	2.752	2.000	.236	8	3.5°	28100	RP..T1204M0#	2.57
4042718	**BMD400R1207S125L200**	4.000	3.528	1.250	2.878	2.000	.236	7	3.3°	23800	RP..T1204M0#	3.23
4002349	**BMD400R1209S125L200**	4.000	3.528	1.250	2.878	2.000	.236	9	3.0°	23800	RP..T1204M0#	3.20

Spare Parts

D1 max	 insert screw	 in. lbs.	 Torx Plus driver	 socket-head cap screw	 socket-head cap screw with coolant groove	 coolant lock screw assembly
1.500	**MS2077**	20	**DT15IP**	**S424**	**S422CG**	**—**
2.000	**MS2077**	20	**DT15IP**	**S446**	**S446CG**	**—**
2.500	**MS2077**	20	**DT15IP**	**S459**	**S459CG**	**—**
3.000	**MS2077**	20	**DT15IP**	**S459**	**S459CG**	**—**
4.000	**MS2077**	20	**DT15IP**	**—**	**—**	**S2162C**

NOTE: Socket-head cap screw with coolant groove must be ordered separately.

Insert Selection Guide

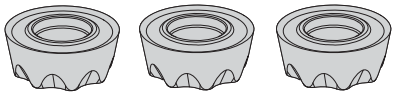
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		←	→	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.S..GE	KCPK30	**.S..GDX**	**KCPM40**	.S..GP	KCPM40
P3–P4	.S..GE	KCPK30	**.S..GDX**	**KCPM40**	.S..GP	KCPM40
P5–P6	.S..GEJ	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	–	–	**–**	**–**	–	–

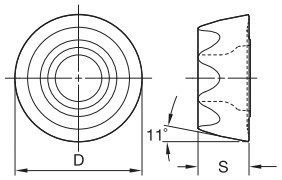
Indexable Inserts

- -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-LE RPET-GEJ



RPET-LEJ

RPET-LEJ

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1204M0ELEJ	.472	.188	.002	8	●	●	●	–	–	●	–

RPET-LE

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1204M0ELE	.472	.188	.002	8	–	–	●	●	–	–	–

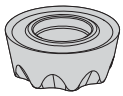
RPET-GEJ

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1204M0SGEJ	.472	.188	.005	8	–	●	●	–	–	●	–

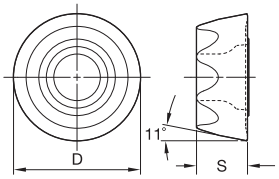
- -SGEJ and -ELEJ are the first choice for titanium machining.
- -ELEJ is the first choice for lower cutting forces to avoid built-up edges.
- -SGEJ geometry for general purpose in roughing operations.

● first choice
○ alternate choice

		KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
P			○	●	●	●		○
M			●	●	○	●	○	●
K			○		○			
N		●						
S			●	●		○	●	●
H								



RPET-GE

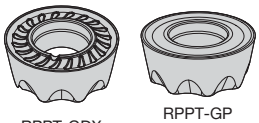


RPET-GE

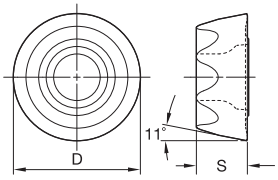
RPET-GE

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1204M0SGE	.472	.188	.005	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

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPPT1204M0SGDX	.472	.187	.007	8	–	–	●	–	●	–	–

RPPT-GP

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPPT1204M0SGP	.472	.188	.005	8	–	–	●	●	●	–	–

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .240 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	.007	**.019**	.030	.005	**.013**	.021	.004	**.010**	.016	.003	**.009**	.014	.003	**.008**	.013	.E..LEJ
.E..LE	.007	**.019**	.030	.005	**.013**	.021	.004	**.010**	.016	.003	**.009**	.014	.003	**.008**	.013	.E..LE
.S..GEJ	.009	**.021**	.033	.007	**.015**	.023	.005	**.011**	.017	.004	**.010**	.015	.004	**.009**	.014	.S..GEJ
.S..GE	.009	**.021**	.033	.007	**.015**	.023	.005	**.011**	.017	.004	**.010**	.015	.004	**.009**	.014	.S..GE
.S..GDX	.009	**.023**	.035	.007	**.017**	.025	.005	**.013**	.019	.004	**.011**	.016	.004	**.010**	.015	.S..GDX
.S..GP	.009	**.023**	.035	.007	**.017**	.025	.005	**.013**	.019	.004	**.011**	.016	.004	**.010**	.015	.S..GP

At .080 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	.009	**.025**	.040	.006	**.018**	.028	.005	**.013**	.021	.004	**.012**	.018	.004	**.011**	.017	.E..LEJ
.E..LE	.009	**.025**	.040	.006	**.018**	.028	.005	**.013**	.021	.004	**.012**	.018	.004	**.011**	.017	.E..LE
.S..GEJ	.012	**.028**	.044	.009	**.020**	.031	.007	**.015**	.023	.006	**.013**	.020	.005	**.012**	.019	.S..GEJ
.S..GE	.012	**.028**	.044	.009	**.020**	.031	.007	**.015**	.023	.006	**.013**	.020	.005	**.012**	.019	.S..GE
.S..GDX	.012	**.031**	.048	.009	**.022**	.034	.007	**.017**	.025	.006	**.015**	.022	.005	**.013**	.020	.S..GDX
.S..GP	.012	**.031**	.048	.009	**.022**	.034	.007	**.017**	.025	.006	**.015**	.022	.005	**.013**	.020	.S..GP

At .050 Axial Depth of Cut (ap)

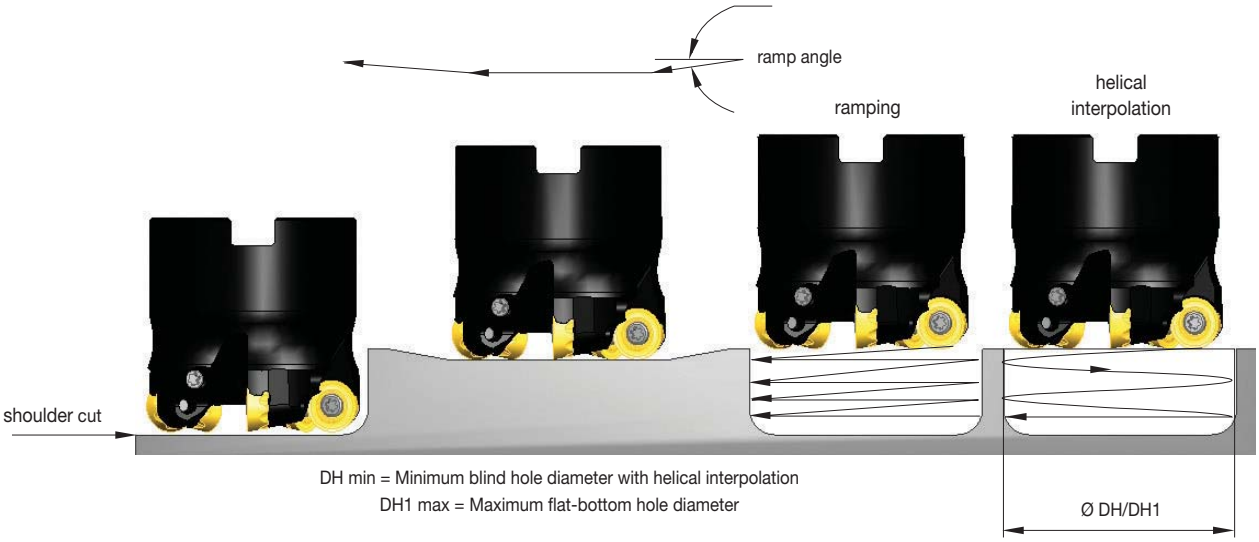
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LEJ	.011	**.031**	.049	.008	**.022**	.035	.006	**.016**	.026	.005	**.014**	.022	.005	**.013**	.020	.E..LEJ
.E..LE	.011	**.031**	.049	.008	**.022**	.035	.006	**.016**	.026	.005	**.014**	.022	.005	**.013**	.020	.E..LE
.S..GEJ	.015	**.034**	.054	.011	**.025**	.038	.008	**.018**	.028	.007	**.016**	.025	.007	**.015**	.023	.S..GEJ
.S..GE	.015	**.034**	.054	.011	**.025**	.038	.008	**.018**	.028	.007	**.016**	.025	.007	**.015**	.023	.S..GE
.S..GDX	.015	**.038**	.059	.011	**.027**	.041	.008	**.020**	.031	.007	**.018**	.027	.007	**.016**	.024	.S..GDX
.S..GP	.015	**.038**	.059	.011	**.027**	.041	.008	**.020**	.031	.007	**.018**	.027	.007	**.016**	.024	.S..GP

At .030 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	.013	**.039**	.062	.010	**.028**	.044	.007	**.021**	.032	.006	**.018**	.028	.006	**.016**	.026	.E..LEJ
.E..LE	.013	**.039**	.062	.010	**.028**	.044	.007	**.021**	.032	.006	**.018**	.028	.006	**.016**	.026	.E..LE
.S..GEJ	.019	**.044**	.069	.014	**.031**	.049	.010	**.023**	.036	.009	**.020**	.031	.008	**.018**	.029	.S..GEJ
.S..GE	.019	**.044**	.069	.014	**.031**	.049	.010	**.023**	.036	.009	**.020**	.031	.008	**.018**	.029	.S..GE
.S..GDX	.019	**.049**	.075	.014	**.035**	.052	.010	**.026**	.039	.009	**.022**	.034	.008	**.021**	.031	.S..GDX
.S..GP	.019	**.049**	.075	.014	**.035**	.052	.010	**.026**	.039	.009	**.022**	.034	.008	**.021**	.031	.S..GP

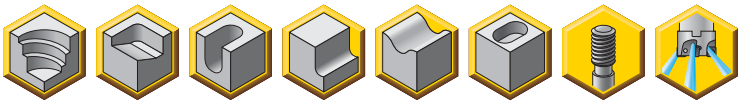
NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

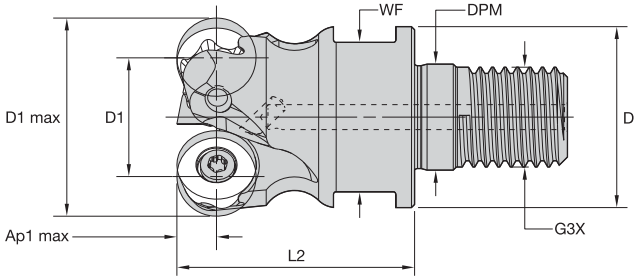
Maximum Linear Ramping and Helical Interpolation from Solid



catalog number	max ramp angle	max plunging depth	min hole diameter (DH min)	max flat-bottom hole diameter (DH1 max)	max diameter (no flat bottom)
BMD125R1203M16L150	5.7°	0.061	1.719	2.028	2.5
BMD150R1204M16L150	9.2°	0.130	2.112	2.528	3.0
BMD125R1203W125L200	5.7°	0.061	1.719	2.028	2.5
BMD150R1204W150L200	9.2°	0.130	2.112	2.528	3.0
BMD125R1203C125L700	5.7°	0.061	1.719	2.028	2.5
BMD150R1203C125L800	9.8°	0.138	2.104	2.528	3.0
BMD150R1204S050L158	9.2°	0.130	2.112	2.528	3.0
BMD200R1203S075L200	10.5°	0.236	3.058	3.528	4.0
BMD200R1205S075L200	7.7°	0.173	3.074	3.528	4.0
BMD250R1207S100L200	4.1°	0.130	4.114	4.528	5.0
BMD300R1206S100L200	5.7°	0.228	5.048	5.528	6.0
BMD300R1208S100L200	3.5°	0.138	5.078	5.528	6.0
BMD400R1207S125L200	3.3°	0.189	7.068	7.528	8.0
BMD400R1209S125L200	3.0°	0.173	7.525	7.528	8.0

- Engineered for titanium and stainless steel machining.
- Anti-rotation components feature eight indexable positions.
- Pocketing, ramping, plunging, and helical interpolation capabilities.







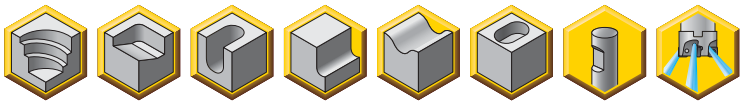
Screw-On End Mills

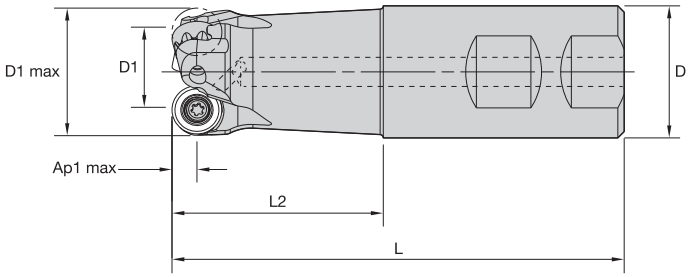
order number	catalog number	D1 max	D1	D	DPM	G3X	L2	WF (mm)	Ap1 max	Z	max ramp angle	max RPM	lbs	insert 1
4043037	BMD150R1603M16	1.500	.870	1.142	.670	M16	1.500	22	.315	3	9.9°	28000	.35	RP..T1605M0..

Spare Parts

D1 max	insert screw	in. lbs.	Torx Plus driver
1.500	MS-2071	35	DT15IP

Weldon® End Mills







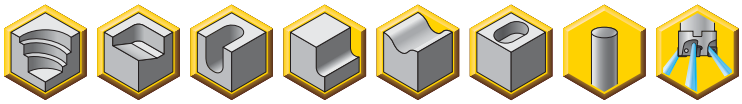
Weldon End Mills

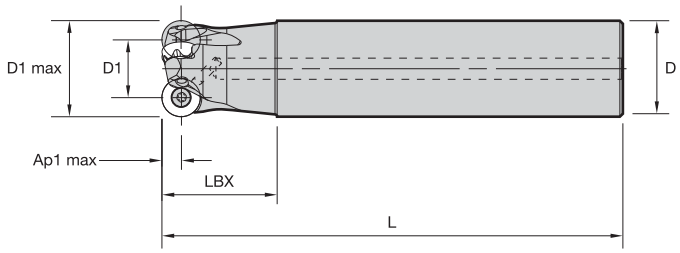
order number	catalog number	D1 max	D1	D	L	L2	Ap1 max	Z	lbs	max ramp angle	max RPM	insert 1
4043038	BMD150R1603W125L200	1.500	.870	1.250	4.280	2.000	.315	3	1.24	9.9°	28000	RP..T1605M0..

Spare Parts

D1 max	insert screw	in. lbs.	Torx Plus driver
1.500	MS-2071	35	DT15IP

- Engineered for titanium and stainless steel machining.
- Anti-rotation components feature eight indexable positions.
- Pocketing, ramping, plunging, and helical interpolation capabilities.







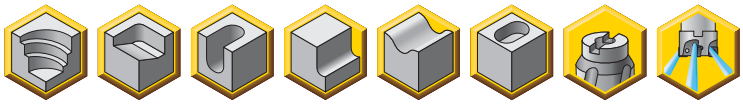
Cylindrical End Mills

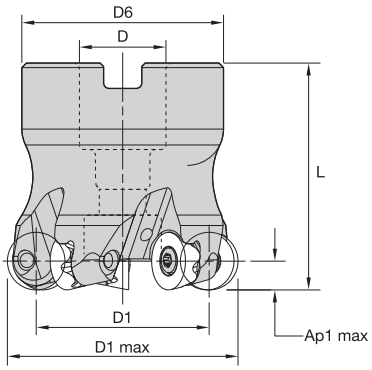
order number	catalog number	D1 max	D1	D	L	LBX	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
4043039	**BMD150R1602C125L800**	1.500	.870	1.250	8.000	1.500	.315	2	11.1°	28000	RP..T1605M0..	2.48

Spare Parts

D1 max	insert screw	in. lbs.	Torx Plus driver
1.500	**MS-2071**	35	**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	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
4043040	BMD200R1603S075L200	2.000	1.370	.750	1.752	2.000	.315	3	11.7°	24200	RP..T1605M0…	.82
4043041	BMD200R1604S075L200	2.000	1.370	.750	1.752	2.000	.315	4	9.7°	24200	RP..T1605M0..	.83
4043042	BMD250R1605S100L200	2.500	1.870	1.000	2.189	2.000	.315	5	11.7°	21700	RP..T1605M0..	1.43
4043053	BMD300R1605S100L200	3.000	2.370	1.000	2.750	2.000	.315	5	8.8°	19800	RP..T1605M0..	2.37
3997748	BMD300R1607S100L200	3.000	2.370	1.000	2.750	2.000	.315	7	6.8°	19800	RP..T1605M0..	2.38
4043054	BMD400R1608S125L200	4.000	3.370	1.250	2.875	2.000	.315	8	4.6°	16600	RP..T1605M0..	2.79
4043056	BMD600R1610S150L250	6.000	5.370	1.500	3.811	2.500	.315	10	3.4°	13100	RP..T1605M0..	7.86

Spare Parts

D1 max	 insert screw	 in. lbs.	 socket-head cap screw	 socket-head cap screw with coolant groove	 coolant lock screw assembly	 T-handle hex wrench	 Torx Plus driver
2.000	MS-2071	35	S446	S446CG	–	–	DT15IP
2.500	MS-2071	35	S459	–	–	–	DT15IP
3.000	MS-2071	35	S459	–	–	–	DT15IP
4.000	MS-2071	35	–	–	S2162C	THW2M	DT15IP
6.000	MS-2071	35	–	–	S2163C	THW2M	DT15IP

NOTE: Socket head cap screw with coolant groove 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..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	–	–	**–**	**–**	–	–

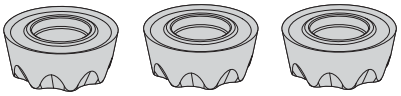
Indexable Inserts

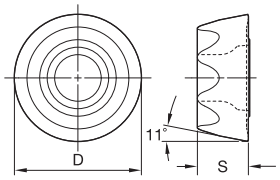
- -SGEJ and -ELEJ are the first choice for titanium machining.
- -ELEJ is the first choice for lower cutting forces to avoid built-up edge.
- -SGEJ geometry for general purpose in roughing operations.

beyond

● first choice
○ alternate choice

		KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
P			○	●	●	●		○
M			●	●	○	●	○	●
K			○		○			
N		●						
S			●	●		○	●	●
H								


RPET-LEJ RPET-GEJ RPET-GE RPET-LE



RPET-GEJ

RPET-LEJ

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1605M0ELEJ	.630	.219	.001	8	–	–	●	–	–	–	–

RPET-LE

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1605M0ELE	.630	.219	.001	8	–	–	–	●	–	–	–

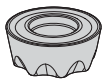
RPET-GEJ

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1605M0SGEJ	.630	.219	.005	8	–	●	●	–	–	●	–

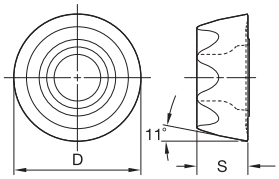
RPET-GE

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET1605M0SGE	.630	.219	.005	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

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPPT1605M0SHP	.630	.219	.007	8	–	–	●	●	●	–	–

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .320 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	.005	**.020**	.032	.003	**.014**	.023	.003	**.011**	.017	.002	**.009**	.015	.002	**.008**	.014	.E..LEJ
.E..LE	.005	**.020**	.032	.003	**.014**	.023	.003	**.011**	.017	.002	**.009**	.015	.002	**.008**	.014	.E..LE
.S..GEJ	.009	**.021**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.010**	.016	.004	**.009**	.015	.S..GEJ
.S..GE	.009	**.021**	.035	.007	**.015**	.025	.005	**.011**	.019	.004	**.010**	.016	.004	**.009**	.015	.S..GE
.S..HP	.009	**.023**	.038	.007	**.017**	.027	.005	**.013**	.020	.004	**.011**	.017	.004	**.010**	.016	.S..HP

At .100 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	.006	**.027**	.045	.005	**.019**	.032	.003	**.014**	.024	.003	**.013**	.021	.003	**.011**	.019	.E..LEJ
.E..LE	.006	**.027**	.045	.005	**.019**	.032	.003	**.014**	.024	.003	**.013**	.021	.003	**.011**	.019	.E..LE
.S..GEJ	.013	**.029**	.048	.009	**.021**	.034	.007	**.015**	.025	.006	**.013**	.022	.005	**.012**	.020	.S..GEJ
.S..GE	.013	**.029**	.048	.009	**.021**	.034	.007	**.015**	.025	.006	**.013**	.022	.005	**.012**	.020	.S..GE
.S..HP	.013	**.032**	.052	.009	**.023**	.037	.007	**.017**	.027	.006	**.015**	.024	.005	**.014**	.022	.S..HP

At .060 Axial Depth of Cut (ap)

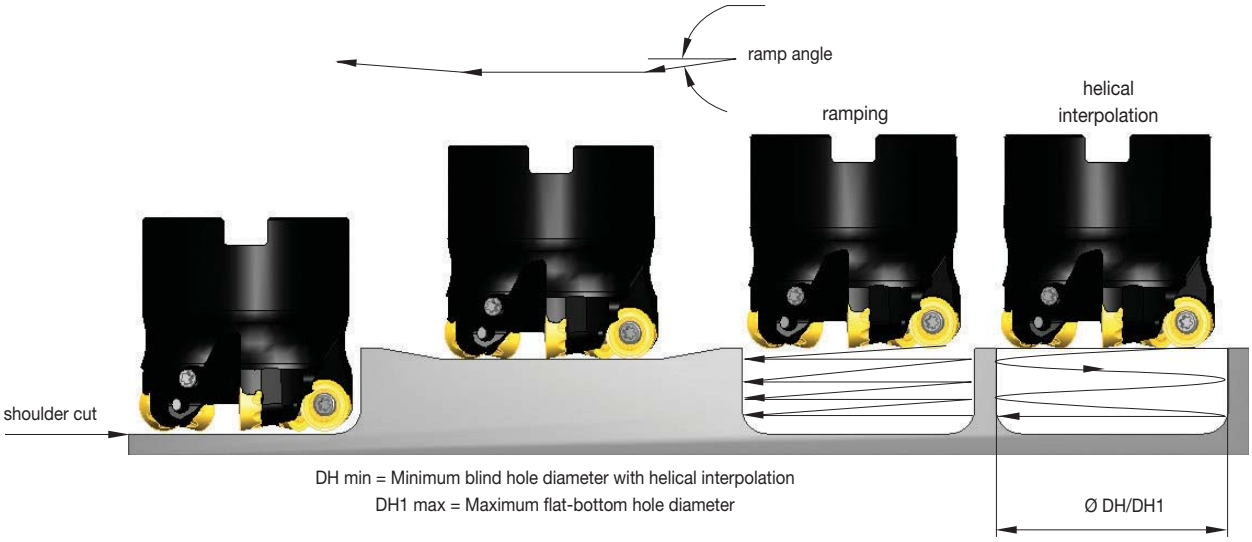
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..LEJ	.008	**.034**	.056	.006	**.024**	.040	.004	**.018**	.030	.004	**.016**	.026	.003	**.014**	.024	.E..LEJ
.E..LE	.008	**.034**	.056	.006	**.024**	.040	.004	**.018**	.030	.004	**.016**	.026	.003	**.014**	.024	.E..LE
.S..GEJ	.016	**.036**	.060	.011	**.026**	.043	.009	**.019**	.032	.007	**.017**	.028	.007	**.015**	.025	.S..GEJ
.S..GE	.016	**.036**	.060	.011	**.026**	.043	.009	**.019**	.032	.007	**.017**	.028	.007	**.015**	.025	.S..GE
.S..HP	.016	**.040**	.065	.011	**.029**	.046	.009	**.021**	.034	.007	**.019**	.030	.007	**.017**	.027	.S..HP

At .040 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	.009	**.041**	.068	.007	**.029**	.048	.005	**.022**	.036	.004	**.019**	.031	.004	**.017**	.028	.E..LEJ
.E..LE	.009	**.041**	.068	.007	**.029**	.048	.005	**.022**	.036	.004	**.019**	.031	.004	**.017**	.028	.E..LE
.S..GEJ	.019	**.044**	.073	.014	**.031**	.052	.010	**.023**	.038	.009	**.020**	.033	.008	**.018**	.030	.S..GEJ
.S..GE	.019	**.044**	.073	.014	**.031**	.052	.010	**.023**	.038	.009	**.020**	.033	.008	**.018**	.030	.S..GE
.S..HP	.019	**.049**	.079	.014	**.035**	.056	.010	**.026**	.041	.009	**.022**	.036	.008	**.021**	.033	.S..HP

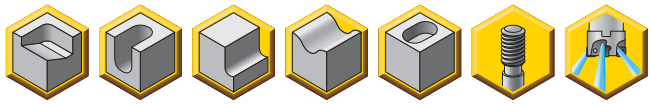
NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

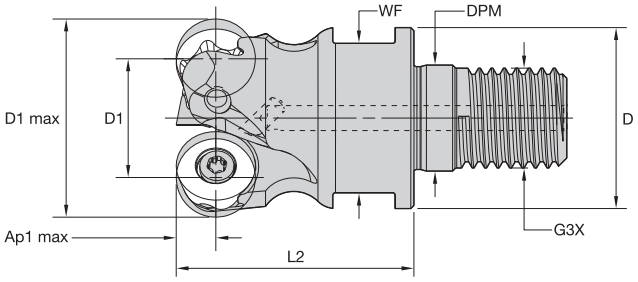
Maximum Linear Ramping and Helical Interpolation from Solid



catalog number	max ramp angle	max plunging depth	min hole diameter (DH min)	max flat-bottom hole diameter (DH1 max)	max diameter (no flat bottom)
BMD150R1603M16L150	9.9°	.106	1.904	2.37	3.0
BMD150R1603W125L200	9.9°	.106	1.904	2.37	3.0
BMD150R1602C125L800	11.0°	.117	1.888	2.37	3.0
BMD200R1603S075L200	11.7°	.217	2.776	3.37	4.0
BMD200R1604S075L200	9.7°	.181	2.810	3.37	4.0
BMD250R1605S100L200	11.7°	.315	3.744	4.37	5.0
BMD300R1605S100L200	8.8°	.315	4.738	5.37	6.0
BMD300R1607S100L200	6.8°	.245	4.768	5.37	6.0
BMD400R1608S125L200	4.6°	.245	6.762	7.37	8.0
BMD500R1609S150L250	4.2°	.295	8.744	9.37	10.0
BMD600R1610S150L250	3.4°	.295	10.744	11.37	12.0

- Engineered for titanium and stainless steel machining.
- Anti-rotation components feature six indexable positions.
- Pocketing, ramping, plunging, and helical interpolation capabilities.







Screw-On End Mills

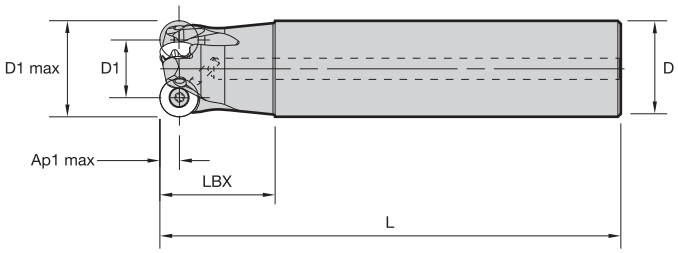
order number	catalog number	D1 max	D1	D	DPM	WF (mm)	G3X	L2	Ap1 max	Z	max ramp angle	max RPM	lbs	insert 1
5175033	**KSRM125R4303M16L150**	1.250	.750	1.142	.670	24	M16	1.500	.250	3	5.3°	44600	.36	RP_T43___
5175034	**KSRM150R4304M16L150**	1.500	1.000	1.142	.670	24	M16	1.500	.250	4	4.7°	38600	.38	RP_T43___

Spare Parts

D1 max	insert screw	in. lbs.
1.250	**MS2085**	35
1.500	**MS2085**	35

- Engineered for titanium and stainless steel machining.
- Anti-rotation components feature six indexable positions.
- Pocketing, ramping, plunging, and helical interpolation capabilities.







Cylindrical End Mills

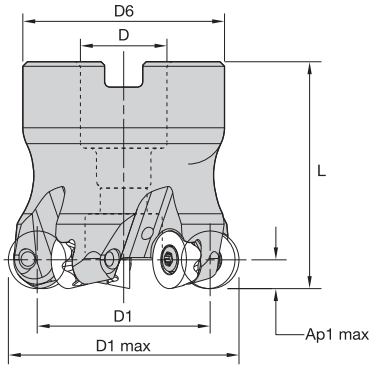
order number	catalog number	D1 max	D1	D	L	LBX	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
5175035	**KSRM125R4302C125L600**	1.250	.750	1.250	6.000	1.500	.250	2	6.0°	44600	RP_T43____	1.77
5175037	**KSRM125R4303C125L1000**	1.250	.750	1.250	10.000	1.500	.250	3	5.3°	44600	RP_T43____	3.10
5175038	**KSRM150R4304C125L600**	1.500	1.000	1.250	6.000	1.500	.250	4	4.7°	38600	RP_T43____	1.85
5175039	**KSRM150R4304C125L1000**	1.500	1.000	1.250	10.000	1.500	.250	4	4.7°	38600	RP_T43____	3.17

Spare Parts

D1 max	 insert screw	 in. lbs.	 Torx Plus driver
1.250	**MS2085**	35	**DT15IP**
1.500	**MS2085**	35	**DT15IP**

- Engineered for titanium and stainless steel machining.
- Anti-rotation components feature six indexable positions.
- Pocketing, ramping, plunging, and helical interpolation capabilities.







Shell Mills

order number	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
5302954	**KSRM200R4303S075L197**	2.000	1.500	.750	1.750	1.969	.250	3	11.5°	31500	RP_T43___	.89
5175380	**KSRM200R4305S075L197**	2.000	1.500	.750	1.750	1.969	.250	5	11.4°	31500	RP_T43___	.92
5302955	**KSRM250R4304S075L197**	2.500	2.000	.750	1.750	1.969	.250	4	8.2°	27300	RP_T43___	1.14
5175381	**KSRM250R4306S075L197**	2.500	2.000	.750	1.750	1.969	.250	6	8.2°	27300	RP_T43___	1.16
5302956	**KSRM300R4305S100L197**	3.000	2.500	1.000	2.750	1.969	.250	5	6.4°	24400	RP_T43___	2.46
5175382	**KSRM300R4307S100L197**	3.000	2.500	1.000	2.750	1.969	.250	7	6.4°	24400	RP_T43___	2.48

Spare Parts

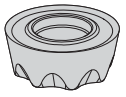
D1 max	 insert screw	 in. lbs.	 socket-head cap screw	 Torx Plus driver
2.000	**MS2085**	35	**S446**	**DT15IP**
2.500	**MS2085**	35	**S446**	**DT15IP**
3.000	**MS2085**	35	**S459**	**DT15IP**

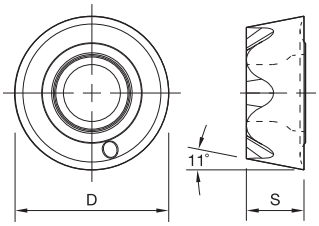
Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..LEJ	KC725M	**.E..GE**	**KC725M**	.S..GE	KCPK30
P3–P4	.E..LEJ	KC725M	**.S..GE**	**KCPK30**	–	–
P5–P6	.E..GE	KCPK30	**.S..GE**	**KCPK30**	–	–
M1–M2	.E..LEJ	KC725M	**.E..LEJ**	**KC725M**	.S..GE	KC725M
M3	.S..GEJ	KC725M	**.E..GE**	**KC725M**	.S..GE	KCPK30
K1–K2	–	–	**.S..GE**	**KCPK30**	–	–
K3	–	–	**.S..GE**	**KCPK30**	–	–
N1–N2	.E..LEJ	KC422M	**.E..LEJ**	**KC422M**	.E..LEJ	KC422M
N3	.E..LEJ	KC422M	**.E..LEJ**	**KC422M**	.E..LEJ	KC422M
S1–S2	.E..LEJ	KC725M	**.S..GEJ**	**KC725M**	.S..GE	KC725M
S3	.E..LEJ	KC725M	**.S..GEJ**	**KC725M**	.S..GE	KC725M
S4	.E..LEJ	KC725M	**.E..GE**	**KC725M**	.S..GE	KC725M
H1	–	–	**.S..GE**	**KC522M**	–	–

Indexable Inserts

- -EGE is the first choice for titanium machining.


RPPT-EGE



RPPT-EGE

● first choice
○ alternate choice

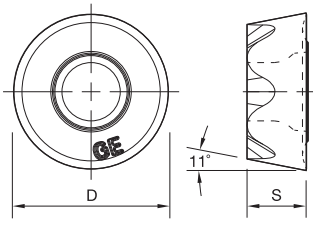
		KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
P			○	●	●	●		○
M			●	●	○	●	○	●
K			○		○			
N		●						
S			●	●		○	●	●
H								

RPPT-EGE

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPPT43EGE	.500	.188	.003	6	–	–	●	●	–	–	–

- -SGE geometry for general purpose in roughing operations in steel.


RPPT-SGE

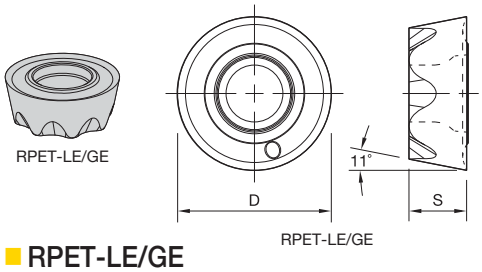


RPPT-SGE

RPPT-SGE

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPPT43SGE	.500	.188	.005	6	–	–	●	●	–	–	–

- ELEJ is the first choice for lower cutting forces to avoid built-up edges.



● first choice
○ alternate choice

		KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
P			○	●	●	●		○
M			●	●	○	●	○	●
K			○		○			
N		●						
S			●	●		○	●	●
H								

RPET-LE/GE

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RPET43SGEJ	.500	.188	.005	6	–	–	●	–	–	–	–

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .250 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..LEJ	.003	**.005**	.007	.003	**.004**	.005	.002	**.003**	.005	.002	**.003**	.004	.002	**.003**	.004	.E..LEJ
.E..GE	.006	**.010**	.015	.004	**.008**	.011	.004	**.007**	.010	.004	**.006**	.009	.004	**.006**	.009	.E..GE
.S..GEJ	.007	**.017**	.023	.005	**.013**	.017	.004	**.011**	.015	.004	**.010**	.014	.004	**.010**	.014	.S..GEJ
.S..GE	.007	**.017**	.023	.005	**.013**	.017	.004	**.011**	.015	.004	**.010**	.014	.004	**.010**	.014	.S..GE

At .125 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..LEJ	.004	**.006**	.008	.003	**.004**	.006	.003	**.004**	.005	.002	**.003**	.005	.002	**.003**	.005	.E..LEJ
.E..GE	.007	**.012**	.017	.005	**.009**	.013	.004	**.008**	.011	.004	**.007**	.010	.004	**.007**	.010	.E..GE
.S..GEJ	.008	**.020**	.027	.006	**.015**	.020	.005	**.013**	.017	.005	**.012**	.016	.005	**.012**	.016	.S..GEJ
.S..GE	.008	**.020**	.027	.006	**.015**	.020	.005	**.013**	.017	.005	**.012**	.016	.005	**.012**	.016	.S..GE

At .063 Axial Depth of Cut (ap)

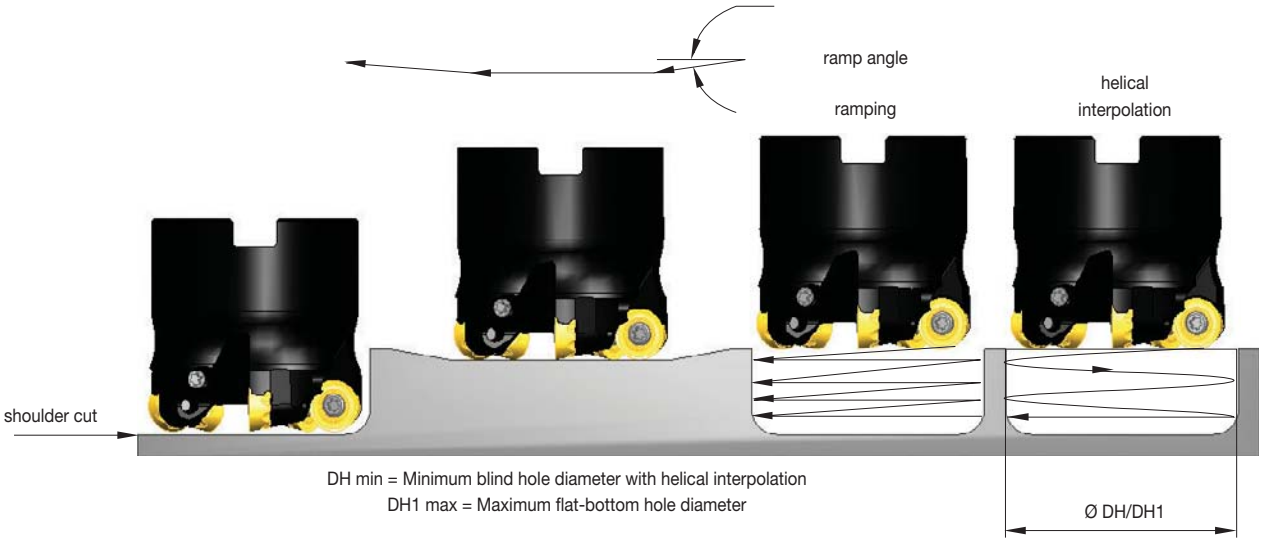
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LEJ	.005	**.007**	.011	.004	**.005**	.008	.003	**.005**	.007	.003	**.004**	.006	.003	**.004**	.006	.E..LEJ
.E..GE	.009	**.015**	.023	.007	**.011**	.017	.006	**.010**	.014	.005	**.009**	.014	.005	**.009**	.013	.E..GE
.S..GEJ	.010	**.026**	.035	.008	**.019**	.026	.007	**.017**	.022	.006	**.015**	.021	.006	**.015**	.020	.S..GEJ
.S..GE	.010	**.026**	.035	.008	**.019**	.026	.007	**.017**	.022	.006	**.015**	.021	.006	**.015**	.020	.S..GE

At .031 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..LEJ	.007	**.010**	.015	.005	**.007**	.011	.005	**.006**	.009	.004	**.006**	.009	.004	**.006**	.009	.E..LEJ
.E..GE	.012	**.021**	.031	.009	**.016**	.023	.008	**.014**	.020	.007	**.013**	.018	.007	**.012**	.018	.E..GE
.S..GEJ	.014	**.036**	.049	.010	**.026**	.035	.009	**.023**	.031	.008	**.021**	.028	.008	**.021**	.028	.S..GEJ
.S..GE	.014	**.036**	.049	.010	**.026**	.035	.009	**.023**	.031	.008	**.021**	.028	.008	**.021**	.028	.S..GE

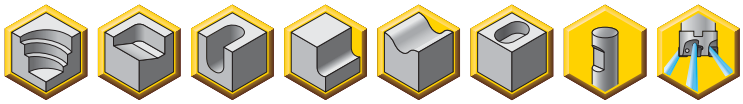
NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

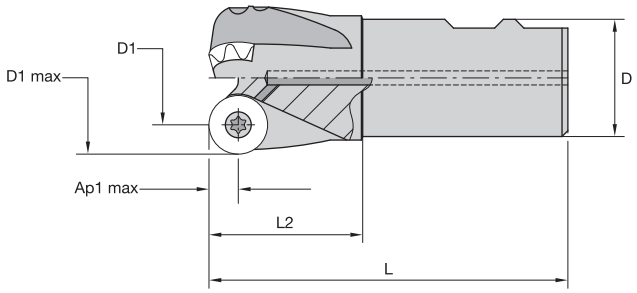
Maximum Linear Ramping and Helical Interpolation from Solid



catalog number	Maximum Ramp Angle (ra) when hx = .01" and ae > ae1	Maximum Ramp Depth (ap) per pass when ae > ae1	Maximum Ramp Depth (ap) per pass when hx = .01" and ae < ae1	ae1	Maximum Plunge Depth (ap) when hx = .01" and ae > ae2	ae2	min hole diameter (DH min)	max flat-bottom hole diameter (DH1 max)	Maximum Hole Diameter (No Flat Bottom)
KSRM125R4303C125L600	5.30°	.055	.250	.406	.250	.500	1.688	2.001	2.500
KSRM125R4302C125L600	5.95°	.061	.250	.413	.250	.500	1.674	2.001	2.500
KSRM125R4303C125L1000	5.30°	.055	.250	.406	.250	.500	1.688	2.001	2.500
KSRM125R4302C125L1000	5.95°	.061	.250	.413	.250	.500	1.674	2.001	2.500
KSRM150R4304C125L600	4.74°	.069	.250	.421	.250	.500	2.157	2.502	3.000
KSRM150R4303C125L600	5.31°	.077	.250	.429	.250	.500	2.142	2.502	3.000
KSRM150R4304C125L1000	4.74°	.069	.250	.421	.250	.500	2.157	2.502	3.000
KSRM150R4303C125L1000	5.31°	.077	.250	.429	.250	.500	2.142	2.502	3.000
KSRM125R4303M16L150	5.30°	.055	.250	.406	.250	.500	1.688	2.001	2.500
KSRM125R4302M16L150	6.43°	.065	.250	.418	.250	.500	1.665	2.001	2.500
KSRM150R4304M16L150	4.74°	.069	.250	.421	.250	.500	2.157	2.502	3.000
KSRM150R4303M16L150	5.31°	.077	.250	.429	.250	.500	2.142	2.502	3.000
KSRM200R4305S075L197	11.43°	.250	.250	.499	.250	.500	3.001	3.501	4.000
KSRM200R4303S075L197	11.45°	.250	.250	.499	.250	.500	3.001	3.501	4.000
KSRM250R4306S075L197	8.16°	.250	.250	.500	.250	.500	4.001	4.500	5.000
KSRM250R4304S075L197	8.16°	.250	.250	.500	.250	.500	4.001	4.500	5.000
KSRM300R4307S100L197	6.35°	.250	.250	.500	.250	.500	5.001	5.500	6.000
KSRM300R4305S100L197	6.35°	.250	.250	.500	.250	.500	5.001	5.500	6.000

- Engineered for roughing with large depths of cut through positive geometries.
- Anti-rotation feature with six indexable positions.
- Excellent for long overhangs.







Weldon • End Mills

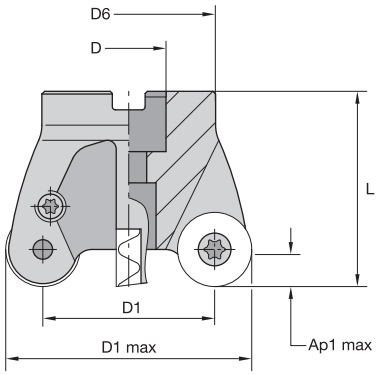
order number	catalog number	D1 max	D1	D	L	L2	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
2610667	**BMD200R6403W150L200**	2.000	1.250	1.500	4.690	2.000	.375	3	.6°	29000	RCG_64___	2.15

Spare Parts

D1 max	insert screw	in. lbs.	anti-rotation screw	Torx wrench
2.000	**MS1162**	45	**S2160**	**TT25**

- Engineered for roughing with large depths of cut through positive geometry inserts.
- Anti-rotation feature with six indexable positions.
- Excellent for long overhangs.
- High coolant pressure capabilities.







Shell Mills

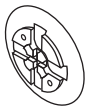
order number	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
2610668	**BMD250R6404S075L200**	2.500	1.750	.750	1.750	2.000	.375	4	.6°	26000	RCG_64___	1.16
2610670	**BMD300R6405S100L200**	3.000	2.250	1.000	2.190	2.000	.375	5	.7°	22000	RCG_64___	1.78
2610672	**BMD400R6405S125L200**	4.000	3.250	1.250	2.875	2.000	.375	5	.7°	18000	RCG_64___	3.17
2610683	**BMD400R6406S125L200**	4.000	3.250	1.250	2.875	2.000	.375	6	.6°	18000	RCG_64___	3.15
2610684	**BMD500R6406S150L250**	5.000	4.250	1.500	3.810	2.500	.375	6	.8°	15000	RCG_64___	7.08
2610685	**BMD500R6408S150L250**	5.000	4.250	1.500	3.810	2.500	.375	8	.7°	15000	RCG_64___	7.07
2610686	**BMD600R6407S150L250**	6.000	5.250	1.500	3.810	2.500	.375	7	.7°	14000	RCG_64___	9.48
2610687	**BMD600R6408S150L250**	6.000	5.250	1.500	3.810	2.500	.375	8	.7°	14000	RCG_64___	9.52
2610688	**BMD800R6409S250L250**	8.000	7.250	2.500	5.000	2.500	.375	9	.6°	12500	RCG_64___	13.08
5971566	**BMD800R6409S250L250HP** *	8.000	7.252	2.500	6.000	2.500	.375	9	.6°	12500	RCG_64___	14.85

NOTE: For high pressure coolant applications (>30 bar/>435 PSI) with cutter diameter 8", use items marked with "HP" in the catalog 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	in. lbs.	Torx wrench	coolant lock screw assembly	socket-head cap screw with coolant groove	coolant cap assembly
2610668	2.500	**MS1162**	45	**TT25**	**–**	**S445CG**	**–**
2610670	3.000	**MS1162**	45	**TT25**	**–**	**S458CG**	**–**
2610672	4.000	**MS1162**	45	**TT25**	**S2162C**	**–**	**–**
2610683	4.000	**MS1162**	45	**TT25**	**S2162C**	**–**	**–**
2610684	5.000	**MS1162**	45	**TT25**	**S2163C**	**–**	**–**
2610685	5.000	**MS1162**	45	**TT25**	**S2163C**	**–**	**–**
2610686	6.000	**MS1162**	45	**TT25**	**S2163C**	**–**	**–**
2610687	6.000	**MS1162**	45	**TT25**	**S2163C**	**–**	**–**
2610688	8.000	**MS1162**	45	**TT25**	**–**	**–**	**MCC080001**
5971566	8.000	**MS1162**	45	**TT25**	**–**	**–**	**MCC0800HP**

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 adapter 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..GF	KC725M	.S..HF	KC725M
P3–P4	.E..LF	KC522M	.S..GF	KC725M	.S..HF	KCPK30
P5–P6	.E..LF	KC522M	.S..HF	KCPK30	.S..HF	KCPK30
M1–M2	.E..LF	KC725M	.S..GF	KC725M	.S..HF	KC725M
M3	.E..LF	KCPK30	.S..GF	KC725M	.S..HF	KCPK30
K1–K2	–	–	.S..HF	KCPK30	–	–
K3	–	–	.S..HF	KCPK30	–	–
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	.E..LF	KC725M	.S..GF	KC725M	.S..HF	KC725M
S3	.E..LF	KC725M	.S..GF	KC725M	.S..HF	KC725M
S4	.E..LF	KC725M	.S..GF	KC725M	.S..HF	KC725M
H1	–	–	–	–	–	–

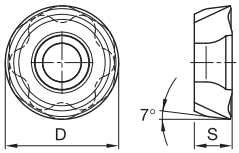
- -ELF is the first choice for lower cutting forces to avoid built-up edge.
- -SGF geometry for general purpose in roughing applications.
- -SHF is the first choice for heavy-duty applications.

● first choice
○ alternate choice

		KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
P			○	●	●	●		○
M			●	●	○	●	○	●
K			○		○			
N		●						
S			●	●		○	●	●
H								



RCGT-LF
RCGT-HF
RCGT-GF



RCGT-LF
RCGT-HF
RCGT-GF

RCGT-LF/LFJ

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RCGT64ELFJ	.750	.250	.002	6	–	–	–	–	–	●	–
RCGT64ELF	.750	.250	.002	6	–	–	●	●	–	–	●

RCGT-HF/-HFJ

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RCGT64SHFJ	.750	.250	.010	6	–	–	–	–	●	–	–
RCGT64SHF	.750	.250	.010	6	–	–	●	●	–	–	●

RCGT-GF

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RCGT64SGFJ	.750	.250	.004	6	–	–	–	–	●	–	–
RCGT64SGF	.750	.250	.004	6	–	●	●	–	–	–	–

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .375 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..LF	.004	**.007**	.013	.003	**.005**	.009	.002	**.004**	.008	.002	**.004**	.008	.002	**.004**	.008	.E..LF
.S..GF	.007	**.017**	.028	.005	**.013**	.020	.004	**.011**	.018	.004	**.010**	.016	.004	**.010**	.016	.S..GF
.S..HF	.007	**.017**	.028	.005	**.013**	.020	.004	**.011**	.018	.004	**.010**	.016	.004	**.010**	.016	.S..HF

At .188 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..LF	.004	**.008**	.015	.003	**.006**	.011	.003	**.005**	.009	.003	**.005**	.009	.002	**.005**	.009	.E..LF
.S..GF	.008	**.020**	.032	.006	**.015**	.023	.005	**.013**	.020	.005	**.012**	.019	.005	**.012**	.018	.S..GF
.S..HF	.008	**.020**	.032	.006	**.015**	.023	.005	**.013**	.020	.005	**.012**	.019	.005	**.012**	.018	.S..HF

At .094 Axial Depth of Cut (ap)

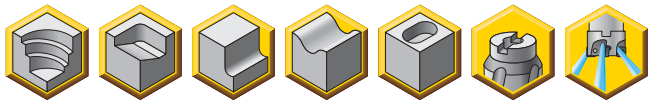
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LF	.005	**.010**	.019	.004	**.008**	.014	.004	**.007**	.012	.003	**.006**	.012	.003	**.006**	.011	.E..LF
.S..GF	.010	**.026**	.042	.008	**.019**	.031	.007	**.017**	.027	.006	**.015**	.025	.006	**.015**	.024	.S..GF
.S..HF	.010	**.026**	.042	.008	**.019**	.031	.007	**.017**	.027	.006	**.015**	.025	.006	**.015**	.024	.S..HF

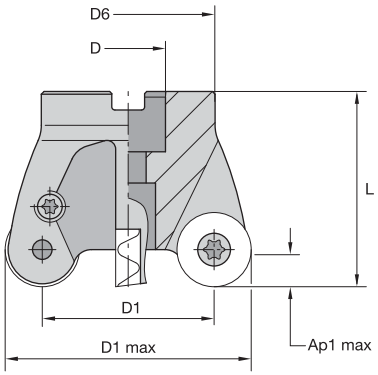
At .047 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LF	.007	**.014**	.027	.005	**.011**	.020	.005	**.009**	.017	.004	**.009**	.016	.004	**.008**	.015	.E..LF
.S..GF	.014	**.036**	.059	.010	**.026**	.042	.009	**.023**	.036	.008	**.021**	.034	.008	**.021**	.033	.S..GF
.S..HF	.014	**.036**	.059	.010	**.026**	.042	.009	**.023**	.036	.008	**.021**	.034	.008	**.021**	.033	.S..HF

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

- Engineered for roughing with large depths of cut through positive geometry inserts.
- Anti-rotation feature with six indexable positions.
- Excellent for long overhangs.
- High coolant pressure capabilities.







Shell Mills

order number	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
2610689	BMD300R8603S075L200	3.000	2.000	.750	1.750	2.000	.500	3	.9°	15500	RCGT86___	1.22
2610691	BMD400R8605S125L250	4.000	3.000	1.250	2.875	2.500	.500	5	.8°	12000	RCGT86___	4.01
2610697	BMD500R8606S150L250	5.000	4.000	1.500	3.810	2.500	.500	6	.8°	9000	RCGT86___	6.62
2610694	BMD600R8607S150L250	6.000	5.000	1.500	3.810	2.500	.500	7	.8°	8800	RCGT86___	8.63
2610696	BMD800R8608S250L250	8.000	7.000	2.500	5.000	2.500	.500	8	.7°	8500	RCGT86___	11.81
5971567	BMD800R8608S250L250HP	8.000	7.000	2.500	6.000	2.500	.500	8	.7°	8500	RCGT86___	14.00

NOTE: For high pressure coolant applications (>30 bar/>435 PSI) with cutter diameter 8", use items marked with "HP" in the catalog number. They are available as per request. Please ask your local sales contact for further information.

Spare Parts



order number	D1 max	insert screw	in. lbs.	Torx wrench	anti-rotation screw	coolant lock screw assembly	coolant cap assembly	socket-head cap screw with coolant groove	high pressure coolant cap assembly	wrench adapter
2610689	3.000	MS1162	45	TT25	S2160	–	–	S445CG	–	–
2610691	4.000	MS1162	45	TT25	S2160	S2164C	–	–	–	–
2610697	5.000	MS1162	45	TT25	S2160	S2163C	–	–	–	–
2610694	6.000	MS1162	45	TT25	S2160	S2163C	–	–	–	–
2610696	8.000	MS1162	45	TT25	S2160	–	MCC080001	–	–	–
5971567	8.000	MS1162	45	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 adapter is not included and needs to be purchased separately.

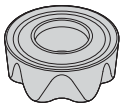
Insert Selection Guide

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..GF**	**KC725M**	.S..HF	KC725M
P3–P4	.S..GF	KC522M	**.S..GF**	**KC725M**	.S..HF	KCPK30
P5–P6	.S..GF	KC522M	**.S..HF**	**KCPK30**	.S..HF	KCPK30
M1–M2	.E..LF	KC725M	**.S..GF**	**KC725M**	.S..HF	KC725M
M3	.E..LF	KC725M	**.S..GF**	**KC725M**	.S..HF	KCPK30
K1–K2	–	–	**.S..HF**	**KCPK30**	–	–
K3	–	–	**.S..HF**	**KCPK30**	–	–
N1–N2	–	–	**–**	**–**	–	–
N3	–	–	**–**	**–**	–	–
S1–S2	.E..LF	KC725M	**.S..GF**	**KC725M**	.S..HF	KC725M
S3	.E..LF	KC725M	**.S..GF**	**KC725M**	.S..HF	KC725M
S4	.E..LF	KC725M	**.S..GF**	**KC725M**	.S..HF	KC725M
H1	–	–	**–**	**–**	–	–

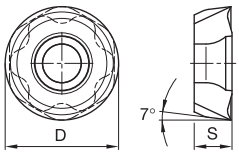
Indexable Inserts

- -ELF is the first choice for lower cutting forces to avoid built-up edge.
- -SGF geometry for general purpose in roughing applications.
- -SHF is the first choice for heavy-duty applications.

● first choice
○ alternate choice



RCGT-LF
RCGT-GF
RCGT-HF



RCGT-LF
RCGT-GF
RCGT-HF

RCGT-LF/-LFJ

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
P						○	●	●	●		○
M						●	●	○	●	○	●
K						○		○			
N					●						
S						●	●		○	●	●
H											
RCGT86ELF	1.000	.375	.002	6	–	–	●	●	–	–	●

RCGT-GF

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RCGT86SGFJ	1.000	.375	.004	6	–	–	–	–	●	–	–
RCGT86SGF	1.000	.375	.004	6	–	●	●	–	–	–	–

RCGT-HF/-HFJ

catalog number	D	S	hm	cutting edges	KC422M	KC522M	KC725M	KCPK30	KCPM40	KCSM30	KCSM40
RCGT86SHFJ	1.000	.375	.010	6	–	–	–	–	●	–	–
RCGT86SHF	1.000	.375	.010	6	–	–	●	●	–	–	●

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .500 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..LF	.004	**.007**	.013	.003	**.005**	.009	.002	**.004**	.008	.002	**.004**	.008	.002	**.004**	.008	.E..LF
.S..GF	.007	**.017**	.028	.005	**.013**	.020	.004	**.011**	.018	.004	**.010**	.016	.004	**.010**	.016	.S..GF
.S..HF	.007	**.017**	.028	.005	**.013**	.020	.004	**.011**	.018	.004	**.010**	.016	.004	**.010**	.016	.S..HF

At .250 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..LF	.004	**.008**	.015	.003	**.006**	.011	.003	**.005**	.009	.003	**.005**	.009	.002	**.005**	.009	.E..LF
.S..GF	.008	**.020**	.032	.006	**.015**	.023	.005	**.013**	.020	.005	**.012**	.019	.005	**.012**	.018	.S..GF
.S..HF	.008	**.020**	.032	.006	**.015**	.023	.005	**.013**	.020	.005	**.012**	.019	.005	**.012**	.018	.S..HF

At .125 Axial Depth of Cut (ap)

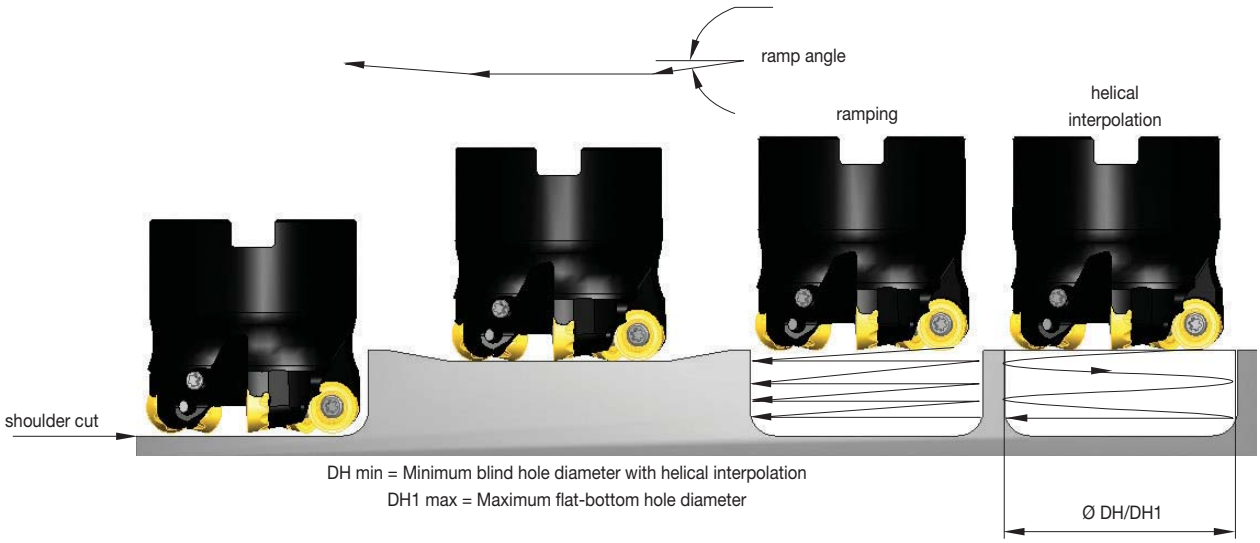
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LF	.005	**.010**	.019	.004	**.008**	.014	.004	**.007**	.012	.003	**.006**	.012	.003	**.006**	.011	.E..LF
.S..GF	.010	**.026**	.042	.008	**.019**	.031	.007	**.017**	.027	.006	**.015**	.025	.006	**.015**	.024	.S..GF
.S..HF	.010	**.026**	.042	.008	**.019**	.031	.007	**.017**	.027	.006	**.015**	.025	.006	**.015**	.024	.S..HF

At .063 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..LF	.007	**.014**	.027	.005	**.011**	.020	.005	**.009**	.017	.004	**.009**	.016	.004	**.008**	.015	.E..LF
.S..GF	.014	**.036**	.059	.010	**.026**	.042	.009	**.023**	.036	.008	**.021**	.034	.008	**.021**	.033	.S..GF
.S..HF	.014	**.036**	.059	.010	**.026**	.042	.009	**.023**	.036	.008	**.021**	.034	.008	**.021**	.033	.S..HF

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

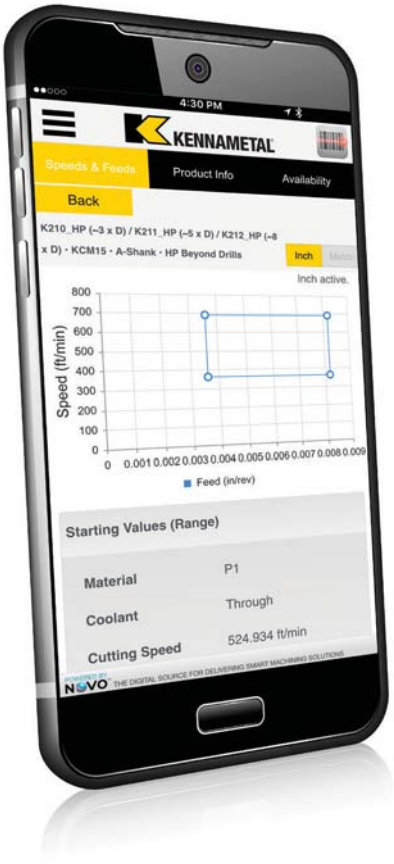
Maximum Linear Ramping and Helical Interpolation from Solid



catalog number	Maximum Ramp Angle (ra) when hx = .01" and ae > ae1	Maximum Ramp Depth (ap) per pass when ae > ae1	Maximum Ramp Depth (ap) per pass when hx = .01" and ae < ae1	ae1	Maximum Plunge Depth (ap) when hx = .01" and ae > ae2	ae2	min hole diameter (DH min)	max flat-bottom hole diameter (DH1 max)	Maximum Hole Diameter (No Flat Bottom)
KSRM125R4303C125L600	5.30°	.055	.250	.406	.250	.500	1.688	2.001	2.500
KSRM125R4302C125L600	5.95°	.061	.250	.413	.250	.500	1.674	2.001	2.500
KSRM125R4303C125L1000	5.30°	.055	.250	.406	.250	.500	1.688	2.001	2.500
KSRM125R4302C125L1000	5.95°	.061	.250	.413	.250	.500	1.674	2.001	2.500
KSRM150R4304C125L600	4.74°	.069	.250	.421	.250	.500	2.157	2.502	3.000
KSRM150R4303C125L600	5.31°	.077	.250	.429	.250	.500	2.142	2.502	3.000
KSRM150R4304C125L1000	4.74°	.069	.250	.421	.250	.500	2.157	2.502	3.000
KSRM150R4303C125L1000	5.31°	.077	.250	.429	.250	.500	2.142	2.502	3.000
KSRM125R4303M16L150	5.30°	.055	.250	.406	.250	.500	1.688	2.001	2.500
KSRM125R4302M16L150	6.43°	.065	.250	.418	.250	.500	1.665	2.001	2.500
KSRM150R4304M16L150	4.74°	.069	.250	.421	.250	.500	2.157	2.502	3.000
KSRM150R4303M16L150	5.31°	.077	.250	.429	.250	.500	2.142	2.502	3.000
KSRM200R4305S075L197	11.43°	.250	.250	.499	.250	.500	3.001	3.501	4.000
KSRM200R4303S075L197	11.45°	.250	.250	.499	.250	.500	3.001	3.501	4.000
KSRM250R4306S075L197	8.16°	.250	.250	.500	.250	.500	4.001	4.500	5.000
KSRM250R4304S075L197	8.16°	.250	.250	.500	.250	.500	4.001	4.500	5.000
KSRM300R4307S100L197	6.35°	.250	.250	.500	.250	.500	5.001	5.500	6.000
KSRM300R4305S100L197	6.35°	.250	.250	.500	.250	.500	5.001	5.500	6.000

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 catalog number to access complete product information.

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

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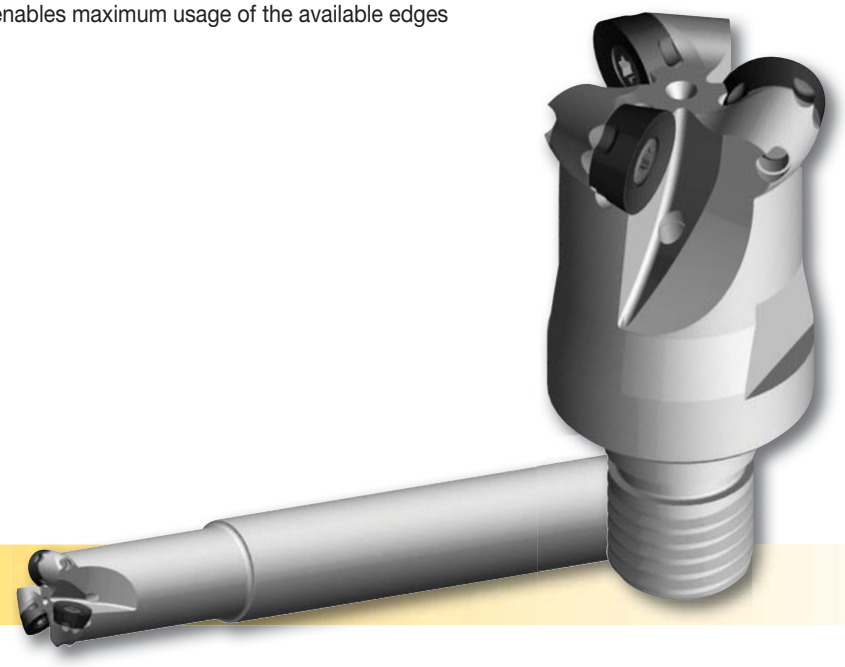
7713VR Series

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 for steel, tool steel, and aluminum alloys.

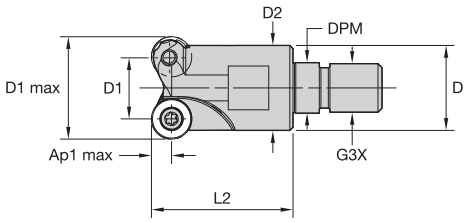


7713VR10:
Maximum ap = .197"
Diameter Range = 1–2.50"

7713VR12:
Maximum ap = .236"
Diameter Range = 1–3"

- 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

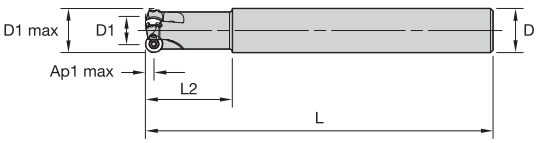
order number	catalog number	D1 max	D1	D	D2	L2	G3X	DPM	Ap1 max	Z
5673043	A7713VR10SA1.25Z4R1.7	1.250	.857	1.142	1.211	1.693	M16	.669	.197	4

Spare Parts

D1 max	insert screw	in. lbs.	Torx driver
1.250	D4008T	27	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

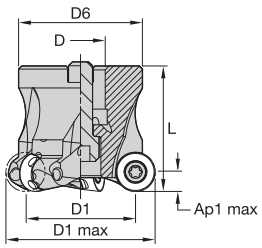
order number	catalog number	D1 max	D1	D	L	L2	Ap1 max	Z
5672803	C7713VR10CA1.00Z3R2.0	1.000	.607	1.000	7.874	1.970	.197	3
5672804	C7713VR10CA1.25Z4R2.7	1.250	.856	1.250	9.842	2.756	.197	4

Spare Parts

D1 max	insert screw	in. lbs.	Torx driver
1.000	D4007T	27	TB15
1.250	D4008T	27	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	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z
5673597	**C7713VR10-A1.50Z05R**	1.500	1.107	.500	1.244	1.260	.197	5
5672805	**C7713VR10-A2.00Z7R**	2.000	1.606	.750	1.638	1.575	.197	7
5673042	**C7713VR10-A2.50Z8R**	2.500	2.107	.750	1.835	1.570	.197	8

Spare Parts



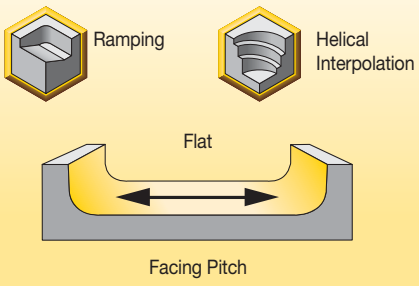



D1 max	insert screw	in. lbs.	Torx driver	socket-head cap screw
1.500	**D4008T**	27	**TB15**	**#1/4-28X3/4SHCSA**
2.000	**D4008T**	27	**TB15**	**#3/8-24X1SHCSA**
2.500	**D4008T**	27	**TB15**	**#3/8-24X1SHCSA**

Technical Information

Technical Information (in)

order number	catalog number	dimension					max RPM
		facing pitch	ramping angle	helical hole min–max		ap max helical/linear	
5672803	**C7713VR10CA1.00Z3R2.0**	0.607	11.70	1.291	1.921	0.130	64,500
5672804	**C7713VR10CA1.25Z4R2.7**	0.857	5.70	1.791	2.421	0.130	53,500
5673597	**C7713VR10-A1.50Z05R**	1.107	7.75	2.291	2.921	0.130	47,000
5672805	**C7713VR10-A2.00Z7R**	1.607	5.10	3.291	3.921	0.130	39,500
5673042	**C7713VR10-A2.50Z8R**	2.107	3.70	4.291	4.921	0.130	34,000
5673043	**A7713VR10SA1.25Z4R1.7**	0.857	5.70	1.791	2.421	0.130	53,500

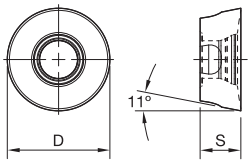


Insert Selection Guide • IC 10

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	–	–	–	–	–	–

- Four indexation positions:
  - — Ap max: .197" (5mm)
  - — Ap recommended: ≤.098" (2,5mm)


RPEX10-701 RPHT10-421 RPHT10-422 RPHT10-422-X8



● first choice
○ alternate choice

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

RPEX10-701-X4 • Precision Ground • 4 Indexes • First Choice for Roughing Non-Ferrous Alloys and Finishing High-Temp Alloys

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPEX10T3M0F701X4	.394	.156	.001	4	●	–	–	–	●	–	–	–

RPHT10-421-X4 • Precision Ground • 4 Indexes

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT10T3M0E421X4	.394	.156	.002	4	–	–	–	–	–	–	●	●

RPHT10-422-X4 • Precision Ground • 4 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT10T3M0E422X4	.394	.156	.001	4	–	–	–	–	–	●	●	●

RPHT10-422-X8 • Precision Ground • 8 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

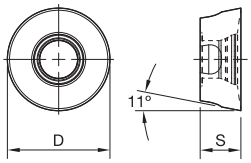
catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT10T3M0E422X8	.394	.156	.001	8	–	–	–	–	–	●	●	●


RPHT10-TX4


RPMT10-41-X4


RPMW10-T-X4


RPPT10-432-X5



● first choice
○ alternate choice

		GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
P			●	●	●	○	○	○	
M			●			●	●	●	●
K	○		●	●	●	○			
N	●								
S		○				●	●	●	●
H				○		○			

RPHT10-TX4 • Precision Ground • 4 Indexes • General Purpose for Roughing

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT10T3M0TX4	.394	.156	.003	4	–	–	–	–	–	●	●	–

RPMT10-41-X4 • 4 Indexes • For Finishing Alloy Steel and Iron

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPMT10T3M0E41X4	.394	.156	.002	4	–	–	●	–	–	●	●	–

RPMW10-T-X4 • 4 Indexes • General Purpose for Roughing

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPMW10T3M0TX4	.394	.156	.005	4	–	–	–	–	–	–	●	–

RPPT10-432-X5 • Precision Pressed • 5 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPPT10T3M0E432X5	.394	.156	.001	5	–	–	–	●	–	●	●	●

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .197 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	.005	**.009**	.013	.003	**.007**	.009	.002	**.005**	.007	.002	**.004**	.006	.002	**.004**	.006	701–X4
422–X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	422–X8
432–X5	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	432–X5
422–X4	.005	**.012**	.023	.003	**.008**	.016	.002	**.006**	.012	.002	**.006**	.010	.002	**.005**	.010	422–X4
T–X4	.009	**.015**	.025	.007	**.011**	.018	.005	**.008**	.013	.004	**.007**	.011	.004	**.007**	.011	T–X4

At .098 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	.005	**.011**	.015	.004	**.008**	.011	.003	**.006**	.008	.002	**.005**	.007	.002	**.005**	.006	701–X4
422–X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	422–X8
432–X5	.005	**.014**	.026	.004	**.010**	.019	.003	**.007**	.014	.002	**.006**	.012	.002	**.006**	.011	432–X5
422–X4	.005	**.014**	.026	.004	**.010**	.019	.003	**.007**	.014	.002	**.006**	.012	.002	**.006**	.011	422–X4
T–X4	.011	**.018**	.029	.008	**.013**	.020	.006	**.010**	.015	.005	**.008**	.013	.005	**.008**	.012	T–X4

At .079 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	.006	**.012**	.016	.004	**.008**	.012	.003	**.006**	.009	.003	**.005**	.008	.002	**.005**	.007	701–X4
422–X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	422–X8
432–X5	.006	**.015**	.029	.004	**.011**	.020	.003	**.008**	.015	.003	**.007**	.013	.002	**.006**	.012	432–X5
422–X4	.006	**.015**	.029	.004	**.011**	.020	.003	**.008**	.015	.003	**.007**	.013	.002	**.006**	.012	422–X4
T–X4	.011	**.019**	.031	.008	**.014**	.022	.006	**.010**	.016	.005	**.009**	.014	.005	**.008**	.013	T–X4

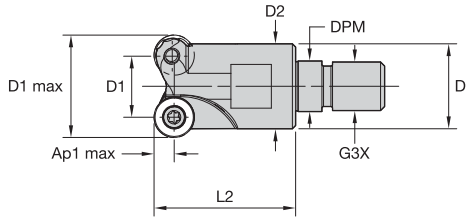
At .059 Axial Depth of Cut (ap)

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	.006	**.013**	.018	.005	**.009**	.013	.003	**.007**	.010	.003	**.006**	.008	.003	**.006**	.008	701-X4
422-X8	.006	**.017**	.032	.005	**.012**	.023	.003	**.009**	.017	.003	**.008**	.015	.003	**.007**	.013	422-X8
432-X5	.006	**.017**	.032	.005	**.012**	.023	.003	**.009**	.017	.003	**.008**	.015	.003	**.007**	.013	432-X5
422-X4	.006	**.017**	.032	.005	**.012**	.023	.003	**.009**	.017	.003	**.008**	.015	.003	**.007**	.013	422-X4
T-X4	.013	**.022**	.035	.009	**.016**	.025	.007	**.012**	.018	.006	**.010**	.016	.006	**.009**	.015	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.







7713VR12 Modular Head Screw-On

order number	catalog number	D1 max	D1	D	D2	L2	G3X	DPM	Ap1 max	Z
5672624	**A7713VR12SA1.00Z2R1.4**	1.000	.528	.827	.967	1.378	M12	.492	.236	2
5672810	**A7713VR12SA1.25Z3R1.7**	1.250	.778	1.142	1.201	1.692	M16	.669	.236	3
5673767	**A7713VR12SA1.50Z4R1.7**	1.500	1.028	1.142	1.455	1.693	M16	.669	.236	4
5673598	**A7713VR12SA1.50Z5R1.7**	1.500	1.028	1.142	1.455	1.692	M16	.669	.236	5

Spare Parts

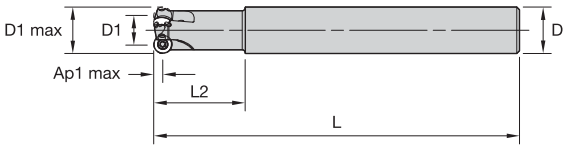




D1 max	insert screw	in. lbs.	Torx driver
1.000	**D4008T**	27	**T15**
1.250	**D4008T**	27	**T15**
1.500	**D4008T**	27	**T15**
1.500	**D4008T**	27	**TB15**

- Turbine blade machining and copy/contour milling applications.
- Patented locking system prevents insert rotation during heavy machining.
- Positive flute design for excellent chip evacuation.







7713VR12 Cylindrical Shank

order number	catalog number	D1 max	D1	D	L	L2	Ap1 max	Z
5672623	**C7713VR12CA1.00Z2R2.0**	1.000	.528	1.000	7.874	1.969	.236	2
5673499	**C7713VR12CA1.25Z3R2.7**	1.250	.778	1.250	9.842	2.755	.236	3

Spare Parts

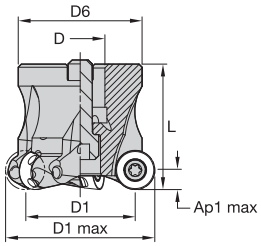




D1 max	insert screw	in. lbs.	Torx driver
1.000	**D4008T**	27	**T15**
1.250	**D4008T**	27	**T15**

- Turbine blade machining and copy/contour milling applications.
- Patented locking system prevents insert rotation during heavy machining.
- Positive flute design for excellent chip evacuation.







7713VR12 Shell Mill

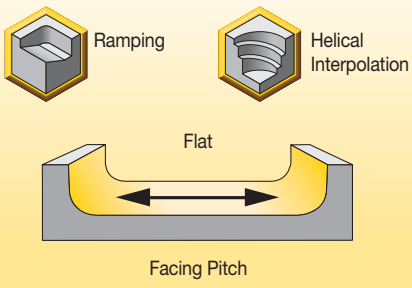
order number	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z
5673826	C7713VR12-A1.50Z4R	1.500	1.028	.500	1.323	1.574	.236	4
5673766	C7713VR12-A1.50Z5R	1.500	1.029	.500	1.323	1.575	.235	5
5672808	C7713VR12-A2.00Z5R	2.000	1.528	.750	1.835	1.574	.236	5
5673044	C7713VR12-A2.00Z4R	2.000	1.528	.750	1.835	1.575	.236	4
5673045	C7713VR12-A2.00Z6R	2.000	1.528	.750	1.835	1.575	.236	6
5673827	C7713VR12-A2.50Z6R	2.500	2.028	.750	2.031	1.986	.236	6
5673046	C7713VR12-A2.50Z7R	2.500	2.028	.750	2.031	1.986	.236	7
5672809	C7713VR12-A3.00Z8R	3.000	2.528	1.000	2.032	1.969	.236	8

Spare Parts

D1 max	 insert screw	 in. lbs.	 Torx driver	 socket-head cap screw
1.500	D4010T	27	T15	#1/4-28X3/4SHCSA
1.500	D4008T	27	TB15	#1/4-28X3/4SHCSA
2.000	D4010T	27	T15	#3/8-24X1SHCSA
2.500	D4010T	27	T15	#3/8-24X1SHCSA
3.000	D4010T	27	T15	#1/2-20X1-1/4SHCSA

Technical Information (in)

order number	catalog number	dimension					max RPM
		facing pitch	ramping angle	helical hole min–max		ap max helical/linear	
5672623	C7713VR12CA1.00Z2R2.0	0.528	9.50	1.134	1.921	0.160	49,000
5673499	C7713VR12CA1.25Z3R2.7	0.778	12.40	1.634	2.421	0.160	40,500
5673766	C7713VR12-A1.50Z5R	1.028	8.60	2.134	2.921	0.160	35,000
5673044	C7713VR12-A2.00Z4R	1.528	5.50	3.134	3.921	0.160	28,500
5672808	C7713VR12-A2.00Z5R	1.528	5.50	3.134	3.921	0.160	28,500
5673045	C7713VR12-A2.00Z6R	1.528	5.50	3.134	3.921	0.160	28,500
5673827	C7713VR12-A2.50Z6R	2.028	3.90	4.134	4.921	0.160	25,000
5673046	C7713VR12-A2.50Z7R	2.028	3.90	4.134	4.921	0.160	25,000
5672809	C7713VR12-A3.00Z8R	2.528	2.95	5.134	5.921	0.160	22,500
5672624	A7713VR12SA1.00Z2R1.4	0.528	9.50	1.134	1.921	0.160	49,000
5672810	A7713VR12SA1.25Z3R1.7	0.778	12.40	1.634	2.421	0.160	40,500
5673598	A7713VR12SA1.50Z5R1.7	1.028	8.60	2.134	2.921	0.160	35,000



Insert Selection Guide • IC 12

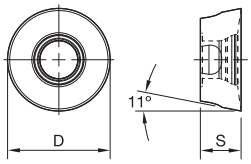
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		◄———	———►	toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	442-X8	SC6525	**432-X5**	**SC6525**	GD-X5	KCM40
P3–P4	432-X8	SP6519	**432-X5**	**SP6519**	GD-X5	KCM40
P5–P6	432-X8	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 IC 12

- Four indexation positions:
  - — Ap max: .236" (6mm)
  - — Ap recommended: ≤.137" (3,5mm)
- Five indexation positions:
  - — Ap max: .157" (4mm)
  - — Ap recommended: ≤.098" (2,5mm)
- Eight indexation positions:
  - — Ap max: .118" (3mm)
  - — Ap recommended: ≤.059" (1,5mm)

● first choice
○ alternate choice


RPEX12-701-X4 RPHT12-421-X4 RPMT12-41-X4 RPHT12-442-X5



RPEX12-701-X4 • Precision Ground • 4 Indexes • For Roughing Non-Ferrous Alloys and Finishing High-Temp Alloys

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPEX1204M0F701X4	.472	.187	.001	4	●	–	–	–	–	–	–	–
RPEX1204M0E701X4	.472	.187	.002	4	–	–	–	–	–	–	●	–

RPHT12-421-X4 • Precision Ground • 4 Indexes

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0E421X4	.472	.187	.002	4	–	–	–	–	–	–	●	–

RPMT12-41-X4 • 4 Indexes • For Finishing Alloy Steel and Iron

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPMT1204M0E41X4	.472	.187	.002	4	–	–	●	–	–	●	●	–

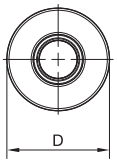
RPHT12-442-X5 • Precision Ground • 5 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0E442X5	.472	.187	.002	5	–	–	–	●	–	●	●	●


RPHT12-442-X8

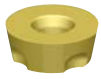

RPHT12-SGD-X5


RPHT12-SGD-X8




RPHT12-422-X4


RPHT12-T-X4


RPMW12-T-X4

● first choice
○ alternate choice

		GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
P			●	●	●	○	○	○	
M			●			●	●	●	●
K		○		●	●	●	○		
N		●							
S			○			●	●	●	●
H				○		○			

RPHT12-442-X8 • Precision Ground • 8 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0E442X8	.472	.187	.002	8	–	–	–	●	–	–	–	–

RPHT12-SGD-X5 • Precision Ground • 5 Indexes • For Stainless Steel and Heat-Resistant Alloys in Tougher Conditions

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0SGDX5	.472	.188	.002	5	–	●	–	–	–	–	–	–

RPHT12-SGD-X8 • Precision Ground • 8 Indexes • For Stainless Steel and Heat-Resistant Alloys in Tougher Conditions

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0SGDX8	.472	.188	.002	8	–	●	–	–	–	–	–	–

RPHT12-442-X4 • Precision Ground • 4 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0E442X4	.472	.188	.002	4	–	–	–	–	–	●	●	●

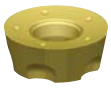
RPHT12-T-X4 • Precision Ground • 4 Indexes • General Purpose for Roughing

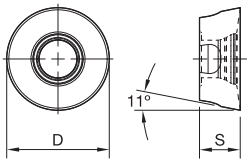
catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPHT1204M0TX4	.472	.187	.004	4	–	–	–	–	–	●	●	●

RPMW12-T-X4 • 4 Indexes • General Purpose for Roughing

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPMW1204M0TX4	.472	.187	.005	4	–	–	●	–	–	●	●	–


RPPT12-
432-X4


RPPT12-
432-X5




RPPT12-
432-X8


RPPT12-
SGD-X5

● first choice
○ alternate choice

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

RPPT12-432-X4 • Precision Pressed • 4 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPPT1204M0E432X4	.472	.188	.002	4	–	–	–	●	–	–	●	●

RPPT12-432-X5 • Precision Pressed • 5 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPPT1204M0E432X5	.472	.188	.002	5	–	–	–	●	–	●	●	●

RPPT12-432-X8 • Precision Pressed • 8 Indexes • For Machining Stainless Steel and Heat-Resistant Alloys

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPPT1204M0E432X8	.472	.188	.002	8	–	–	–	–	–	●	●	●

RPPT12-SGD-X4, X5, X8 • Precision Pressed • 4, 5, or 8 Indexes • For Stainless Steel and Heat-Resistant Alloys in Tougher Conditions

catalog number	D	S	hm	cutting edges	GH1	KCM40	MP91M	SC6525	SP4019	SP6519	X500	X700
RPPT1204M0SGDX4	.472	.187	.002	4	–	●	–	–	–	–	–	–
RPPT1204M0SGDX5	.472	.188	.002	5	–	●	–	–	–	–	–	–
RPPT1204M0SGDX8	.472	.188	.002	8	–	●	–	–	–	–	–	–

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .236 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	.005	**.008**	.011	.003	**.006**	.008	.002	**.004**	.006	.002	**.004**	.005	.002	**.004**	.005	701-X4
432-X5	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	432-X5
432-X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	432-X8
442-X5	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	442-X5
442-X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	442-X8
442-X4	.007	**.021**	.037	.005	**.015**	.027	.004	**.011**	.020	.003	**.010**	.017	.003	**.009**	.016	442-X4
GD-X5	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	GD-X5
GD-X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	GD-X8
T-X4	.009	**.023**	.037	.007	**.017**	.027	.005	**.012**	.020	.004	**.011**	.017	.004	**.010**	.016	T-X4

At .118 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	.005	**.009**	.013	.004	**.007**	.009	.003	**.005**	.007	.002	**.004**	.006	.002	**.004**	.005	701-X4
432-X5	.006	**.019**	.037	.005	**.014**	.027	.003	**.010**	.020	.003	**.009**	.017	.003	**.008**	.016	432-X5
432-X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	432-X8
442-X5	.006	**.019**	.037	.005	**.014**	.027	.003	**.010**	.020	.003	**.009**	.017	.003	**.008**	.016	442-X5
442-X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	442-X8
442-X4	.008	**.024**	.043	.006	**.017**	.031	.004	**.013**	.023	.004	**.011**	.020	.003	**.010**	.018	442-X4
GD-X5	.006	**.022**	.040	.005	**.016**	.028	.003	**.012**	.021	.003	**.010**	.018	.003	**.009**	.017	GD-X5
GD-X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	GD-X8
T-X4	.011	**.027**	.043	.008	**.019**	.031	.006	**.014**	.023	.005	**.012**	.020	.005	**.011**	.018	T-X4

At .098 Axial Depth of Cut (ap)

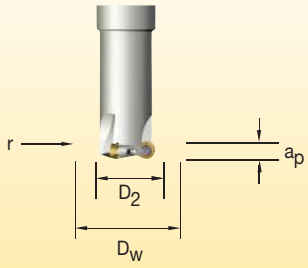
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
701-X4	.006	**.010**	.014	.004	**.007**	.010	.003	**.005**	.007	.003	**.005**	.006	.002	**.004**	.006	701-X4
432-X5	.007	**.021**	.040	.005	**.015**	.028	.004	**.011**	.021	.003	**.010**	.018	.003	**.009**	.017	432-X5
432-X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	432-X8
442-X5	.007	**.021**	.040	.005	**.015**	.028	.004	**.011**	.021	.003	**.010**	.018	.003	**.009**	.017	442-X5
442-X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	442-X8
442-X4	.009	**.026**	.046	.006	**.019**	.033	.005	**.014**	.024	.004	**.012**	.021	.004	**.011**	.019	442-X4
GD-X5	.007	**.023**	.042	.005	**.017**	.030	.004	**.012**	.022	.003	**.011**	.019	.003	**.010**	.018	GD-X5
GD-X8	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	GD-X8
T-X4	.011	**.029**	.046	.008	**.020**	.033	.006	**.015**	.024	.005	**.013**	.021	.005	**.012**	.019	T-X4

At .059 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	.007	**.012**	.017	.005	**.009**	.012	.004	**.007**	.009	.003	**.006**	.008	.003	**.005**	.007	701-X4
432-X5	.008	**.026**	.049	.006	**.018**	.035	.005	**.014**	.026	.004	**.012**	.022	.004	**.011**	.021	432-X5
432-X8	.008	**.026**	.049	.006	**.018**	.035	.005	**.014**	.026	.004	**.012**	.022	.004	**.011**	.021	432-X8
442-X5	.008	**.026**	.049	.006	**.018**	.035	.005	**.014**	.026	.004	**.012**	.022	.004	**.011**	.021	442-X5
442-X8	.008	**.026**	.049	.006	**.018**	.035	.005	**.014**	.026	.004	**.012**	.022	.004	**.011**	.021	442-X8
442-X4	.011	**.032**	.058	.008	**.023**	.041	.006	**.017**	.030	.005	**.015**	.026	.005	**.014**	.024	442-X4
GD-X5	.008	**.028**	.053	.006	**.020**	.037	.005	**.015**	.027	.004	**.013**	.024	.004	**.012**	.022	GD-X5
GD-X8	.008	**.028**	.053	.006	**.020**	.037	.005	**.015**	.027	.004	**.013**	.024	.004	**.012**	.022	GD-X8
T-X4	.014	**.035**	.058	.010	**.025**	.041	.007	**.019**	.030	.006	**.016**	.026	.006	**.015**	.024	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 (a_p).

$$D_w = D_2 + 2 \times \sqrt{r^2 - (r - a_p)^2}$$

where:

D_w = Working diameter
D_2 = Diameter of cutter insert center to center
r = Insert radius
a_p = Axial depth of cut

where:

f_z = Feed per tooth
hm = 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 h_m 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: Program 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: Program 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)

$$h_m = f_z \times \sqrt{\frac{d}{a_p}}$$



Carbide Recycling

Help preserve and protect our planet!

It's easy for your company to be environmentally conscious with the Kennametal Carbide Recycling Program.

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 Program, 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.

Program is not currently available in all geographical areas.
For more information, please visit **kennametal.com/carbiderecycling**.

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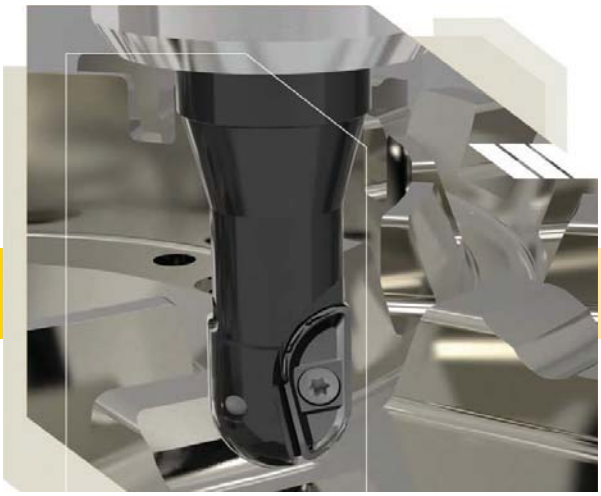
5505VX Series



Copy/3D



Contour Milling

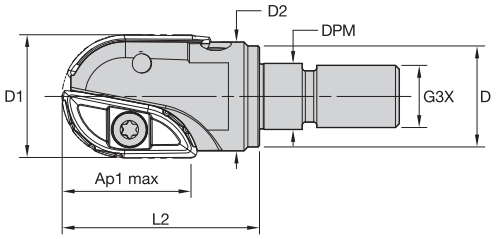


Ball Nose Contour Milling Cutter

- 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 optimized inventory.







Screw-On End Mills

order number	catalog number	D1	D	D2	L2	G3X	DPM	Ap1 max	Z
5673710	**A5505VX05SA.625R1.00**	.625	.512	.585	1.000	M8	.335	.630	2
5673603	**A5505VX06SA.750R1.377**	.750	.709	.705	1.378	M10	.413	.750	2
5673624	**A5505VX08SA1.00R1.575**	1.000	.827	.907	1.575	M12	.492	.992	2
5672841	**A5505VX10SA1.25R1.968**	1.250	1.141	1.147	1.969	M16	.669	1.250	2

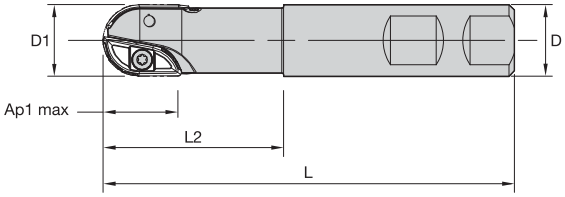
NOTE: **Products available by April 1st, 2018.**

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver	 Torx driver
.625	**FP3006T**	12.4	**TP8**	**–**
.750	**FP3007T**	12.4	**TP8**	**–**
1.000	**D4010T**	12.9	**–**	**T15**
1.250	**D5013T**	54.0	**–**	**T20**

- Rough to semi-finish profiling and contour milling.
- Helical insert design for increased speeds and feeds.
- One insert geometry covers most materials for optimized inventory.







Weldon® End Mills

order number	catalog number	D1	D	L	L2	Ap1 max	Z
5673595	**C5505VX08WA1.00R2.37**	1.000	1.000	4.650	2.370	.992	2
5672838	**C5505VX10WA1.25R3.00**	1.250	1.250	5.280	3.000	1.250	2
5673709	**C5505VX10WA1.25R4.00**	1.250	1.250	6.280	4.000	1.276	2
5672839	**C5505VX12WA1.50R4.00**	1.500	1.500	6.680	3.990	1.500	2
5673110	**C5505VX12WA1.50R6.00**	1.500	1.500	8.684	5.997	1.511	2
5672840	**C5505VX16WA2.00R4.00**	2.000	1.500	6.687	4.000	2.019	2
5673111	**C5505VX16WA2.00R6.00**	2.000	2.000	9.328	6.079	2.000	2

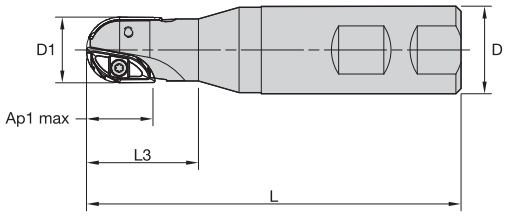
NOTE: **Products available by April 1st, 2018.**

Spare Parts

D1	 insert screw	 in. lbs.	 Torx driver
1.000	**D4010T**	12.9	**T15**
1.250	**D5013T**	54.0	**T20**
1.500	**D6014T**	62.0	**T20**
2.000	**D6018S**	146.0	**—**

- Rough to semi-finish profiling and contour milling.
- Helical insert design for increased speeds and feeds.
- One insert geometry covers most materials for optimized inventory.







Weldon® End Mills Flat

order number	catalog number	D1	D	L	L3	Ap1 max	Z
5673296	**C5505VX06WA.750R2.00**	.750	1.000	4.280	1.260	.760	2

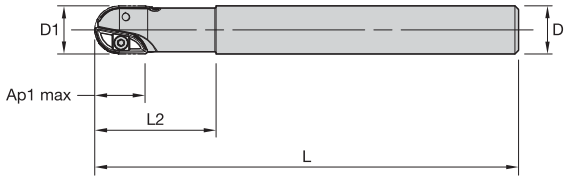
NOTE: **Products available by April 1st, 2018.**

Spare Parts

D1	insert screw	in. lbs.	Torx Plus driver
.750	**F3006T**	16.0	**TP8**

- Rough to semi-finish profiling and contour milling.
- Helical insert design for increased speeds and feeds.
- One insert geometry covers most materials for optimized inventory.







Cylindrical End Mills

order number	catalog number	D1	D	L	L2	Ap1 max	Z
5673633	**C5505VX05CA.62R1.6**	.625	.625	5.500	1.575	.630	2
5672846	**C5505VX05CA.75/.62R1**	.625	.750	7.000	1.575	.654	2
5672847	**C5505VX06CA.75R1.7**	.750	.750	5.000	2.000	.654	2
5673786	**C5505VX06CA1/.75R1.5**	.750	1.000	8.000	1.969	.760	2
5672848	**C5505VX08CA1.00R2.2**	1.000	1.000	10.000	2.165	1.000	2
5673142	**C5505VX10CA1.25R2.2**	1.250	1.250	10.000	2.559	1.276	2

NOTE: **Products available by April 1st, 2018.**

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver
.625	**FP3006T**	12.4	**TP8**
.750	**FP3007T**	16.0	**TP8**
1.000	**D4010T**	27.4	**TP15**
1.250	**D5013T**	53.1	**–**

Technical Information

Technical Information (in)

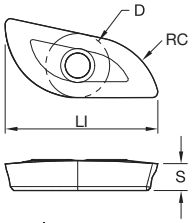
order number	catalog number	dimension					max RPM
		facing pitch	ramping angle	helical hole min–max		ap max helical/linear	
5673296	**C5505VX06WA.750R2.00**	–	85	–	–	–	37,250
5673595	**C5505VX08WA1.00R2.37**	–	85	–	–	–	30,250
5672658	**C5505VX08WA1.00R3.55 032344**	–	85	–	–	–	30,250
5672838	**C5505VX10WA1.25R3.00**	–	85	–	–	–	23,500
5673709	**C5505VX10WA1.25R4.00**	–	85	–	–	–	23,500
5672839	**C5505VX12WA1.50R4.00**	–	85	–	–	–	19,000
5673110	**C5505VX12WA1.50R6.00**	–	85	–	–	–	19,000
5672840	**C5505VX16WA2.00R4.00**	–	85	–	–	–	16,750
5673111	**C5505VX16WA2.00R6.00**	–	85	–	–	–	16,750
5673633	**C5505VX05CA.62R1.6**	–	85	–	–	–	54,250
5672846	**C5505VX05CA.75/.62R1**	–	85	–	–	–	54,250
5672847	**C5505VX06CA.75R1.7**	–	85	–	–	–	37,250
5673786	**C5505VX06CA1/.75R1.5**	–	85	–	–	–	37,250
5672848	**C5505VX08CA1.00R2.2**	–	85	–	–	–	30,250
5673142	**C5505VX10CA1.25R2.2**	–	85	–	–	–	23,500
5673710	**A5505VX05SA.625R1.00**	–	85	–	–	–	54,250
5673603	**A5505VX06SA.750R1.377**	–	85	–	–	–	37,250
5673624	**A5505VX08SA1.00R1.575**	–	85	–	–	–	30,250
5672841	**A5505VX10SA1.25R1.968**	–	85	–	–	–	23,500

 Ramping

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

catalog number	D	LI	S	RC	hm	SP6519
XPNT050522RF	.291	.685	.125	.312	.002	●
XPNT06062515RF	.336	.783	.156	.375	.002	●
XPNT080832RF	.433	1.023	.187	.500	.002	●
XPNT101043RF	.555	1.315	.249	.625	.002	●
XPNT121254RF	.669	1.575	.312	.750	.002	●
XPNT161654RF	.875	2.081	.336	1.000	.002	●

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 [IPT]

Light Machining	General Purpose	Heavy Machining

At .315 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	.004	**.008**	.014	.003	**.006**	.010	.002	**.004**	.007	.002	**.004**	.006	.002	**.004**	.006	R-F

At .157 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	.004	**.009**	.016	.003	**.007**	.011	.002	**.005**	.009	.002	**.004**	.007	.002	**.004**	.007	R-F

At .079 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	.006	**.012**	.021	.004	**.009**	.015	.003	**.007**	.011	.003	**.006**	.010	.002	**.005**	.009	R-F

At .039 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	.008	**.017**	.028	.006	**.012**	.020	.004	**.009**	.015	.004	**.008**	.013	.003	**.007**	.012	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 [IPT]

Light Machining	General Purpose	Heavy Machining

At .394 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	.004	**.010**	.016	.003	**.007**	.011	.002	**.006**	.008	.002	**.005**	.007	.002	**.004**	.007	R-F

At .197 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	.004	**.012**	.018	.003	**.009**	.013	.002	**.006**	.010	.002	**.006**	.008	.002	**.005**	.008	R-F

At .098 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	.006	**.016**	.024	.004	**.011**	.017	.003	**.008**	.013	.003	**.007**	.011	.002	**.007**	.010	R-F

At .049 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	.008	**.021**	.032	.006	**.015**	.023	.004	**.012**	.017	.004	**.010**	.015	.003	**.009**	.014	R-F

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .492 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	.004	**.011**	.019	.003	**.008**	.013	.002	**.006**	.010	.002	**.005**	.009	.002	**.005**	.008	R-F

At .250 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	.004	**.013**	.021	.003	**.010**	.015	.002	**.007**	.012	.002	**.006**	.010	.002	**.006**	.009	R-F

At .125 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	.006	**.017**	.028	.004	**.012**	.020	.003	**.009**	.015	.003	**.008**	.013	.002	**.007**	.012	R-F

At .063 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	.008	**.024**	.038	.005	**.017**	.028	.004	**.013**	.021	.004	**.011**	.018	.003	**.010**	.016	R-F

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .630 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	.004	**.011**	.019	.003	**.008**	.013	.002	**.006**	.010	.002	**.005**	.009	.002	**.005**	.008	R-F

At .315 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	.004	**.013**	.021	.003	**.010**	.015	.002	**.007**	.012	.002	**.006**	.010	.002	**.006**	.009	R-F

At .157 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	.006	**.017**	.028	.004	**.013**	.020	.003	**.009**	.015	.003	**.008**	.013	.002	**.007**	.012	R-F

At .079 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	.008	**.024**	.039	.006	**.017**	.028	.004	**.013**	.021	.004	**.011**	.018	.003	**.010**	.017	R-F

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .787 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	.004	**.013**	.022	.003	**.009**	.016	.002	**.007**	.012	.002	**.006**	.010	.002	**.005**	.010	R-F

At .394 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	.004	**.015**	.026	.003	**.010**	.019	.002	**.008**	.014	.002	**.007**	.012	.002	**.006**	.011	R-F

At .197 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	.006	**.019**	.034	.004	**.014**	.024	.003	**.010**	.018	.003	**.009**	.016	.002	**.008**	.015	R-F

At .098 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	.008	**.026**	.047	.006	**.019**	.033	.004	**.014**	.025	.004	**.012**	.022	.003	**.011**	.020	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 [IPT]

Light Machining	General Purpose	Heavy Machining

At .984 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	.004	**.015**	.025	.003	**.011**	.018	.002	**.008**	.014	.002	**.007**	.012	.002	**.006**	.011	R-F

At .500 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	.004	**.017**	.029	.003	**.012**	.021	.002	**.009**	.016	.002	**.008**	.014	.002	**.007**	.012	R-F

At .250 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	.006	**.022**	.038	.004	**.016**	.027	.003	**.012**	.020	.003	**.010**	.018	.002	**.010**	.016	R-F

At .125 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	.008	**.031**	.052	.005	**.022**	.038	.004	**.016**	.028	.004	**.014**	.024	.003	**.013**	.022	R-F

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

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 optimization. Hardware support. Tooling selection. Troubleshooting.
BEST-IN-CLASS SUPPORT TOOLS AND TECHNOLOGY	Materials database. Application calculators. Tooling performance experts.



Originating Country	Language	Phone	E-mail
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China	Chinese	400 889 2238	k-cn.techsupport@kennametal.com
Denmark	English	808 89298	na.techsupport@kennametal.com
Finland	English	0800 919412	na.techsupport@kennametal.com
France	French	080 5540 367	eu.techsupport@kennametal.com
Germany	German	0800 0006651	eu.techsupport@kennametal.com
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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
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Numbers shown only serve the originating country listed.

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 .0004".
- Improved geometries for roughing and finishing operations.
- Smaller diameters from .25" to replace SCEM, setting a more productive machining process.

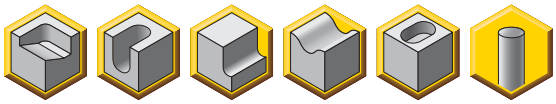
Superior Productivity

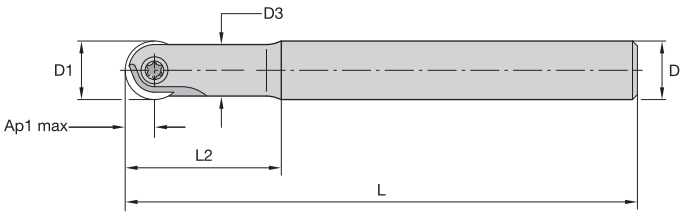
- Achieve better surface quality with the new helical geometry.
- New ultra-grain grade for outstanding tool life.
- Diameters .250" and .312" are a natural replacement for SEM tools.
- Better cost per edge.

Usability and Flexibility

- Wide diameter range enables use in a wide range of machining conditions.
- Many workpiece materials are possible — from hardened steel to aluminum.
- Large holder style offering: screw-on, cylindrical, and tapered steel and carbide holders.

- Cutting diameter ranges from .375–1.250".
- Ball nose finishers for 3D milling applications.
- Suitable for roughing and fi nishing operations.
- High precision and runout accuracy.
- Can be used with heat shrink technology, h6 shank tolerance.







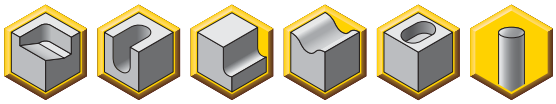
Necked End Mills • Cylindrical Shank • Steel

order number	catalog number	D1	D	D3	L	L2	Ap1 max	Z	Z U	coolant supply	max ramp angle	max RPM	insert 1	lbs
2877812	KDMB0375R354A038SN	.375	.500	.335	3.543	1.378	.188	1	2	No	3.0°	40000	KDMB0375..	.07
2878434	KDMB0500R512A050SN	.500	.500	.413	5.120	1.260	.250	1	2	No	3.0°	40000	KDMB0500..	.22
2878433	KDMB0500R591A050SN	.500	.500	.413	5.906	1.810	.250	1	2	No	3.0°	40000	KDMB0500..	.22
2878435	KDMB0625R551A063SN	.625	.625	.551	5.512	1.420	.313	1	2	No	3.0°	40000	KDMB0625..	.44
2878436	KDMB0625R630A063SN	.625	.625	.551	6.299	2.090	.313	1	2	No	3.0°	40000	KDMB0625..	.44
2878437	KDMB0750R630A075SN	.750	.750	.709	6.281	1.753	.375	1	2	No	3.0°	40000	KDMB0750..	.88
2878438	KDMB0750R689A075SN	.750	.750	.709	6.890	2.362	.375	1	2	No	3.0°	40000	KDMB0750..	.88
2878439	KDMB0750R827A075SN	.750	.750	.709	8.268	2.360	.375	1	2	No	3.0°	40000	KDMB0750..	.99
2878440	KDMB1000R630A100SN	1.000	1.000	.882	6.299	1.770	.500	1	2	No	3.0°	40000	KDMB1000..	1.32
2878441	KDMB1000R748A100SN	1.000	1.000	.882	7.480	2.760	.500	1	2	No	3.0°	40000	KDMB1000..	1.54
2878442	KDMB1250R689A125SN	1.250	1.250	1.126	6.890	2.205	.625	1	2	No	3.0°	40000	KDMB1250..	2.20
2878443	KDMB1250R827A125SN	1.250	1.250	1.126	8.268	3.150	.625	1	2	No	3.0°	40000	KDMB1250..	2.57

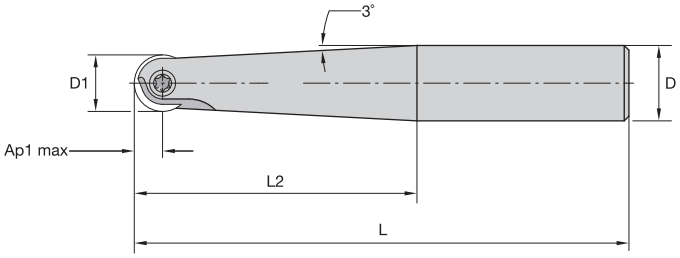
Spare Parts

D1	 insert screw	 in. lbs.	 Torx wrench
.375	193.394	27	KT15
.500	193.393	35	KT20
.625	193.392	44	KT20
.750	193.391	53	KT20
1.000	193.390	58	KT30
1.250	193.389	58	KT30

- Available diameters: .312–1.250".
- 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.







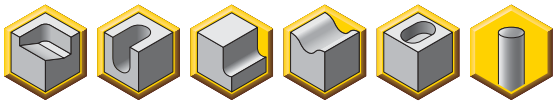
Tapered End Mills • Cylindrical Shank • Steel

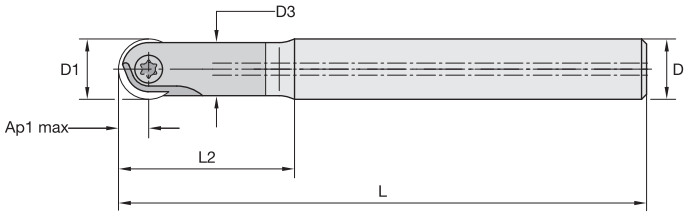
order number	catalog number	D1	D	L	L2	Ap1 max	Z	Z U	max ramp angle	max RPM	insert 1	lbs
2878444	**KDMB0312R551A031ST**	.312	.500	5.510	1.970	.156	1	2	3.0°	40000	KDMB0312..	.25
2878445	**KDMB0375R591A038ST**	.375	.500	5.910	1.380	.188	1	2	3.0°	40000	KDMB0375..	.29
2878446	**KDMB0500R630A050ST**	.500	.625	6.300	2.360	.250	1	2	3.0°	40000	KDMB0500..	.47
2878448	**KDMB0750R748A075ST**	.750	1.000	7.480	3.150	.375	1	2	3.0°	40000	KDMB0750..	1.41
2878449	**KDMB1000R827A100ST**	1.000	1.250	8.270	3.940	.500	1	2	3.0°	30000	KDMB1000..	2.52
2878450	**KDMB1250R945A125ST**	1.250	1.500	9.450	4.840	.625	1	2	3.0°	40000	KDMB1250..	3.82

Spare Parts

D1	 insert screw	 in. lbs.	 Torx wrench
.312	**193.395**	18	**KT8**
.375	**193.394**	27	**KT15**
.500	**193.393**	35	**KT20**
.750	**193.391**	53	**KT20**
1.000	**193.390**	58	**KT30**
1.250	**193.389**	58	**KT30**

- Available diameters: .250–1.250".
- 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	catalog number	D1	D	D3	L	L2	Ap1 max	Z	Z U	coolant supply	max ramp angle	max RPM	insert 1	lbs
4177170	**KDMB025R394A025HN**	.250	.250	.211	3.937	1.575	.125	1	2	No	3.0°	40000	KDMB0250..	.11
4177171	**KDMB025R591A025HN**	.250	.250	.211	5.906	2.756	.125	1	2	No	3.0°	40000	KDMB0250..	.11
4177172	**KDMB025R788A025HN**	.250	.250	.211	7.874	3.937	.125	1	2	No	3.0°	40000	KDMB0250..	.11
4177167	**KDMB025R394A038HN**	.250	.375	.213	3.937	1.599	.125	1	2	No	3.0°	40000	KDMB0250..	.11
4177169	**KDMB0312R591A038HN**	.312	.375	.276	5.906	1.623	.156	1	2	No	3.0°	40000	KDMB0312..	.22
2879403	**KDMB0375R472A038HNC**	.375	.375	.350	4.730	1.310	.375	1	2	Yes	3.0°	30000	KDMB0375..	.23
2879404	**KDMB0375R591A038HNC**	.375	.375	.350	5.910	1.900	.188	1	2	Yes	3.0°	30000	KDMB0375..	.28
2879405	**KDMB0500R472A050HNC**	.500	.500	.420	4.730	1.392	.188	1	2	Yes	3.0°	40000	KDMB0500..	.39
2879406	**KDMB0500R630A050HNC**	.500	.500	.420	6.300	1.982	.313	1	2	Yes	3.0°	40000	KDMB0500..	.53
2879408	**KDMB0625R689A063HNC**	.625	.625	.560	6.890	2.163	.250	1	2	Yes	3.0°	40000	KDMB0625..	.87
2879409	**KDMB0750R551A075HNC**	.750	.750	.710	5.520	1.950	.250	1	2	Yes	3.0°	40000	KDMB0750..	1.04
2879410	**KDMB0750R827A075HNC**	.750	.750	.710	8.270	2.362	.500	1	2	Yes	3.0°	40000	KDMB0750..	.96
2879411	**KDMB1000R630A100HNC**	1.000	1.000	.890	6.307	2.370	.375	1	2	Yes	3.0°	30000	KDMB1000..	2.01
2879412	**KDMB1000R906A100HNC**	1.000	1.000	.890	8.270	3.539	.500	1	2	Yes	3.0°	30000	KDMB1000..	2.01

Spare Parts

D1	 insert screw	 in. lbs.	 Torx wrench
.250	**MS2236**	18	**KT6**
.312	**193.395**	18	**KT8**
.375	**193.394**	27	**KT15**
.500	**193.393**	35	**KT20**
.625	**193.392**	44	**KT20**
.750	**193.391**	53	**KT20**
1.000	**193.390**	58	**KT30**

Insert Selection Guide

KDMB Ball Nose Platform • .250"

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..GP	KC515M
P3–P4	.E..GP	KC515M	**.E..GP**	**KC515M**	.E..GP	KC515M
P5–P6	.E..GP	KC515M	**.E..GP**	**KC515M**	.E..GP	KC515M
M1–M2	.E..GP	KC515M	**.E..GP**	**KC515M**	–	–
M3	.E..GP	KC515M	**.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..GP**	**KC515M**	–	–
H1	.E..GP	KC515M	**.E..GP**	**KC515M**	–	–

KDMB Ball Nose Platform • .312"

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..GP	KC515M
P3–P4	.E..GP	KC505M	**.E..GP**	**KC515M**	.E..GP	KC515M
P5–P6	.E..GP	KC505M	**.E..GP**	**KC515M**	.E..GP	KC515M
M1–M2	.E..GP	KC515M	**.E..GP**	**KC515M**	–	–
M3	.E..GP	KC515M	**.E..GP**	**KC515M**	–	–
K1–K2	.E..GP	KC515M	**–**	**–**	–	–
K3	.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..GP	KC515M

KDMB Ball Nose Platform • .375"

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..GP	KC515M
P3–P4	.E..GP	KC505M	**.E..GP**	**KC515M**	.E..GP	KC515M
P5–P6	.E..GP	KC505M	**.E..GP**	**KC515M**	.E..GP	KC515M
M1–M2	.E..GP	KC515M	**.E..GP**	**KC515M**	–	–
M3	.E..GP	KC515M	**.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..GP	KC515M

KDMB Ball Nose Platform • .500"

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	KC515M

KDMB Ball Nose Platform • .625"

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..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**	.E..HC	KC530M
H1	.E..GP	KC505M	**.E..GP**	**KC505M**	.E..GP	KC515M

KDMB Ball Nose Platform • .750"

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	KC515M

Insert Selection Guide

KDMB Ball Nose Platform • 1.00"

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	KC515M

KDMB Ball Nose Platform • 1.25"

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..GP	KC515M
P3–P4	.E..GP	KC505M	**.E..GP**	**KC515M**	.E..GP	KC515M
P5–P6	.E..GP	KC505M	**.E..GP**	**KC515M**	.E..GP	KC515M
M1–M2	.E..GP	KC515M	**.E..GP**	**KC515M**	–	–
M3	.E..GP	KC515M	**.E..GP**	**KC515M**	–	–
K1–K2	.E..GP	KC515M	**–**	**–**	–	–
K3	.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..GP	KC515M

Insert Style

HC Geometry:

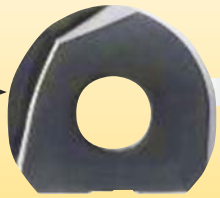
PSTS geometry with chipbreaker for roughing. Semi-finishing and rest material of steel, cast steel, and high-temperature alloys.



roughing, rest material

GP Geometry:

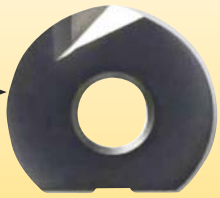
High-precision insert with helical geometry for semi-finishing and finishing of steel up to 63 HRC, cast steel, and high-temperature alloys.



semi-finishing, finishing

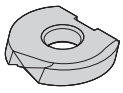
GN Geometry:

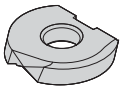
Geometry with extremely solid cutting edge for roughing cast steel, high-temperature alloys, and hardened steel up to 60 HRC.

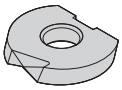


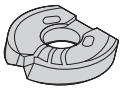
finishing

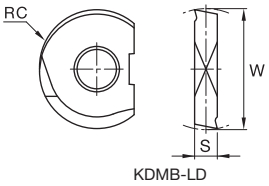
• High-precision positive geometry.


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

catalog number	W	S	RC	hm	K115M	KC505M	KC515M	KC530M
KDMB0250M0ERLD	.250	.063	.125	.002	●	–	–	–
KDMB0312M0ERLD	.313	.079	.156	.002	●	–	–	–
KDMB0375M0ERLD	.375	.098	.188	.002	●	–	–	–
KDMB0500M0ERLD	.500	.098	.250	.002	●	–	–	–
KDMB0625M0ERLD	.625	.118	.313	.002	●	–	–	–
KDMB0750M0ERLD	.750	.118	.375	.002	●	–	–	–
KDMB1000M0ERLD	1.000	.158	.500	.002	●	–	–	–
KDMB1250M0ERLD	1.250	.197	.625	.002	●	–	–	–

• High-precision helical geometry.

KDMB-GP • High-Precision Helical Geometry and Lower Cutting Forces

catalog number	W	S	RC	hm	K115M	KC505M	KC515M	KC530M
KDMB0250M0ERGP	.250	.063	.125	.002	–	–	●	–
KDMB0312M0ERGP	.312	.079	.156	.002	–	●	–	–
KDMB0375M0ERGP	.375	.098	.188	.002	–	●	●	–
KDMB0500M0ERGP	.500	.098	.250	.002	–	–	●	–
KDMB0500M0ERGP	.500	.098	.250	.002	–	●	–	–
KDMB0625M0ERGP	.625	.118	.313	.002	–	●	●	–
KDMB0750M0ERGP	.750	.118	.375	.002	–	●	●	–
KDMB1000M0ERGP	1.000	.158	.500	.002	–	●	●	–
KDMB1250M0ERGP	1.250	.197	.625	.002	–	●	●	–

• High-precision insert.

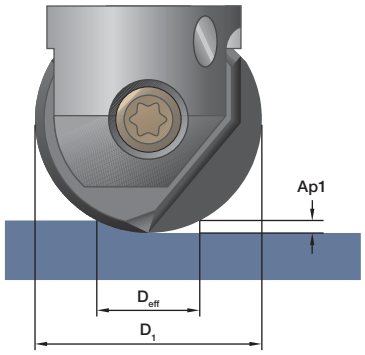
KDMB-GN • High Precision • Extremely Solid Cutting Edge

catalog number	W	S	RC	hm	K115M	KC505M	KC515M	KC530M
KDMB0500M0ERGN	.500	.098	.250	.003	–	–	●	–
KDMB0750M0ERGN	.750	.118	.375	.003	–	–	●	–
KDMB1000M0ERGN	1.000	.158	.500	.003	–	–	●	–

• Pressed insert.

KDMB-HC • PSTS Insert Developed for Roughing and Rest Material Operations

catalog number	W	S	RC	hm	K115M	KC505M	KC515M	KC530M
KDMB0500M0ERHC	.500	.098	.250	.004	–	–	–	●
KDMB0625M0ERHC	.625	.118	.313	.004	–	–	–	●
KDMB0750M0ERHC	.750	.118	.375	.004	–	–	–	●
KDMB1000M0ERHC	1.000	.158	.500	.004	–	–	–	●



KDMB Ball Nose • .250"

D1 max	Working Diameter (Dw) at Axial Depth of Cut (ap)			
	0.125	0.050	0.025	0.013
0.250	0.250	0.200	0.150	0.109

KDMB Ball Nose • .312"

D1 max	Working Diameter (Dw) at Axial Depth of Cut (ap)			
	0.156	0.047	0.031	0.016
0.313	0.313	0.223	0.188	0.136

KDMB Ball Nose • .375"

D1 max	Working Diameter (Dw) at Axial Depth of Cut (ap)			
	0.188	0.056	0.038	0.019
0.375	0.375	0.268	0.225	0.163

KDMB Ball Nose • .500"

D1 max	Working Diameter (Dw) at Axial Depth of Cut (ap)			
	0.250	0.075	0.050	0.025
0.500	0.500	0.357	0.300	0.218

KDMB Ball Nose • .625"

D1 max	Working Diameter (Dw) at Axial Depth of Cut (ap)			
	0.313	0.094	0.063	0.031
0.625	0.625	0.446	0.375	0.272

KDMB Ball Nose • .750"

D1 max	Working Diameter (Dw) at Axial Depth of Cut (ap)			
	0.375	0.113	0.075	0.038
0.750	0.750	0.536	0.450	0.327

KDMB Ball Nose • 1.00"

D1 max	Working Diameter (Dw) at Axial Depth of Cut (ap)			
	0.500	0.150	0.100	0.050
1.000	1.000	0.714	0.600	0.436

KDMB Ball Nose • 1.25"

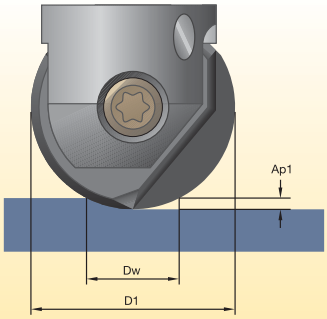
D1 max	Working Diameter (Dw) at Axial Depth of Cut (ap)			
	0.625	0.188	0.125	0.063
1.250	1.250	0.893	0.750	0.545

NOTE: Working diameter (Dw) or effective diameter has to be considered when calculating appropriate RPMs.

Calculating Working Diameter and Resulting Surface Speed

Case 1:

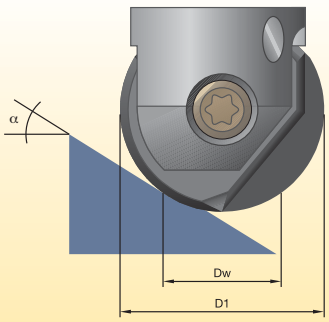
It is important to consider the effective diameter (Dw) when using light depths of cut in order to properly calculate RPM values. Use the following formula when machining flat surfaces or inclinations of 10° or less to find the Dw value. Then, use this for RPM calculations, as opposed to using the overall insert diameter (D1).



$$Dw = \sqrt{D1_2\text{-}(D1\text{-}2Ap1)_2}$$

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.



$$k = \frac{1}{\sin [\alpha + \arccos (1\text{-}(2\ (Ap1/D1)))]}$$

$$vceff = vc \times k$$

Recommended Starting Feeds [IPT] • Ball Nose Insert Size .250"

Light Machining	General Purpose	Heavy Machining

At .125 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	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..LD
.E..GP	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..GP

At .050 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	.006	**.008**	.015	.004	**.006**	.011	.004	**.005**	.010	.004	**.005**	.009	.004	**.005**	.009	.E..LD
.E..GP	.006	**.008**	.015	.004	**.006**	.011	.004	**.005**	.010	.004	**.005**	.009	.004	**.005**	.009	.E..GP

At .025 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	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..LD
.E..GP	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..GP

At .013 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	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..LD
.E..GP	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..GP

Recommended Starting Feeds [IPT] • Ball Nose Insert Size .312"

At .156 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	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..LD
.E..GP	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..GP

At .047 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	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..LD
.E..GP	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..GP

At .031 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	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..LD
.E..GP	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..GP

At .016 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	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..LD
.E..GP	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..GP

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [IPT] • Ball Nose Insert Size .375"

Light Machining	General Purpose	Heavy Machining

At .188 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	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..LD
.E..GP	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..GP

At .056 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	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..LD
.E..GP	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..GP

At .038 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	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..LD
.E..GP	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..GP

At .019 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	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..LD
.E..GP	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..GP

Recommended Starting Feeds [IPT] • Ball Nose Insert Size .500"

At .250 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	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..LD
.E..GP	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..GP
.E..GN	.007	**.010**	.018	.005	**.008**	.013	.004	**.007**	.011	.004	**.006**	.011	.004	**.006**	.011	.E..GN
.E..HC	.007	**.014**	.024	.005	**.010**	.018	.004	**.009**	.015	.004	**.008**	.014	.004	**.008**	.014	.E..HC

At .075 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	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..LD
.E..GP	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..GP
.E..GN	.009	**.014**	.025	.007	**.011**	.019	.006	**.009**	.016	.006	**.009**	.015	.006	**.008**	.015	.E..GN
.E..HC	.009	**.019**	.034	.007	**.014**	.025	.006	**.012**	.021	.006	**.011**	.020	.006	**.011**	.020	.E..HC

At .050 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	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..LD
.E..GP	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..GP
.E..GN	.011	**.017**	.030	.008	**.013**	.022	.007	**.011**	.019	.007	**.010**	.018	.007	**.010**	.018	.E..GN
.E..HC	.011	**.023**	.041	.008	**.017**	.030	.007	**.015**	.026	.007	**.014**	.024	.007	**.013**	.023	.E..HC

At .025 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	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..LD
.E..GP	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..GP
.E..GN	.016	**.024**	.042	.012	**.017**	.031	.010	**.015**	.026	.009	**.014**	.025	.009	**.014**	.024	.E..GN
.E..HC	.016	**.032**	.057	.012	**.023**	.041	.010	**.020**	.035	.009	**.019**	.033	.009	**.018**	.032	.E..HC

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [IPT] • Ball Nose Insert Size .625"

Light Machining	General Purpose	Heavy Machining

At .313 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	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..LD
.E..GP	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..GP
.E..HC	.007	**.014**	.024	.005	**.010**	.018	.004	**.009**	.015	.004	**.008**	.014	.004	**.008**	.014	.E..HC

At .094 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	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..LD
.E..GP	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..GP
.E..HC	.009	**.019**	.034	.007	**.014**	.025	.006	**.012**	.021	.006	**.011**	.020	.006	**.011**	.020	.E..HC

At .063 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	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..LD
.E..GP	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..GP
.E..HC	.011	**.023**	.041	.008	**.017**	.030	.007	**.015**	.026	.007	**.014**	.024	.007	**.013**	.023	.E..HC

At .031 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	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..LD
.E..GP	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..GP
.E..HC	.016	**.032**	.057	.012	**.023**	.041	.010	**.020**	.035	.009	**.019**	.033	.009	**.018**	.032	.E..HC

Recommended Starting Feeds [IPT] • Ball Nose Insert Size .750"

At .375 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	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..LD
.E..GP	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..GP
.E..GN	.007	**.010**	.018	.005	**.008**	.013	.004	**.007**	.011	.004	**.006**	.011	.004	**.006**	.011	.E..GN
.E..HC	.007	**.014**	.024	.005	**.010**	.018	.004	**.009**	.015	.004	**.008**	.014	.004	**.008**	.014	.E..HC

At .113 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	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..LD
.E..GP	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..GP
.E..GN	.009	**.014**	.025	.007	**.011**	.019	.006	**.009**	.016	.006	**.009**	.015	.006	**.008**	.015	.E..GN
.E..HC	.009	**.019**	.034	.007	**.014**	.025	.006	**.012**	.021	.006	**.011**	.020	.006	**.011**	.020	.E..HC

At .075 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	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..LD
.E..GP	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..GP
.E..GN	.011	**.017**	.030	.008	**.013**	.022	.007	**.011**	.019	.007	**.010**	.018	.007	**.010**	.018	.E..GN
.E..HC	.011	**.023**	.041	.008	**.017**	.030	.007	**.015**	.026	.007	**.014**	.024	.007	**.013**	.023	.E..HC

At .038 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	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..LD
.E..GP	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..GP
.E..GN	.016	**.024**	.042	.012	**.017**	.031	.010	**.015**	.026	.009	**.014**	.025	.009	**.014**	.024	.E..GN
.E..HC	.016	**.032**	.057	.012	**.023**	.041	.010	**.020**	.035	.009	**.019**	.033	.009	**.018**	.032	.E..HC

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [IPT] • Ball Nose Insert Size 1.00"

Light Machining	General Purpose	Heavy Machining

At .500 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	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..LD
.E..GP	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..GP
.E..GN	.007	**.010**	.018	.005	**.008**	.013	.004	**.007**	.011	.004	**.006**	.011	.004	**.006**	.011	.E..GN
.E..HC	.007	**.014**	.024	.005	**.010**	.018	.004	**.009**	.015	.004	**.008**	.014	.004	**.008**	.014	.E..HC

At .150 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	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..LD
.E..GP	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..GP
.E..GN	.009	**.014**	.025	.007	**.011**	.019	.006	**.009**	.016	.006	**.009**	.015	.006	**.008**	.015	.E..GN
.E..HC	.009	**.019**	.034	.007	**.014**	.025	.006	**.012**	.021	.006	**.011**	.020	.006	**.011**	.020	.E..HC

At .100 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	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..LD
.E..GP	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..GP
.E..GN	.011	**.017**	.030	.008	**.013**	.022	.007	**.011**	.019	.007	**.010**	.018	.007	**.010**	.018	.E..GN
.E..HC	.011	**.023**	.041	.008	**.017**	.030	.007	**.015**	.026	.007	**.014**	.024	.007	**.013**	.023	.E..HC

At .050 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	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..LD
.E..GP	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..GP
.E..GN	.016	**.024**	.042	.012	**.017**	.031	.010	**.015**	.026	.009	**.014**	.025	.009	**.014**	.024	.E..GN
.E..HC	.016	**.032**	.057	.012	**.023**	.041	.010	**.020**	.035	.009	**.019**	.033	.009	**.018**	.032	.E..HC

Recommended Starting Feeds [IPT] • Ball Nose Insert Size 1.25"

At .625 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	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..LD
.E..GP	.005	**.007**	.012	.004	**.005**	.009	.003	**.004**	.008	.003	**.004**	.007	.003	**.004**	.007	.E..GP

At .188 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	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..LD
.E..GP	.007	**.009**	.017	.005	**.007**	.012	.004	**.006**	.011	.004	**.006**	.010	.004	**.006**	.010	.E..GP

At .125 Axial Depth of Cut (ap)

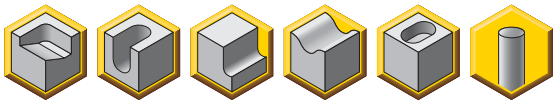
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.E..LD	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..LD
.E..GP	.008	**.011**	.020	.006	**.008**	.015	.005	**.007**	.013	.005	**.007**	.012	.005	**.007**	.012	.E..GP

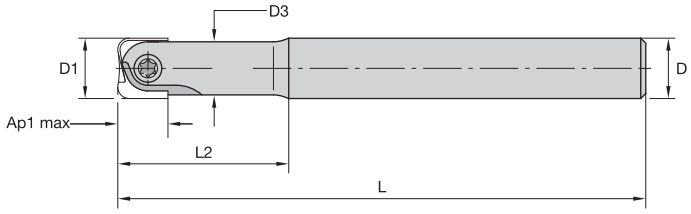
At .063 Axial Depth of Cut (ap)

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	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..LD
.E..GP	.011	**.016**	.028	.008	**.012**	.020	.007	**.010**	.018	.007	**.009**	.016	.006	**.009**	.016	.E..GP

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X32–X37 for recommended starting speeds.

- Cutting diameter ranges from .500–1.000".
- 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.







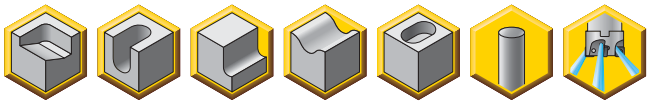
Necked End Mills • Cylindrical Shank • Steel

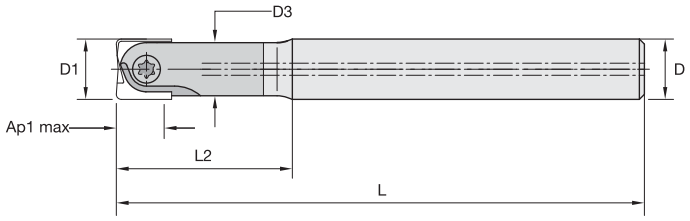
order number	catalog number	D1	D	D3	L	L2	Ap1 max	Z	Z U	max ramp angle	max RPM	insert 1	lbs
2957828	**KDMT0500R512A050SN**	.500	.500	.420	5.120	1.339	.118	1	2	3.0°	40000	KDMT0500..	.22
2957829	**KDMT0500R591A050SN**	.500	.500	.420	5.909	1.890	.118	1	2	3.0°	40000	KDMT0500..	.22
2957831	**KDMT0625R630A063SN**	.625	.625	.560	6.300	2.165	.157	1	2	3.0°	40000	KDMT0625..	.44
2957832	**KDMT0750R630A075SN**	.750	.750	.710	6.300	1.850	.197	1	2	3.0°	40000	KDMT0750..	.88
2958143	**KDMT0750R827A075SN**	.750	.750	.710	8.270	2.362	.197	1	2	3.0°	40000	KDMT0750..	.88
2958144	**KDMT1000R630A100SN**	1.000	1.000	.890	6.300	1.850	.236	1	2	3.0°	40000	KDMT1000..	1.32
2958146	**KDMT1000R906A100SN**	1.000	1.000	.890	9.059	3.150	.236	1	2	3.0°	40000	KDMT1000..	1.76

Spare Parts

D1	 insert screw	 in. lbs.	 Torx wrench
.500	**193.393**	35	**KT20**
.625	**193.392**	44	**KT20**
.750	**193.391**	53	**KT20**
1.000	**193.390**	58	**KT30**

- Cutting diameter ranges from .500–1.000".
- 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 • Carbide Shank with Through Coolant

order number	catalog number	D1	D	D3	L	L2	Ap1 max	Z	Z U	max ramp angle	max RPM	insert 1	lbs
2878733	**KDMT0500R630A050HNC**	.500	.500	.420	6.378	2.047	.118	1	2	3.0°	40000	KDMT0500..	.53
2878737	**KDMT0750R748A075HNC**	.750	.750	.710	7.559	3.032	.197	1	2	3.0°	40000	KDMT0750..	1.46

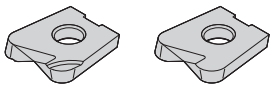
Spare Parts

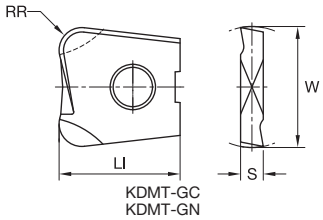
D1	insert screw	in. lbs.	Torx wrench
.500	**193.393**	35	**KT20**
.750	**193.391**	53	**KT20**

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..GN	KC515M	**.E..GN**	**KC515M**	.E..GN	KC515M
P5–P6	.E..GN	KC515M	**.E..GN**	**KC515M**	.E..GN	KC515M
M1–M2	–	–	**.E..GN**	**KC515M**	–	–
M3	–	–	**.E..GN**	**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	–	–	–	–	–	–
H1	–	–	**.E..GN**	**KC515M**	–	–

Indexable Inserts • KDMT...





● first choice
○ alternate choice

P		●
M		○
K		●
N		
S		
H		●

KDMT-GC • High-Tolerance Helical Geometry • Finishing Lower Cutting Force

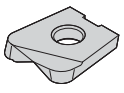
catalog number	LI	W	S	RR	hm	KC515M
KDMT05002ERGC	.550	.500	.098	.032	.003	●
KDMT05004ERGC	.550	.500	.098	.063	.003	●
KDMT07502ERGC	.700	.750	.118	.032	.003	●
KDMT10002ERGC	.925	1.000	.157	.032	.003	●
KDMT10004ERGC	.925	1.000	.157	.063	.003	●

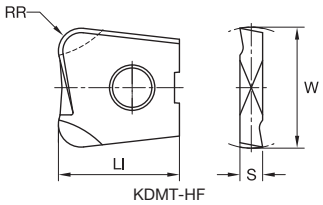
NOTE: Ap1 max is equal to RR
RT = Programming Radius

KDMT-GN • High-Precision Insert • Semi-Finishing and Finishing

catalog number	LI	W	S	RR	hm	KC515M
KDMT05002ERGN	.550	.500	.098	.032	.003	●
KDMT05004ERGN	.550	.500	.098	.063	.003	●
KDMT06254ERGN	.625	.625	.118	.063	.003	●
KDMT07502ERGN	.700	.750	.118	.032	.003	●
KDMT07504ERGN	.700	.750	.118	.063	.003	●

NOTE: Ap1 max is equal to RR.


KDMT-HF



KDMT-HF

● first choice
○ alternate choice

P		●
M		○
K		●
N		
S		
H		●

KDMT-HF • Geometry Developed for High-Feed Machining up to 55 HRC

catalog number	LI	W	S	RT	hm	KC515M
KDMT0750SRHF	.710	.750	.118	.080	.003	●

NOTE: RT = Programming Radius

Recommended Starting Feeds [IPT]

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	.007	**.010**	.014	.005	**.008**	.010	.004	**.007**	.009	.004	**.006**	.008	.004	**.006**	.008	.E..GC
.E..GN	.007	**.010**	.014	.005	**.008**	.010	.004	**.007**	.009	.004	**.006**	.008	.004	**.006**	.008	.E..GN

Recommended Starting Feeds [IPT] • KDMT High-Feed

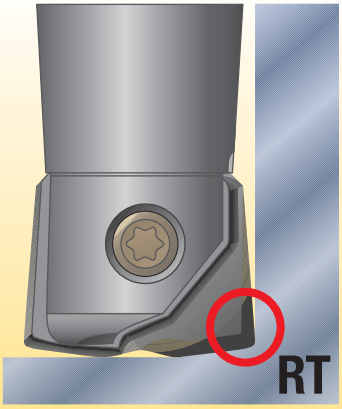
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.S..HF	.059	**.092**	.131	.042	**.064**	.086	.036	**.054**	.073	.034	**.050**	.067	.033	**.049**	.066	.S..HF

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	inch			
	Ap max	diameter	RT	max fz
KDMT0500SRHF	0.025	0.500	0.045	0.050
KDMT0625SRHF	0.030	0.625	0.050	0.050
KDMT0750SRHF	0.040	0.750	0.080	0.050



Data for Face Milling, Pocketing, and Profiling Operations

Starting Values

tool diameter	Ø.500"	Ø.625"	Ø.750"
Ap max (mm)	0.024	0.031	0.039
fz recommended for 45 HRC (approximately)	0.020	0.022	0.026
fz recommended for 55 HRC (approximately)	0.016	0.020	0.022
fz recommended for general purpose	0.026	0.028	0.031

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:

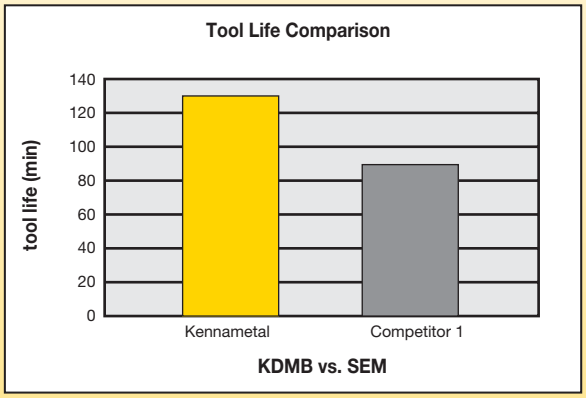
KDMB™ Indexable Milling Cutter vs. Solid Carbide End Mills

1.

Workpiece:
Forging die
Material:
X38 CrMoV 5 3 (1.2367)
Size:
154mm x 115mm x 80mm
Machine:
Vertical milling machine center

Kennametal
Tool: KDMB06R100A06HN
Insert: KDMB06M0ERGN KC505M
Competitor 1
Solid Carbide End Mill
Ø 6 R3





Cutting data:
vc = 825 SFM (250 m/min)
Ap = .099" (0,28mm)
ae = .052" (1,32mm)
fz = .0052" (0,131mm)

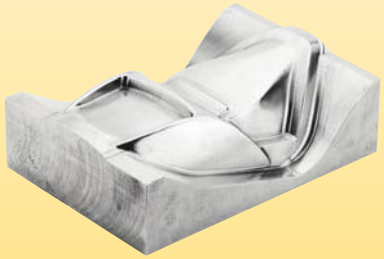
Superior Productivity:
Higher tool life and cost per piece

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

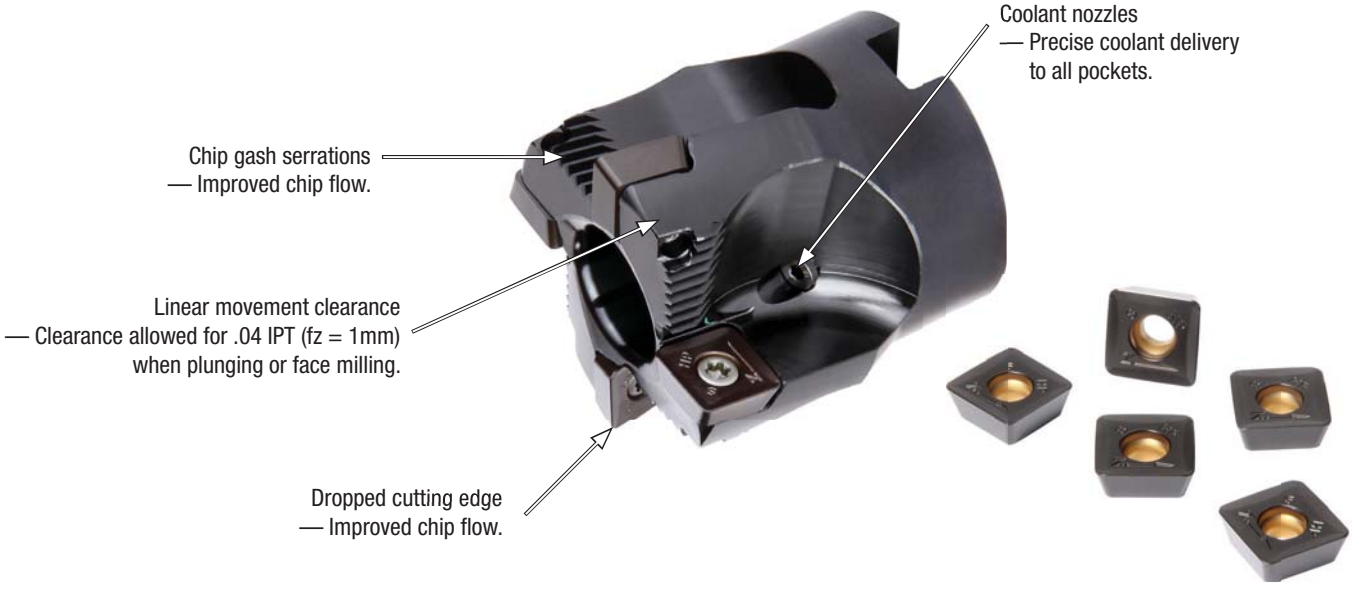
Primary Application

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 mold, and power generation.

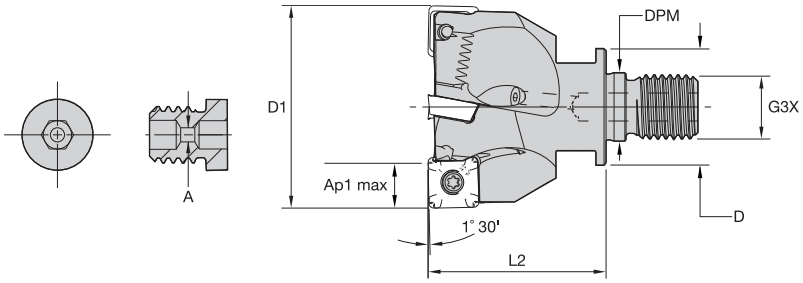
Features and Benefits

Platform Features

- Nine coolant nozzle sizes enable customized 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 .433" stepover.
- Unique coolant delivery.
- Chip control when slotting.





Screw-On End Mills

order number	catalog number	D1	D	DPM	G3X	L2	Ap1 max	Z	max RPM	lbs	insert 1
3449167	**KTSZR125SD430CM16A02**	1.250	1.142	.669	M16	1.750	.433	2	25800	.33	SD_T43_PD_N__Z
3449168	**KTSZR150SD430CM16A03**	1.500	1.142	.669	M16	1.750	.433	3	23550	.40	SD_T43_PD_N__Z
3449169	**KTSZR200SD430CM16A04**	2.000	1.142	.669	M16	1.750	.433	4	20400	.62	SD_T43_PD_N__Z

Spare Parts

D1	insert screw	in. lbs.	Torx Plus driver	coolant nozzle screw	T-handle hex wrench
1.250	**MS2197**	35	**DT15IP**	**MS2191C20**	**THW2M**
1.500	**MS2197**	35	**DT15IP**	**MS2191C20**	**THW2M**
2.000	**MS2197**	35	**DT15IP**	**MS2191C20**	**THW2M**

Coolant Screw Detail

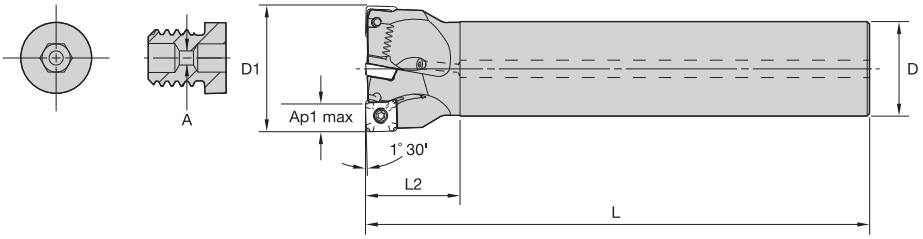
order number	catalog number	A
3400611	**MS2191C00**	—
3400612	**MS2191C06**	.024
3400613	**MS2191C08**	.032
3400616	**MS2191C12**	.047
3400617	**MS2191C14**	.055
3400618	**MS2191C16**	.063
3400619	**MS2191C18**	.071
3400620	**MS2191C20**	.079

Coolant Nozzle Key

order number	catalog 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 .047" (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 .433" stepover.
- Unique coolant delivery.
- Chip control when slotting.

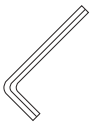




End Mills

order number	catalog number	D1	D	L	L2	Ap1 max	Z	max RPM	insert 1	lbs
3064601	**KISZR125SD430C4A02**	1.250	1.000	8.000	1.500	.433	2	25800	SD_T43_PD_N__Z	1.59
3107215	**KISZR150SD430C5A03**	1.500	1.250	8.000	1.500	.433	3	23550	SD_T43_PD_N__Z	2.47
3107216	**KISZR200SD430C6A04**	2.000	1.500	8.000	1.500	.433	4	20450	SD_T43_PD_N__Z	3.72

Spare Parts

D1	 insert screw	 in. lbs.	 Torx Plus driver	 T-handle hex wrench	 coolant nozzle screw
1.250	**MS2197**	35	**DT15IP**	**THW2M**	**MS2191C20**
1.500	**MS2197**	35	**DT15IP**	**THW2M**	**MS2191C20**
2.000	**MS2197**	35	**DT15IP**	**THW2M**	**MS2191C20**

Coolant Screw Detail

order number	catalog number	A
3400611	**MS2191C00**	—
3400612	**MS2191C06**	.024
3400613	**MS2191C08**	.032
3400616	**MS2191C12**	.047
3400617	**MS2191C14**	.055
3400618	**MS2191C16**	.063
3400619	**MS2191C18**	.071
3400620	**MS2191C20**	.079

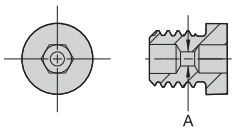
Coolant Nozzle Key

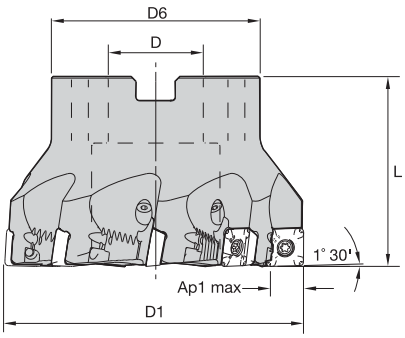
order number	catalog number	drive size
1993552	**THW2M**	2 MM

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 .047" (1,20mm) hole. All coolant nozzles are interchangeable with the original that is supplied with the cutter, which gives flexibility with coolant flow.

- Easy cutting.
- Four cutting edges.
- Consumes less power.
- Suitable for a wide variety of workpiece materials.
- Up to .433" stepover.
- Fast and easy insert indexing.
- Unique coolant delivery.
- Chip control when slotting.









Shell Mills

order number	catalog number	D1	D	D6	L	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
3054849	KSSZR200SD430C3A04	2.000	.750	1.664	1.750	.433	4	1.5°	20450	SD_T43_PD_N__Z	.66
3064755	KSSZR200SD430M3A05	2.000	.750	1.664	1.750	.433	5	1.5°	20450	SD_T43_PD_N__Z	.72
3448592	KSSZR250SD430C3A05	2.500	.750	1.664	1.750	.433	5	.6°	18290	SD_T43_PD_N__Z	.98
3448913	KSSZR250SD430M3A06	2.500	.750	1.664	1.750	.433	6	.6°	18290	SD_T43_PD_N__Z	1.03
3064493	KSSZR300SD430C4A05	3.000	1.000	2.190	2.000	.433	5	.7°	16700	SD_T43_PD_N__Z	1.94
3064902	KSSZR300SD430F4A07	3.000	1.000	2.190	2.000	.433	7	.7°	16700	SD_T43_PD_N__Z	1.97
3064602	KSSZR300SD430M4A06	3.000	1.000	2.190	2.000	.433	6	.7°	16700	SD_T43_PD_N__Z	1.96
3448914	KSSZR400SD430C5A07	4.000	1.250	2.880	2.500	.433	7	.5°	14460	SD_T43_PD_N__Z	4.23
3066674	KSSZR400SD430F5A09	4.000	1.250	2.880	2.500	.433	9	.5°	14460	SD_T43_PD_N__Z	4.41
3448915	KSSZR400SD430M5A08	4.000	1.250	2.880	2.500	.433	8	.5°	14460	SD_T43_PD_N__Z	4.34
3448916	KSSZR400SD430C6A07	4.000	1.500	3.375	2.500	.433	7	.5°	14460	SD_T43_PD_N__Z	4.51
3448918	KSSZR400SD430F6A09	4.000	1.500	3.375	2.500	.433	9	.5°	14460	SD_T43_PD_N__Z	4.72
3448917	KSSZR400SD430M6A08	4.000	1.500	3.375	2.500	.433	8	.5°	14460	SD_T43_PD_N__Z	4.64
3448920	KSSZR500SD430M6A09	5.000	1.500	3.810	2.500	.433	9	.5°	12940	SD_T43_PD_N__Z	7.40

Spare Parts

order number	D1	insert screw	in. lbs.	Torx Plus wrench	coolant nozzle screw	T-handle hex wrench	coolant lock screw assembly	socket-head cap screw with coolant groove
3054849	2.000	MS2197	35	DT15IP	MS2191C12	THW2M	–	S445CG
3064755	2.000	MS2197	35	DT15IP	–	THW2M	–	S445CG
3448592	2.500	MS2197	35	DT15IP	–	THW2M	–	S445CG
3448913	2.500	MS2197	35	DT15IP	–	THW2M	–	S445CG
3064493	3.000	MS2197	35	DT15IP	–	THW2M	–	S458CG
3064902	3.000	MS2197	35	DT15IP	MS2191C08	THW2M	–	S458CG
3064602	3.000	MS2197	35	DT15IP	–	THW2M	–	S458CG
3448914	4.000	MS2197	35	DT15IP	–	THW2M	S2162C	–
3448916	4.000	MS2197	35	DT15IP	–	THW2M	S2163C	–
3066674	4.000	MS2197	35	DT15IP	–	THW2M	S2162C	–
3448918	4.000	MS2197	35	DT15IP	–	THW2M	S2163C	–
3448915	4.000	MS2197	35	DT15IP	–	THW2M	S2162C	–
3448917	4.000	MS2197	35	DT15IP	–	THW2M	S2163C	–
3448920	5.000	MS2197	35	DT15IP	–	THW2M	S2163C	–

(continued)

(Shell Mills — continued)

Coolant Screw Detail

order number	catalog number	A
3400611	MS2191C00	—
3400612	MS2191C06	.024
3400613	MS2191C08	.032
3400616	MS2191C12	.047
3400617	MS2191C14	.055
3400618	MS2191C16	.063
3400619	MS2191C18	.071
3400620	MS2191C20	.079

Coolant Nozzle Key

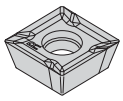
order number	catalog number	drive size
1993552	THW2M	2 MM

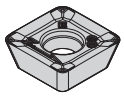
NOTE: Check the Spare Parts table for the coolant hole size that is incorporated in the cutters.
If you need an alternative, there are eight other variants to choose from to increase or decrease the pressure.
Example: MS2191C12 is a .047" (1,20mm) hole. All coolant nozzles are interchangeable with the original that is supplied with the cutter, which gives flexibility with coolant flow.

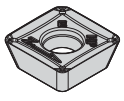
Inserts

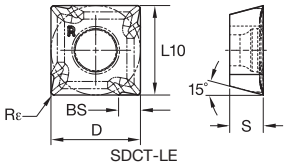
Insert Selection Guide

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	.F..LE	KC410M	.F..LE	KC410M	.F..LE	KC410M
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	–	–	–	–	–	–

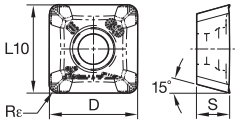

SDCT-LE


SDET-GDZ

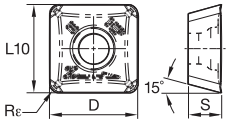

SDPT-HPZ



SDCT-LE



SDET-GDZ



SDPT-HPZ

● first choice
○ alternate choice

beyond

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

- High positive rake insert.

SDCT-LE

catalog number	D	L10	S	BS	Rε	hm	cutting edges	KC410M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30
SDCT431PDFL8LE	.500	.500	.188	.106	.016	.001	4	●	–	–	–	–	–	–	–
SDCT431PDFR8LE	.500	.500	.188	.106	.016	.001	4	●	–	–	–	–	–	–	–
SDCT433PDFL8LE	.500	.500	.188	.106	.047	.001	4	●	–	–	–	–	–	–	–
SDCT433PDFR8LE	.500	.500	.188	.106	.047	.001	4	●	–	–	–	–	–	–	–
SDCT434FNLE	.500	.500	.188	–	.063	.001	4	●	–	–	–	–	–	–	–
SDCT435FNLE	.500	.500	.188	–	.078	.001	4	●	–	–	–	–	–	–	–
SDCT436FNLE	.500	.500	.188	–	.094	.001	4	●	–	–	–	–	–	–	–
SDCT438FNLE	.500	.500	.188	–	.125	.001	4	●	–	–	–	–	–	–	–
SDCT43PDFL8LE	.500	.500	.188	.106	.031	.001	4	●	–	–	–	–	–	–	–
SDCT43PDFR8LE	.500	.500	.188	.106	.031	.001	4	●	–	–	–	–	–	–	–

- Precision ground insert.

SDET-GDZ

catalog number	D	L10	S	BS	Rε	hm	cutting edges	KC410M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30
SDET433PDENGDZ	.500	.500	.188	–	.047	.003	4	–	–	–	●	–	●	●	–
SDET433PDSNGDZ	.500	.500	.188	–	.047	.005	4	–	●	–	●	–	●	●	–

- Pressed to size insert.

SDPT-HPZ

catalog number	D	L10	S	BS	Rε	hm	cutting edges	KC410M	KC522M	KC525M	KC725M	KCK15	KCPK30	KCPM40	KCSM30
SDPT433PDENHPZ	.500	.500	.188	–	.047	.003	4	–	–	–	●	–	●	●	–
SDPT433PDSNHPZ	.500	.500	.188	–	.047	.006	4	–	–	–	●	–	●	●	–

Recommended Starting Feeds [IPT]

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	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	.002	**.004**	.008	.F..LE
.E..GDZ	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	.004	**.010**	.016	.E..GDZ
.S..GDZ	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	.004	**.010**	.016	.S..GDZ
.E..HPZ	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	.004	**.010**	.016	.E..HPZ
.S..HPZ	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	.004	**.010**	.016	.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.

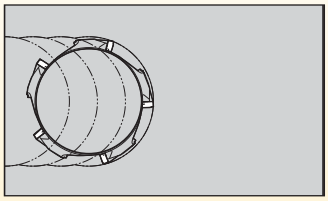


Figure 1

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 spiraling upwards.

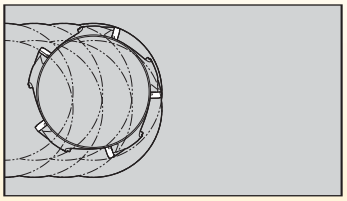


Figure 2

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 2.00" (50mm) diameter cutter is being used to machine a slot of 2.50" (63mm) wide on a vertical 3-axis machine.

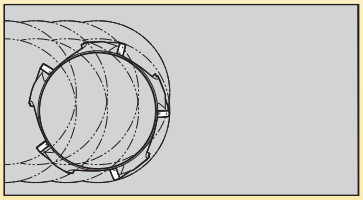


Figure 3

Align the cutter with the center 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, program 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.

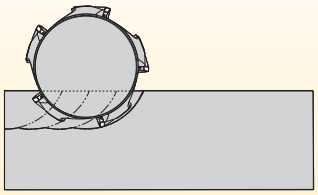
Move the cutter to the left of the slot to define the new position and make the cut. When reaching the base, a 3-axis move will need to be made. Again, the Z-axis will be in a positive direction at 45° (.010"), and the corresponding Y-axis will move away the same respective amount from the wall.

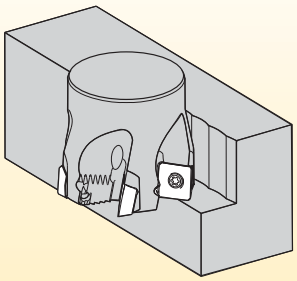
The insert/cutter has now moved away from the workpiece, and the rapid Z+ can take place. Repeat the process on the other side of the slot, remembering the X-axis move needs to be moving the other way.

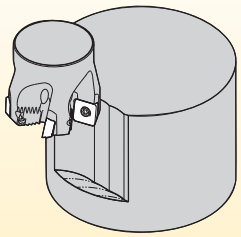
NOTE: When starting the process, it’s better to start at the center of the slot. After the slot has been defined, you no longer need to put the cutter on the center path. Passes from both sides create the slot width and enable clearance for the subsequent moves, so the insert/cutter can be moved away from the side walls of the material.

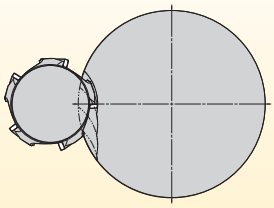
(continued)

Z-Axis *(continued)*









Linear Plunge Milling

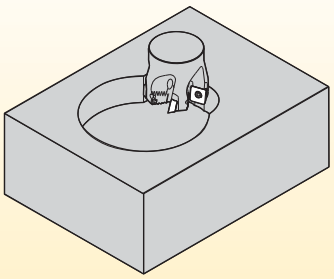
Entering the cutter along a parallel axis, the radial width of cut needs to be defined because the cutter might need to move away from the workpiece material.

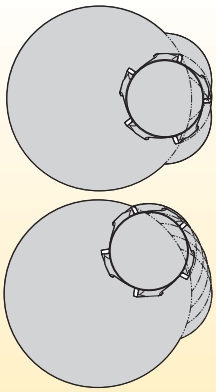
If the radial width of cut takes more than 60% of the cutter diameter, it is more difficult to remove the insert/cutter because the machine program wants to move the cutter upwards to (G00) Z+. When taking more than 60% of the cutter diameter, the material is enveloping the cutter and is difficult to remove because a cusp has been created.

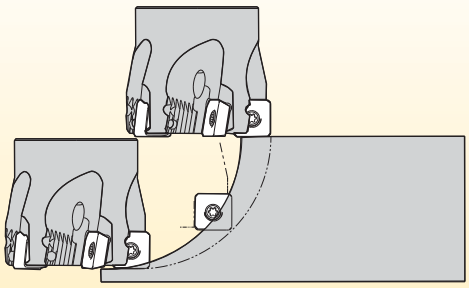
It is suggested to make the radial width of cut 50% of the cutter diameter to allow the insert/cutter to be removed without any problems.

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

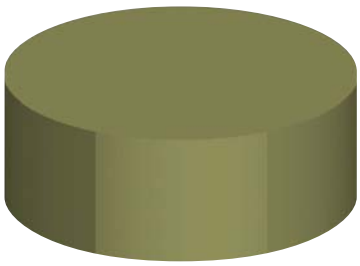
Double-Sided Ceramic Round Insert

KCRA is our newest (patent pending) indexable milling ceramic round platform specifically engineered to maximize 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.



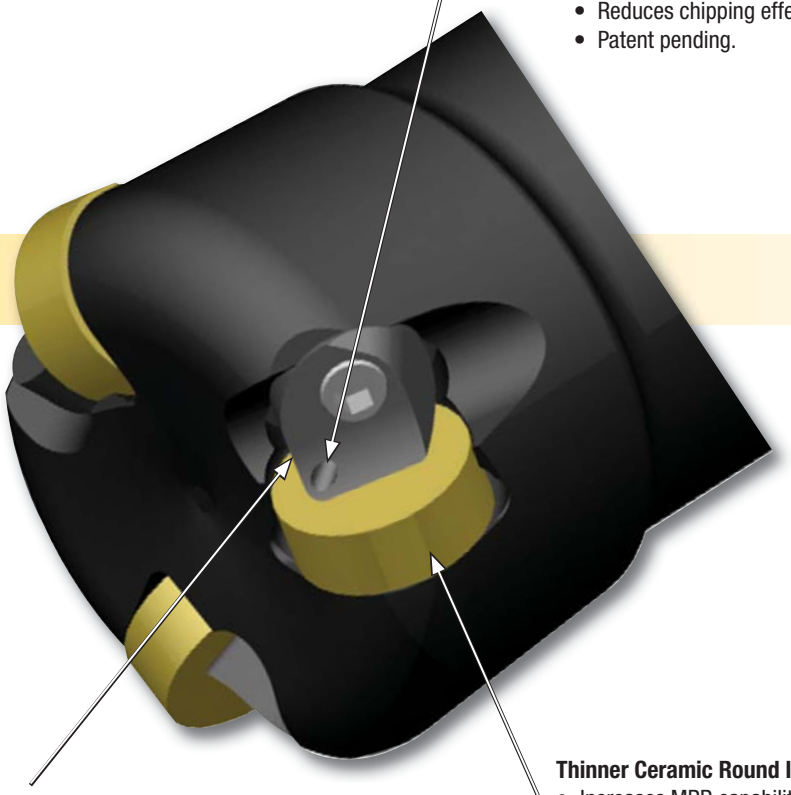
Flat-top geometry for roughing applications in Ni- and Co-based alloys.

-EGN
Lower cutting forces.

-TGN
Strongest cutting edge.

*Alternative for unstable situations.

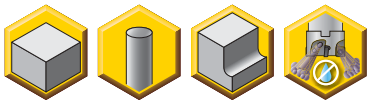
Unique Air Coolant Feature
- Improves chip flow.
- Reduces chipping effect on cutting edges.
- Patent pending.

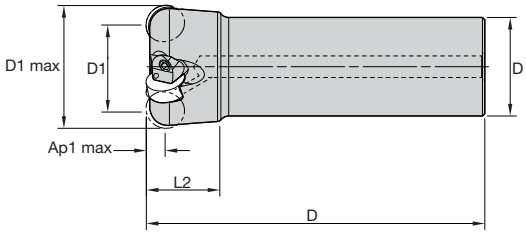


Secure Clamping System
- Improves stability.
- Increases process reliability.
- Facilitates insert change.

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

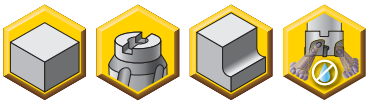
order number	catalog number	D1 max	D1	D	L	L2	Ap1 max	Z	max RPM	lbs	insert 1
5703935	**KCRA150RN4303C125L400**	1.500	1.000	1.250	4.000	.934	.250	3	28700	1.32	RNGN120400

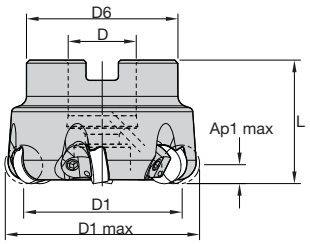
Spare Parts

D1 max	 clamp screw	 in. lbs.	 Torx driver	 wedge
1.500	**STCM25**	29	**MW25**	**KW1008**

Copy Milling

- 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	catalog number	D1 max	D1	D	D6	L	Ap1 max	Z	max RPM	lbs	insert 1
5703936	**KCRA200RN4304S075L175**	2.000	1.500	.750	1.654	1.750	.250	4	23400	.99	RNGN120400
5703937	**KCRA200RN4306S075L175**	2.000	1.500	.750	1.654	1.750	.250	6	23400	.94	RNGN120400
5703938	**KCRA250RN4306S075L175**	2.500	2.000	.750	1.750	1.750	.250	6	20300	1.41	RNGN120400
5703939	**KCRA250RN4309S075L175**	2.500	2.000	.750	1.750	1.750	.250	9	20300	1.34	RNGN120400
5704050	**KCRA300RN4308S100L200**	3.000	2.500	1.000	2.750	2.000	.250	8	18100	2.92	RNGN120400
5704051	**KCRA300RN4311S100L200**	3.000	2.500	1.000	2.750	2.000	.250	11	18100	2.82	RNGN120400

Spare Parts

D1 max	 socket-head cap screw	 clamp screw	 in. lbs.	 Torx driver	 wedge
2.000	**S446**	**STCM25**	29	**MW25**	**KW1008**
2.500	**S446**	**STCM25**	29	**MW25**	**KW1008**
3.000	**S459**	**STCM25**	29	**MW25**	**KW1008**

Insert Selection Guide

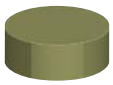
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		⟷		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	–	–	–	–	–	–
P3–P4	–	–	–	–	–	–
P5–P6	–	–	–	–	–	–
M1–M2	–	–	–	–	–	–
M3	–	–	–	–	–	–
K1–K2	–	–	–	–	–	–
K3	–	–	–	–	–	–
N1–N2	–	–	–	–	–	–
N3	–	–	–	–	–	–
S1–S2	.EGN	KYS30	**.EGN**	**KYS30**	.TGN	KYS30
S3	.EGN	KYSP30	**.EGN**	**KYSP30**	.TGN	KYSP30
S4	–	–	–	–	–	–
H1	–	–	–	–	–	–

Indexable Inserts

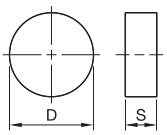
- -EGN geometry is the first choice for unstable situations and/or lower cutting forces.
- -TGN geometry has a stronger cutting edge.
- KYSP30 is the first choice for S3 group materials, Ni-based alloys.

● first choice
○ alternate choice

	KYS30	KYSP30
P		
M		
K		
N		
S	●	●
H		



RNGN1204



RNGN1204

RNGN43

catalog number	D	S	KYS30	KYSP30
RNGN43EGN	.500	.188	●	●
RNGN43TGN	.500	.188	●	●

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.

Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining

At .250 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	.003	**.004**	.005	.003	**.003**	.003	.002	**.002**	.003	.002	**.002**	.003	.002	**.002**	.003	.EGN
.TGN	.005	**.007**	.008	.004	**.005**	.006	.003	**.004**	.005	.003	**.004**	.005	.003	**.004**	.005	.TGN

At .125 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	.004	**.004**	.005	.003	**.003**	.004	.003	**.003**	.003	.002	**.003**	.003	.002	**.003**	.003	.EGN
.TGN	.006	**.008**	.009	.004	**.006**	.007	.004	**.005**	.006	.004	**.005**	.005	.003	**.005**	.005	.TGN

At .063 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	.005	**.006**	.007	.004	**.004**	.005	.003	**.004**	.004	.003	**.003**	.004	.003	**.003**	.004	.EGN
.TGN	.008	**.010**	.012	.006	**.008**	.009	.005	**.007**	.008	.005	**.006**	.007	.005	**.006**	.007	.TGN

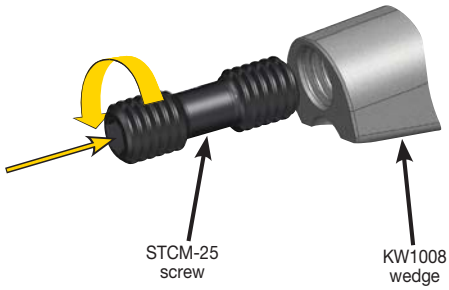
At .031 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
.EGN	.007	**.008**	.009	.005	**.006**	.007	.005	**.005**	.006	.004	**.005**	.006	.004	**.005**	.006	.EGN
.TGN	.010	**.014**	.016	.008	**.010**	.012	.007	**.009**	.010	.006	**.008**	.010	.006	**.008**	.010	.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.
	

Kennametal on the Web

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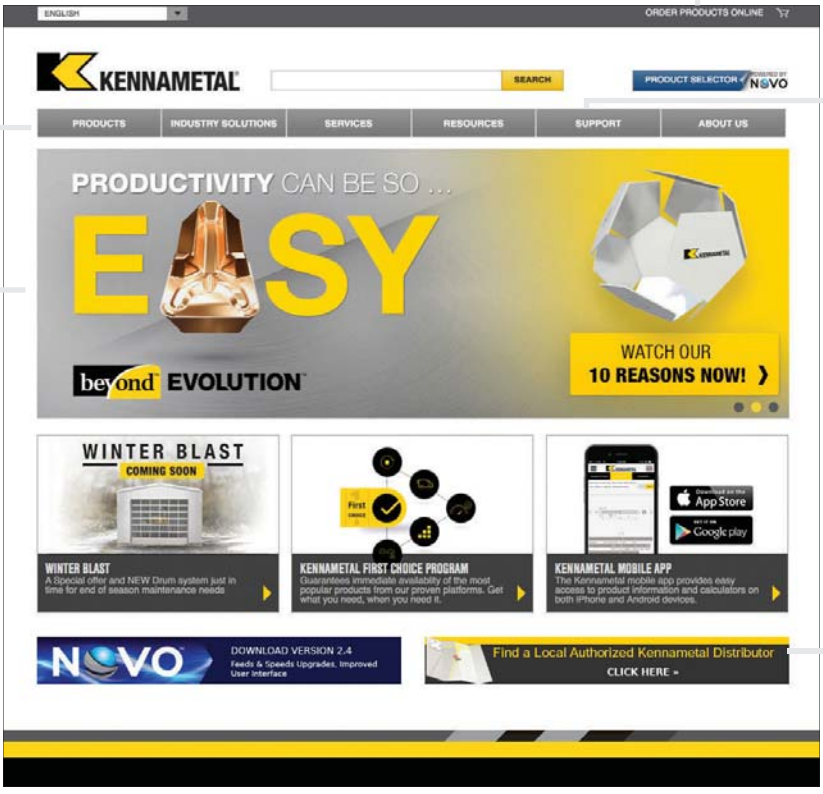


CONTACT US

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 AUTHORIZED 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.

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

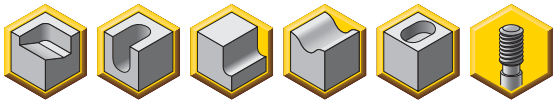
Unbeatable Productivity

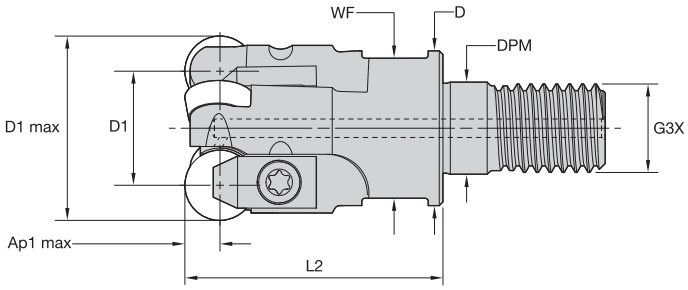
- Engineering to provide outstanding metal removal rates and productivity in nickel-based and/or cobalt-based alloys, stellites, stainless steel, and PH series through HSM.
- High axial and radial runout accuracy.
- Improved insert clearance and thickness tolerance to increase overall performance.
- 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 0.625".
- 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.







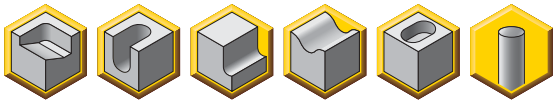
Screw-On End Mills

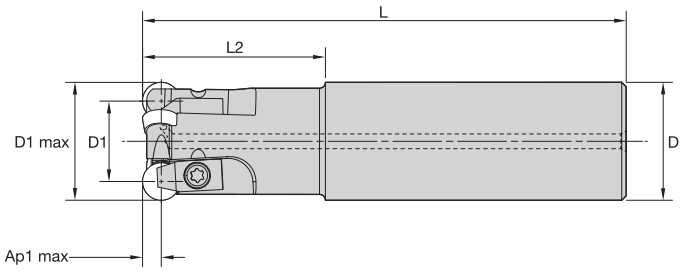
order number	catalog number	D1 max	D1	D	DPM	G3X	L2	WF	Ap1 max	Z	max ramp angle	max RPM	lbs	insert 1
3760369	**KIPR100RP32M1203**	1.000	.625	.827	.492	M12	1.250	.709	.188	3	8.0°	20450	.17	RP_32_
3760370	**KIPR125RP43M1603**	1.250	.750	1.142	.669	M16	1.500	.866	.250	3	2.5°	21000	.32	RP_43_

Spare Parts

D1 max	clamp	clamp screw	in. lbs.	Torx driver	Torx Plus wrench
1.000	**KCI2**	**191.725**	31	**DT15**	**–**
1.250	**KCI3M**	**193.409**	53	**–**	**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	catalog number	D1 max	D1	D	L	L2	Ap1 max	Z	max ramp angle	max RPM	insert 1	lbs
3759533	**KIPR062RP21229**	.625	.375	.625	2.950	1.021	.125	2	12.0°	37400	RP_2150_	.21
3759534	**KIPR075RP21332**	.750	.500	.750	3.200	1.192	.125	3	10.0°	34150	RP_2150_	.33
3759535	**KIPR100RP32438**	1.000	.625	1.000	3.800	1.556	.188	3	8.0°	20450	RP_32_	.70
1873486	**KIPR125RP43540**	1.250	.761	1.250	4.000	1.610	.249	3	4.3°	21000	RP_43_	1.09
1775726	**KIPR125RP43555**	1.250	.761	1.250	5.500	3.110	.249	3	4.3°	21000	RP_43_	1.54
1775728	**KIPR150RP43655**	1.500	1.009	1.500	5.500	3.500	.249	3	3.0°	19500	RP_43_	2.28

Spare Parts

D1 max	clamp	clamp screw	in. lbs.	Torx driver	Torx Plus wrench
.625	**KCI1**	**191.924**	17	**DT9**	**–**
.750	**KCI1**	**191.924**	17	**DT9**	**–**
1.000	**KCI2**	**191.725**	31	**DT15**	**–**
1.250	**KCI3M**	**193.409**	55	**–**	**TTP20**
1.500	**KCI3M**	**193.409**	55	**–**	**TTP20**

Insert Selection Guide

RPG2150... 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	–	–	–	–	–	–

RPG32... 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	–	–	–	–	–	–

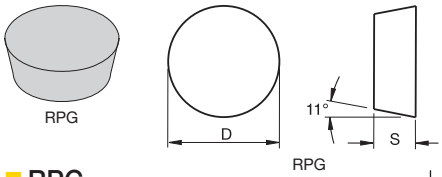
RPG43... High Temp

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	–	–	–	–	–	–

- Two grades and three insert sizes with positive clearances for ramping.
- For machining high-temp alloys, PH stainless, stainless steels, and hardened materials.

● first choice
○ alternate choice

P	○	○
M		
K		
N		
S	●	●
H		



RPG

catalog number	D	S	KYS30	KYSP30
RPG2150E	.250	.094	●	●
RPG32E	.375	.125	●	●
RPG32T0420	.375	.125	●	–
RPG43E	.500	.188	●	●
RPG43T0420	.500	.188	●	–

NOTE: A — Use these tools with the appropriate equipment/machines. Machines have to be covered for safety reasons: Hot flowing chips and loud noise 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.
D — Consider increasing the fz in hard machining when smaller Ap are applied.

Recommended Starting Feeds [IPT] RPG2150..

Light Machining	General Purpose	Heavy Machining

At .125 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	.005	**.005**	.007	.004	**.004**	.005	.003	**.003**	.004	.003	**.003**	.004	.003	**.003**	.004	..E

At .063 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	.005	**.006**	.008	.004	**.004**	.006	.004	**.004**	.005	.003	**.004**	.005	.003	**.004**	.005	..E

At .031 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	.007	**.008**	.010	.005	**.006**	.008	.005	**.005**	.007	.004	**.005**	.006	.004	**.005**	.006	..E

At .016 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	.010	**.011**	.014	.007	**.008**	.010	.006	**.007**	.009	.006	**.007**	.008	.006	**.006**	.008	..E

Recommended Starting Feeds [IPT] RPG32..

At .188 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	.005	**.005**	.007	.004	**.004**	.005	.003	**.003**	.004	.003	**.003**	.004	.003	**.003**	.004	..E
..T	.007	**.008**	.010	.005	**.006**	.008	.004	**.005**	.007	.004	**.005**	.006	.004	**.005**	.006	..T

At .094 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	.005	**.006**	.008	.004	**.004**	.006	.004	**.004**	.005	.003	**.004**	.005	.003	**.004**	.005	..E
..T	.008	**.009**	.012	.006	**.007**	.009	.005	**.006**	.008	.005	**.006**	.007	.005	**.006**	.007	..T

At .047 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	.007	**.008**	.010	.005	**.006**	.008	.005	**.005**	.007	.004	**.005**	.006	.004	**.005**	.006	..E
..T	.010	**.012**	.015	.008	**.009**	.011	.007	**.008**	.010	.006	**.007**	.009	.006	**.007**	.009	..T

At .023 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	.010	**.011**	.014	.007	**.008**	.010	.006	**.007**	.009	.006	**.007**	.008	.006	**.006**	.008	..E
..T	.014	**.017**	.021	.010	**.012**	.016	.009	**.011**	.014	.008	**.010**	.013	.008	**.010**	.012	..T

NOTE: Use “Light Machining” values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.

Recommended Starting Feeds [IPT] RPG43..

Light Machining	General Purpose	Heavy Machining

At .250 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	.005	**.005**	.007	.004	**.004**	.005	.003	**.003**	.004	.003	**.003**	.004	.003	**.003**	.004	..E
..T	.007	**.010**	.011	.005	**.008**	.009	.004	**.007**	.007	.004	**.006**	.007	.004	**.006**	.007	..T

At .125 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	.005	**.006**	.008	.004	**.004**	.006	.004	**.004**	.005	.003	**.004**	.005	.003	**.004**	.005	..E
..T	.008	**.012**	.013	.006	**.009**	.010	.005	**.008**	.009	.005	**.007**	.008	.005	**.007**	.008	..T

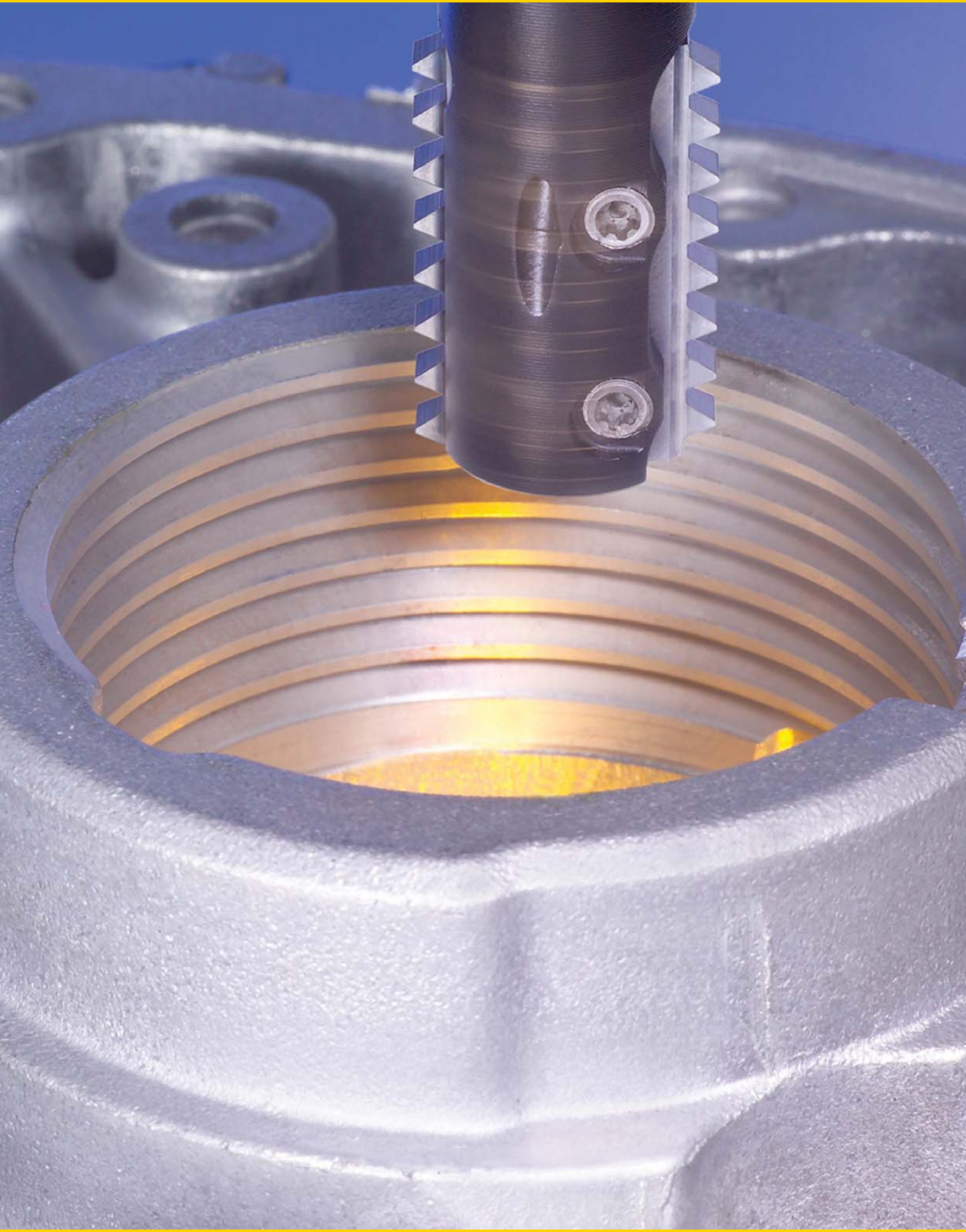
At .063 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	10%			20%			30%			40%			50–100%			
..E	.007	**.008**	.010	.005	**.006**	.008	.005	**.005**	.007	.004	**.005**	.006	.004	**.005**	.006	..E
..T	.010	**.016**	.017	.008	**.012**	.013	.007	**.010**	.011	.006	**.010**	.010	.006	**.009**	.010	..T

At .031 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	.010	**.011**	.014	.007	**.008**	.010	.006	**.007**	.009	.006	**.007**	.008	.006	**.006**	.008	..E
..T	.014	**.022**	.024	.010	**.016**	.018	.009	**.014**	.015	.008	**.013**	.014	.008	**.013**	.014	..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

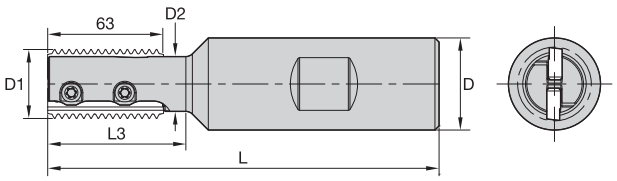
- Number of flutes:
  - TM24: 1–2 per body
  - TM25: 2–8 per body
  - TM40: 3–8 per body
  - TM41: 2–6 per body
- Short and long toolholders for multiple applications.
- Cutters available in parallel Weldon® and conical Weldon holders.
- Effective through coolant for each flute.
- Better chip evacuation.

Insert Offering

- Robust design.
- Inserts for ISO, UN, W, NPT, NPTF, and BSPT thread profiles.
- Pitch:
  - TM24: 32–10 TPI (0,50–2,50mm)
  - TM25: 20–8 TPI (1,00–3,00mm)
  - TM40: 32–10 TPI (1,00–3,00mm)
  - TM41: 8–4 TPI (3,00–6,00mm)
- Grades for most workpiece materials.
- Easy clamping systems.
- Fast indexing of inserts.



- .530–.630" 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.
- Utilizes inserts with various profiles and pitches.



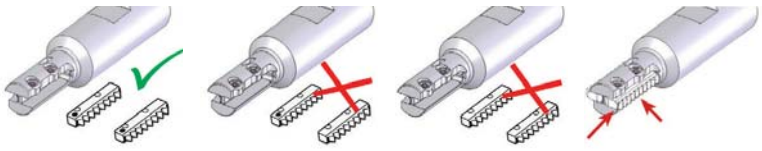


Thread Mill • Weldon Shank • Parallel Threads

order number	catalog number	D1	D	D2	L	L3	Z	insert screw	Torx Plus driver
5593154	**TM24D053L102Z1**	.530	.750	.420	3.270	1.020	1	**TM25INSERTSCREW**	**DT8IP**
5593155	**TM24D059L118Z1**	.590	.750	.470	3.390	1.180	1	**TM25INSERTSCREW**	**DT8IP**
5593156	**TM24D063L110Z2**	.630	.750	.490	3.310	1.100	2	**TM25INSERTSCREW**	**DT8IP**
5593157	**TM24D063L142Z1**	.630	.750	.460	3.630	1.420	1	**TM25INSERTSCREW**	**DT8IP**

NOTE: Torque value for insert screw is 35 in. lbs. (4 Nm).
Through coolant is recommended, especially when D2 > 0.7 x nominal thread diameter.

		Thread Application per Toolholder min thread Ø					
toolholder	D1	ISO (coarse)	ISO (fine)	UNC	UN/UNF/UNEF/UNS	BSF	BSP(G)
TM24D053L102Z1	.530	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; 5/8–32YB	11/16–14; 3/4–12	3/8–19
TM24D059L118Z1	.590	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	–
TM24D063L110Z2	.630	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–UNS; 3/4–16UN; 3/4–18UNS; 3/4–20UNEF; 11/16–24UNEF; 1 1/16–28UN; 1 1/16–32UN	3/4–12	–
TM24D063L142Z1	.630	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; 11/16–32UN	3/4–12	–



Side with identification marks

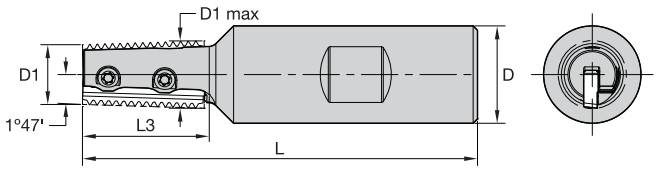
Always mount all inserts on the same side

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.

- .550" cutting diameter.
- 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.
- Utilizes inserts with various profiles and pitches.



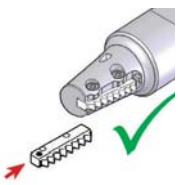


Thread Mill • Weldon Shank • Conical Threads

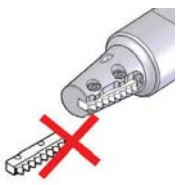
order number	catalog number	D1	D1 max	D	L	L3	Z	insert screw	Torx Plus driver
5593158	TMT24D055L102Z1	.450	.550	.750	3.230	1.020	1	TM25INSERTSCREW	DT8IP

NOTE: Torque value for insert screw is 35 in. lbs. (4 Nm).

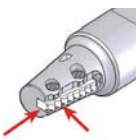
	Thread Application per Toolholder min thread Ø			
toolholder	D1 max	NPT	NPTF	BSPT
TMT24D055L102Z1	.550	3/8–18	3/8–18	3/8–19



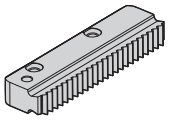
On Conical inserts, the identification mark must face up

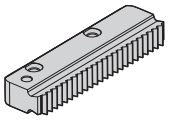


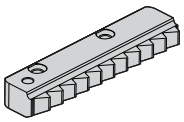
On Conical inserts, the identification mark must face up

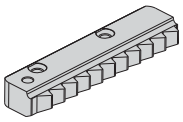


To mount insert correctly, push the insert toward the pocket walls


ISO Profiles

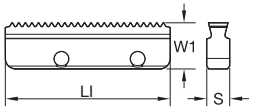

UN Profiles

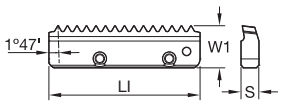

BSF and BSP Profiles


NPT Profiles

● first choice
○ alternate choice

		KC610M	KC635M
P		○	●
M			●
K		●	
N		●	
S		○	●
H		●	○





Conical Insert

ISO Profiles • Internal

catalog number	thread pitch mm	LI	W1	S	number of teeth	KC610M	KC635M
TM24N050ISO	0,5	.945	.276	.118	49	●	●
TM24N075ISO	0,75	.945	.276	.118	33	●	●
TM24N100ISO	1,0	.945	.276	.118	24	●	●
TM24N150ISO	1,5	.945	.276	.118	16	●	●
TM24N125ISO	1,25	.945	.276	.118	20	●	●
TM24N175ISO	1,75	.945	.276	.118	14	●	●
TM24N200ISO	2,0	.945	.276	.118	12	●	●
TM24N250ISO	2,5	.945	.276	.118	10	●	●

UN Profiles • Internal

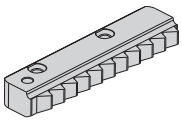
catalog number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM24N10UN	10	.945	.276	.118	9	●	●
TM24N12UN	12	.945	.276	.118	11	●	●
TM24N14UN	14	.945	.276	.118	13	●	●
TM24N16UN	16	.945	.276	.118	15	●	●
TM24N18UN	18	.945	.276	.118	17	●	●
TM24N20UN	20	.945	.276	.118	19	●	●
TM24N24UN	24	.945	.276	.118	23	●	●
TM24N28UN	28	.945	.276	.118	27	●	●
TM24N32UN	32	.945	.276	.118	31	●	●

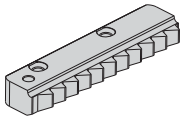
BSF and BSP Profiles • Internal and External

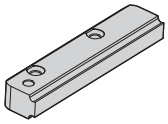
catalog number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM24EN14BSF	14	.945	.276	.118	13	●	●
TM24EN19BSF	19	.984	.276	.118	18	●	●

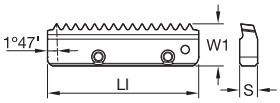
NPT Profiles • Internal and External

catalog number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM24EN18NPT	18	.945	.276	.118	17	●	●

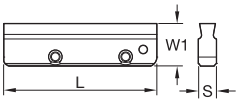

NPTF Profiles


BSPT Profiles


Blank Insert



Conical Insert



Blank Insert

● first choice
○ alternate choice

P	○	●
M		●
K	●	
N	●	
S	○	●
H	●	○

NPTF Profiles • Internal and External

catalog number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM24EN18NPTF	18	.945	.276	.118	17	●	●

BSPT Profiles • Internal and External

catalog number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM24EN19BSPT	19	.945	.276	.118	18	●	●

Blank/Plug-In Insert • Internal and External

catalog number	L	W1	S
TM24ENBLANK	.945	.276	.118

TM24 Inserts

materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (IPT)
P1	125	325–675	290–590	.002–.008
P2	180	290–550	290–520	.002–.008
P3	225	200–425	225–375	.002–.008
P4	250	250–490	250–500	.002–.008
P5	275	250–425	250–500	.002–.006
P6	325	225–350	200–325	.002–.004
stainless steel				
M1	180	325–550	375–590	.002–.004
M2	250	225–450	325–450	.002–.004
M3	330	225–375	325–375	.002–.004
cast iron				
K1	180	200–425	325–450	.001–.003
K2	220	200–390	250–325	.002–.006
K3	260	160–290	200–275	.002–.004
non-ferrous				
N1	60–100	325–820	–	.002–.010
high-temp alloys				
S1	200	65–140	65–130	.002–.004
S2	250	65–90	65–90	.001–.002
S3	280	50–65	50–65	.001–.002
S4	350	30–50	30–50	.001–.002
hardened steel				
H1	55HRc	65–140	65–140	.0004–.001

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 outdated method of finding a tool in a catalog, and then manually inputting the tooling information from the catalog 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 maximizes every shift. **kennametal.com/novo**



- .670–2.047" 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.
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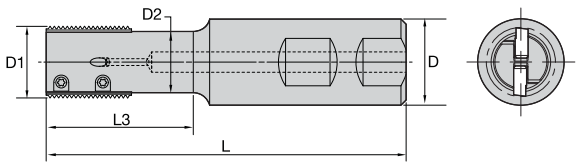
- Utilizes inserts with various profiles and pitches.



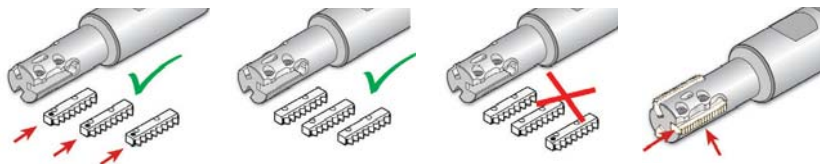


Thread Mill • Weldon Shank • Parallel Threads

order number	catalog number	D1	D	D2	L	L3	Z	insert screw	Torx Plus driver
3030845	TM25D17L26Z2	.669	.984	.551	3.347	1.024	2	TM25INSERTSCREW	DT8IP
3030846	TM25D17L36Z2	.669	.984	.551	3.740	1.417	2	TM25INSERTSCREW	DT8IP
3030848	TM25D20L37Z3	.807	.984	.649	3.780	1.457	3	TM25INSERTSCREW	DT8IP
3030849	TM25D20L44Z3	.807	.984	.649	4.055	1.732	3	TM25INSERTSCREW	DT8IP
3030850	TM25D22L43Z3	.866	.984	.709	4.016	1.693	3	TM25INSERTSCREW	DT8IP
3030852	TM25D22L55Z3	.866	.984	.709	4.488	2.165	3	TM25INSERTSCREW	DT8IP
3031703	TM25D30L55Z5	1.181	.984	1.024	4.528	2.165	5	TM25INSERTSCREW	DT8IP
3031705	TMC25D30L80Z4	1.181	.984	1.024	5.512	3.150	4	TM25INSERTSCREW	DT8IP
5593142	TMS25D36L34Z5	1.417	.630	1.498	1.319	—	5	TM25INSERTSCREW	DT8IP
5593143	TMS25D44L38Z6	1.732	.866	1.575	1.496	—	6	TM25INSERTSCREW	DT8IP
5593141	TMS25D52L40Z8	2.047	1.063	1.890	1.575	—	3	TM25INSERTSCREW	DT8IP

NOTE: Torque value for insert screw is 35 in. lbs. (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	ISO (coarse)	ISO (fine)	UNC	UN/UNF/UNEF/UNS	BSF
TM25D17L26Z2 TM25D17L36Z2	.669	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	.807	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	.866	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	1.181	–	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

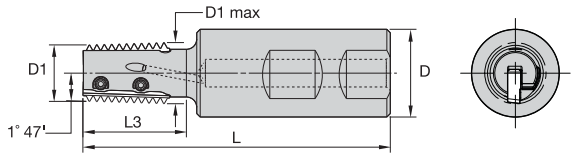
Side without identification marks

Always mount all inserts 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.

- .670–1.100" 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.
- Utilizes inserts with various profiles and pitches.



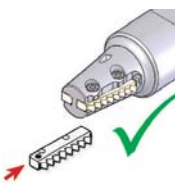


Thread Mill • Weldon Shank • Conical Threads

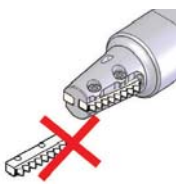
order number	catalog number	D1	D1 max	D	L	L3	Z	insert screw	in. lbs.	Torx Plus driver
3031708	**TMT25D067L110Z2**	.608	.670	1.000	3.500	1.100	2	**TM25INSERTSCREW**	35	**DT8IP**
3031712	**TMT25D087L170Z3**	.802	.870	1.000	4.090	1.700	3	**TM25INSERTSCREW**	35	**DT8IP**
3031715	**TMT25D110L170Z4**	1.039	1.100	1.000	4.060	1.700	4	**TM25INSERTSCREW**	35	**DT8IP**

NOTE: Torque value for insert screw is 35 in. lbs. (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 max	NPT	NPTF	BSPT
TMT25D17L26Z2	.669	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	.866	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	1.102	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



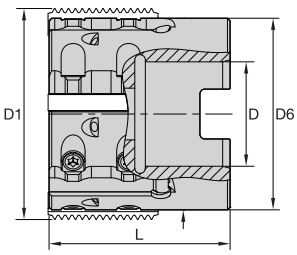
Side without identification marks

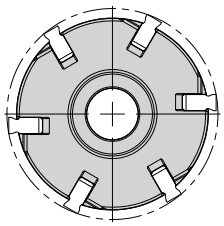


To mount insert correctly, push the insert toward the pocket walls*

* When not using an insert in each pocket, protect the pocket by using a TM25 blank insert.

- 1.540–2.320" 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.
- Utilizes inserts with various profiles and pitches.





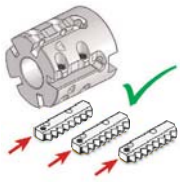


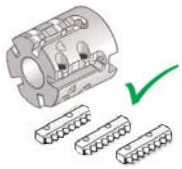
Thread Mill • Shell Mill • Parallel Threads

order number	catalog number	D1	D	D6	L	Z	insert screw	Torx Plus driver	socket-head cap screw
5593147	TMS25D154L126Z5	1.540	.500	1.382	1.260	5	TM25INSERTSCREW	DT8IP	MS5007
5593146	TMS25D193L138Z7	1.930	.750	1.772	1.380	7	TM25INSERTSCREW	DT8IP	MS5008
5593145	TMS25D232L158Z9	2.320	1.000	2.169	1.580	9	TM25INSERTSCREW	DT8IP	MS5006

NOTE: Torque value for insert screw is 35 in. lbs. (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	ISO (fine)	UN/UNF/UNEF/UNS	BSW	BSP(G)
TMS25D154L126Z5	1.540	M42 x 1; M42 x 1.5; M45 x 2; M45 x 3	1 11/16–12UNF; 1 3/4–14UNS; 1 5/8–16UN; 1 5/8–18UNEF; 1 5/8–20UN	1 3/4–16; 1 3/4–12	1 1/2–11
TMS25D193L138Z7	1.930	M52 x 1; M55 x 1.5; M55 x 2; M55 x 3	2 1/8–12UN; 2 1/16–16UN; 2 1/8–20UN; 2 1/8–8UN; 2 1/4–10UNS; 2 1/4–14UNS; 2 1/4–18UNS	2 1/4–16; 2 1/4–12	1 3/4–11
TMS25D232L158Z9	2.320	M64 x 1; M64 x 1.5; M64 x 2; M65 x 3	2 1/2–18UN; 2 1/2–20UN; 2 1/2–8UN; 2 1/2–12UN; 2 1/2–10UN; 2 1/2–14UN; 2 1/2–16UN	2 1/2–16; 2 1/2–12	2 1/4–11


Side with identification marks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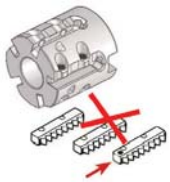
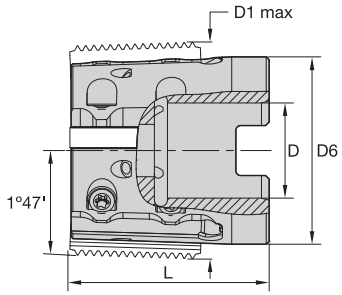
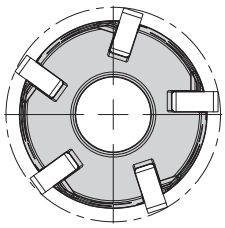

Always mount all inserts on the same side


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.

- 1.478" cutting diameter.
- 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.
- Utilizes inserts with various profiles and pitches.





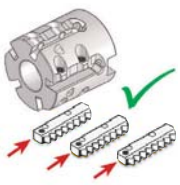


Thread Mill • Shell Mill • Conical Threads

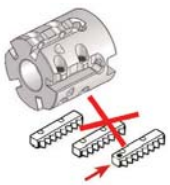
order number	catalog number	D1 max	D	D6	L	Z	insert screw	Torx Plus driver	socket-head cap screw
5593148	TMST25D154L126Z5	1.538	.500	1.358	1.260	5	TM25INSERTSCREW	DT8IP	MS5007

NOTE: Torque value for insert screw is 35 in. lbs. (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	NPT	NPTF	BSPT
TMST25D154L126Z5	1.478	1 1/2–11.5; 2–11.5	1 1/2–11.5; 2–11.5	1 1/2–6 x 11



Side with identification marks



Always mount all inserts on the same side

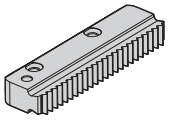


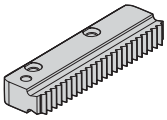
To mount insert correctly, push the insert toward the pocket walls*

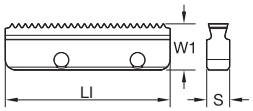
* When not using an insert in each pocket, protect the pocket by using a TM25 blank insert.

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

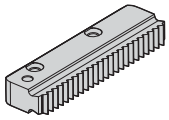
catalog number	thread pitch mm	LI	W1	S	number of teeth	KC610M	KC635M
TM25N300ISO	3	.984	.300	.140	8	●	●
TM25N250ISO	2,5	.984	.300	.140	10	●	●
TM25N200ISO	2	.984	.300	.140	12	●	●
TM25N150ISO	1,5	.984	.300	.140	16	●	●
TM25N100ISO	1	.984	.300	.140	24	●	●

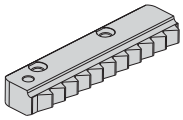
• Unified Thread Standard Style.

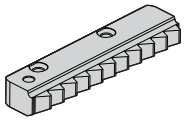
UN Profiles • Internal

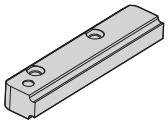
catalog number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM25N8UN	8	.984	.300	.140	7	●	●
TM25N9UN	9	.984	.300	.140	8	●	●
TM25N10UN	10	.984	.300	.140	9	●	●
TM25N12UN	12	.984	.300	.140	11	●	●
TM25N14UN	14	.984	.300	.140	13	●	●
TM25N16UN	16	.984	.300	.140	15	●	●
TM25N18UN	18	.984	.300	.140	17	●	–
TM25N20UN	20	.984	.300	.140	19	●	●

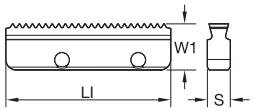
• British Standard Whitworth Thread Style.

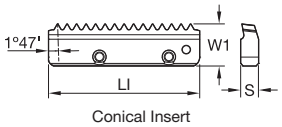

Whitworth Profiles


NPT Profiles

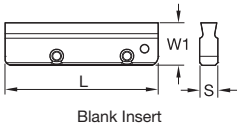

BSPT Profiles


Blank Insert





Conical Insert



Blank Insert

● first choice
○ alternate choice

P	○	●
M		●
K	●	
N	●	
S	○	●
H	●	○

Whitworth Profiles • Internal/External

catalog number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM25EN11W	11	.984	.300	.140	10	●	●
TM25EN12W	12	.984	.300	.140	11	●	–
TM25EN14W	14	.984	.300	.140	13	●	●

• National Pipe Thread Taper Style.

NPT Profiles • Internal/External

catalog number	TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM25EN115NPT	11.5	.984	.300	.140	11	●	●
TM25EN14NPT	14	.984	.300	.140	11	●	●

• British Standard Pipe Standard Thread Style.

BSPT Profiles • Internal/External

catalog number	internal TPI	LI	W1	S	number of teeth	KC610M	KC635M
TM25EN11BSPT	11.0	.984	.300	.140	10	●	–
TM25EN14BSPT	14.0	.984	.300	.140	11	●	–

Blank Insert Form • Internal/External

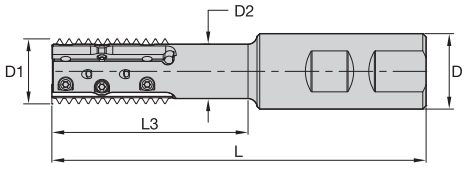
catalog number	L	W1	S
TM25BLANK	.988	.220	.140

TM25 Inserts

materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (IPT)
P1	125	325–675	290–590	.002–.008
P2	180	290–550	290–520	.002–.008
P3	225	200–425	225–375	.002–.008
P4	250	250–490	250–500	.002–.008
P5	275	250–425	250–500	.002–.006
P6	325	225–350	200–325	.002–.004
stainless steel				
M1	180	325–550	375–590	.002–.004
M2	250	225–450	325–450	.002–.004
M3	330	225–375	325–375	.002–.004
cast iron				
K1	180	200–425	325–450	.001–.003
K2	220	200–390	250–325	.002–.006
K3	260	160–290	200–275	.002–.004
non-ferrous				
N1	60–100	325–820	–	.002–.010
high-temp alloys				
S1	200	65–140	65–130	.002–.004
S2	250	65–90	65–90	.001–.002
S3	280	50–65	50–65	.001–.002
S4	350	30–50	30–50	.001–.002
hardened steel				
H1	55HRc	65–140	65–140	.0004–.001

NOTE: Use Kennametal thread mill software:
TM-CNC Generator for CNC Programming on our website under: **http://www.kennametal.com/en/resources/software.html**.

- .870–1.180" 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.
- Utilizes inserts with various profiles and pitches.





Thread Mill • Weldon Shank • Parallel Threads

order number	catalog number	D1	D	D2	L	L3	Z	insert screw	Torx Plus driver	screw
5593191	TM40D087L169Z3	.870	1.000	.710	4.000	1.690	3	TM25INSERTSCREW	DT8IP	MS9000
5593192	TM40D087L256Z3	.870	1.000	.710	4.870	2.560	3	TM25INSERTSCREW	DT8IP	MS9000
5593193	TM40D118L215Z4	1.180	1.250	1.020	4.550	2.150	4	TM25INSERTSCREW	DT8IP	MS9000
5593194	TM40D118L315Z3	1.180	1.250	1.020	5.350	3.150	3	TM25INSERTSCREW	DT8IP	MS9000

NOTE: Torque value for insert screw is 35 in. lbs. (4 Nm).

Thread Application per Toolholder min thread Ø						
toolholder	D1	ISO (coarse)	ISO (fine)	UN/UNF/UNEF/UNS	BSF	BSP(G)
TM40D087L169Z3	.870	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; 15/16–20UNEF	1–11; 1–12; 1–14; 1–16	3/4–14
TM40D087L256Z3	.870	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; 15/16–20UNEF	1–11; 1–12; 1–14; 1–16	3/4–14
TM40D118L215Z4	1.180	–	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; 15/16UN; 15/16–18UNEF; 15/16–20UN	1 3/8–11; 1 3/8–12; 1 3/8–14; 1 3/8–16	1–11
TM40D118L315Z3	1.180	–	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; 15/16UN; 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

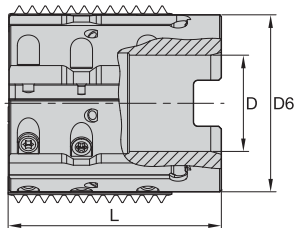
Step 1. Location Screw

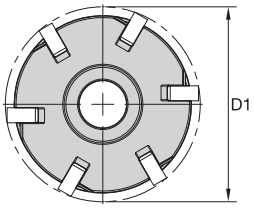


Step 2. Clamping Screw (2)



- 1.930–2.320" 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.
- Utilizes inserts with various profiles and pitches.





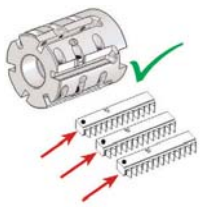


Thread Mill • Shell Mill • Parallel Threads

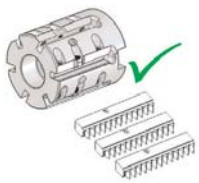
order number	catalog number	D1	D	D6	L	Z	insert screw	Torx Plus driver	socket-head cap screw	screw
5593195	**TMS40D193L197Z7**	1.930	.750	1.770	1.970	7	**TM25INSERTSCREW**	**DT8IP**	**MS5008**	**MS9000**
5593196	**TMS40D232L200Z9**	2.320	1.000	2.170	2.000	9	**TM25INSERTSCREW**	**DT8IP**	**MS5009**	**MS9000**

NOTE: Torque value for insert screw is 35 in. lbs. (4 Nm).

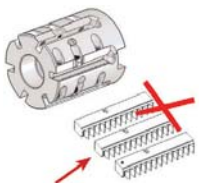
Thread Application per Toolholder min thread Ø					
toolholder	**D1**	**ISO (fine)**	**UN/UNF/UNEF/UNS**	**BSW**	**BSP(G)**
TMS40D193L197Z7	1.930	M52 x 1; M55 x 1.5; M55 x 2; M55 x 3	1 7/8–12UN; 1 13/16–16UN; 1 13/16–20UN; 1 15/16–8UN; 1 7/8–10UNS; 1 7/8–14UNS	2 1/4–12; 2 1/4–16	1 3/4–11
TMS40D232L200Z9	2.320	M64 x 1; M64 x 1.5; M64 x 2; M65 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 1/2–12; 2 1/2–16	2 1/4–11



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!

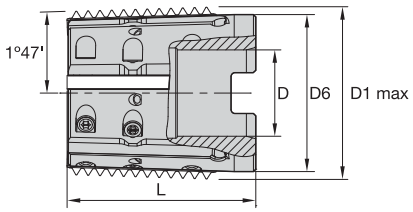
Step 1. Location Screw



Step 2. Clamping Screw (2)



- 1.930" cutting diameter.
- 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.
- Utilizes inserts with various profiles and pitches.



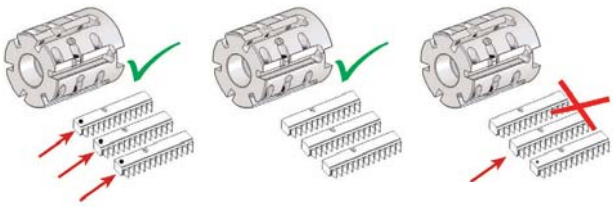


Thead Mill • Shell Mill • Conical Threads

order number	catalog number	D1 max	D	D6	L	Z	insert screw	Torx Plus driver	socket-head cap screw	screw
5593197	TMST40D193L197Z7	1.930	.750	1.770	1.970	7	TM25INSERTSCREW	DT8IP	MS5006	MS9000

NOTE: Torque value for insert screw is 35 in. lbs. (4 Nm).

Thread Application per Toolholder min thread Ø				
toolholder	D1 max	NPT	NPTF	BSPT
TMST40D193L197Z7	1.930	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.

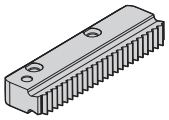
2 Step Clamping System!

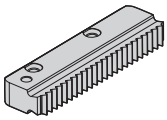
Step 1. Location Screw

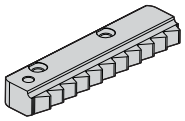


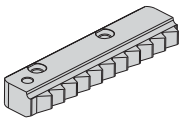
Step 2. Clamping Screw (2)




ISO Profiles

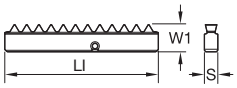

UN Profiles

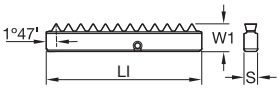

BSF and BSP Profiles


NPT Profiles

● first choice
○ alternate choice

P	○	●
M		●
K	●	
N	●	
S	○	●
H	●	○





Conical Inserts

ISO Profiles • Internal

catalog number	thread pitch mm	LI	W1	S	KC610M	KC635M
TM40N100ISO	1,0	1.575	.278	.137	●	●
TM40N150ISO	1,5	1.575	.278	.137	●	●
TM40N200ISO	2,0	1.575	.278	.137	●	●
TM40N250ISO	2,5	1.575	.278	.137	●	–
TM40N300ISO	3,0	1.575	.278	.137	●	●

UN Profiles • Internal

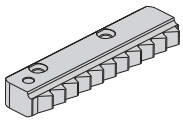
catalog number	TPI	LI	W1	S	KC610M	KC635M
TM40N8UN	8	1.575	.278	.138	●	●
TM40N9UN	9	1.575	.278	.137	●	–
TM40N10UN	10	1.575	.278	.137	●	–
TM40N12UN	12	1.575	.278	.137	●	●
TM40N14UN	14	1.575	.278	.137	●	–
TM40N16UN	16	1.575	.278	.137	●	●
TM40N18UN	18	1.575	.278	.137	●	–
TM40N20UN	20	1.575	.278	.137	●	●

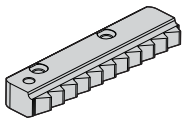
BSF and BSP Profiles • Internal and External

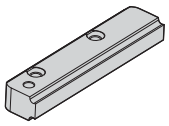
catalog number	TPI	LI	W1	S	KC610M	KC635M
TM40EN11BSF	11	1.575	.278	.138	●	●
TM40EN12BSF	12	1.575	.278	.138	●	–
TM40EN14BSF	14	1.575	.278	.138	●	–
TM40EN16BSF	16	1.575	.278	.138	●	–

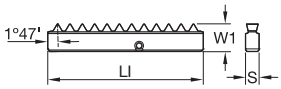
NPT Profiles • Internal and External

catalog number	TPI	LI	W1	S	KC610M	KC635M
TM40EN008NPT	8.0	1.575	.287	.138	●	●
TM40EN115NPT	11.5	1.575	.287	.138	●	–

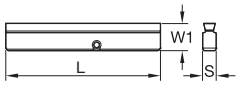

NPT Profiles


BSPT Profiles


Blank Insert



Conical Insert



Blank Insert

● first choice
○ alternate choice

P	○	●
M		●
K	●	
N	●	
S	○	●
H	●	○

NPTF Profiles • Internal and External

catalog number	TPI	LI	W1	S	KC610M	KC635M
TM40EN008NPTF	8.0	1.575	.287	.138	●	●
TM40EN115NPTF	11.5	1.575	.287	.138	●	–

BSPT Profiles • Internal and External

catalog number	TPI	LI	W1	S	KC610M	KC635M
TM40EN011BSPT	11	1.575	.287	.138	●	●

Blank/Plug-In Insert • Internal and External

catalog number	L	W1	S
TM40ENBLANK	1.575	.278	.137

TM40 Inserts

materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (IPT)
P1	125	325–675	290–590	.002–.008
P2	180	290–550	290–520	.002–.008
P3	225	200–425	225–375	.002–.008
P4	250	250–490	250–500	.002–.008
P5	275	250–425	250–500	.002–.006
P6	325	225–350	200–325	.002–.004
stainless steel				
M1	180	325–550	375–590	.002–.004
M2	250	225–450	325–450	.002–.004
M3	330	225–375	325–375	.002–.004
cast iron				
K1	180	200–425	325–450	.001–.003
K2	220	200–390	250–325	.002–.006
K3	260	160–290	200–275	.002–.004
non-ferrous				
N1	60–100	325–820	–	.002–.010
high-temp alloys				
S1	200	65–140	65–130	.002–.004
S2	250	65–90	65–90	.001–.002
S3	280	50–65	50–65	.001–.002
S4	350	30–50	30–50	.001–.002
hardened steel				
H1	55HRc	65–140	65–140	.0004–.001

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 Program.

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 Program, you will receive:

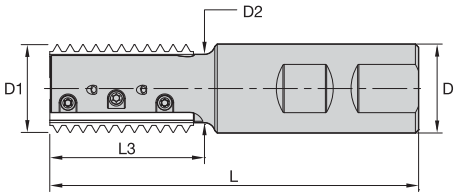
- A partner who cares about a sustainable environment.
- Easy-to-use web portal to value your used carbide.
- Access to our popular Green Box™ options for carbide collection.
- Systematic and efficient disposal of carbide materials.
- Improved profitability.

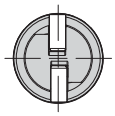
Program is not currently available in all geographical areas.
For more information, please visit **kennametal.com/carbiderecycling**.

KENNAMETAL®

kennametal.com

- 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.
- Utilizes inserts with various profiles and pitches.





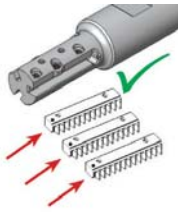


Thread Mill • Weldon Shank • Parallel Threads

order number	catalog number	D1	D	D2	L	L3	Z	insert screw	Torx Plus driver	screw
5593177	TM41D083L177Z1	.835	1.000	.630	4.130	1.770	1	TM25INSERTSCREW	DT8IP	MS9000
5593178	TM41D097L169Z2	.970	1.000	.760	4.130	1.690	2	TM25INSERTSCREW	DT8IP	MS9000
5593179	TM41D118L256Z3	1.180	1.250	.953	5.000	2.560	3	TM25INSERTSCREW	DT8IP	MS9000
5593180	TM41D142L169Z5	1.420	1.250	1.110	4.130	1.690	5	TM25INSERTSCREW	DT8IP	MS9000
5593181	TM41D142L256Z4	1.420	1.250	1.110	4.980	2.560	4	TM25INSERTSCREW	DT8IP	MS9000

NOTE: Torque value for insert screw is 35 in. lbs. (4 Nm).

		Thread Application per Toolholder min thread Ø						
toolholder	D1	ISO (coarse)	ISO (fine)	UNC	UN/UNF/UNEF/UNS	BSW/BSF	NPT	NPTF
TM41D083L177Z1	.835	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	–	–
TM41D097L169Z2	.970	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	–	–
TM41D118L256Z3	1.180	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	–	–
TM41D142L169Z5	1.420	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
TM41D142L256Z4	1.420	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!

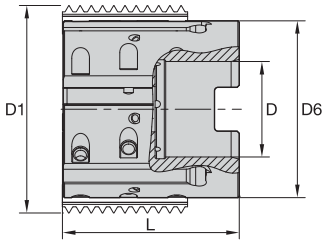
Step 1. Location Screw (2)

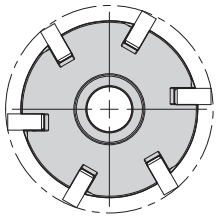


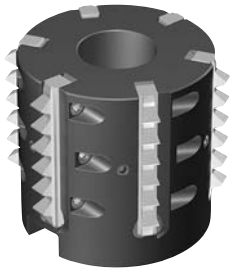
Step 2. Clamping Screw



- 2.090–2.480" 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.
- Utilizes inserts with various profiles and pitches.





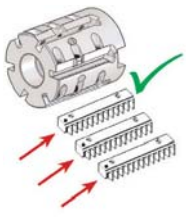


Thread Mill • Shell Mill • Parallel Threads

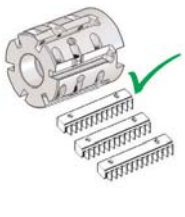
order number	catalog number	D1	D	D6	L	Z	insert screw	Torx Plus driver	socket-head cap screw	screw
5593182	TMS41D210L200Z5	2.090	.750	1.770	2.000	5	TM25INSERTSCREW	DT8IP	MS5008	MS9000
5593183	TMS41D250L200Z6	2.480	1.000	2.170	2.000	6	TM25INSERTSCREW	DT8IP	MS5009	MS9000

NOTE: Torque value for insert screw is 35 in. lbs. (4 Nm).

	Thread Application per Toolholder min thread Ø							
toolholder	D1	ISO (coarse)	ISO (fine)	UNC	UN/UNF/UNEF/UNS	BSF	NPT	NPTF
TMS41D210L200Z5	2.090	M64 x 6	M58 x 4; M70 x 6	2 1/2–4	2 3/8–6UN; 2 3/8–8UN	2 3/8–8; 2 1/2–6	2 1/2–8	2 1/2–8
TMS41D250L200Z6	2.480	–	M68 x 4; M70 x 6	3–4	2 3/4–6UN; 2 3/4–8UN	2 3/4–8; 2 3/4–6	2 1/2–8	2 1/2–8



Side with identification marks



Side without identification marks



Always mount all inserts on the same side*

* When not using an insert in each pocket, protect the pocket by using a TM41 blank insert.

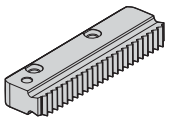
2 Step Clamping System

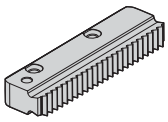
Step 1. Location Screw (2)

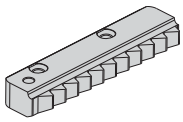


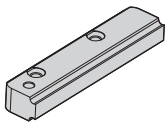
Step 2. Clamping Screw




ISO Profiles

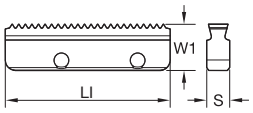

UN Profiles

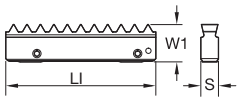

NPT Profiles


Blank Inserts

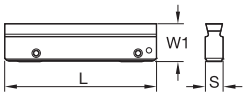
P	○	●
M		●
K	●	
N	●	
S	○	●
H	●	○

● first choice
○ alternate choice





Conical Insert



Blank Inserts

ISO Profiles • Internal

catalog number	thread pitch mm	LI	W1	S	KC610M	KC635M
TM41N300ISO	3,0	1.614	.392	.187	●	●
TM41N350ISO	3,5	1.614	.392	.187	●	●
TM41N400ISO	4,0	1.614	.392	.187	●	●
TM41N450ISO	4,5	1.614	.392	.187	●	●
TM41N500ISO	5,0	1.614	.392	.187	●	●
TM41N550ISO	5,5	1.614	.392	.187	●	●
TM41N600ISO	6,0	1.614	.392	.187	●	●

UN Profiles • Internal

catalog number	TPI	LI	W1	S	KC610M	KC635M
TM41N4UN	4	1.614	.392	.187	●	●
TM41N45UN	4.5	1.614	.392	.187	●	●
TM41N5UN	5	1.614	.392	.187	●	●
TM41N6UN	6	1.614	.392	.187	●	●
TM41N7UN	7	1.614	.392	.187	●	●
TM41N8UN	8	1.614	.392	.187	●	●

NPT Profiles • Internal and External

catalog number	TPI	LI	W1	S	KC610M	KC635M
TM41EN8NPT	8	1.614	.392	.187	●	●

Blank/Plug-In Insert • Internal and External

catalog number	L	W1	S
TM41ENBLANK	1.614	.392	.187

TM41 Inserts

materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (IPT)
P1	125	325–675	290–590	.002–.008
P2	180	290–550	290–520	.002–.008
P3	225	200–425	225–375	.002–.008
P4	250	250–490	250–500	.002–.008
P5	275	250–425	250–500	.002–.006
P6	325	225–350	200–325	.002–.004
stainless steel				
M1	180	325–550	375–590	.002–.004
M2	250	225–450	325–450	.002–.004
M3	330	225–375	325–375	.002–.004
cast iron				
K1	180	200–425	325–450	.001–.003
K2	220	200–390	250–325	.002–.006
K3	260	160–290	200–275	.002–.004
non-ferrous				
N1	60–100	325–820	–	.002–.010
high-temp alloys				
S1	200	65–140	65–130	.002–.004
S2	250	65–90	65–90	.001–.002
S3	280	50–65	50–65	.001–.002
S4	350	30–50	30–50	.001–.002
hardened steel				
H1	55HRc	65–140	65–140	.0004–.001

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

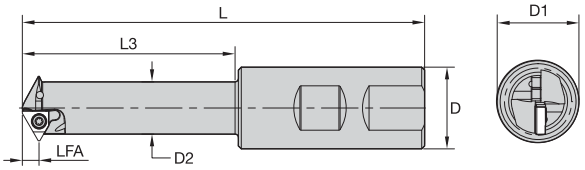
- Reduced load on the cutting edges due to single-point insert.
- Low cutting forces enable fast machining.
- Suitable for hard material applications.
- Wide range of applications, with partial profile insert (60°/55°).
- Pitch range 16–3 TPI (1,5–8mm).

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 0.5–1.2" (2" with shell mills).
- Improved chip evacuation and cooling.

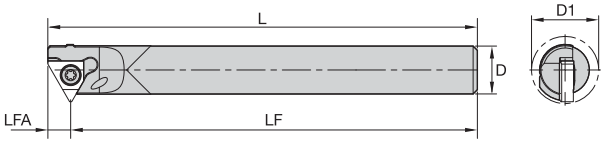




Thread Mill • U Style • Weldon® Shank • 1/4" IC

order number	catalog number	D1	D	D2	L	L3	LFA	Z	max RPM	insert screw	Torx driver
5593105	KTMDUWD058L157Z1	.580	.625	.420	3.760	1.780	.210	1	7970	KTMDUSCREW1	DT8
5593106	KTMDUWD081L236Z2	.810	1.000	.630	4.920	2.570	.210	2	6740	KTMDUSCREW1	DT8
5593107	KTMDUWD091L276Z2	.910	1.000	.700	5.380	2.960	.210	2	6380	KTMDUSCREW1	DT8
5593108	KTMDUWD102L315Z3	1.020	1.000	.800	5.790	3.360	.210	3	6000	KTMDUSCREW1	DT8
5593120	KTMDUWD122L374Z4	1.220	1.250	1.010	6.370	3.950	.210	4	5500	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
KTMDUWD058L157Z1	.580	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; 7/8-9; 1-8; 1 1/8-7	TR22 x 3; TR24 x 3
KTMDUWD081L236Z2	.810	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	1–8; 1 1/8–7; 1 3/8–6	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)
KTMDUWD091L276Z2	.910	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 1/8–10UNS; 1 1/8UN	3/4–14; 1–11	1–26; 1–20; 1–16; 1 1/16–12; 1 1/8–9; 1 1/8–7	–
KTMDUWD102L315Z3	1.020	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; 1 3/16–8UN	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	–
KTMDUWD122L374Z4	1.220	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	1 5/16–28UN; 1 3/8–24UNS; 1 5/16–20UN; 1 5/16–18UNEF; 1 5/16–16UN; 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	–

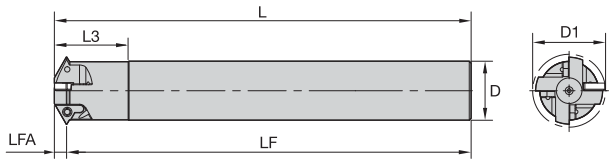




Thread Mill • U Style • Carbide Cylindrical Shank • 1/4" IC

order number	catalog number	D1	D	L	LF	LFA	Z	max RPM	insert screw	Torx driver
5593125	KTMDUCD058L236Z1	.600	.438	4.720	4.510	.210	1	7970	KTMDUSCREW1	DT8
5593126	KTMDUCD068L256Z2	.680	.563	5.350	5.140	.210	2	7380	KTMDUSCREW1	DT8
5593127	KTMDUCD081L315Z2	.810	.625	5.300	5.090	.210	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
KTMDUCD058L236Z1	.600	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; 7/8–9; 1–8	5/8–32UN; 5/8–28UN; 5/8–27UNS; 11/16–28UNEF; 11/16–20UN; 11/16–16UN; 3/4–14UNS; 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	TR22 x 3; TR24 x3
KTMDUCD068L256Z2	.680	M20 x 2.5; M22 x 2.5	M21 x 2.0	7/8–9	7/8–10UNS; 13/16/12UN	–	–	–
KTMDUCD081L315Z2	.810	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	1–8; 1 1/8–7; 1 3/8–6	7/8–32UN; 7/8–28UN; 7/8–27UNS; 7/8–24UNS; 7/8–20UNEF; 1–18UNS; 15–16UN; 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

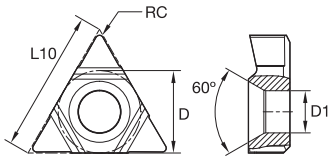


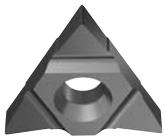


Thread Mill • U Style • Steel Cylindrical Shank • 1/4" IC

order number	catalog number	D1	D	L	L3	LF	LFA	Z	max RPM	insert screw	Torx driver
5593132	KTMDUED091L300Z2	.910	.625	5.600	3.210	5.390	.210	2	6340	KTMDUSCREW1	DT8
5593133	KTMDUED102L415Z3	1.020	.750	7.200	4.360	6.990	.210	3	6000	KTMDUSCREW1	DT8
5593135	KTMDUED122L452Z4	1.220	1.000	7.700	4.730	7.490	.210	4	5500	KTMDUSCREW1	DT8

Thread Application per Toolholder min thread Ø							
toolholder	D1	ISO (coarse)	ISO (fine)	UNC	UN/UNF/ UNEF/UNS	BSP (G)	Partial 55°
KTMDUED091L300Z2	.910	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; 1 1/16–12UN; 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
KTMDUED102L415Z3	1.020	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 1/7–7; 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 1/8–16UN; 1 1/8–14UNS; 1 1/8–12UNF; 1 3/8–10UNS; 1 7/16–8UN	3/4–14; 1–11	1 1/8–26; 1 1/8–20; 1 3/16–16; 1 3/16–12; 1 3/16–8; 1 1/4–7
KTMDUED122L452Z4	1.220	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	1 5/16–28UN; 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°

catalog number	Thread Pitch min	Thread Pitch max	TPI min	TPI max	D1	D	L10	RC	KC610M	KC635M
KTMDU11L0515N60	1	2	16	48	.128	.250	.433	.002	●	●
KTMDU11L2025N60	2	3	9	12	.103	.250	.433	.004	●	●
KTMDU11L1520N60	2	2	12	16	.128	.250	.433	.002	●	●
KTMDU11L2540N60	3	4	6	10	.128	.250	.433	.006	●	●
KTMDU11L2525N60	3	3	10	10	.082	.250	.433	.004	●	●

NOTE: KTMDU11L2525N60 can only be used with holder KTMDUCD17L065Z2.

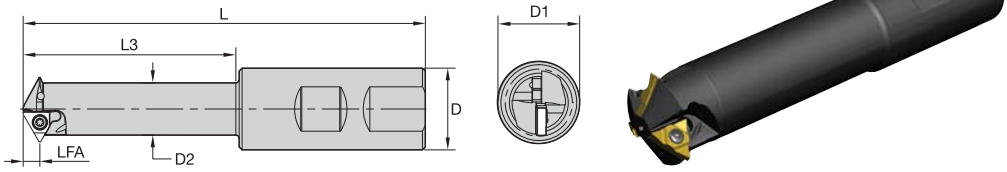
KTMD • 1/4" IC • Partial Profile 55°

catalog number	TPI min	TPI max	D1	D	L10	RC	KC610M	KC635M
KTMDU11L1107N55	7	11	.128	.250	.433	.009	●	●
KTMDU11L1612N55	12	16	.128	.250	.433	.003	●	●
KTMDU11L4816N55	16	48	.128	.250	.433	.004	●	●

KTMD • 1/4" IC

materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (IPT)
P1	125	325–675	290–590	.002–.008
P2	180	290–550	290–520	.002–.008
P3	225	200–425	225–375	.002–.008
P4	250	250–490	250–500	.002–.008
P5	275	250–425	250–500	.002–.006
P6	325	225–350	200–325	.002–.004
stainless steel				
M1	180	325–550	375–590	.002–.004
M2	250	225–450	325–450	.002–.004
M3	330	225–375	325–375	.002–.004
cast iron				
K1	180	200–425	325–450	.001–.003
K2	220	200–390	250–325	.002–.006
K3	260	160–290	200–275	.002–.004
non-ferrous				
N1	60–100	325–820	–	.002–.010
high-temp alloys				
S1	200	65–140	65–130	.002–.004
S2	250	65–90	65–90	.001–.002
S3	280	50–65	50–65	.001–.002
S4	350	30–50	30–50	.001–.002
hardened steel				
H1	55HRc	65–140	65–140	.0004–.001

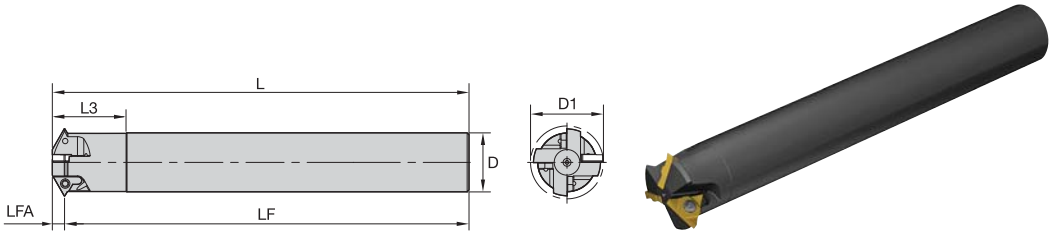
NOTE: Use Kennametal thread mill software:
TM-CNC Generator for CNC Programming on our website under: **http://www.kennametal.com/en/resources/software.html**.



Thread Mill • U Style • Weldon® Shank • 3/8" IC

order number	catalog number	D1	D	D2	L	L3	LFA	Z	max RPM	insert screw	Torx Plus driver
5593109	**KTMDUWD144L374Z3**	1.440	1.250	1.140	6.450	4.060	.320	3	3680	**KTMDUSCREW2**	**DT3IP**
5593121	**KTMDUWD165L472Z4**	1.660	1.500	1.350	7.820	5.040	.320	4	3430	**KTMDUSCREW2**	**DT3IP**

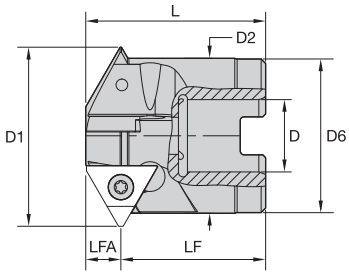
		Thread Application per Toolholder min thread Ø					
toolholder	D1	ISO (coarse)	ISO (fine)	UNC	UN/UNF/ UNEF/UNS	BSP(G)	Partial 55°
KTMDUWD144L374Z3	1.440	M42 x 4.5; M48 x 5.0; M56 x 5.5; M64 x 6.0	M39 x 1.5; M39 x 2.0; M40 x 2.5; M41 x 3.0; M42 x 3.5; M42 x 4.0	1 3/4–5; 2–4.5; 2 1/2–4	1 9/16UN; 1 5/8UNS; 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 5/8–12; 1 5/8–8; 2 1/4–6; 1 3/4–5
KTMDUWD165L472Z4	1.660	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; M48x4.0	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

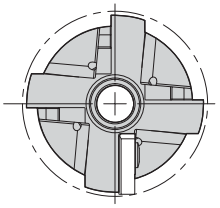


Thread Mill • U Style • Steel Cylindrical Shank • 3/8" IC

order number	catalog number	D1	D	L	L3	LF	LFA	Z	max RPM	insert screw	Torx Plus driver
5593134	**KTMDUED144L512Z3**	1.440	1.000	8.350	5.430	8.040	.310	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°
KTMDUED144L512Z3	1.4400	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 5/8–8UN; 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



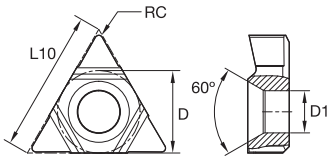


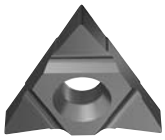


Thread Mill • U Style • Shell Mill • 3/8" IC

order number	catalog number	D1	D	D2	D6	L	LF	LFA	Z	max RPM	insert screw	Torx Plus driver
5593139	KTMDUSD169L158Z4	1.653	.500	1.350	1.339	1.580	1.268	.310	4	3430	KTMDUSCREW2	DT3IP
5593140	KTMDUSD209L158Z5	2.046	.750	1.756	1.740	1.580	1.268	.299	5	3210	KTMDUSCREW2	DT3IP

Thread Application per Toolholder min thread Ø							
toolholder	D1	ISO (coarse)	ISO (fine)	UNC	UN/UNF/ UNEF/UNS	BSP (G)	Partial 55°
KTMDUSD169L158Z4	1.6530	M56 x 5.5; M64 x 6.0	M45 x 1.5; M48 x 2.0; M48 x 3.0; M48 x 4.0	2–4.5; 2 1/2–4	1 13/16–16UN; 1 7/8–14UNS; 1 13/16–12UN; 1 7/8–10UNS; 1 7/8–8UN; 1 15/16–6UN	1 1/2–11	1 7/8–16; 1 7/8–12; 1 7/8–8; 2 1/8–6; 2–4.5; 2 1/4–4
KTMDUSD209L158Z5	2.0460	M64 x 6.0	M55 x 1.5; M56 x 2.0; M58 x 3.0; M58 x 4.0	2 1/2–4	2 1/4–16UN; 2 1/4–14UNS; 3 1/4–12UN; 2 1/4–10UNS; 2 1/4–8UN; 2 3/8–6UN	2–11	2 1/4–16; 2 1/4–12; 3/8–8; 2 3/8–6; 3–5; 3 1/2–4.5





● first choice
○ alternate choice

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

KTMD • 3/8" IC • Partial Profile 60°

catalog number	Thread Pitch min	Thread Pitch max	TPI min	TPI max	D1	D	L10	RC	KC610M	KC635M
KTMDU16L1520N60	2	2	12	16	.152	.375	.630	.002	●	●
KTMDU16L2535N60	3	4	7	10	.152	.375	.630	.006	●	●
KTMDU16L4060N60	4	6	4	6	.152	.375	.630	.010	●	●

KTMD • 3/8" IC • Partial Profile 55°

catalog number	TPI min	TPI max	D1	D	L10	RC	KC610M	KC635M
KTMDU16L0604N55	5	6	.152	.375	.630	.011	●	●
KTMDU16L1107N55	7	11	.152	.375	.630	.009	●	●
KTMDU16L1612N55	12	16	.152	.375	.630	.003	●	–

KTMD • 3/8" IC

materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (IPT)
P1	125	325–675	290–590	.002–.008
P2	180	290–550	290–520	.002–.008
P3	225	200–425	225–375	.002–.008
P4	250	250–490	250–500	.002–.008
P5	275	250–425	250–500	.002–.006
P6	325	225–350	200–325	.002–.004
stainless steel				
M1	180	325–550	375–590	.002–.004
M2	250	225–450	325–450	.002–.004
M3	330	225–375	325–375	.002–.004
cast iron				
K1	180	200–425	325–450	.001–.003
K2	220	200–390	250–325	.002–.006
K3	260	160–290	200–275	.002–.004
non-ferrous				
N1	60–100	325–820	–	.002–.010
high-temp alloys				
S1	200	65–140	65–130	.002–.004
S2	250	65–90	65–90	.001–.002
S3	280	50–65	50–65	.001–.002
S4	350	30–50	30–50	.001–.002
hardened steel				
H1	55HRc	65–140	65–140	.0004–.001

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 utilizes 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 (in)	indexable insert	largest milling cutter
M11 x 0,75	.401	STN10075ISO-I	9X1R .. STN10M
M12	.398	STN10175ISO-I-C	9X1R015B20-STN10C
M12 x 1,00	.430	STN10100ISO-I	9X1R .. STN10M
M14	.466	STN11200ISO-I-C	11X1R .. STN11N
M16	.545	STN11200ISO-I-C	11X1R .. STN11N
M20	.681	STN16250ISO-I-C	15X1R020B16-STN16C
M20 x 1,50	.724	STN11150ISO-I	11X1R .. STN11N
M20 x 1,00	.745	STN11100ISO-I	11X1R .. STN11N
M24	.817	STN22300ISO-I-C	18X1R030B25-STN22C
M24 x 2,00	.860	STN16200ISO-I	17X1R022B16-STN16N
M24 x 1,50	.881	STN11150ISO-I	11X1R .. STN11N
M24 x 1,50	.881	STN16150ISO-I	17X1R022B16-STN16N
M27	.935	STN22300ISO-I-C	18X1R030B25-STN22C
M30	1.032	STN27350ISO-I-C	25X1R040B25-STN27C
M30 x 2,00	1.096	STN16200ISO-I	22X1R025B25-STN16L
M33	1.150	STN27350ISO-I-C	25X1R040B25-STN27C
M33 x 2,00	1.214	STN16200ISO-I	22X1R025B25-STN16L
M33 x 1,50	1.254	STN16150ISO-I	22X1R025B25-STN16L
M35 x 1,50	1.314	STN16150ISO-I	22X1R025B25-STN16L
M36 x 2,00	1.332	STN16200ISO-I	22X1R025B25-STN16L
M42 x 2,00	1.569	STN27200ISO-I	30X1R052B25-STN27N
M45 x 2,00	1.687	STN27200ISO-I	37X1R .. STN27N or L
M48 x 2,00	1.805	STN27200ISO-I	37X1R058B32-STN27N or L
M55 x 2,00	2.080	STN27200ISO-I	37X1R .. STN27N or L
M56 x 2,00	2.120	STN27200ISO-I	37X1R .. STN27N or L
M72 x 2,00	2.750	STN27200ISO-I	37X1R .. STN27N or L

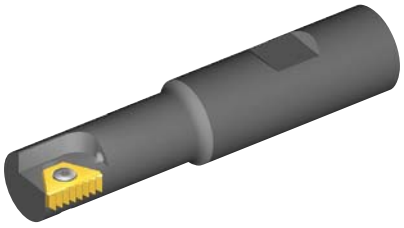
Internal Threads • Insert and Holder Recommendations

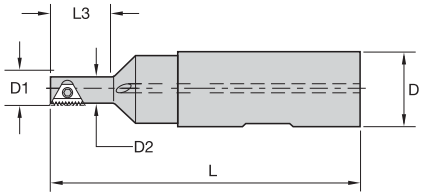
thread	tap hole fl (in)	indexable insert	largest milling cutter
9/16 - 18UNF	.502	STN1018UN-I	9X1R .. STN10M
5/8 - 24UNEF	.580	STN1124UN-I	11X1R .. STN11N
5/8 - 18UNF	.565	STN1118UN-I	11X1R .. STN11N
3/4 - 20UNEF	.696	STN1120UN-I	11X1R .. STN11N
3/4 - 16UNF	.682	STN1116UN-I	11X1R .. STN11N
7/8 - 14UNF	.798	STN1114UN-I	11X1R .. STN11N
1 - 16UN	.932	STN1616UN-I	18X1R030B25-STN22C
1 - 12UNF	.910	STN1612UN-I	17X1R .. STN16N
1 1/8 - 12UNF	1.035	STN1612UN-I	22X1R .. STN16L
1 1/4 - 12UNF	1.160	STN1612UN-I	22X1R .. STN16L
1 3/8 - 12UNF	1.285	STN1612UN-I	22X1R .. STN16L

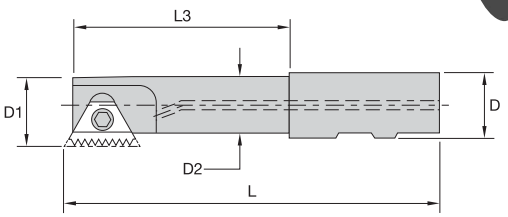
Whitworth Pipe Thread (Internal) to DIN 259

thread	tap hole fl (in)	indexable insert	largest milling cutter
R 5/8	.811	STN1614BSW	17X1R022B16-STN16N
R 3/4	.950	STN1614BSW	20X1R043B20-STN16N
R 7/8	1.098	STN1614BSW	22X1R025B25-STN16L
R 1	1.271	STN1611BSW	22X1R025B25-STN16L

- 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.
- Utilizes inserts with various profiles and pitches.







Thread Mill • Mini

order number	catalog number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Torx driver
1132616	**9X1R012B12STN10M**	.354	.472	.268	2.717	.472	1	39935	STN10	**SN7T**	**DT7**
1191395	**9X1R017B20STN10M**	.354	.787	.280	3.307	.669	1	39935	STN10	**SN7T**	**DT7**

Thread Mill • Normal Shank • STN11

order number	catalog number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Torx driver
1294964	**11X1R012B12STN11N**	.453	.472	.350	2.756	.472	1	36825	STN11	**SN2TPKG**	**DT8**
1130302	**11X1R020B20STN11N**	.453	.787	.350	3.347	.787	1	36825	STN11	**SN2TPKG**	**DT8**

Thread Mills • Normal Shank • STN16

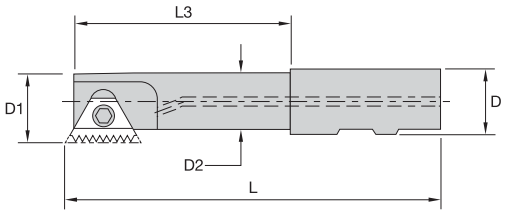
order number	catalog number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Torx driver
1130686	**17X1R022B16STN16N**	.669	.630	.535	3.543	.866	1	25750	STN16	**SN3TM**	**DT10**
1130740	**20X1R043B20STN16N**	.787	.787	.654	3.740	1.693	1	23330	STN16	**SN3TPKG**	**DT10**

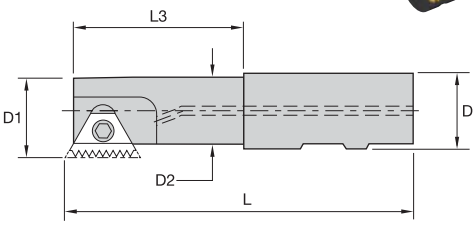
Thread Mills • Normal Shank • STN27

order number	catalog number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Torx wrench
1130969	**30X1R052B25STN27N**	1.181	.984	.945	4.331	2.047	1	12900	STN27	**SN5TM**	**TT25**
1131069	**37X1R058B32STN27N**	1.457	1.260	1.063	4.724	2.283	1	11600	STN27	**SN5TM**	**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.
- Utilizes inserts with various profiles and pitches.







Thread Mills • Normal Shank • STN.38

order number	catalog number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Torx wrench
1178986	35X1R055B32STNB38N	1.378	1.260	1.221	4.528	2.165	1	11000	STNB38	SM7TPKG	TT30

Thread Mill • Long Shank • STN16

order number	catalog number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Torx driver
1130837	22X1R025B25STN16L	.866	.984	.732	4.921	.984	1	22230	STN16	SN3TPKG	DT10

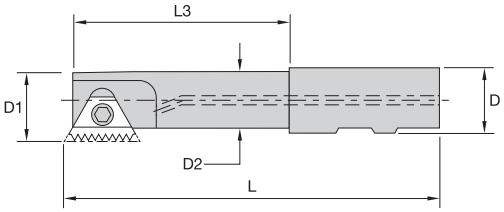
Thread Mill • Long Shank • STN27

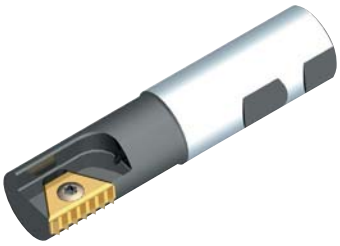
order number	catalog number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Torx wrench
1130977	30X1R092B25STN27L	1.181	.984	.945	5.906	3.622	1	12900	STN27	SN5TM	TT25
1131086	37X1R098B32STN27L	1.457	1.260	1.221	6.299	3.858	1	11600	STN27	SN5TM	TT25

Thread Mill • Long Shank • STN38

order number	catalog number	D1	D	D2	L	L3	Z	max RPM	insert 1	insert screw	Torx wrench
1566071	46X1R100B40STNB38L	1.811	1.575	1.496	6.693	3.937	1	10000	STNB38	SM7TPKG	TT30

- Thread milling system.



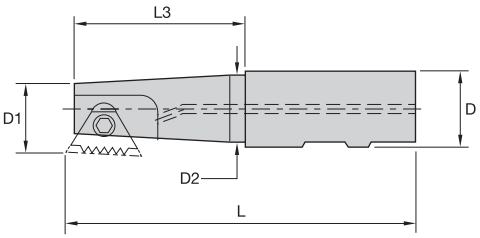


Thread Mill • Internal Coarse Pitch Thread

order number	catalog number	D1	D	D2	L	L3	Z	max RPM	insert 1
1176964	**15X1R020B16STN16C**	.610	.630	.480	3.583	–	1	26550	STN16___C
1176967	**25X1R040B25STN27C**	.984	.984	.748	3.858	1.575	1	22000	STN27___C

Spare Parts

D1	insert screw	Nm	Torx driver	Torx wrench
.610	**SN3TPKG**	2,3	**DT10**	–
.984	**SN5TM**	5,0	–	**TT25**





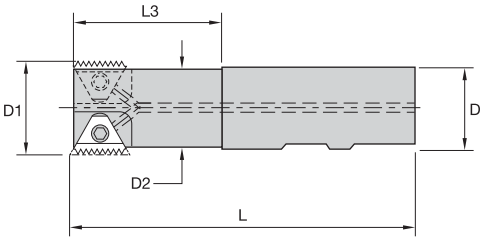
Thread Mill • Tapered Shank • Right Hand

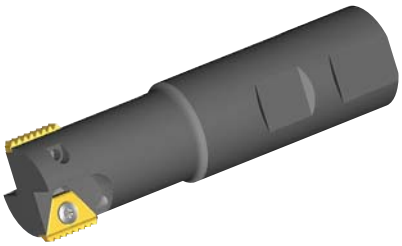
order number	catalog number	D1	D	D2	L	L3	Z	max RPM	insert 1
1176970	**10X1R015B20STN11T**	.390	.787	.291	3.032	.610	1	36500	STN11
1132781	**15X1R022B16STN16T**	.610	.630	.492	3.150	.866	1	26550	STN16
1135826	**19X1R023B20STN16T**	.748	.787	.591	3.347	.906	1	24350	STN16

Spare Parts

D1	insert screw	Nm	Torx driver
.390	**SN2TPKG**	1,7	**DT8**
.610	**SN3TPKG**	2,3	**DT10**
.748	**SN3TM**	2,3	**DT10**

- Cutting diameter ranges from .670–1.654".
- 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.
- Utilizes inserts with various profiles and pitches.



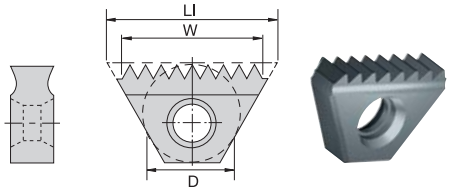


Thread Mill • Double Insert

order number	catalog number	D1	D	D2	L	L3	Z	max RPM	insert 1
1280494	**K067TM2RW075STN11D**	.670	.750	.537	3.420	1.340	2	30275	STN11
1124019	**26X2R043B25STN16D**	1.024	.984	.886	3.937	1.693	2	20530	STN16
1280517	**K102TM2RW100STN16D**	1.024	1.000	.891	4.020	1.690	2	20530	STN16
1131118	**42X2R045B32STN27D**	1.654	1.260	1.417	4.724	1.772	2	10900	STN27
1280598	**K165TM2RW125STN27D**	1.654	1.250	1.417	4.650	1.770	2	10900	STN27

Spare Parts

D1	 insert screw	 Nm	 Torx driver	 Torx wrench
.670	**SN2TPKG**	2,0	**DT8**	**–**
1.024	**SN3TPKG**	2,3	**DT10**	**–**
1.654	**SN5TM**	5,0	**–**	**TT25**



● first choice
○ alternate choice

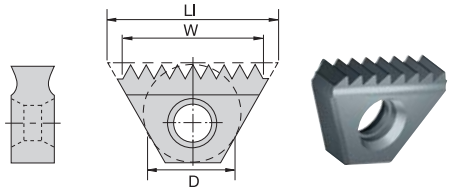
		KC610M	KC620M	KC635M
P		●	○	○
M		○	●	●
K		●		
N		●		
S			●	●
H			●	●

Internal • UN Thread • Unified Thread Standard Style

catalog number	TPI	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN1612UNI	12	.375	.630	.580	7	–	–	●
STN1114UNI	14	.250	.430	.360	5	–	–	●
STN1614UNI	14	.375	.630	.570	8	–	–	●
STN1116UNI	16	.250	.430	.380	6	–	–	●
STN1616UNI	16	.375	.630	.560	9	●	–	–
STN1018UNI	18	.236	.410	.330	6	–	–	●
STN1118UNI	18	.250	.430	.390	7	–	–	●
STN1120UNI	20	.250	.430	.400	8	–	–	●
STN1020UNI	20	.236	.410	.350	7	–	–	●
STN1124UNI	24	.250	.430	.380	9	–	–	●
STN1624UNI	24	.375	.630	.580	14	–	–	●
STN1627UNI	27	.375	.630	.560	15	–	–	●
STN1632UNI	32	.375	.630	.590	9	–	–	●

External • UN Thread • Unified Thread Standard Style

catalog number	TPI	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN1118UNE	18	1/4	.430	.390	7	–	–	●
STN1614UNE	14	3/8	.630	.570	8	–	–	●
STN1616UNE	16	3/8	.630	.560	9	–	–	●
STN1620UNE	20	3/8	.630	.550	11	–	–	●
STN1624UNE	24	3/8	.630	.580	14	–	–	●



● first choice
○ alternate choice

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

Internal • ISO Thread • ISO Metric Screw Thread Style

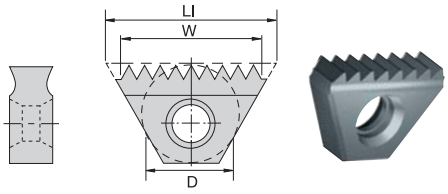
catalog number	thread pitch mm	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN10075ISOI	0,750	.236	.410	.380	13	–	–	●
STN10100ISOI	1,000	.236	.410	.350	9	–	●	●
STN10125ISOI	1,250	.236	.410	.340	7	–	–	●
STN10150ISOI	1,500	.236	.410	.350	6	–	–	●
STN11100ISOI	1,000	.250	.430	.390	10	–	–	●
STN11150ISOI	1,500	.250	.430	.410	7	–	–	●
STN16100ISOI	1,000	.375	.630	.590	15	–	–	●
STN16150ISOI	1,500	.375	.630	.590	10	–	–	●
STN16175ISOI	1,750	.375	.630	.550	8	–	–	●
STN16200ISOI	2,000	.375	.630	.550	7	–	–	●

External • ISO Thread • ISO Metric Screw Thread Style • Coarse

catalog number	thread pitch mm	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN22300ISOIC	3,000	.500	.870	.700	6	●	–	–
STN27350ISOIC	3,500	.625	1.060	.960	7	●	–	–

External • ISO Thread • ISO Metric Screw Thread Style

catalog number	thread pitch mm	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN16150ISOE	1,500	.375	.630	.590	10	●	●	–
STN27200ISOE	2,000	.625	1.060	.940	12	●	–	–



● first choice
○ alternate choice

		KC610M	KC620M	KC635M
P		●	○	○
M		○	●	●
K		●		
N		●		
S			●	●
H			●	●

BSW Thread • British Standard Whitworth Thread Style

catalog number	TPI	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN1119BSW	19	1/4	.430	.370	7	–	–	●
STN1614BSW	14	3/8	.630	.570	8	●	–	●
STN1612BSW	12	3/8	.630	.580	7	–	–	●
STN1611BSW	11	3/8	.630	.550	6	●	–	●
STN2711BSW	11	5/8	1.060	.910	10	–	–	●

NPS Thread • Nominal Pipe Size Style

catalog number	TPI	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN16115NPS	11.5	.375	.630	.520	6	–	–	●
STN1614NPS	14	.375	.630	.570	8	–	–	●

NPT Thread • National Pipe Thread Taper Style

catalog number	TPI	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN1118NPT	18	.250	.430	.390	7	–	–	●
STN16115NPT	11.5	.375	.630	.520	6	–	–	●
STN1614NPT	14	.375	.630	.570	8	–	–	●

NPTF Thread • ISO Metric Screw Thread Style

catalog number	TPI	D	LI	W	number of teeth	KC610M	KC620M	KC635M
STN1118NPTF	18	.250	.430	.390	7	–	–	●
STN16115NPTF	11.5	.375	.630	.520	6	–	–	●
STN1614NPTF	14	.375	.630	.570	8	–	–	●

NOTE: NPTF = Dry Seal
NPT and NPTF inserts possess right- and left-hand edges.
Must order left-hand bar for left-hand inserts.

STN Series

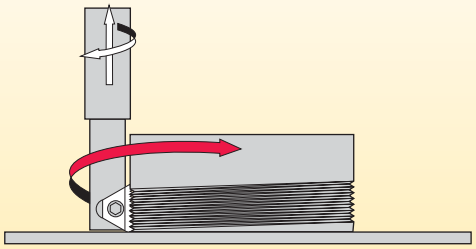
materials	Brinell	surface speeds		indexable inserts
steel	HB	KC610M	KC635M	feed fz (IPT)
P1	125	325–675	290–590	.002–.008
P2	180	290–550	290–520	.002–.008
P3	225	200–425	225–375	.002–.008
P4	250	250–490	250–500	.002–.008
P5	275	250–425	250–500	.002–.006
P6	325	225–350	200–325	.002–.004
stainless steel				
M1	180	325–550	375–590	.002–.004
M2	250	225–450	325–450	.002–.004
M3	330	225–375	325–375	.002–.004
cast iron				
K1	180	200–425	325–450	.001–.003
K2	220	200–390	250–325	.002–.006
K3	260	160–290	200–275	.002–.004
non-ferrous				
N1	60–100	325–820	–	.002–.010
high-temp alloys				
S1	200	65–140	65–130	.002–.004
S2	250	65–90	65–90	.001–.002
S3	280	50–65	50–65	.001–.002
S4	350	30–50	30–50	.001–.002
hardened steel				
H1	55HRc	65–140	65–140	.0004–.001

NOTE: Use Kennametal thread mill software:
TM-CNC Generator for CNC Programming on our website under: **http://www.kennametal.com/en/resources/software.html**.

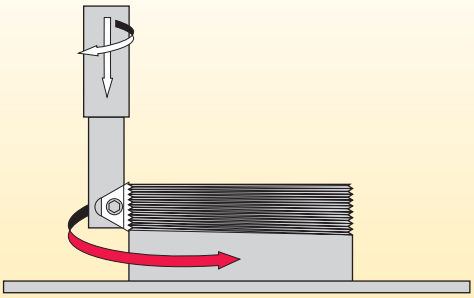
The Following Are a Few Thread Milling Methods (Work Directions)

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.

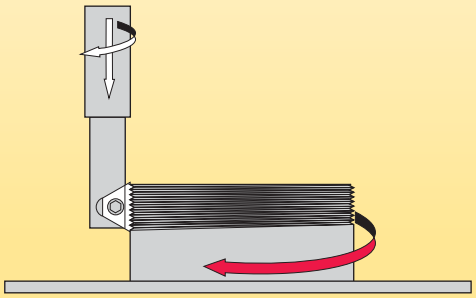
Methods of External Thread Milling



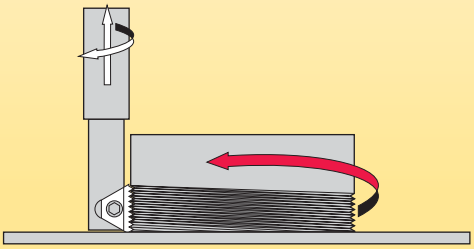
right-hand thread... conventional milling



left-hand thread... conventional milling

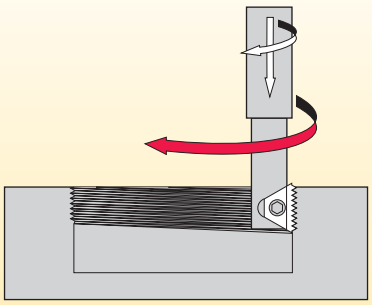


right-hand thread... climb milling

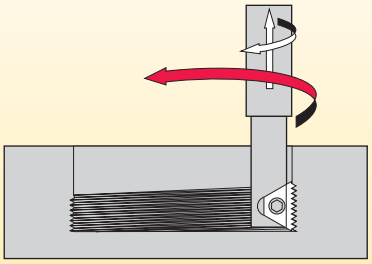


left-hand thread... climb milling

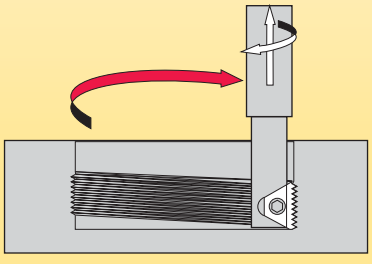
Methods of Internal Thread Milling



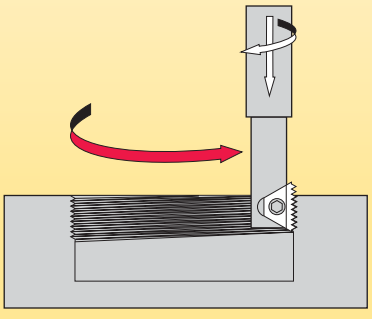
right-hand thread... conventional milling



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

cutter	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 diameter (D1)	minimum bore diameter (D) (inches)															
K035TM1RW050-STN10	.35	.374	.394	.421	.449												
K045TM1RW050-STN11N	.45	.472	.492	.520	.547	.571											
K049TM1RW037LT11S	.49	.512	.531	.559	.587	.610											
K061TM1RW062-STN16T	.61	.630	.650	.667	.705	.728	.768										
K067TM2RW075-STN11D	.67	.693	.717	.748	.772	.787	.827										
K075TM1RW075-STN16T	.75	.776	.803	.827	.850	.866	.906										
K079TM1RW075-STN16N	.79	.815	.843	.866	.890	.906	.945										
K087TM1RW100-STN16L	.87	.893	.921	.945	.969	.984	1.024										
K102TM2RW100-STN16D	1.02	1.051	1.079	1.102	1.130	1.154	1.193										
K118TM1RW100-STN27N	1.18	1.209	1.236	1.260	1.291	1.319	1.362	1.441	1.535	1.654	1.772	1.890					
K146TM1RW125-STN27N	1.46	1.496	1.520	1.555	1.591	1.614	1.654	1.732	1.830	1.929	2.047	2.185					
K165TM2RW125-STN27D	1.65	1.701	1.724	1.772	1.811	1.831	1.866	1.929	2.047	2.146	2.268	2.401					
–	1.38 (UN)	–	–	–	–	–	–	–	–	–	1.969	–	1.843	–	1.756	–	2.228
–	1.38 (ISO)	–	–	–	–	–	–	–	–	–	1.969	2.102	1.673	1.969	–	2.264	–
–	1.38 (BSW)	–	–	–	–	–	–	–	–	–	1.961	–	1.831	–	1.866	–	–

Cutting Data Recommendation

workpiece material	Cutting Speed — vc SFM	feed rate per revolution (inch)
	KC635M	
carbon steels <187 HB	300–700	.004–.008
carbon steels 187–220 HB	300–500	.004–.006
alloy steel 200–250 HB	200–425	.004–.006
alloy steel 250–325 HB	150–300	.004–.006
stainless steel, austenitic <210 HB	300–450	.004–.006
stainless steel, martensitic <321 HB	250–350	.002–.006
stainless steel, ferritic <245 HB	350–550	.002–.004
cast steel <140 HB	350–550	.002–.006
cast steel 220–302 HB	225–425	.002–.004
titanium alloys	200–400	.001–.003
high-temperature (nickel and iron base)	75–150	.001–.002
high-temperature (cobalt base)	50–100	.001–.002
cast iron	250–350	.002–.006
malleable iron	250–400	.001–.003

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 a counterclockwise 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.

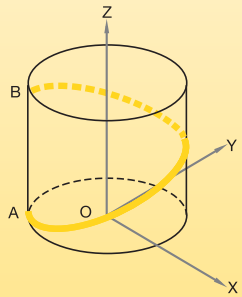
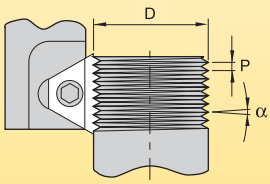


figure A



α - helix angle
D - external diameter
P - pitch

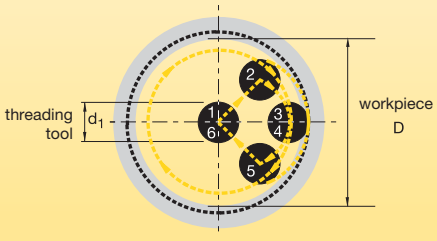
figure B

Tangential Approach (Arc)

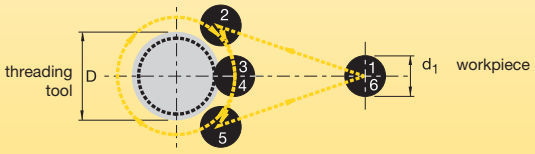
With this method, the tool enters and exits the workpiece smoothly. No marks are left on the workpiece and there is no vibration, even with harder materials.

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



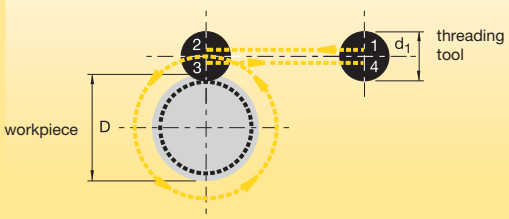
internal left-hand thread



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

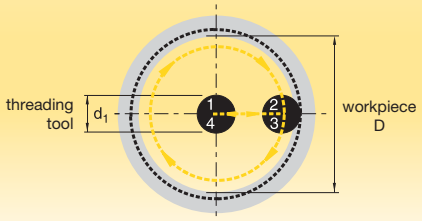
This radial approach is often considered the simplest. There are two characteristics worth noting about the radial approach:

a. A small vertical mark may be left at the entry (and exit) point. This is of no significance to the thread itself.

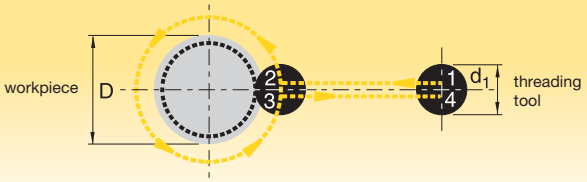
b. When using this method with very hard materials, there may be a tendency for the tool to vibrate as it approaches the full cutting depth.

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 (in/min)
fz = inch 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:

$$RPM = \frac{12 \times SFM}{\pi \times d_1}$$

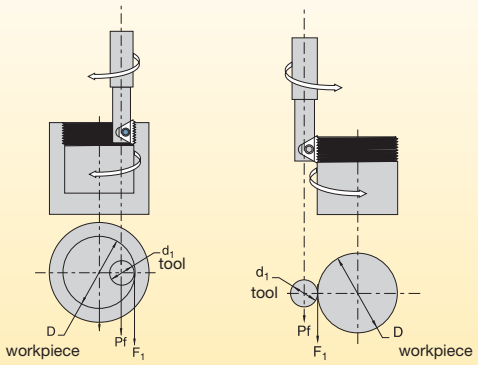
SFM = cutting speed, surface feet per minute
d_1 = cutter diameter, over insert
π = 3.1416

Calculation of Program Feed Rate

On most CNC machines, the feed rate required for programming is at the centerline of the tool. When dealing with linear tool movement, the feed rate at the cutting edge and the centerline are identical. With circular tool movement this is not the case. The following equations define the relationship between feed rates at the tool centerline.

$$P_1 = F_1 + \frac{(F_1 \times d_1)}{D}$$

P_1 = program feed rate (in/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.) = 1.182"

Do (nominal dia.) = 1.25"

thread length: .50"

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 1.02" or smaller can be utilized.

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			
.67	.748	.772	.787	.827
.75	.827	.850	.866	.906
.79	.866	.890	.906	.945

Figure B: cutter selected: K079TMIRW075STN16N
outer dimensions: d_1 = .79, R_t (radius of tool) = $d_1 \div 2$ = .395"

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 inch (mm)	pitch (TPI)	internal thread catalog number	b inch thread length (in)	number of teeth	grade KC610M	grade KC620M	external thread catalog number	b inch thread length (in)	number of teeth	grade KC610M	grade KC620M	cutter type
		32	STN16 32UN-I	.59	19	□	□	STN16 32UN-E	.59	19	□	□	
		28	STN16 28UN-I	.57	16	■	■	STN16 28UN-E	.57	16	□	□	
		27	STN16 27UN-I	.56	15	□	■	STN16 27UN-E	.56	15	■	□	
		24	STN16 24UN-I	.55	14	□	□	STN16 24UN-E	.58	14	■	□	
3/8	.63 (16)	20	STN16 20UN-I	.55	11	■	■	STN16 20UN-E	.55	11	■	■	STN16
		18	STN16 18UN-I	.56	10	■	■	STN16 18UN-E	.56	10	■	■	
		16	STN16 16UN-I	.56	9	■	■	STN16 16UN-E	.56	9	■	■	
		14	STN16 14UN-I	.57	8	■	■	STN16 14UN-E	.57	8	■	■	
		13	STN16 13UN-I	.54	7	□	□	STN16 13UN-E	.54	7	□	□	
		12	STN16 12UN-I	.58	7	■	■	STN16 12UN-E	.58	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.

$$RPM = \frac{12 \times SFM}{\pi \times d_1} = \frac{12 \times 500}{3.14 \times .79} = 2418 \text{ RPM}$$

Next, calculate the feed rate at the insert cutting edge (F_1):

(using the chosen feed per tooth of .004.)

$$F_1 = IPT \times nt \times RPM = .004 \times 1 \times 2418 = 9.67 \text{ in/min}$$

Finally, calculate the feed rate at the cutter centerline (F_2):

$$F_2 = \frac{F_1 \times (D - d_1)}{D} = \frac{9.67 \times (1.182 - .79)}{1.182} = 3.207 \text{ in/min}$$

Select the thread milling method.

Climb milling (preferred) see page W48.

Calculate the radius of the tangential arc R_e:

$$R_e = \frac{(R_i - C_L)^2 + R_0^2}{2R_0} = \frac{(.591 - .02)^2 + .625^2}{2 \times .625}$$

$$R_e = .573333 \text{ in.}$$

Calculate the angle (β):

$$\beta = 90° + \arcsin \frac{R_0 - R_e}{R_e}$$

$$\beta = 90° + \arcsin \frac{.625 - .573333}{.57333}$$

$$\beta = 90° + 5.17° = 95.17° = 95° 10'$$

Calculate the movement along the Z-axis during the entry approach from point "A" to point "B" ($Z\alpha$).
(NOTE: P = pitch)

$$Z\alpha = P \text{ (in)} \times \frac{\alpha°}{360°} = \frac{.0625}{4} = .0156 \text{ in, because } \alpha = 90°$$

Calculate the "X" and "Y" values at the start of the entry approach.

$$X = 0Y = -R_i + C_L = -.591 + .02 = -.571 \text{ in.}$$

Define Z-axis location at the start of the entry approach.
(NOTE: L = length of thread)

$$Z = -(L + Z\alpha) = -(.50 + .0156) = -.5156 \text{ in.}$$

Define the starting point.

$X_a = 0$

$Y_a = 0$

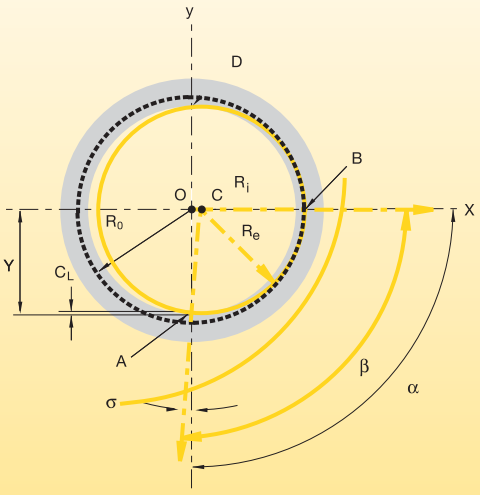
CNC Program (Fanuc 11M)

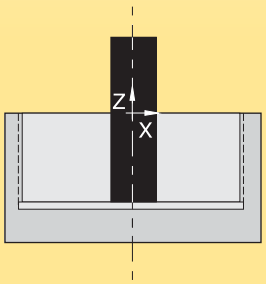
```
%
N10G90G00G57X0.000Y0.000
N20G43H10Z0.M3S2417
N30G91G00X0.Y0.Z–0.5156
N40G41D60X0.000Y–0.5710Z0.
N50G03X0.6250Y0.5710Z0.0156R0.5733F3.206
N60G03X0.Y0.Z0.0625I–0.625J0.
N70G03X–0.625Y0.5710Z0.0156R0.5733
N80G00G40X0.Y–0.5710Z0.
N90G49G57G00Z8.0M5
N100M30
%
```

$$R_i = \frac{D}{2} \qquad R_O = \frac{D_O}{2}$$

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:

$OA = R_i - C_L$
$CA = R_e$
$OC = R_o - R_e$

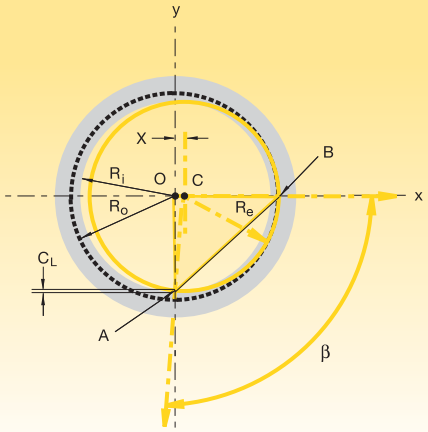
Pythagoras' law states: $OA^2 + OC^2 = AC^2$

Replacing actual values, we get:

$$(R_i - C_L)^2 + (R_o - R_e)^2 = R_e^2$$

Simplifying, we get:

$$R_e = \frac{(R_i - C_L)^2 + R_o^2}{2R_0}$$



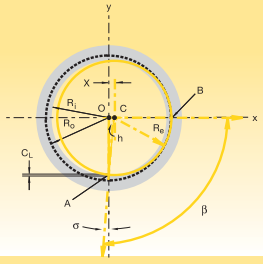
Find the angle β.

$\beta = 90° + \sigma$

$\sin \sigma = \frac{OC}{CA} = \frac{(R_o - R_e)}{R_e}$

$\sigma = \text{arc sin} \left(\frac{R_o - R_e}{R_e}\right)$

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:

$OA = R_o - C_L$
$CA = R_e$
$OC = R_e - R_i$

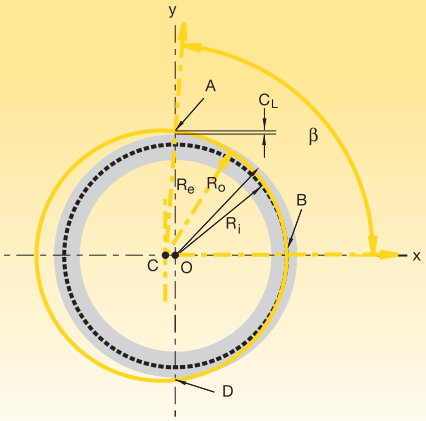
Pythagoras' law states: $OA^2 + OC^2 = AC^2$

Replacing actual values, we get:

$$(R_o - C_L)^2 + (R_e - R_i)^2 = R_e^2$$

Simplifying, we get:

$$R_e = \frac{(R_o - C_L)^2 + R_i^2}{2R_i}$$

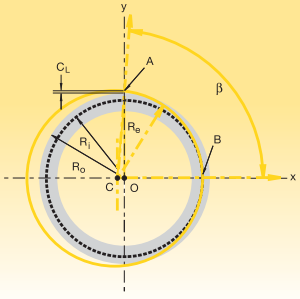


Find the angle β.

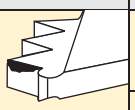
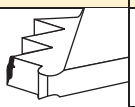
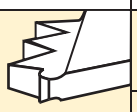
β can be easily found using the same triangle:

$\sin \beta = \frac{AO}{AC} = \frac{(R_o + C_L)}{R_e}$

$\beta = \text{arc sin} \left(\frac{R_o + C_L}{R_e}\right)$



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 • 5.3–47.8 in. lbs. (0,6–5,4 Nm)

Order Number	Catalog 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 • 3.7–10.3 in. lbs. (5–14 Nm)

Order Number	Catalog 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 Adapter

Order Number	Catalog Number	Drive Size	Description
1963869	**DRIVER**	hex 1/4"	Bit Adapter suitable for standard and extended length 1/4" drive bits

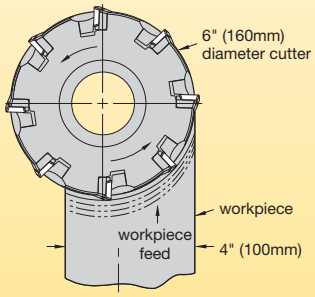
Workpiece dimensions determine the best face mill diameter to select.

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 4" (100mm), choose a 6" (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 24" (610mm) and the machine has a standard #50 taper spindle, you should use an 8" (200mm) diameter cutter and take five passes, at slightly less than 5" (125mm) per pass, or four passes at 6" (160mm) per pass, depending on horsepower and rigidity.

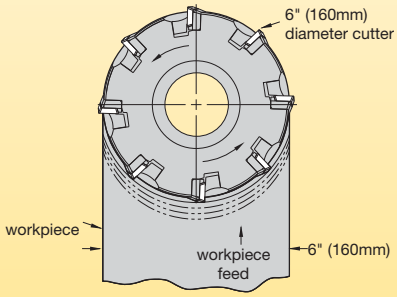
An undesirable situation is when the cutter diameter is about equal to the width of cut. The chip being formed at the entrance and exit of the cut will be very thin. The thin chips formed cannot carry away heat as well as thicker chips; therefore, the heat is transferred back into the insert causing 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.

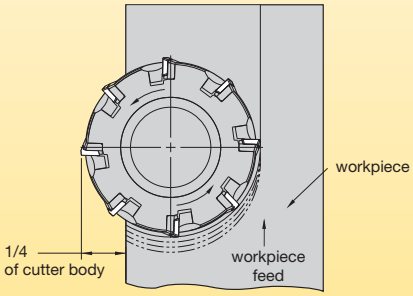
- Position cutter with approximately 1/4 of the cutter body outside the workpiece and make two passes.
- Produces negative angle of entry (desirable).
- Can result in longer tool life.



desirable



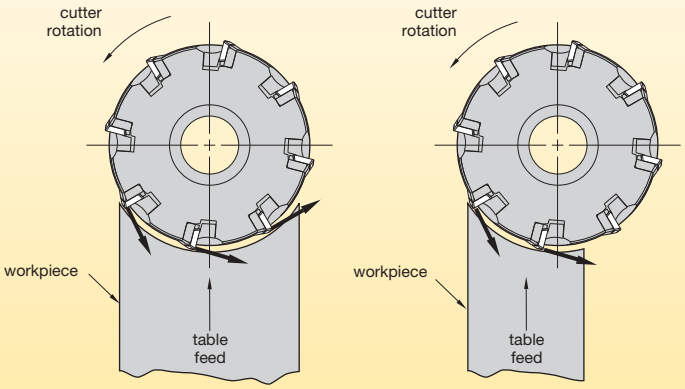
undesirable



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.

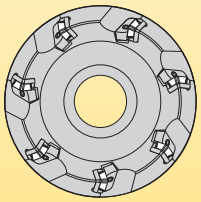
In medium pitch cutters, the chip clearance area in the body is usually slightly smaller than a coarse pitch cutter. And, in fine pitch cutters, the chip clearance is considerably less.

Coarse pitch is recommended for general purpose milling where adequate horsepower is available, and where maximum depth of cut is required.

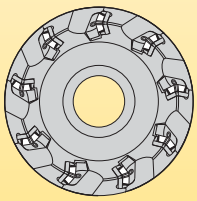
Medium pitch is recommended when moderate feed per insert is required, and where it is more advantageous to have more than one insert in the cut. Medium pitch also reduces entry shock and cutting pressure while maintaining feed rates.

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.

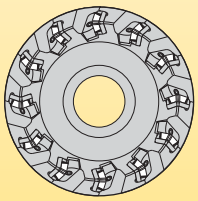
Differential pitch is a differential-pitch milling cutter with unequally spaced inserts. This configuration breaks up the harmonics that result from equally spaced inserts, greatly reducing the chance of vibration. Most cutters use this design regardless of the cutter pitch.



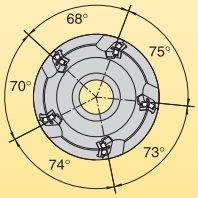
coarse pitch



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.

0° 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.

15° and 20° 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.

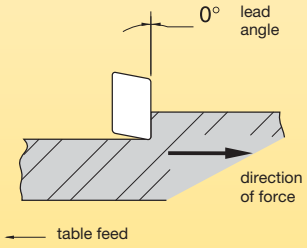
45° Lead Angle

Advantages:

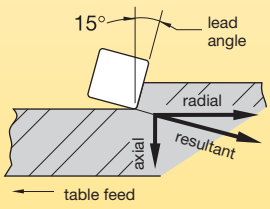
- Well-balanced axial and radial cutting forces.
- Less breakout on workpiece corner.
- Entry shock minimized.
- Less radial forces directed into spindle bearings.
- Higher feed rates possible.

Disadvantages:

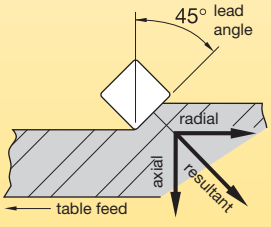
- Reduced maximum depth of cut due to lead angle.
- Larger body diameter can cause fixture clearance problems.



0° lead



15° and 20° lead



45° lead

(continued)

(continued)

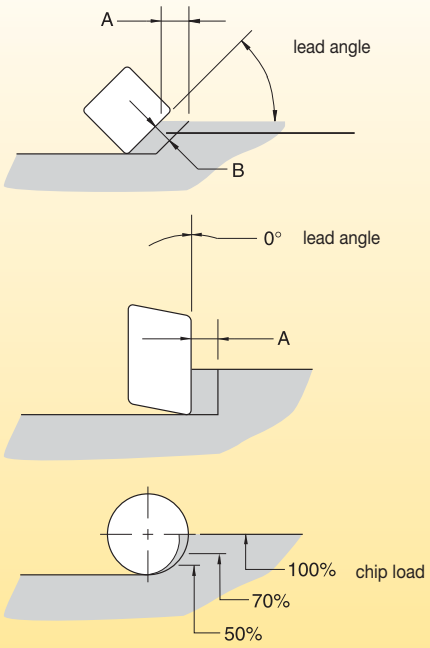
Lead Angle/Chip Thickness

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"
0°	A	A
15°	A	.96 x A
20°	A	.94 x A
30°	A	.86 x A
45°	A	.707 x A

example:

0°	.010" (0,25mm)	.010" (0,25mm)
15°	.010" (0,25mm)	.0096" (0,25mm)
20°	.010" (0,25mm)	.0094" (0,24mm)
30°	.010" (0,25mm)	.0086" (0,22mm)
45°	.010" (0,25mm)	.0071" (0,18mm)



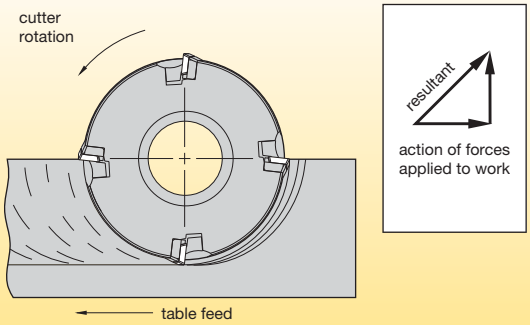
On round inserts, the chip load and lead angle vary with the depth of cut.

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.

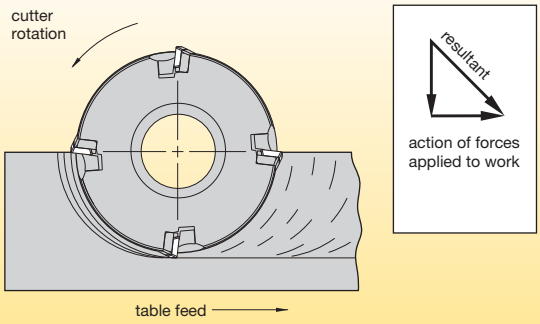


conventional milling

Climb Milling (preferred)

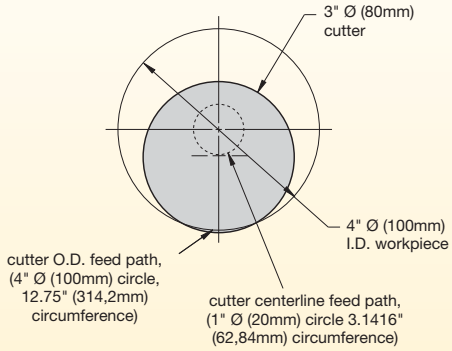
Climb milling is normally recommended. The insert enters the workpiece material with some chip load and produces a chip that thins as it exits the cut. This reduces the heat by dissipating it into the chip. Work-hardening is minimized.

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

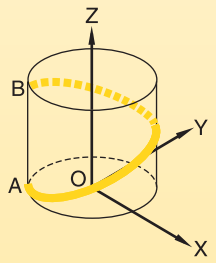
Circular Interpolation: Consists of a cutter rotating about its own axis while traveling in an orbiting motion about an I.D. or O.D. workpiece circumference without any vertical shift during the operation. This orbiting movement utilizes the "X" and "Y" axis.



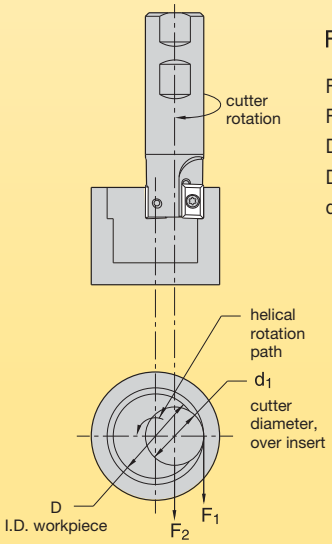
I.D. circular interpolation

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 a counterclockwise direction.



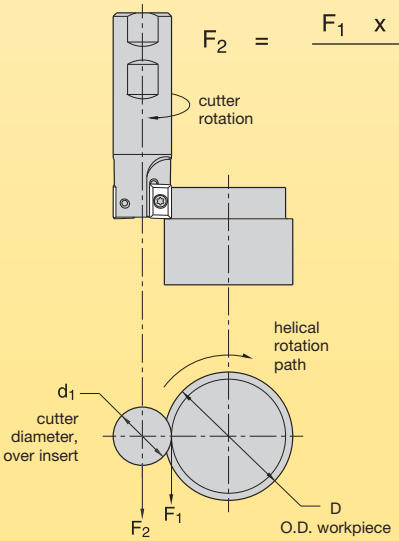
helical interpolation



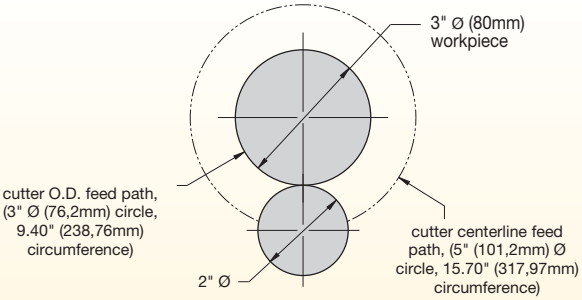
inside diameter (I.D.) helical interpolation

$$F_2 = \frac{F_1 \times (D - d_1)}{D}$$

F_1 = tool feed rate at the cutting edge (in./min.)
F_2 = tool centerline feed rate (in./min.)
D = O.D. workpiece diameter
D = I.D. workpiece diameter
d_1 = cutter diameter, over insert



outside diameter (O.D.) helical interpolation



O.D. circular 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 centerline of the tool. When dealing with linear tool movement, the feed rate at the cutting edge and centerline 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 (in./min.)

f_z = inch per tooth (chip load)

z = number of effective inserts in the cutter

n = revolutions per minute

Calculation of the Feed Rate at the Tool Centerline: Use the following equations to define the relationship between feed rates at the cutting edge and at the tool centerline.

$$F_2 = \frac{F_1 \times (d_1 + D)}{D}$$

(continued)

(continued)

In I.D. contour applications, you will find the tool centerline feed is always less than the cutting edge feed rate.

Example for I.D.

D = 4" (100mm) I.D. workpiece

d_1 = 3" (80mm) cutter diameter

fz = .008 IPT (0,2 mm/tooth)

n = 637 RPM

z = 7 effective inserts

1. Calculate feed rate at the cutting edge.

$F_1 = f_2 \times z \times n$

F_1 = .008 x 7 x 637 = 35.7 in./min (0.2 x 7 x 637 = 892 mm/min)

2. Calculate feed rate at the tool centerline.

$$F_2 = \frac{F_1 \times (D - d_1)}{D}$$

$$F_2 = \frac{35.7 \times (4.0 - 3.0)}{4.0} = 8.9 \text{ in./min}$$

$$F_2 = \frac{892 \times (100 - 80)}{100} = 178 \text{ mm/min}$$

To have (F_1) 35.7 in/min (892 mm/min) at the cutting edge feed rate, we must program the machine tool for (F_2) 8.9 in/min (178 mm/min) at the tool centerline 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 centerline feed rate is always larger than the cutting edge feed rate.

Example for O.D.

D = 5" (125mm) O.D. workpiece

d_1 = 2" (50mm) cutter diameter

f_z = .008 IPT (0,2 mm/tooth)

n = 955 RPM

z = 5 effective teeth

1. Calculate feed rate at the cutting edge.

$F_1 = f_2 \times z \times n$

F_1 = .008 x 5 x 955 = 38.2 in./min (0.2 x 5 x 955 = 955 mm/min)

2. Calculate feed rate at the tool centerline.

$$F_2 = \frac{F_1 \times (d_1 + D)}{D}$$

$$F_2 = \frac{38.2 \times (2 + 5)}{5} = 53.5 \text{ in./min}$$

$$F_2 = \frac{955 \times (50 + 125)}{125} = 1{,}337 \text{ mm/min}$$

To have (F_1) 38.2 in/min (955 mm/min) at the cutting edge feed rate, we must program the machine tool for (F_2) 53.5in/min (1,337 mm/min) at the tool centerline 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.

Maximize Metal Removal Rate

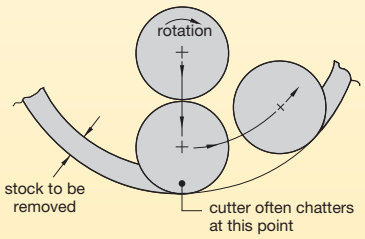
Concentrate on Metal Removal Rate (MRR), not just on higher SFM (cutting speeds). Increasing spindle speed without increasing chip load will not improve MRR. However, by doubling fz, MRR does increase and horsepower consumption only increases by approximately 50%.

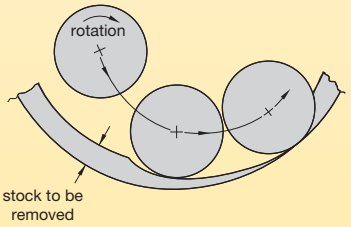
Preset

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.

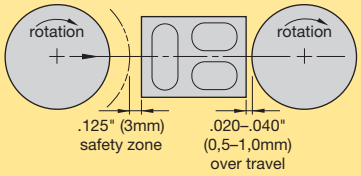




Safety and Over Travel

Program the milling cutter to rapid advance up to the part, within a range of .125" (3mm) before engaging the workpiece. This allows the machine to reach its proper operating parameters before actual chip making begins.

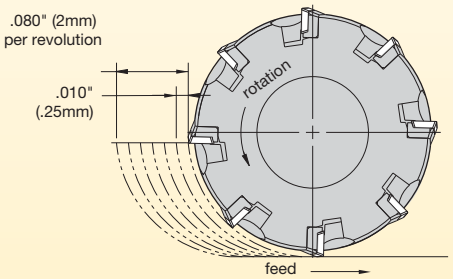
Rapid advance to the next cutting location, when the cutter is .020" (0,5mm) to .040" (1mm) past the edge of the part. If the spindle has built-in tilt or programmed runout, the cutter can be advanced to the next cutting location while the back half of the cutter is still over the finished milled surface.



to find	given	formula
Vc	D n	$Vc = \frac{\pi \times D \times n}{12}$
n	D Vc	$n = \frac{12 \times Vc}{\pi \times D}$
Vf	fz n z	**Vf = fz x z x n**
fz	z Vf n	$fz = \frac{Vf}{2 \times n}$

given	calculated
D = 6" cutter diameter Z = 8 teeth in cutter Vc = 600 SFM fz = .010 IPT	$n = \frac{12 \times 600}{3.1416 \times 6} = 382$ **Vf (IPM) = .010 x 8 x 382 = 30.6**

legend
Vc = surface feed per minute
n = revolutions per minute
D = cutter diameter
Vf = feed (inch per minute)
fz = inch per tooth (chip load)
z = number of effective teeth or inserts in cutter
π = 3.1416

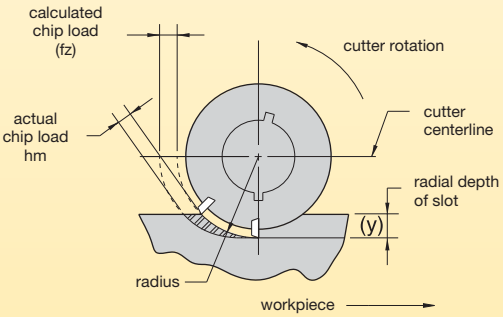


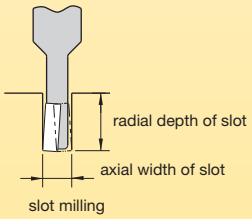
Slotting or Periphery Milling

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 arbor 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

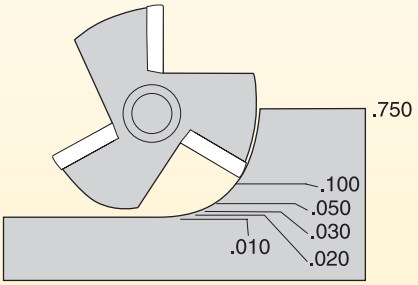
$$\text{chip load (fz)} = \frac{\left(\frac{\sqrt{(\text{dia.} - y) \times (y)}}{\text{radius}}\right) \times \left(\frac{vf}{n}\right)}{z}$$

or

$$F = \frac{n \times z \times fz}{\left(\frac{\sqrt{(\text{dia.} - y) \times (y)}}{\text{radius}}\right)}$$

Operations such as **periphery milling with a light radial depth of cut or slotting with an arbor 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 3/4" diameter cutter taking a .010" 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.

radial depth of cut	actual chip load (IPT)	feed required (IPM) to maintain .004 IPT	increase
.750	.0040	5.5	0%
.100	.0020	11.5	109%
.050	.0014	15.3	178%
.030	.0011	19.6	256%
.020	.0009	23.9	335%
.010	.0006	33.8	515%



1.5" B end mill – 6 flutes
90 SFM 230 RPM
.004 IPT 5.5 IPM

Formulas — Horsepower

Metal Removal Rate

The Metal Removal Rate (MRR) calculation is a good basis for determining metalcutting efficiency.

MRR = doc x woc x F = cu. inches/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 . . . . 1.64"
depth of cut 200
feed . . . . . 19.5 IPM
4140 220 HB . . . . . "K" factor 1.56

MRR = .200 x 1.64 x 19.5 = 6.4 cu. in/mi

$$HPc = \frac{6.4}{1.56} = 4.1 \text{ HP at the cutter}$$

For horsepower at the motor (HP_m), use formula:

$$HPm = \frac{HPc}{E} \qquad HPm = \frac{4.1}{.8} = 5.1$$

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.

"K" Factors

workpiece material	hardness	"K" factor
steels, and wrought and cast irons (plain carbon alloy steels, and tool steels)	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 (gray, 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
aluminum 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 utilizes 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 (ft. lbs.)

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 (psi)
A = cross-sectional area of the chip removed by the milling insert (in^2)
Z_c = number of inserts in cut
C_m = machinability factor
C_w = tool wear factor

2. Ultimate material strength (psi)

The approximate relationship between the ultimate material strength and hardness of the most commonly used work materials such as steels, irons (for example: gray cast iron), titanium alloys (Ti – 6Al – 4V), and aluminum alloys (2024, 5052) can be expressed by the empirical formula:

$$S = 500 \times HB \text{ (psi)}$$

Where HB = Brinell hardness numbers obtained, primarily, at the 3000-kgf load. When testing soft metals such as aluminum 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 pages Y210-Y211.

3. Cross-sectional area of the chip (A)

Cross-sectional area of the chip (Fig. 1) is defined by:

where: A = d f (in^2, or mm^2)
d = axial depth of cut (in, or mm)
fz = feed per tooth (in, or mm)

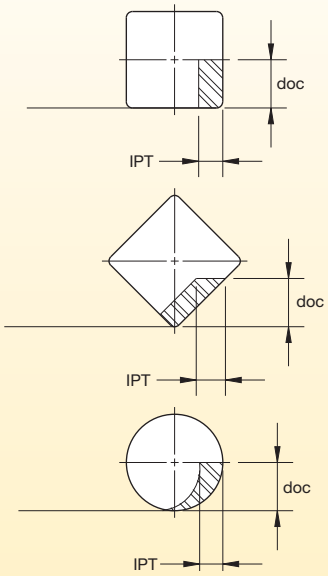


Figure 1: Cross-sectional area of the chip and insert's shape

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.

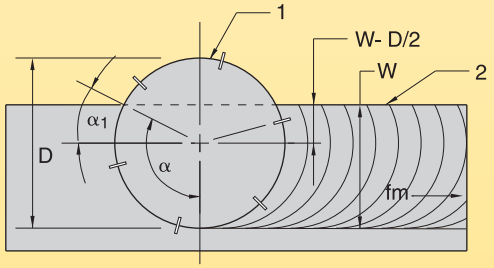


Figure 2: Schematic for calculating the number of inserts in cut

1 = milling cutter
2 = workpiece
α = engagement angle
α_1 = the angle between cutter centerline 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
gray cast iron	1.0	1.15	1.3
titanium alloys	1.0	1.20	1.4
aluminum 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 centerline 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 (ft. lbs.)

The torque "T" generated by tangential force is calculated using the following formula:

$T = F_t \times D/2$ (in.-lb.)

where D = cutter diameter inch

8. Calculating horsepower (HP_c or HP_m)

The machining power at the cutter (sharp edges) is calculated by either of these two formulas:

$$HP_c = \frac{F_t \times SFM}{33{,}000}$$

or

$$HP_c = \frac{T \times RPM}{63{,}000}$$

where SFM = peripheral cutting speed (SFM)
RPM = spindle speed (RPM)
33,000 and 63,000 = 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 KSSISR – 492 – SE443 – 45 – 06:

effective diameter	D = 4.92".
number of inserts	Z = 6

workpiece material:
alloy steel AISI 4140
hardness 220 HB

machining conditions:

spindle speed	n = 349
cutting speed	Vc = 450
machine feed rate	F = 19.5
inch per tooth (chip load)	fz = .008"
axial depth of cut	doc = .200"
radial width of cut	woc = 1.64"
W/D ratio	W/D = .33

Step-By-Step Calculations

1. Calculating tangential force

1.1 ultimate strength of the workpiece material
S = 500 x HB = 500 x 220 = 110,000 psi

1.2 cross-sectional area of the chip
$A = doc \times IPT = .200 \times .008 = .0016\ in.^2$

1.3 number of inserts in cut:
width of cut-to-diameter ratio (w/d)
W/D = 1.64 / 4.92 = .33 (See Table 1, page X12).
Now use Z_c value shown in Table 1 under .33.
$Z_c = .20 \times Z = .20 \times 6 = 1.2$ inserts in cut.

NOTE: Z = number of inserts in cutter.

1.4 tangential force
$F_t = S \times A \times Z_c \times C_m \times C_w$
$F_t = 110{,}000 \times .0016 \times 1.2 \times 1.1 \times 1.1 = 256$ lbs.

NOTE: $C_m = 1.1$ and $C_w = 1.1$

2. Calculating torque at the cutter

$$T = (F_t \times D)/2 = \frac{256 \times 4.92}{2} = 630\ in.\text{-}lb.$$

3. Calculating horsepower

- At the cutter...reference formulas in paragraph 8 on page X12.

$$HP_c = \frac{F_t \times SFM}{33{,}000} = \frac{256 \times 450}{33{,}000} = 3.5\ hp$$

or

$$HP_c = \frac{T \times RPM}{63{,}000} = \frac{630 \times 349}{63{,}000} = 3.5\ hp$$

- At the motor...reference formula in paragraph 9 on page X12.
- Where E = machine tool efficiency factor (E = .75 to .90).

$$HP_m = \frac{HP_c}{E} = \frac{3.5}{.8} = 4.4\ hp$$

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 .001" (0,025mm) relative to each other, the finish produced will be better than if the inserts were set to within .003" (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.

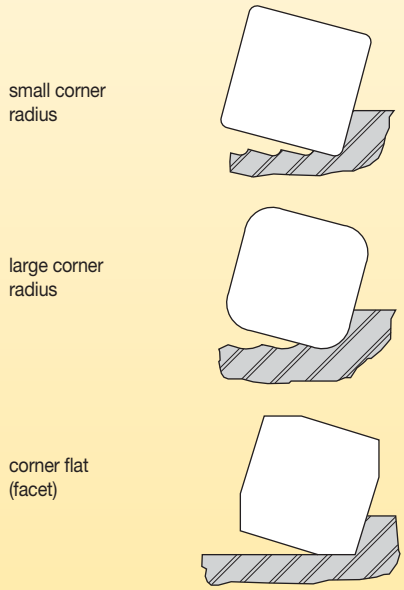


Figure 1: Larger insert corner radii or flats produce finer milling finishes.

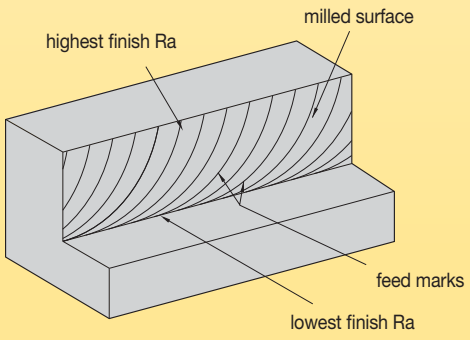


Figure 2: Quality of Ra finish corresponds to the distance between feed marks.

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 center where the feed marks are farthest apart. Peaks produced are highest at the center 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.

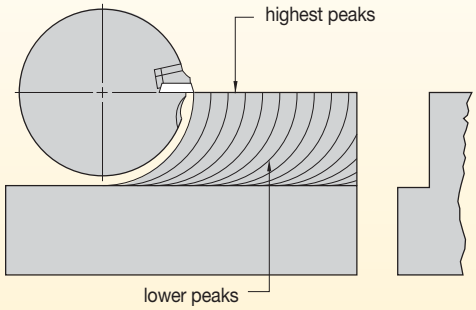


Figure 3: Ra finish is higher at the widest feed marks.

Both finish and flatness are affected by feed marks. A taper will be produced from the high peaks down to the low peaks.

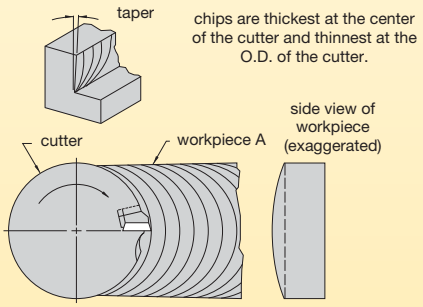


Figure 4: A taper is produced from the high peaks to the low ones.

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.

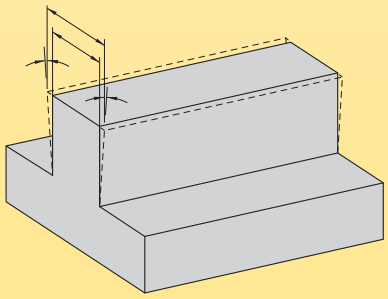


Figure 5: Flatness affects part tolerance more when milling both sides of a part.

(continued)

(continued)

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 3.2 (100) 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 .001–.0015" (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.

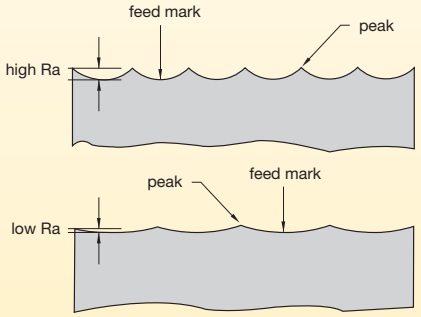


Figure 6: Peaks produced with a standard radii insert (top) compared to those produced with a large radius wiper insert (bottom).

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 burrs 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 .001–.0015" (0,025–0,04mm) above highest insert.
chatter	Check rigidity of machine and table fixturing. Check arbor and spindle, adjust feed rates, adjust RPM, or reduce cut width. Consider cutter with fewer pockets.

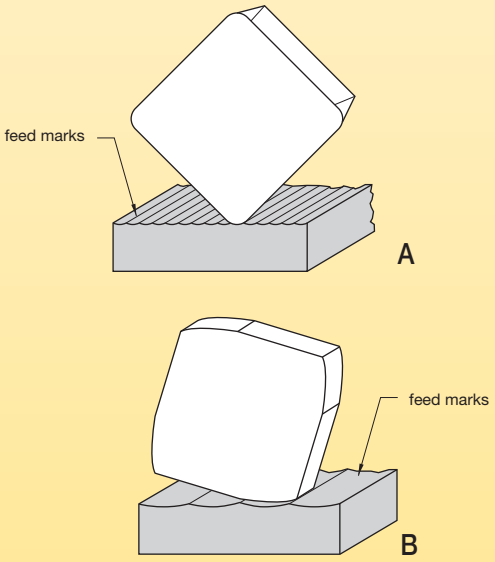


Figure 7: Feed marks produced with a nose radius insert (A) compared to marks produced with a wiper insert (B).

(continued)

(continued)

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.

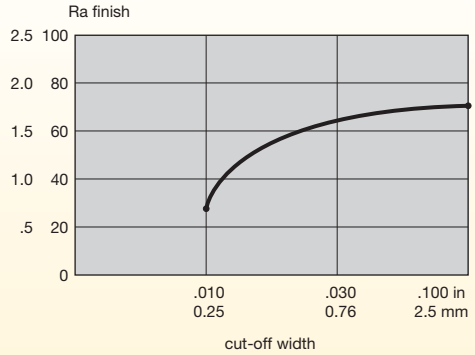


Figure 10: Finish quality is directly proportional to the cut-off width.

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 .010" (0,25mm) cut-off width will produce a .6 (25) Ra finish; whereas, a .100" (0,76mm) cut-off width will produce a 2.0 (75) Ra finish.

Also, figure 10 demonstrates that most measuring devices are provided with .010" (0,25mm), .030" (0,76mm), and .100" (2,54mm) cut-offs. In most cases, the .030" (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.

Preferred Method

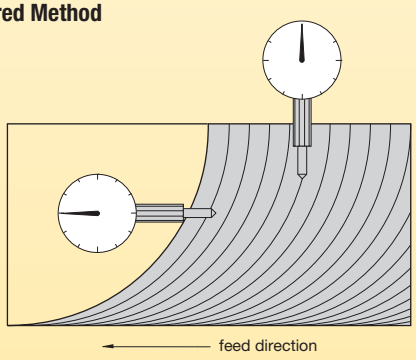


Figure 8: Measuring surface finish

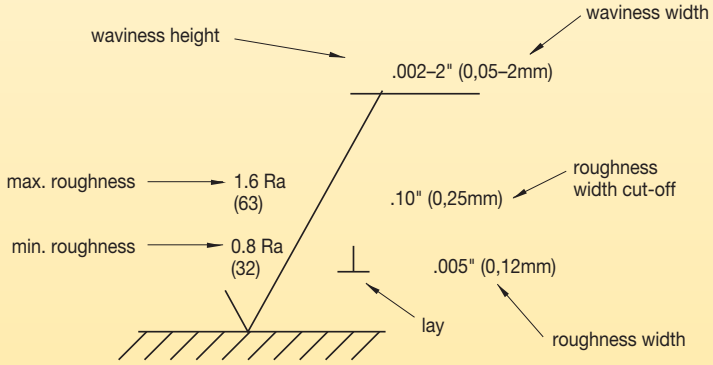


Figure 11: Standard surface symbols

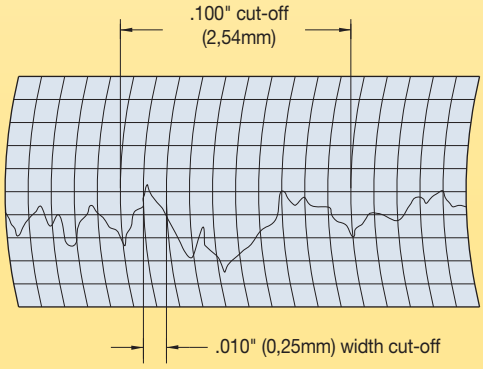


Figure 9: Increasing the cut-off width creates a variation in roughness.

Troubleshooting Introduction

Troubleshooting should be performed in a sequential method to identify and solve your milling problems. These problems can be recognized 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/adapter
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.

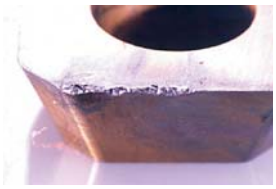
Edge Condition Problems and Solutions

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.

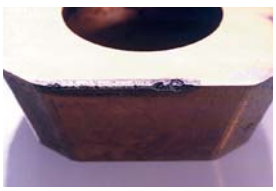
Chipping can also be caused by recutting of chips. A good example of this would be a slotting operation where chip clearance or chip gullet space does not allow the chips to evacuate cleanly. In this instance, packing of the chips also occurs.

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° (0°) 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 localized 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.

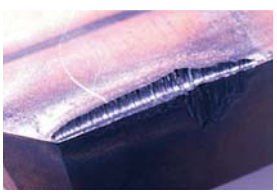
problem	cause	solution
built-up edge 	• speed	• Increase SFM.
	• feed	• Increase feed per tooth.
	• coolant	• Use mist or flood coolant to avoid chips sticking to the insert when machining stainless steel and aluminum alloys.
	• grade	• Use sharp edge PVD inserts.
		• Higher speeds require diamond-tipped 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.

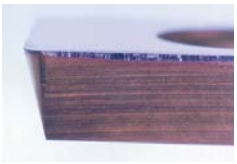
Crater wear is rarely encountered in milling, but can appear when machining certain steel and cast iron alloys. If crater wear becomes severe, there is a risk that the cutting edge will break, destroying the insert.

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 .015–.020" (0,38–0,50mm). For finish applications, inserts should be indexed once flank wear reaches 0.01–0.015" (0,25–0,38mm), if not sooner.

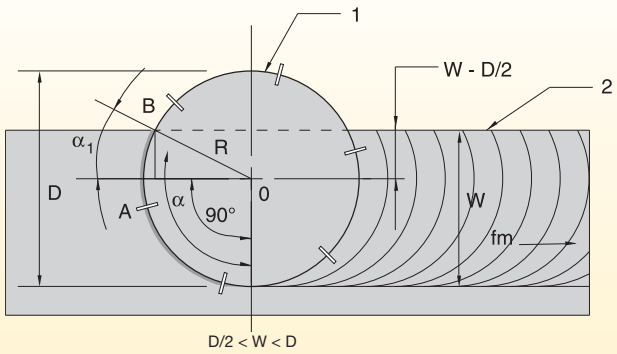
problem	cause	solution
flank wear 	• speed	• Check this area first. Recalculate SFM (Vc) to assure correctness. • Speed should be reduced without changing feed per tooth.
	• feed	• Increase feed per tooth (feed should be high enough to avoid the pure rubbing, which occurs with small chip thickness).
	• 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 arbor 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

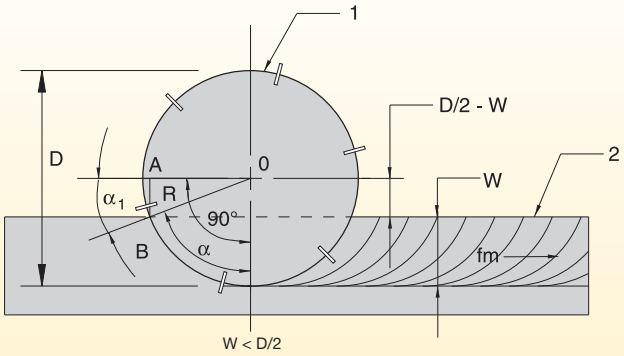


$$Z_c = \frac{Z \times \alpha^\circ}{360^\circ} \qquad \alpha = 90^\circ + \alpha_1$$

$$\sin \alpha_1 = \frac{AB}{OB} = \frac{W - D/2}{D/2} = \frac{2(W - D/2)}{D} = \frac{2W - D}{D};$$

$$\alpha_1 = \arcsin \frac{2W - D}{D};$$

$$Z_c = \frac{Z\left(90^\circ + \arcsin \frac{2W - D}{D}\right)}{360^\circ}$$



$$Z_c = \frac{Z \times \alpha^\circ}{360^\circ} \qquad \alpha = 90^\circ - \alpha_1$$

$$\sin \alpha_1 = \frac{AB}{OB} = \frac{D/2 - W}{D/2} = \frac{2(D/2 - W)}{D} = \frac{D - 2W}{D};$$

$$\alpha_1 = \arcsin \frac{D - 2W}{D}$$

$$Z_c = \frac{Z\left(90^\circ - \arcsin \frac{D - 2W}{D}\right)}{360^\circ}$$

D = cutter diameter
W = width of cut (woc)
α = engagement angle
α_1 = angle between cutter centerline 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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Numbers shown only serve the originating country listed.

Inch • Face Milling, Contour Milling, Profiling, and Die & Mold

Material Group		GH1			GH2			K110M			K115M			K313			KBK50			KC410M*		
P	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
M	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
K	1	1150	**855**	525	985	**720**	475	510	**475**	460	720	**590**	475	755	**675**	590	3935	**2625**	1970	–	–	–
	2	970	**720**	475	855	**625**	410	460	**410**	395	590	**475**	360	–	–	–	3935	**2625**	1970	–	–	–
	3	785	**625**	460	720	**575**	395	395	**360**	310	360	**295**	230	–	–	–	3935	**2625**	1970	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KC422M*			KC505M			KC510M			KC515M			KC520M			KC522M			KC524M		
P	1	–	–	–	–	–	–	–	–	–	1085	**970**	855	–	–	–	1295	**1115**	1065	–	–	–
	2	–	–	–	–	–	–	–	–	–	1015	**900**	785	–	–	–	1085	**950**	785	–	–	–
	3	–	–	–	–	–	–	–	–	–	900	**785**	675	–	–	–	1000	**855**	690	–	–	–
	4	–	–	–	1180	**870**	705	970	**785**	675	785	**675**	525	–	–	–	885	**720**	590	–	–	–
	5	–	–	–	1180	**870**	705	–	–	–	675	**525**	410	–	–	–	720	**675**	590	–	–	–
	6	–	–	–	1150	**785**	625	–	–	–	525	**410**	360	–	–	–	655	**490**	395	–	–	–
M	1	–	–	–	–	–	–	–	–	–	1085	**900**	785	–	–	–	805	**705**	655	–	–	–
	2	–	–	–	–	–	–	–	–	–	900	**720**	525	–	–	–	720	**625**	510	–	–	–
	3	–	–	–	–	–	–	–	–	–	720	**590**	475	–	–	–	560	**475**	375	–	–	–
K	1	–	–	–	755	**675**	590	1165	**1050**	950	1445	**1085**	720	1065	**970**	855	900	**805**	720	1475	**1050**	755
	2	–	–	–	690	**605**	525	900	**805**	755	1085	**855**	590	820	**755**	690	705	**625**	590	1280	**805**	625
	3	–	–	–	460	**375**	295	770	**690**	625	475	**360**	230	690	**625**	575	590	**525**	475	985	**720**	510
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	870	**675**	560	625	**510**	360	560	**395**	310	–	–	–	475	**360**	280	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Technical Information

*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)

Inch • Face Milling, Contour Milling, Profiling, and Die & Mold

Material Group		KC525M			KC530M			KC725M			KC735M			KCK15			KCK20			KCPK30		
P	1	870	**785**	705	900	**785**	675	1015	**900**	855	510	**475**	395	–	–	–	–	–	–	1790	**1560**	1460
	2	705	**625**	590	785	**675**	525	870	**755**	625	475	**425**	410	–	–	–	–	–	–	1100	**1000**	900
	3	625	**590**	560	675	**590**	525	785	**675**	560	425	**395**	360	–	–	–	–	–	–	1000	**900**	805
	4	560	**510**	475	590	**525**	475	705	**590**	475	395	**360**	310	–	–	–	–	–	–	755	**690**	625
	5	590	**560**	510	525	**475**	410	590	**525**	475	360	**310**	295	–	–	–	–	–	–	1015	**900**	820
	6	510	**475**	425	410	**360**	295	510	**395**	310	310	**295**	280	–	–	–	–	–	–	625	**525**	–
M	1	590	**560**	510	900	**720**	590	675	**590**	525	410	**360**	310	–	–	–	–	–	–	805	**720**	605
	2	510	**475**	425	590	**475**	410	605	**510**	425	375	**330**	295	–	–	–	–	–	–	720	**625**	560
	3	360	**310**	280	475	**410**	360	460	**395**	310	280	**230**	–	–	–	–	–	–	–	575	**510**	460
K	1	–	–	–	–	–	–	–	–	–	–	–	–	1655	**1510**	1345	1150	**1000**	855	1165	**1050**	950
	2	–	–	–	–	–	–	–	–	–	–	–	–	1310	**1165**	1085	900	**785**	690	920	**820**	755
	3	–	–	–	–	–	–	–	–	–	–	–	–	1100	**985**	900	755	**675**	575	770	**690**	625
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KCPM40			KCSM30			KCSM40			KD1400*			KD1410*			KD1415*			KD1425*		
P	1	1165	**1015**	970	1460	**1265**	1180	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	985	**855**	705	1200	**1065**	870	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	900	**770**	625	1115	**950**	770	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	805	**675**	525	985	**805**	655	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	5	675	**605**	525	805	**755**	655	675	**575**	475	–	–	–	–	–	–	–	–	–	–	–	–
	6	590	**460**	360	720	**560**	425	590	**425**	310	–	–	–	–	–	–	–	–	–	–	–	–
M	1	770	**675**	605	885	**785**	720	820	**675**	560	–	–	–	–	–	–	–	–	–	–	–	–
	2	690	**590**	490	805	**705**	575	705	**575**	475	–	–	–	–	–	–	–	–	–	–	–	–
	3	510	**460**	360	605	**525**	410	575	**425**	330	–	–	–	–	–	–	–	–	–	–	–	–
K	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	525	**395**	295	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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)

Inch • Face Milling, Contour Milling, Profiling, and Die & Mold

Material Group		KTPK20			KY3500			KYS30			KYSP30			MP91M			SC3025			SC6525		
P	1	1445	**1180**	1000	–	–	–	–	–	–	–	–	–	1360	**970**	560	–	–	–	1460	**1000**	560
	2	885	**755**	625	–	–	–	–	–	–	–	–	–	1200	**855**	475	–	–	–	1280	**885**	475
	3	805	**675**	575	–	–	–	–	–	–	–	–	–	1065	**755**	410	–	–	–	1150	**785**	410
	4	590	**510**	425	–	–	–	–	–	–	–	–	–	805	**575**	310	–	–	–	820	**575**	310
	5	820	**690**	575	–	–	–	2985	**2395**	1790	2985	**2395**	1790	–	–	–	–	–	–	625	**475**	310
	6	510	**410**	–	–	–	–	2985	**2395**	1790	2985	**2395**	1790	–	–	–	–	–	–	560	**395**	230
M	1	950	**770**	655	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	785	**705**	560
	2	855	**720**	590	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	755	**625**	475
	3	625	**525**	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	575	**510**	360
K	1	900	**770**	625	3165	**2870**	2560	–	–	–	–	–	–	1445	**1000**	575	1560	**1085**	590	1540	**1065**	575
	2	720	**590**	510	2495	**2245**	2085	–	–	–	–	–	–	1115	**785**	460	1310	**900**	475	1200	**820**	460
	3	590	**510**	410	–	–	–	–	–	–	–	–	–	1015	**720**	410	1085	**755**	410	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	2640	**2165**	1675	2640	**2165**	1675	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	2640	**2165**	1675	2640	**2165**	1675	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	3840	**3135**	2395	3840	**3135**	2395	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	410	**310**	195	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	375	**280**	165	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		SP4019			SP6519			X400			X500			X700		
P	1	1245	**900**	560	1165	**855**	510	1015	**755**	475	1065	**785**	510	–	–	–
	2	1085	**785**	475	1015	**755**	460	900	**675**	410	950	**705**	460	–	–	–
	3	970	**690**	410	900	**655**	395	785	**590**	375	820	**605**	395	–	–	–
	4	755	**525**	310	690	**490**	295	590	**425**	280	625	**475**	295	–	–	–
	5	590	**425**	280	560	**410**	280	–	–	–	510	**395**	280	525	**410**	280
	6	510	**360**	195	475	**330**	195	–	–	–	425	**310**	195	460	**330**	195
M	1	1100	**785**	475	1065	**770**	460	–	–	–	985	**720**	460	1015	**755**	460
	2	985	**705**	425	920	**675**	410	–	–	–	870	**625**	395	900	**675**	410
	3	785	**575**	360	770	**560**	330	–	–	–	705	**510**	310	755	**560**	330
K	1	1295	**950**	575	1165	**870**	560	–	–	–	1015	**870**	675	–	–	–
	2	1000	**720**	460	950	**690**	425	–	–	–	870	**705**	510	–	–	–
	3	920	**675**	410	870	**625**	395	–	–	–	675	**560**	395	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	395	**295**	195	–	–	–	375	**280**	180	–	–	–	–	–	–
	2	360	**260**	165	–	–	–	310	**230**	130	–	–	–	–	–	–
	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

Inch • 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	950	**705**	445	820	**605**	395	425	**395**	375	605	**490**	395	625	**560**	490	3280	**2180**	1640	–	–	–
	2	805	**605**	395	705	**525**	345	375	**345**	330	490	**395**	295	–	–	–	3280	**2180**	1640	–	–	–
	3	655	**525**	375	605	**475**	330	330	**295**	260	295	**245**	195	–	–	–	3280	**2180**	1640	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KC422M*			KC505M			KC510M			KC515M			KC520M			KC522M			KC524M		
P	1	–	–	–	–	–	–	–	–	–	900	**805**	705	–	–	–	1085	**935**	885	–	–	–
	2	–	–	–	–	–	–	–	–	–	855	**755**	655	–	–	–	900	**785**	655	–	–	–
	3	–	–	–	–	–	–	–	–	–	755	**655**	560	–	–	–	835	**705**	575	–	–	–
	4	–	–	–	985	**720**	590	805	**655**	560	655	**560**	445	–	–	–	740	**605**	490	–	–	–
	5	–	–	–	985	**720**	590	–	–	–	560	**445**	345	–	–	–	605	**560**	490	–	–	–
	6	–	–	–	950	**655**	525	–	–	–	445	**345**	295	–	–	–	540	**410**	330	–	–	–
M	1	–	–	–	–	–	–	–	–	–	900	**755**	655	–	–	–	675	**590**	540	–	–	–
	2	–	–	–	–	–	–	–	–	–	755	**605**	445	–	–	–	605	**525**	425	–	–	–
	3	–	–	–	–	–	–	–	–	–	605	**490**	395	–	–	–	460	**395**	310	–	–	–
K	1	–	–	–	625	**560**	490	970	**870**	785	1200	**900**	605	885	**805**	705	755	**675**	605	1230	**870**	625
	2	–	–	–	575	**510**	445	755	**675**	625	900	**705**	490	690	**625**	575	590	**525**	490	1065	**675**	525
	3	–	–	–	375	**310**	245	640	**575**	525	395	**295**	195	575	**525**	475	490	**445**	395	820	**605**	425
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	720	**560**	460	525	**425**	295	460	**330**	260	–	–	–	395	**295**	230	–	–	–
	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)

Inch • Shoulder Milling, Slotting, and Thread Mills

Material Group		KC525M			KC530M			KC725M			KC735M			KCK15			KCK20			KCPK30		
P	1	720	**655**	590	755	**655**	560	855	**755**	705	425	**395**	330	–	–	–	–	–	–	1495	**1295**	1215
	2	590	**525**	490	655	**560**	445	720	**625**	525	395	**360**	345	–	–	–	–	–	–	920	**835**	755
	3	525	**490**	460	560	**490**	445	655	**560**	460	360	**330**	295	–	–	–	–	–	–	835	**755**	675
	4	460	**425**	395	490	**445**	395	590	**490**	395	330	**295**	260	–	–	–	–	–	–	625	**575**	525
	5	490	**460**	425	445	**395**	345	490	**445**	395	295	**260**	245	–	–	–	–	–	–	855	**755**	690
	6	425	**395**	360	345	**295**	245	425	**330**	260	260	**245**	230	–	–	–	–	–	–	525	**445**	–
M	1	490	**460**	425	755	**605**	490	560	**490**	445	345	**295**	260	–	–	–	–	–	–	675	**605**	510
	2	425	**395**	360	490	**395**	345	510	**425**	360	310	**280**	245	–	–	–	–	–	–	605	**525**	460
	3	295	**260**	230	395	**345**	295	375	**330**	260	230	**195**	–	–	–	–	–	–	–	475	**425**	375
K	1	–	–	–	–	–	–	–	–	–	–	–	–	1380	**1265**	1115	950	**835**	705	970	**870**	785
	2	–	–	–	–	–	–	–	–	–	–	–	–	1100	**970**	900	755	**655**	575	770	**690**	625
	3	–	–	–	–	–	–	–	–	–	–	–	–	920	**820**	755	625	**560**	475	640	**575**	525
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KCPM40			KCSM30			KCSM40			KD1400*			KD1410*			KD1415*			KD1425*		
P	1	970	**855**	805	1215	**1050**	985	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	820	**705**	590	1000	**885**	720	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	755	**640**	525	935	**785**	640	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	675	**560**	445	820	**675**	540	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	5	560	**510**	445	675	**625**	540	560	**475**	395	–	–	–	–	–	–	–	–	–	–	–	–
	6	490	**375**	295	605	**460**	360	490	**360**	260	–	–	–	–	–	–	–	–	–	–	–	–
M	1	640	**560**	510	740	**655**	605	690	**560**	460	–	–	–	–	–	–	–	–	–	–	–	–
	2	575	**490**	410	675	**590**	475	590	**475**	395	–	–	–	–	–	–	–	–	–	–	–	–
	3	425	**375**	295	510	**445**	345	475	**360**	280	–	–	–	–	–	–	–	–	–	–	–	–
K	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	445	**330**	245	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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)

Inch • Shoulder Milling, Slotting, and Thread Mills

Material Group		KTPK20			KY3500			KYS30			KYSP30			MP91M			SC3025			SC6525		
P	1	1200	**985**	835	–	–	–	–	–	–	–	–	–	1130	**805**	460	–	–	–	1215	**835**	460
	2	740	**625**	525	–	–	–	–	–	–	–	–	–	1000	**705**	395	–	–	–	1065	**740**	395
	3	675	**560**	475	–	–	–	–	–	–	–	–	–	885	**625**	345	–	–	–	950	**655**	345
	4	490	**425**	360	–	–	–	–	–	–	–	–	–	675	**475**	260	–	–	–	690	**475**	260
	5	690	**575**	475	–	–	–	2495	**2000**	1495	2495	**2000**	1495	–	–	–	–	–	–	525	**395**	260
	6	425	**345**	–	–	–	–	2495	**2000**	1495	2495	**2000**	1495	–	–	–	–	–	–	460	**330**	195
M	1	785	**640**	540	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	655	**590**	460
	2	705	**605**	490	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	625	**525**	395
	3	525	**445**	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	475	**425**	295
K	1	755	**640**	525	2640	**2395**	2135	–	–	–	–	–	–	1200	**835**	475	1295	**900**	490	1280	**885**	475
	2	605	**490**	425	2085	**1870**	1740	–	–	–	–	–	–	935	**655**	375	1100	**755**	395	1000	**690**	375
	3	490	**425**	345	–	–	–	–	–	–	–	–	–	855	**605**	345	900	**625**	345	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	2200	**1805**	1395	2200	**1805**	1395	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	2200	**1805**	1395	2200	**1805**	1395	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	3200	**2610**	2000	3200	**2610**	2000	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	345	**260**	165	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	310	**230**	130	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		SP4019			SP6519			X400			X500			X700		
P	1	1035	**755**	460	970	**705**	425	855	**625**	395	885	**655**	425	–	–	–
	2	900	**655**	395	855	**625**	375	755	**560**	345	785	**590**	375	–	–	–
	3	805	**575**	345	755	**540**	330	655	**490**	310	690	**510**	330	–	–	–
	4	625	**445**	260	575	**410**	245	490	**360**	230	525	**395**	245	–	–	–
	5	490	**360**	230	460	**345**	230	–	–	–	425	**330**	230	445	**345**	230
	6	425	**295**	165	395	**280**	165	–	–	–	360	**260**	165	375	**280**	165
M	1	920	**655**	395	885	**640**	375	–	–	–	820	**605**	375	855	**625**	375
	2	820	**590**	360	770	**560**	345	–	–	–	720	**525**	330	755	**560**	345
	3	655	**475**	295	640	**460**	280	–	–	–	590	**425**	260	625	**460**	280
K	1	1085	**785**	475	970	**720**	460	–	–	–	855	**720**	560	–	–	–
	2	835	**605**	375	785	**575**	360	–	–	–	720	**590**	425	–	–	–
	3	770	**560**	345	720	**525**	330	–	–	–	560	**460**	330	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
H	1	330	**245**	165	–	–	–	310	**230**	150	–	–	–	–	–	–
	2	295	**215**	130	–	–	–	260	**195**	115	–	–	–	–	–	–
	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

Inch • Face Milling, Contour Milling, Profiling, and Die & Mold

Material Group		GH1			GH2			K110M			K115M			K313			KBK50 *			KC410M		
P	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
M	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
K	1	920	**685**	420	790	**575**	380	410	**380**	370	575	**470**	380	605	**540**	470	3150	**2100**	1575	–	–	–
	2	775	**575**	380	685	**500**	330	370	**330**	315	470	**380**	290	–	–	–	3150	**2100**	1575	–	–	–
	3	630	**500**	370	575	**460**	315	315	**290**	250	290	**235**	185	–	–	–	3150	**2100**	1575	–	–	–
N	1	3780	**2940**	1260	3780	**2980**	1260	1590	**1495**	1415	1155	**870**	575	2510	**2190**	1890	–	–	–	3830	**3400**	3135
	2	3780	**2940**	1260	3780	**2980**	1260	1290	**1155**	1010	775	**575**	470	–	–	–	–	–	–	3400	**3135**	2890
	3	2785	**2585**	930	2785	**2295**	930	1290	**1155**	1010	775	**575**	470	–	–	–	–	–	–	3400	**3135**	2890
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	235	**185**	145	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KC422M			KC505M			KC510M			KC515M			KC520M			KC522M			KC524M		
P	1	–	–	–	–	–	–	–	–	–	870	**775**	685	–	–	–	1035	**890**	850	–	–	–
	2	–	–	–	–	–	–	–	–	–	810	**720**	630	–	–	–	870	**760**	630	–	–	–
	3	–	–	–	–	–	–	–	–	–	720	**630**	540	–	–	–	800	**685**	550	–	–	–
	4	–	–	–	945	**695**	565	775	**630**	540	630	**540**	420	–	–	–	710	**575**	470	–	–	–
	5	–	–	–	945	**695**	565	–	–	–	540	**420**	330	–	–	–	575	**540**	470	–	–	–
	6	–	–	–	920	**630**	500	–	–	–	420	**330**	290	–	–	–	525	**390**	315	–	–	–
M	1	–	–	–	–	–	–	–	–	–	870	**720**	630	–	–	–	645	**565**	525	–	–	–
	2	–	–	–	–	–	–	–	–	–	720	**575**	420	–	–	–	575	**500**	410	–	–	–
	3	–	–	–	–	–	–	–	–	–	575	**470**	380	–	–	–	450	**380**	300	–	–	–
K	1	–	–	–	605	**540**	470	930	**840**	760	1155	**870**	575	850	**775**	685	720	**645**	575	1180	**840**	605
	2	–	–	–	550	**485**	420	720	**645**	605	870	**685**	470	655	**605**	550	565	**500**	470	1025	**645**	500
	3	–	–	–	370	**300**	235	615	**550**	500	380	**290**	185	550	**500**	460	470	**420**	380	790	**575**	410
N	1	3385	**2980**	2755	–	–	–	2020	**1795**	1650	–	–	–	–	–	–	–	–	–	–	–	–
	2	2980	**2755**	2390	–	–	–	1825	**1680**	1550	–	–	–	–	–	–	–	–	–	–	–	–
	3	2980	**2755**	2390	–	–	–	1825	**1680**	1550	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	130	**105**	80	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	130	**105**	80	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	155	**130**	80	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	225	**155**	105	–	–	–
H	1	–	–	–	695	**540**	450	500	**410**	290	450	**315**	250	–	–	–	380	**290**	225	–	–	–
	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)

Inch • Face Milling, Contour Milling, Profiling, and Die & Mold

Material Group		KC525M			KC530M			KC725M			KC735M			KCK15			KCK20			KCPK30		
P	1	695	**630**	565	720	**630**	540	810	**720**	685	410	**380**	315	–	–	–	–	–	–	1430	**1250**	1170
	2	565	**500**	470	630	**540**	420	695	**605**	500	380	**340**	330	–	–	–	–	–	–	880	**800**	720
	3	500	**470**	450	540	**470**	420	630	**540**	450	340	**315**	290	–	–	–	–	–	–	800	**720**	645
	4	450	**410**	380	470	**420**	380	565	**470**	380	315	**290**	250	–	–	–	–	–	–	605	**550**	500
	5	470	**450**	410	420	**380**	330	470	**420**	380	290	**250**	235	–	–	–	–	–	–	810	**720**	655
	6	410	**380**	340	330	**290**	235	410	**315**	250	250	**235**	225	–	–	–	–	–	–	500	**420**	–
M	1	470	**450**	410	720	**575**	470	540	**470**	420	330	**290**	250	–	–	–	–	–	–	645	**575**	485
	2	410	**380**	340	470	**380**	330	485	**410**	340	300	**265**	235	–	–	–	–	–	–	575	**500**	450
	3	290	**250**	225	380	**330**	290	370	**315**	250	225	**185**	–	–	–	–	–	–	–	460	**410**	370
K	1	–	–	–	–	–	–	–	–	–	–	–	–	1325	**1210**	1075	920	**800**	685	930	**840**	760
	2	–	–	–	–	–	–	–	–	–	–	–	–	1050	**930**	870	720	**630**	550	735	**655**	605
	3	–	–	–	–	–	–	–	–	–	–	–	–	880	**790**	720	605	**540**	460	615	**550**	500
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	185	**170**	155	–	–	–	105	**90**	80	–	–	–	–	–	–	–	–	–	–	–	–
	2	185	**170**	155	–	–	–	105	**90**	80	–	–	–	–	–	–	–	–	–	–	–	–
	3	155	**145**	130	–	–	–	145	**105**	80	–	–	–	–	–	–	–	–	–	–	–	–
	4	185	**155**	130	210	**155**	145	170	**145**	90	–	–	–	–	–	–	–	–	–	210	**155**	105
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KCPM40			KCSM30			KCSM40			KD1400			KD1410			KD1415			KD1425		
P	1	930	**810**	775	1170	**1010**	945	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	790	**685**	565	960	**850**	695	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	720	**615**	500	890	**760**	615	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	645	**540**	420	790	**645**	525	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	5	540	**485**	420	645	**605**	525	540	**460**	380	–	–	–	–	–	–	–	–	–	–	–	–
	6	470	**370**	290	575	**450**	340	470	**340**	250	–	–	–	–	–	–	–	–	–	–	–	–
M	1	615	**540**	485	710	**630**	575	655	**540**	450	–	–	–	–	–	–	–	–	–	–	–	–
	2	550	**470**	390	645	**565**	460	565	**460**	380	–	–	–	–	–	–	–	–	–	–	–	–
	3	410	**370**	290	485	**420**	330	460	**340**	265	–	–	–	–	–	–	–	–	–	–	–	–
K	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
N	1	–	–	–	–	–	–	–	–	–	2390	**5195**	12810	12625	**11035**	9425	12625	**11035**	9425	2390	**5195**	12810
	2	–	–	–	–	–	–	–	–	–	2390	**5195**	12810	5040	**4710**	4410	5040	**4710**	4410	2390	**5195**	12810
	3	–	–	–	–	–	–	–	–	–	1210	**1600**	1865	5040	**4710**	4410	5040	**4710**	4410	1210	**1600**	1865
S	1	130	**105**	90	145	**130**	90	130	**105**	80	–	–	–	–	–	–	–	–	–	–	–	–
	2	130	**105**	90	145	**130**	90	130	**105**	80	–	–	–	–	–	–	–	–	–	–	–	–
	3	155	**130**	90	170	**145**	90	155	**130**	80	–	–	–	–	–	–	–	–	–	–	–	–
	4	210	**155**	105	225	**185**	130	185	**155**	90	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	420	**315**	235	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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)

Inch • Face Milling, Contour Milling, Profiling, and Die & Mold

Material Group		KTPK20			KY3500			KYS30*			KYSP30*			SC3025			SC6525			SP4019		
P	1	1155	**945**	800	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	1170	**800**	450	995	**720**	450
	2	710	**605**	500	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	1025	**710**	380	870	**630**	380
	3	645	**540**	460	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	920	**630**	330	775	**550**	330
	4	470	**410**	340	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	655	**460**	250	605	**420**	250
	5	655	**550**	460	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	500	**380**	250	470	**340**	225
	6	410	**330**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	450	**315**	185	410	**290**	155
M	1	760	**615**	525	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	630	**565**	450	880	**630**	380
	2	685	**575**	470	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	605	**500**	380	790	**565**	340
	3	500	**420**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	460	**410**	290	630	**460**	290
K	1	720	**615**	500	2530	**2295**	2050	–	**–**	–	–	**–**	–	1250	**870**	470	1230	**850**	460	1035	**760**	460
	2	575	**470**	410	1995	**1795**	1670	–	**–**	–	–	**–**	–	1050	**720**	380	960	**655**	370	800	**575**	370
	3	470	**410**	330	–	**–**	–	–	**–**	–	–	**–**	–	870	**605**	330	–	**–**	–	735	**540**	330
N	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	9120	**5195**	1260
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	9120	**5195**	1260
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	7310	**4120**	930
S	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	195	**145**	80
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	155	**130**	80
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	185	**145**	80
	4	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	265	**185**	120
H	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	315	**235**	155
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	290	**210**	130
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–

Material Group		SP6519			X400			X500			X700		
P	1	930	**685**	410	810	**605**	380	850	**630**	410	–	**–**	–
	2	810	**605**	370	720	**540**	330	760	**565**	370	–	**–**	–
	3	720	**525**	315	630	**470**	300	655	**485**	315	–	**–**	–
	4	550	**390**	235	470	**340**	225	500	**380**	235	–	**–**	–
	5	450	**330**	225	–	**–**	–	410	**315**	225	420	**330**	225
	6	380	**265**	155	–	**–**	–	340	**250**	155	370	**265**	155
M	1	850	**615**	370	–	**–**	–	790	**575**	370	810	**605**	370
	2	735	**540**	330	–	**–**	–	695	**500**	315	720	**540**	330
	3	615	**450**	265	–	**–**	–	565	**410**	250	605	**450**	265
K	1	930	**695**	450	–	**–**	–	810	**695**	540	–	**–**	–
	2	760	**550**	340	–	**–**	–	695	**565**	410	–	**–**	–
	3	695	**500**	315	–	**–**	–	540	**450**	315	–	**–**	–
N	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
S	1	170	**130**	80	–	**–**	–	155	**105**	80	155	**130**	80
	2	155	**105**	65	–	**–**	–	145	**105**	65	145	**105**	65
	3	170	**130**	80	–	**–**	–	155	**130**	80	170	**130**	80
	4	250	**185**	120	–	**–**	–	235	**170**	105	235	**170**	120
H	1	–	**–**	–	300	**225**	145	–	**–**	–	–	**–**	–
	2	–	**–**	–	250	**185**	105	–	**–**	–	–	**–**	–
	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

Inch • 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	760	**565**	355	655	**485**	315	340	**315**	300	485	**390**	315	500	**450**	390	2625	**1745**	1310	–	–	–
	2	645	**485**	315	565	**420**	275	300	**275**	265	390	**315**	235	–	–	–	2625	**1745**	1310	–	–	–
	3	525	**420**	300	485	**380**	265	265	**235**	210	235	**195**	155	–	–	–	2625	**1745**	1310	–	–	–
N	1	3150	**2455**	1050	3150	**2480**	1050	1325	**1250**	1180	960	**720**	485	2090	**1825**	1575	–	–	–	3190	**2835**	2610
	2	3150	**2455**	1050	3150	**2480**	1050	1075	**960**	840	645	**485**	390	–	–	–	–	–	–	2835	**2610**	2400
	3	2325	**2150**	775	2325	**1915**	775	1075	**960**	840	645	**485**	390	–	–	–	–	–	–	2835	**2610**	2400
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	195	**155**	120	–	–	–	–	–	–	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KC422M			KC505M			KC510M			KC515M			KC520M			KC522M			KC524M		
P	1	–	–	–	–	–	–	–	–	–	720	**645**	565	–	–	–	870	**750**	710	–	–	–
	2	–	–	–	–	–	–	–	–	–	685	**605**	525	–	–	–	720	**630**	525	–	–	–
	3	–	–	–	–	–	–	–	–	–	605	**525**	450	–	–	–	670	**565**	460	–	–	–
	4	–	–	–	790	**575**	470	645	**525**	450	525	**450**	355	–	–	–	590	**485**	390	–	–	–
	5	–	–	–	790	**575**	470	–	–	–	450	**355**	275	–	–	–	485	**450**	390	–	–	–
	6	–	–	–	760	**525**	420	–	–	–	355	**275**	235	–	–	–	430	**330**	265	–	–	–
M	1	–	–	–	–	–	–	–	–	–	720	**605**	525	–	–	–	540	**470**	430	–	–	–
	2	–	–	–	–	–	–	–	–	–	605	**485**	355	–	–	–	485	**420**	340	–	–	–
	3	–	–	–	–	–	–	–	–	–	485	**390**	315	–	–	–	370	**315**	250	–	–	–
K	1	–	–	–	500	**450**	390	775	**695**	630	960	**720**	485	710	**645**	565	605	**540**	485	985	**695**	500
	2	–	–	–	460	**410**	355	605	**540**	500	720	**565**	390	550	**500**	460	470	**420**	390	850	**540**	420
	3	–	–	–	300	**250**	195	510	**460**	420	315	**235**	155	460	**420**	380	390	**355**	315	655	**485**	340
N	1	2820	**2480**	2295	–	–	–	1680	**1495**	1380	–	–	–	–	–	–	–	–	–	–	–	–
	2	2480	**2295**	1995	–	–	–	1525	**1405**	1290	–	–	–	–	–	–	–	–	–	–	–	–
	3	2480	**2295**	1995	–	–	–	1525	**1405**	1290	–	–	–	–	–	–	–	–	–	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	105	**90**	65	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	105	**90**	65	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	130	**105**	65	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	185	**130**	90	–	–	–
H	1	–	–	–	575	**450**	370	420	**340**	235	370	**265**	210	–	–	–	315	**235**	185	–	–	–
	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.

(continued)

Dry

Wet

(continued)

Inch • Shoulder and Slotting Cutters, Thread Mills

Material Group		KC525M			KC530M			KC725M			KC735M			KCK15			KCK20			KCPK30		
P	1	575	**525**	470	605	**525**	450	685	**605**	565	340	**315**	265	–	–	–	–	–	–	1195	**1035**	970
	2	470	**420**	390	525	**450**	355	575	**500**	420	315	**290**	275	–	–	–	–	–	–	735	**670**	605
	3	420	**390**	370	450	**390**	355	525	**450**	370	290	**265**	235	–	–	–	–	–	–	670	**605**	540
	4	370	**340**	315	390	**355**	315	470	**390**	315	265	**235**	210	–	–	–	–	–	–	500	**460**	420
	5	390	**370**	340	355	**315**	275	390	**355**	315	235	**210**	195	–	–	–	–	–	–	685	**605**	550
	6	340	**315**	290	275	**235**	195	340	**265**	210	210	**195**	185	–	–	–	–	–	–	420	**355**	–
M	1	390	**370**	340	605	**485**	390	450	**390**	355	275	**235**	210	–	–	–	–	–	–	540	**485**	410
	2	340	**315**	290	390	**315**	275	410	**340**	290	250	**225**	195	–	–	–	–	–	–	485	**420**	370
	3	235	**210**	185	315	**275**	235	300	**265**	210	185	**155**	–	–	–	–	–	–	–	380	**340**	300
K	1	–	–	–	–	–	–	–	–	–	–	–	–	1105	**1010**	890	760	**670**	565	775	**695**	630
	2	–	–	–	–	–	–	–	–	–	–	–	–	880	**775**	720	605	**525**	460	615	**550**	500
	3	–	–	–	–	–	–	–	–	–	–	–	–	735	**655**	605	500	**450**	380	510	**460**	420
N	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
S	1	155	**145**	130	–	–	–	90	**80**	65	–	–	–	–	–	–	–	–	–	–	–	–
	2	155	**145**	130	–	–	–	90	**80**	65	–	–	–	–	–	–	–	–	–	–	–	–
	3	130	**120**	105	–	–	–	120	**90**	65	–	–	–	–	–	–	–	–	–	–	–	–
	4	155	**130**	105	170	**130**	120	145	**120**	80	–	–	–	–	–	–	–	–	–	170	**130**	90
H	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KCPM40			KCSM30			KCSM40			KD1400			KD1410			KD1415			KD1425		
P	1	775	**685**	645	970	**840**	790	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	655	**565**	470	800	**710**	575	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	605	**510**	420	750	**630**	510	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	540	**450**	355	655	**540**	430	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	5	450	**410**	355	540	**500**	430	450	**380**	315	–	–	–	–	–	–	–	–	–	–	–	–
	6	390	**300**	235	485	**370**	290	390	**290**	210	–	–	–	–	–	–	–	–	–	–	–	–
M	1	510	**450**	410	590	**525**	485	550	**450**	370	–	–	–	–	–	–	–	–	–	–	–	–
	2	460	**390**	330	540	**470**	380	470	**380**	315	–	–	–	–	–	–	–	–	–	–	–	–
	3	340	**300**	235	410	**355**	275	380	**290**	225	–	–	–	–	–	–	–	–	–	–	–	–
K	1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
N	1	–	–	–	–	–	–	–	–	–	1995	**4330**	10670	10525	**9200**	7850	10525	**9200**	7850	1995	**4330**	10670
	2	–	–	–	–	–	–	–	–	–	1995	**4330**	10670	4200	**3925**	3675	4200	**3925**	3675	1995	**4330**	10670
	3	–	–	–	–	–	–	–	–	–	1010	**1340**	1550	4200	**3925**	3675	4200	**3925**	3675	1010	**1340**	1550
S	1	105	**90**	80	120	**105**	80	105	**90**	65	–	–	–	–	–	–	–	–	–	–	–	–
	2	105	**90**	80	120	**105**	80	105	**90**	65	–	–	–	–	–	–	–	–	–	–	–	–
	3	130	**105**	80	145	**120**	80	130	**105**	65	–	–	–	–	–	–	–	–	–	–	–	–
	4	170	**130**	90	185	**155**	105	155	**130**	80	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	355	**265**	195	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	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)

Inch • Shoulder and Slotting Cutters, Thread Mills

Material Group		KTPK20			KY3500 *			KYS30*			KYSP30*			SC3025			SC6525			SP4019		
P	1	960	**790**	670	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	970	**670**	370	830	**605**	370
	2	590	**500**	420	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	850	**590**	315	720	**525**	315
	3	540	**450**	380	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	760	**525**	275	645	**460**	275
	4	390	**340**	290	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	550	**380**	210	500	**355**	210
	5	550	**460**	380	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	420	**315**	210	390	**290**	185
	6	340	**275**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	370	**265**	155	340	**235**	130
M	1	630	**510**	430	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	525	**470**	370	735	**525**	315
	2	565	**485**	390	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	500	**420**	315	655	**470**	290
	3	420	**355**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	380	**340**	235	525	**380**	235
K	1	605	**510**	420	2110	**1915**	1710	–	**–**	–	–	**–**	–	1035	**720**	390	1025	**710**	380	870	**630**	380
	2	485	**390**	340	1670	**1495**	1390	–	**–**	–	–	**–**	–	880	**605**	315	800	**550**	300	670	**485**	300
	3	390	**340**	275	–	**–**	–	–	**–**	–	–	**–**	–	720	**500**	275	–	**–**	–	615	**450**	275
N	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	7600	**4330**	1050
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	7600	**4330**	1050
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	6090	**3440**	775
S	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	165	**120**	65
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	135	**105**	60
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	155	**120**	70
	4	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	220	**155**	95
H	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	265	**195**	130
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	235	**170**	105
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–

Material Group		SP6519			X400			X500			X700		
P	1	775	**565**	340	685	**500**	315	710	**525**	340	–	**–**	–
	2	685	**500**	300	605	**450**	275	630	**470**	300	–	**–**	–
	3	605	**430**	265	525	**390**	250	550	**410**	265	–	**–**	–
	4	460	**330**	195	390	**290**	185	420	**315**	195	–	**–**	–
	5	370	**275**	185	–	**–**	–	340	**265**	185	355	**275**	185
	6	315	**225**	130	–	**–**	–	290	**210**	130	300	**225**	130
M	1	710	**510**	300	–	**–**	–	655	**485**	300	685	**500**	300
	2	615	**450**	275	–	**–**	–	575	**420**	265	605	**450**	275
	3	510	**370**	225	–	**–**	–	470	**340**	210	500	**370**	225
K	1	775	**575**	370	–	**–**	–	685	**575**	450	–	**–**	–
	2	630	**460**	290	–	**–**	–	575	**470**	340	–	**–**	–
	3	575	**420**	265	–	**–**	–	450	**370**	265	–	**–**	–
N	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
S	1	145	**105**	60	–	**–**	–	125	**90**	60	135	**105**	60
	2	125	**90**	55	–	**–**	–	115	**90**	55	120	**90**	55
	3	145	**105**	65	–	**–**	–	130	**105**	65	140	**105**	65
	4	210	**155**	95	–	**–**	–	190	**145**	90	195	**145**	95
H	1	–	**–**	–	250	**185**	120	–	**–**	–	–	**–**	–
	2	–	**–**	–	210	**155**	90	–	**–**	–	–	**–**	–
	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

Inch • 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	900	**590**	425	1410	**1000**	720	1050	**690**	475	1050	**690**	475	920	**820**	755	3035	**2770**	2460
	2	705	**510**	360	1215	**785**	590	785	**575**	395	785	**575**	395	755	**675**	590	2395	**2165**	2000
	3	590	**425**	360	950	**705**	510	690	**475**	375	690	**475**	375	605	**560**	510	–	–	–
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.

(continued)

Dry

Wet

Inch • 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	720	**470**	340	1130	**800**	575	840	**550**	380	840	**550**	380	735	**655**	605	–	**–**	–
	2	565	**410**	290	970	**630**	470	630	**460**	315	630	**460**	315	605	**540**	470	–	**–**	–
	3	470	**340**	290	760	**565**	410	550	**380**	300	550	**380**	300	485	**450**	410	–	**–**	–
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

Inch • High Speed Cutting • Face Milling, Round Insert, Profiling, Chamfer, and Die & Mold

Material Group		GH1			GH2		
P	1	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–
	5	–	**–**	–	–	**–**	–
	6	–	**–**	–	–	**–**	–
M	1	–	–	–	–	–	–
	2	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–
K	1	920	**685**	420	790	**575**	380
	2	775	**575**	380	685	**500**	330
	3	630	**500**	370	575	**460**	315
N	1	9610	**5430**	1260	8650	**4960**	1260
	2	9610	**5430**	1260	8650	**4960**	1260
	3	7690	**4315**	930	6720	**3830**	930
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.

(continued)

Dry

Wet

Inch • 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	760	**565**	355	655	**485**	315
	2	645	**485**	315	565	**420**	275
	3	525	**420**	300	485	**380**	265
N	1	8005	**4530**	1050	7205	**4135**	1050
	2	8005	**4530**	1050	7205	**4135**	1050
	3	6405	**3595**	775	5605	**3190**	775
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.	Catalog No.	Page(s)
1015658	SUWTCR	E64
1015659	SUWTCL	E64
1015684	NUWTC	E65
1015687	FUWTCR	E63
1015688	FUWTCL	E63
1015689	NUFRR	E64
1015690	NUFRL	E64
1015723	HUWTCR	E63
1015754	HUWTCL	E63
1016432	MCLNL164C	B63
1016454	MDJNR204D	B89
1016456	A16TMCLNR4	B71
1016462	NSR163D	C182, D27
1016474	NSR245D	C182, D27
1016544	SM837 K9	B186, B397
1016582	SM449 K9	T113
1016596	SM414 K9	E40, E48–49
1016598	SM432 K9	B372–373
1016602	SKTP343 K9	B259–260
1016624	SKCP343 K9	B193–196
1016626	SKDP343 K9	B227–229
1016628	SKCP453 K9	B194
1016644	IWSN433 K9	B163
1016646	SMRN42B K9	B170, B385
1016648	ITSN323 K9	B131–135, B137, B139, B143
1016650	ITSN636 K9	B134, B137
1016652	ISSN322 K9	B111, B113
1016674	ISSN433 K9	B109, B111–113, B120
1016678	ICSN433 K9	B58–65, B67–71, B75–76
1016682	IDSN443 K9	B87–93, B96
1016694	IDSN533 K9	B89–90
1016700	SM26 K9	B375
1016724	SM36 K9	B172–173, B376–378
1016726	SM37 K9	B179–184, B188, B378–382, B389–390, B393
1016728	SM40 K9	B172–173, B376–378
1016730	SM41 K9	B179–184, B188, B378–382, B389–390, B393
1016746	SM45 K9	B373
1016748	SM46 K9	B373
1016750	SM47 K9	B374
1016752	SM48 K9	B375
1016820	SM119 K9	B179, B181–182, B378, B381–382
1016822	SM120 K9	B172, B376
1016922	SM216 K9	B375
1016944	SM218 K9	B373
1016950	SM271 K9	E41, E45
1016952	SM272 K9	E41
1016964	SM285 K9	E41–42, E44–46
1016966	SM286 K9	E41–42, E44–46
1017084	SM369 K9	B165, B376, B389
1017166	SM396 K9	B372
1017168	SM412 K9	E43, E47, E49
1017170	SM417 K9	B210–211
1017172	SM420 K9	C184, D28
1017174	SMYE3 K9	D71–72, D74–75, D77–79
1017176	SMYI3 K9	D71, D74–79
1017178	SMYE4 K9	D71–72, D74, D77–78
1017180	SMYI4 K9	D71, D74–79
1017182	SMRN63B K9	B170, B385
1017214	SMRN84B K9	B170, B385
1017220	ITSN322 K9	B140–142
1017222	ISSN332 K9	B113
1017224	IRSN33 K9	B98
1017226	IVSN322 K9	B150–155
1017228	SKVN343 K9	B282
1017230	IDSN432 K9	B94–95
1017246	IRSN43 K9	B98
1017248	IRSN44 K9	B98–99, B371
1017252	ICSN432 K9	B72–74
1017274	ICSN442 K9	B66, B371
1017276	ITSN433 K9	B132–143
1017278	ISSN432 K9	B115–117, B119
1017282	IVSN432 K9	B150–151
1017294	ITSN534 K9	B133–137
1017296	ISSN533 K9	B111–113
1017298	ICSN533 K9	B61–65, B67–69, B71, B74–76
1017300	ISSN633 K9	B111–115, B119–120
1017302	IRSN63 K9	B98
1017334	ICSN633 K9	B59, B61–65, B68, B71, B74–76
1018325	CK6	B63, B71, B98, B111, B113, B132–137, B163, B373
1018327	CK7	B69, B76, B89–90, B93, B96, B133, B139, B143, B165, B172, B183–185, B376, B389–390, B392
1018329	CK9	B62, B65, B98, B111–114, B132–139, B143, B172–173, B179, B181–184, B374–382, B389–390
1018331	CK10	B172–173, B179, B181–184, B188, B374–382, B389–390, B393
1018333	CK7LP	B170, B388, B392–393
1018345	CK12	B61–65, B69, B71, B75–76, B89–90, B93, B96, B98, B111–112, B114, B120, B133–134, B137, B165, B373, B376
1018347	CK13	B165, B180, B376, B379–380
1018349	CK19	B132, B135–136, B179, B181–185, B378, B381–382, B389–390, B392
1018351	CK20	B60–64, B69–71, B75–76, B89–90, B163, B165, B183–185, B372–374, B389–390, B392
1018353	CK21	B61, B66, B69, B98–99, B120, B371–372
1018365	CK22	B92, B96, B155, B165, B389
1018367	CK23	B89–90, B180, B379–380
1018369	CK24	B63–64, B98, B111–112
1018373	CK27	B183–185, B388–390, B392
1018395	CK28	B374
1018397	CK29	B172, B376
1018401	CK43	B152–155
1018407	CM105	E45
1018409	CM106	E44–45
1018413	CM109	C190, D36–37
1018447	CM111	E46
1018449	CM112	E46
1018525	CM66	E41, E45
1018527	CM68	E41–42, E44–46
1018529	CM71	E41, E44–45
1018531	CM-72	C193, D31–33, D36, D39
1018533	CM73	C193, D31–33, D36, D39
1018567	CM79	E41, E44–46
1018569	CM80	C182, C187, C191, D26–27, D32, D35
1018571	CM81	C182, C187, D26–27, D32
1018647	MW25	U28–29, V148–149
1018649	MW3	U35–37
1019380	STC4	B61–65, B69, B71, B75–76, B89–90, B93, B96, B98, B111–114, B120, B132–139, B143, B152–155, B165, B172–173, B179–184, B188, B373–382, B389–390, B393
1019382	STC5	B63, B71, B89–90, B93, B96, B98, B111, B113, B132–137, B163, B172, B179, B373, B376, B378
1019388	STC8	B165, B172–173, B179–184, B188, B376–382, B389–390, B393
1019390	STC9	B69, B76, B132–133, B135–136, B139, B143, B165, B170, B179, B181–185, B376, B378, B381–382, B388–390, B392–393
1019392	STC11	B71, B165, B180, B183–185, B372–373, B379–380, B389–390, B392
1019434	STC19	B63–64, B98, B111–112, B172, B376
1019436	STC20	B60–64, B66, B69–71, B75–76, B89–90, B92, B96, B98–99, B120, B155, B163, B371–372, B374
1019480	STC27	B183–185, B388–390, B392
1019640	S111	B165, B172–173, B179–182, B184, B188, B372–382, B390, B393, C184, D28, D38, E40, E48–49
1019656	S125	B172–173, B179–184, B188, B375–382, B389–390, B393
1019694	S19	B165, B183, B376, B389
1019696	S112	C184, D28
1019818	S625	E41, E45
1019858	S518	E44–46
1019864	S524	E41–42, E44–46
1019866	S532	E40, E48–49
1019886	S322	B406–407
1019888	S325	B409
1019892	S327	B406–407, B409
1019924	S330	B406–407, B409
1019926	S415	B407–408
1019932	S425	B408, S122
1019938	S39	C191, C193, D35–37
1019940	S310	C182, C185–187, C191, C193, D25–27, D29, D35–37
1019978	S304	C190, D36–37
1019990	S412	B407–408, C184, C187, C193, C195, D26, D28, D36, D38, E43, E47, E49
1020018	S337	B406–407, B409
1020044	S340	B406–407, B409
1020056	S350	B406–407, B409
1020058	S352	C182, C187, C191, D26–27, D35
1020060	S353	B406–407, B409
1020272	S965	D29
1020355	SL344	B170, B172, B179, B181–182, B372–374, B376, B378, B381–382, B393, C184, D28, E41, E45
1020361	S959	E41–47, E49
1020545	MS1861	H100
1020657	CKM41	B74, B94
1020787	KUAM20	B217–223, B245, B276–278
1020789	KUAM22	B72–74, B94, B115–119, B140–142, B174, B186–187, B394, B397–398
1020791	KUAM23	B198, B245, B249–251, B276–279, C196, D41
1020805	KUAM26	B74, C196, D41
1020807	KUAM27	B74, B115, B119, T91–92
1020809	KUAM28	B72, B115–119, B175–176, B186, B217, B220, B236–237, B254–255, B276–279, B395–397
1020811	KUAM30	B72, B115–119, B175–176, B186, B217, B220, B236–237, B254–255, B276–279, B395–397
1020813	KUAM31	B72–74, B94, B115–119, B140–142, B174, B186–187, B198, B245, B249–251, B276–279, B394, B397–398, C196, D41
1020835	KUAM32	B72–74, B94–95, B115–117, B119, B140–142, B186, B198, B249, B397
1020839	KUAM34	B217–223, B245, B276–278
1020841	KUAM35	B217, B220, B222–223
1020843	KUAM25	B72–74, B94–95, B115–117, B119, B140–142, B186, B198, B249, B397
1020917	SRS3	B193–196, B227–229, B259–260, B282, S39, T113
1020919	SRS4	B194
1020923	SSY3T	D71–72, D74–79
1020935	SSY4T	D71–72, D74–79
1020939	MS1374	T89–92
1020941	SSN2T	D74–75
1020943	SSA3T	D71–72, D74–79
1020965	SSA4T	D71–72, D74–79
1020973	MS412	C196, D41
1020975	MS125	B186, B397
1020977	MS1273	C52–55, T119–120
1021007	MS1321	B168–169, B386–387
1021037	MS1027	B209–212, B216
1021039	MS1028	B210–211
1021051	MS1025	C196, D41
1021143	MS364	B74, B115, B119
1021183	MS1375	K89–90
1021301	MS1571	C135–136
1021337	MS1152	B273, B276–278, J25, J27, J29, J31, J33, J35, J37, J39
1021339	MS1153	B193–197, B209–215, B217–223, B227–230, B234–237, B243–245, B259–262, B270–279, B282–285, B287, B289–290, B292, K78–80, K85, K89–90
1021341	MS1155	B193, B195–198, B212–215, B217, B220, B227–230, B234–235, B237, B245, B254–255, B261–262, B271–279, B282–285, B287, B289–290
1021343	MS1156	B193–196, B227–229, B243–244, B259–260, B282, C127–128
1021375	MS1158	B194, B243
1021393	MS1281	U17–18
1021415	MS1282	U17–18
1021417	MS1284	U17–18
1021419	MS1285	C52–55
1021421	STCM9	B72–74, B94–95, B115–117, B119, B140–142
1021423	STCM11	U28–29, U35–36
1021455	STCM8	B74, B115, B119, B186, B397
1021463	STCM20	B74
1021503	STCM32	U28
1021505	STCM37	B140–142
1021507	STCM38	B72–74, B94, B115–119, B140–142, B174–176, B186–187, B394–398
1021511	STCM40	B74, B94, B115–117, B119
1021535	KLM43	B72–74, B115–119
1021537	KLM46	B72, B74, B94–95, B140–142
1021539	KLM58	B74
1021541	KLM68	B74, B115, B119
1021543	KLM33L	B94, B140–142
1021565	KLM34L	B140–142
1021569	KLM46S	B72–74, B94–95, B115–117, B119
1021589	FT5	K78
1021591	FT7	K78–80, K85, K89–90, K124–125
1021593	FT8	K42, K85
1021605	FT15	K85, K124–125
1021607	FT20	K124–125
1021657	CM113	E43, E47, E49
1021659	CM114	E43
1021661	CM116	E40, E48
1021663	CM117	E40
1021675	CM118	E48–49
1021677	CM119	E49
1021679	CM120	C184, C187, C191, D26, D28, D32, D35
1021681	CM121	C184, C187, C191, C195, D26, D28, D32, D35, D38
1021711	CM145	C195, D38
1021827	BP812	B170, B385
1021829	BP46	B170, B385
1021831	BP68	B170, B385
1021895	SU3	E65
1022051	CM144	C184, D28
1022075	KL23	B132, B134–136
1022077	KL33L	B93, B96, B139, B143, B163
1022081	KL33	B63, B71
1022083	KL34	B111, B113

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1022115	KL34L	B63, B89–90, B96, B98, B132–137, B139, B143, B152–155
1022117	KL46	B60–65, B69–71, B75–76, B98, B111–113, B120, B132–139, B143, B152–155, B163
1022119	KL46L	B66, B89–90, B92–93, B96, B99, B371
1022121	KL58	B61–65, B69, B71, B75–76, B89–90, B111–113, B133–137
1022123	KL68	B61–65, B71, B75–76, B98, B111–114, B120
1022135	KL44	B69, B71, B76, B114
1022141	KL810	B63–64, B98, B111–112
1022315	TT15	K42–43, T119–120, U17–18
1022436	CKM37	B74, B115–117, B119
1022485	DT7	U13, W40
1022487	DT8	U3, W29–31, W40, W42–43
1022489	DT9	V156
1022491	DT10	U3, W40–43
1022493	DT15	S56, S58, T89–92, U3, V155–156
1022519	TT25	K42–43, V87–88, V91, W40–43
1022521	TT30	K42–43, W41
1022649	S319PKG	B406–407
1022691	KT6	V123
1022695	KT8	K76, V122–123
1022697	KT9	S64, S67, S70
1022701	KT15	K76, K89–90, S122–123, V121–123
1022703	KT20	V121–123, V132–133
1022725	KT25	C143, C145
1022727	KT27	K77–78, K88
1023055	S1006PKG	E65
1023244	S422	B408, C184, C195, D28, D38, T109, V47, V54
1023315	S458	S5, S10, S14, S17, S20, S24, S32, S45, S50, S56, S58, S64, S67, S121–123, T7, T33, T113, U18, U29, V38, V54, V58
1024853	D32TTB28	B409
1024930	KSSISR300SD430C4	T113
1024931	KSSISR300SD430M4	T113
1024932	KSSISR300SD430F4	T113
1024933	KSSISR500SD430C6	T113
1024964	KSSISR500SD430M6	T113
1024965	KSSISR500SD430F6	T113
1024966	KSSISR600SD430C6	T113
1024967	KSSISR600SD430M6	T113
1024968	KSSISR600SD430F6	T113
1024970	KSSISR200SD430C3	T113
1024972	KSSISR200SD430M3	T113
1024994	KSSISR200SD430F3	T113
1024998	KSSISR250SD430M4	T113
1025000	KSSISR250SD430F4	T113
1025025	KSSISR400SD430C5	T113
1025027	KSSISR400SD430C6	T113
1025029	KSSISR400SD430M5	T113
1025031	KSSISR400SD430M6	T113
1025033	KSSISR400SD430F5	T113
1025065	KSSISR400SD430F6	T113
1025071	KSSISR600SD430C8	T113
1025094	KSSISR600SD430M8	T113
1025102	KSSISR800SD430C10	T113
1025134	KSSISR800SD430M10	T113
1025136	KSSISR800SD430F10	T113
1025140	KSSISR1000SD430M10	T113
1025612	HSFS0125	H86, H128–129, J13–15, J52–53, J89
1025861	KS44BLNE1240	U18
1025862	KS45BLNE1245	U18
1025863	KS46BLNE1245	U18
1025894	KS48BLNE1255	U18
1025895	KS54LNE1240	U17
1025896	KS55LNE1245	U17
1025897	KS85LNE1245	U17
1025898	KS56LNE1245	U17
1025899	KS58LNE1255	U17
1025930	KS34LNE1240	U17
1025931	KS44LNE1240	U17
1025932	KS64LNE1240	U17
1025933	KS84LNE1240	U17
1025964	KS45LNE1245	U17
1025965	KS65LNE1245	U17
1025966	KS46LNE1245	U17
1025967	KS66LNE1245	U17
1025968	KS86LNE1245	U17
1025969	KS48LNE1255	U17
1025970	KS68LNE1255	U17
1025971	KS88LNE1255	U17
1067613	CM74	C182–183, C185–188, C191–193, C196, D25–27, D29–31, D33, D35–36, D39, D41
1067614	CM75	C182–183, C185, C187–188, C191–193, C196, D25–27, D30–31, D33, D35–37, D39, D41
1067630	CM146	C191–193, D35–37, D39–40
1067631	CM147	C191–193, D35–37, D39–40
1067765	KS254BLNE1240	U18
1067766	KS255BLNE1245	U18
1080487	S4440W	B406
1082075	D24TTB21	B409
1082671	SCFPR08CA06	B217
1083005	MCLNR164C	B63
1085234	CSSPR164D	B173, B378
1085914	D20TTB18	B409
1086536	SCSPR08CA06	B222
1086694	D28TTB25	B409
1091551	D16TTB16	B409
1091555	D40TTB35	B409
1092071	STC26	B165, B389
1093271	75HC060M	G79
1093272	75HC080M	G79
1093273	75HC100M	G79
1093524	75HC120M	G79
1093525	75HC140M	G79
1093526	75HC160M	G79
1094300	MS1595	C34–41, C46–47, C49–50, C52–55, C122–126, C129, C131–133
1094409	STFCR062	B259
1094410	STFCL062	B259
1094421	STGCR062	B260
1094422	STGCL062	B260
1094423	STGCR082	B260
1094424	STGCL082	B260
1094427	STGCR103	B260
1094428	STGCL103	B260
1094429	STGCR123	B260
1094430	STGCL123	B260
1094433	SCACR052D	B193
1094435	SCACR062D	B193
1094436	SCACL062D	B193
1094437	SCACR083D	B193
1094438	SCACL083D	B193
1094443	SCFCR082	B193
1094444	SCFCL082	B193
1094453	SCGCR062	B194
1094455	SCGCR082	B194
1094457	SCGCR102	B194
1094459	SCGCR103	B194
1094461	SCGCR123	B194
1094462	SCGCL123	B194
1094475	SCLCR052	B194
1094476	SCLCL052	B194
1094477	SCLCR062	B194
1094478	SCLCL062	B194
1094479	SCLCR082	B194
1094480	SCLCL082	B194
1094481	SCLCR102	B194
1094482	SCLCL102	B194
1094483	SCLCR103	B194
1094484	SCLCL103	B194
1094485	SCLCR123	B194
1094486	SCLCL123	B194
1094491	SCLCRF062D	B195
1094492	SCLCLF062D	B195
1094493	SCLCRF082D	B195
1094494	SCLCLF082D	B195
1094495	SCLCRF083D	B195
1094496	SCLCLF083D	B195
1094497	SCMCN062	B195
1094498	SCMCN082	B195
1094500	SCMCN083	B195
1094501	SCMCN103	B195
1094502	SCMCN123	B195
1094511	SCRCR083	B196
1094512	SCRCL083	B196
1094513	SCRCR103	B196
1094519	SDJCR062	B228
1094520	SDJCL062	B228
1094521	SDJCR082	B228
1094522	SDJCL082	B228
1094523	SDJCR102	B228
1094524	SDJCL102	B228
1094525	SDJCR083	B228
1094526	SDJCL083	B228
1094527	SDJCR103	B228
1094528	SDJCL103	B228
1094529	SDJCR123	B228
1094530	SDJCL123	B228
1094531	SDJCR163	B228
1094532	SDJCL163	B228
1094533	SVJBR062	B282
1094534	SVJBL062	B282
1094535	SVJBR082	B282
1094536	SVJBL082	B282
1094537	SVJBR102	B282
1094538	SVJBL102	B282
1094539	SVJBR123	B282
1094540	SVJBL123	B282
1094541	SVJBR163	B282
1094542	SVJBL163	B282
1094543	SROCN102	B244
1094544	SROCN122	B244
1094545	SROCN162	B244
1094546	SROCN123	B244
1094547	SROCN163	B244
1094548	SRGCR122	B244
1094550	SRGCR162	B244
1094551	SRGCL162	B244
1094554	SRGCR163	B244
1094556	SRGCR203	B244
1094557	SRGCL203	B244
1094572	SCGCR163	B194
1094573	SCGCL163	B194
1094576	SCLCR163	B194
1094577	SCLCL163	B194
1094578	SCMCN163	B195
1094581	STFCR163	B259
1094583	STGCR163	B260
1094584	STGCL163	B260
1094589	SCACR103B	B193
1094590	SCACL103B	B193
1094591	SCLCRF523Z	B195
1094593	SCLCRF103B	B195
1094594	SCLCLF103B	B195
1094595	SDACR062D	B227
1094596	SDACL062D	B227
1094597	SDACR082D	B227
1094598	SDACL082D	B227
1094599	SDACR103B	B227
1094600	SDACL103B	B227
1094601	SDJCRF062D	B228
1094602	SDJCLF062D	B228
1094603	SDJCRF082D	B228
1094604	SDJCLF082D	B228
1094605	SDJCRF103B	B228
1094606	SDJCLF103B	B228
1094607	SVABR062D	B282
1094608	SVABL062D	B282
1094609	SVABR082D	B282
1094610	SVABL082D	B282
1094611	SVABR103B	B282
1094612	SVABL103B	B282
1094613	SVJBRF103B	B283
1094614	SVJBLF103B	B283
1094615	SVJBRF062D	B283
1094616	SVJBLF062D	B283
1094617	SVJBRF082D	B283
1094618	SVJBLF082D	B283
1094621	SROCN203	B244
1094651	A0506STFPR18	B273
1094653	A06MSTFPR2	B271
1094654	A06MSTFPL2	B271
1094655	A08RSTFPR2	B271
1094656	A08RSTFPL2	B271
1094657	A10SSTFPR2	B271
1094659	A12SSTFPR3	B271
1094660	A12SSTFPL3	B271
1094661	A16STFPR3	B271
1094663	A0306GSCLDR12	B203
1094664	A0306GSCLDL12	B203
1094665	A0406HSCLDR12	B203
1094666	A0406HSCLDL12	B203
1094667	A0506KSCLPR18	B215
1094669	A06MSCLPR2	B213
1094670	A06MSCLPL2	B213
1094671	A08RSCLPR2	B213
1094672	A08RSCLPL2	B213
1094673	A10SSCLPR2	B213
1094674	A10SSCLPL2	B213
1094675	A10SSCLPR3	B213
1094676	A10SSCLPL3	B213
1094677	A12SSCLPR3	B213
1094678	A12SSCLPL3	B213
1094679	A16TSCLPR3	B213
1094680	A16SCLPL3	B213
1094681	A08RSDXPR2	B235
1094682	A08RSDXPL2	B235
1094683	A10SSDXPR2	B235
1094684	A10SSDXPL2	B235
1094685	A12SSDXPR3	B235
1094687	A16TSDXPR3	B235
1094688	A16TSDXPL3	B235
1094689	A06MSDUPR2	B234
1094690	A06MSDUPL2	B234
1094691	A08RSDUPR2	B234
1094692	A08RSDUPL2	B234
1094693	A10SSDUPR2	B234
1094694	A10SSDUPL2	B234
1094695	A12SSDUPR3	B234
1094696	A12SSDUPL3	B234
1094697	A16TSDUPR3	B234
1094698	A16TSDUPL3	B234
1094699	A12SSVUBR2	B285
1094700	A12SSVUBL2	B285
1094701	A16TSVUBR3	B285
1094702	A16TSVUBL3	B285
1094703	A0306SWLPR15	B291
1094704	A0306SWLPL15	B291
1094705	A0406SWLPR15	B291
1094707	A0506KSWLPR15	B291
1094709	A06MSWLPR2	B289
1094711	A08RSWLPR2	B289
1094712	A08RSWLPL2	B289
1094713	A10SSWLPR3	B289
1094714	A10SSWLPL3	B289
1094715	A12SSWLPR3	B289
1094716	A12SSWLPL3	B289
1094717	A16SWLPR3	B289
1094719	A10SSVQBR2	B284
1094720	A10SSVQBL2	B284
1094721	A12SSVQBR2	B284
1094722	A12SSVQBL2	B284
1094723	A16TSVQBR3	B284
1094724	A16TSVQBL3	B284
1094725	A06MSCFPR2	B212
1094726	A06MSCFPL2	B212
1094727	A08RSCFPR2	B212
1094728	A08RSCFPL2	B212
1094729	A10SSCFPR2	B212
1094730	A10SSCFPL2	B212
1094731	A12SSCFPR3	B212
1094732	A12SSCFPL3	B212
1094733	A16SCFPR3	B212
1094745	A06MSTLPR2	B274
1094746	A06MSTLPL2	B274
1094747	A08RSTLPR2	B274
1094748	A08RSTLPL2	B274
1094749	A10SSTLPR2	B274
1094750	A10SSTLPL2	B274

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1094751	A12SSTLPR3	B274
1094752	A12SSTLPL3	B274
1094753	A16STLPR3	B274
1094755	A05KSTFPR18	B271
1094757	A08SCLPR2D	B217
1094758	A10SCLPR2D	B217
1094759	A12SCLPR3D	B217
1094792	A16CRGNR3	B388
1094793	A16CRGNL3	B388
1094816	A08RCTLNR2	B388
1094818	A10SCTLNR2	B388
1094819	A10CTLNL2	B388
1094824	A08NER2	C191, D35
1094825	A08NEL2	C191, D35
1094826	A06NER1	C190, D36
1094827	A08NER1	C190, D36
1094828	A10NER1	C190, D36
1094829	A10SNER2	C191, D35
1094830	A10SNEL2	C191, D35
1094831	A12SNER2	C191, D35
1094832	A12NEL2	C191, D35
1094833	A16TNER2	C191, D35
1094834	A16TNEL2	C191, D35
1094835	A16NER3	C191, D35
1094836	A16NEL3	C191, D35
1094837	A20NER3	C191, D35
1094838	A20NEL3	C191, D35
1094839	A24NER3	C191, D35
1094840	A24NEL3	C191, D35
1094841	A28NER3	C191, D35
1094842	A28NEL3	C191, D35
1094843	A32NER3	C191, D35
1094844	A32NEL3	C191, D35
1094845	A40NER3	C191, D35
1094846	A40NEL3	C191, D35
1094847	A28NER4	C191, D35
1094848	A28NEL4	C191, D35
1094849	A32NER4	C191, D35
1094850	A32NEL4	C191, D35
1094853	A40NER4	C191, D35
1094856	A32NEL5	C191, D35
1094859	A32NER6	C191, D35
1094860	A32NEL6	C191, D35
1094863	A16CTLPL3	B185, B390
1094872	A06RCTFPR2	B183, B389
1094874	A08RCTFPR2	B183, B389
1094875	A08RCTFPL2	B183, B389
1094876	A10SCTFPR2	B183, B389
1094877	A10CTFPL2	B183, B389
1094878	A12SCTFPR3	B183, B389
1094879	A12SCTFPL3	B183, B389
1094880	A16TCTFPR3	B183, B389
1094882	A20UCTFPR3	B183, B389
1094884	A24CTFPR3	B183, B389
1094888	A24CTFPR4	B183, B389
1094889	A24CTFPL4	B183, B389
1094892	A32CTFPR4	B183, B389
1094896	A16CCLPR4	B165, B389
1094900	A24CCLPR4	B165, B389
1094904	A06MCTLPR2	B185, B390
1094906	A08RCTLPR2	B185, B390
1094907	A08RCTLPL2	B185, B390
1094908	A12SCTLPR3	B185, B390
1094909	A12SCTLPL3	B185, B390
1094910	A16CTLPR3	B185, B390
1094911	A16TNSR3	C194
1094912	A16TNSL3	C194
1094913	A20UNSR3	C194
1094915	A24UNSR3	C194
1094916	A24UNSL3	C194
1094919	A32VNSR3	C194
1094920	A32VNSL3	C194
1094921	A40VNSR3	C194
1094941	S4416W	B406
1094942	S4420W	B406
1094943	S4424W	B406
1094944	S4428W	B406
1094945	S4432W	B406
1094947	S4440W48	B406
1094953	A10SSCLPR3AP5	B216
1094954	A12SSCLPR3AP5	B216
1094955	A16SCLPR3AP5	B216
1094956	A10SSCLPL3AP5	B216
1094957	A12SSCLPL3AP5	B216
1094958	A16SCLPL3AP5	B216
1095001	H24CRGNR4	B170, B393
1095003	H32CRGNR4	B170, B393
1095216	H16LSER3	D76
1095218	H20LSER3	D76
1095220	H24LSER3	D76
1095222	H32LSER3	D76
1095224	H24LSER4	D76
1095226	H32LSER4	D76
1095291	H40MCKNR6	B75
1095308	H16MCLNR4	B76
1095309	H16MCLNL4	B76
1095313	H20MTFNR3	B143
1095314	H20NER3W	C195, D38
1095315	H20NEL3W	C195, D38
1095317	H20MVUNR3	B155
1095318	H20MVUNL3	B155
1095321	H20CTFPR3W	B188, B393
1095325	H20MCLNR4	B76
1095326	H20MCLNL4	B76
1095334	H20MDUNR4	B96
1095335	H20MDUNL4	B96
1095341	H20MWLNR4	B163
1095360	H24MSSNR4	B120
1095361	H24MTFNR3	B143
1095362	H24NER3W	C195, D38
1095363	H24NEL3W	C195, D38
1095365	H24MVUNR3	B155
1095366	H24MVUNL3	B155
1095367	H24NER8W	C195, D38
1095369	H24MCKNR4	B75
1095377	H24MCLNR4	B76
1095378	H24MCLNL4	B76
1095379	H24MCLNR5	B76
1095380	H24MCLNL5	B76
1095383	H24MDPNR4	B96
1095385	H24MDUNR3	B96
1095388	H24MDUNR4	B96
1095389	H24MDUNL4	B96
1095392	H24MSKNR4	B120
1095395	H24MWLNR4	B163
1095400	H24MWLNL4	B163
1095417	H28MTFNR3	B143
1095418	H28NER3W	C195, D38
1095419	H28NEL3W	C195, D38
1095421	H28NER4W	C195, D38
1095429	H28MCLNR4	B76
1095430	H28MCLNL4	B76
1095436	H28MDUNR4	B96
1095437	H28MDUNL4	B96
1095442	H28MWLNR4	B163
1095452	H28NER6W	C195, D38
1095456	H32NER3W	C195, D38
1095457	H32NEL3W	C195, D38
1095458	H32NER4W	C195, D38
1095459	H32NEL4W	C195, D38
1095461	H32MVUNR4	B155
1095464	H32MCKNR4	B75
1095469	H32MCLNR4	B76
1095472	H32MCLNL4	B76
1095474	H32MCLNR5	B76
1095475	H32MCLNL5	B76
1095476	H32MCLNR6	B76
1095477	H32MCLNL6	B76
1095479	H32MDUNR3	B96
1095480	H32MDUNR4	B96
1095483	H32MDUNL4	B96
1095485	H32MSKNR4	B120
1095489	H32MWLNR4	B163
1095495	H32MWLNL4	B163
1095512	H32NER6W	C195, D38
1095514	H32MTFNR4	B143
1095515	H32MVUNL4	B155
1095516	H36NER4W	C195, D38
1095531	H40MSSNR6	B120
1095533	H40NER3W	C195, D38
1095534	H40NEL3W	C195, D38
1095535	H40NER4W	C195, D38
1095536	H40NEL4W	C195, D38
1095538	H40MVUNR4	B155
1095539	H40MVUNL4	B155
1095540	H40MCKNR5	B75
1095541	H40MCKNL5	B75
1095542	H40CTFPR4W	B188, B393
1095548	H40MCLNR5	B76
1095549	H40MCLNL5	B76
1095550	H40MCLNR6	B76
1095551	H40MCLNL6	B76
1095553	H40MDUNR4	B96
1095556	H40MDUNL4	B96
1095558	H40MSKNR6	B120
1095560	H40MSKNL6	B120
1095571	H40NER6W	C195, D38
1095573	H40MTFNR4	B143
1095574	NASR083D	C185, D25
1095575	NASL083D	C185, D25
1095576	NASR102B	C185, D25
1095577	NASL102B	C185, D25
1095580	NEL062	C187, D26
1095581	NER062	C187, D26
1095582	NSL062	C182, D27
1095583	NSR062	C182, D27
1095588	STGPR062	B270
1095589	STGPR082V	B270
1095590	STFPR062	B270
1095592	SCLPR123B	B210
1095594	SCLPR062	B210
1095595	SCLPR083V	B210
1095596	SCGPR123B	B210
1095597	SCGPR062	B210
1095598	SCGPR083V	B210
1095600	SCFPR083V	B209
1095601	SCRPR062	B212
1095602	SCRPR083V	B212
1095605	SCMPN123B	B211
1095606	SCMPN062	B211
1095607	SCMPN083V	B211
1095632	SVUBR082	B283
1095633	SVUBR102	B283
1095634	SVUBL082	B283
1095635	SVUBL102	B283
1095644	SDUCR083	B229
1095645	SDUCR082	B229
1095647	SDUCR103	B229
1095648	SDUCL083	B229
1095649	SDUCL082	B229
1095651	SDUCL103	B229
1095654	SCLPRF062D	B211
1095655	SCLPRF083D	B211
1095658	SCLPLF062D	B211
1095659	SCLPLF083D	B211
1095661	SCAPR052D	B209
1095662	SCAPR062D	B209
1095663	SCAPR083D	B209
1095665	SCAPL052D	B209
1095667	SCAPL083D	B209
1095668	NASR103B	C185, D25
1095670	NASR082D	C185, D25
1095671	NASR062D	C185, D25
1095672	NASL103B	C185, D25
1095674	NASL082D	C185, D25
1095675	NASL062D	C185, D25
1095681	STGPL062	B270
1095682	STGPL082V	B270
1095685	SCLPL123B	B210
1095686	SCLPL062	B210
1095687	SCLPL083V	B210
1095688	SCGPL123B	B210
1095689	SCGPL062	B210
1095690	SCGPL083V	B210
1095692	SCFPL083V	B209
1095693	SCRPL062	B212
1095694	SCRPL083V	B212
1095802	PROON164D	B170, B385
1095803	PROON204D	B170, B385
1095804	PROON206D	B170, B385
1095805	PROON208D	B170, B385
1095806	PROON244D	B170, B385
1095808	PROON246	B170, B385
1095829	B10CTFPR2	B184, B390
1095830	B12CTFPR3	B184, B390
1095831	B14CTFPR3	B184, B390
1095832	B16CTFPR3	B184, B390
1095833	B20CTFPR3	B184, B390
1095834	B24CTFPR4	B184, B390
1095836	B32CTFPR4	B184, B390
1095839	D5420W	B407
1095840	D5424W	B407
1095841	D5428W	B407
1095842	D5432W	B407
1095844	D5440W	B407
1095901	A10NKLCR05	E44
1095902	A12SNKLCR05	E44
1095903	A16NKLCR05	E44
1095904	A20NKLCR05	E44
1095905	A24NKLCR05	E44
1095908	A10SNKLCL05	E44
1095909	A12SNKLCL05	E44
1095910	A16TNKLCL05	E44
1095915	A08NKQCR05	E46
1095916	A12SNKQCR05	E46
1095917	A16NKQCR05	E46
1095918	A08NKQCL05	E46
1095919	A12SNKQCL05	E46
1095920	A16NKQCL05	E46
1095921	A12NKXCR05	E46
1095922	A16NKXCR05	E46
1095926	A20NVLCR3	E47
1095927	A32NVLCR3	E47
1095928	A24NVLCR3	E47
1095943	H32NDQPL4W	E48
1095945	H20NDLPR4W	E48
1095946	H24NDLPR4W	E48
1095956	H24NDXPR4W	E49
1095959	H20NDXPL4W	E49
1095962	H40NDXPL4W	E49
1095964	H24NVLPR3W	E49
1095975	MRGNR163D	B98
1095981	MRGNR166D	B98
1095982	MRGNL166D	B98
1096002	MVVNN123B	B153
1096003	MVVNN163C	B153
1096004	MVVNN163D	B153
1096005	MVVNN164D	B153
1096006	MVVNN203D	B153
1096007	MVVNN204D	B153
1096008	MTJNR082B	B136
1096009	MTJNL082B	B136
1096012	MTJNR103B	B136
1096013	MTJNL103B	B136
1096014	MTJNR123B	B136
1096015	MTJNL123B	B136
1096016	MTJNR163C	B136
1096017	MTJNL163C	B136
1096018	MTJNR163D	B136
1096019	MTJNL163D	B136
1096022	MTJNR164D	B136
1096023	MTJNL164D	B136
1096024	MTJNR204D	B136
1096025	MTJNL204D	B136
1096026	MTJNR205D	B136
1096027	MTJNL205D	B136
1096029	MSRNL204D	B112
1096032	MCFNR124B	B60
1096033	MCFNR164C	B60
1096034	MCFNR164D	B60
1096037	MCFNL164D	B60
1096038	MSSNR123B	B113
1096039	MSSNR124B	B113
1096040	MSSNR164C	B113
1096041	MSSNR164D	B113
1096042	MSSNR206D	B113
1096047	MSSNL164C	B113
1096048	MSSNL164D	B113
1096049	MSSNL206D	B113
1096052	MTANR123B	B132
1096053	MTANR164D	B132
1096056	MTANR082B	B132
1096058	MTANR103B	B132
1096059	MTANL123B	B132
1096060	MTANL164D	B132
1096065	MTANL103B	B132
1096066	MCLNR123B	B63
1096067	MCLNR124B	B63

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1096068	MCLNR163C	B63
1096069	MCLNR163D	B63
1096070	MCLNR164D	B63
1096071	MCLNR165C	B63
1096072	MCLNR165D	B63
1096073	MCLNR166D	B63
1096075	MCLNR204D	B63
1096076	MCLNR205D	B63
1096077	MCLNR206D	B63
1096079	MCLNR244D	B63
1096080	MCLNR245E	B63
1096081	MCLNR246D	B63
1096082	MCLNR246E	B63
1096083	MCLNR854D	B63
1096086	MCLNR083A	B63
1096087	MCLNR103A	B63
1096088	MCLNL123B	B63
1096089	MCLNL124B	B63
1096092	MCLNL164D	B63
1096093	MCLNL165C	B63
1096094	MCLNL165D	B63
1096095	MCLNL166D	B63
1096097	MCLNL204D	B63
1096101	MCLNL244D	B64
1096102	MCLNL245E	B64
1096103	MCLNL246D	B64
1096104	MCLNL246E	B64
1096105	MCLNL854D	B64
1096107	MCLNL866E	B64
1096108	MCLNL083A	B63
1096109	MCLNL103A	B63
1096110	MCGNR124B	B61
1096111	MCGNR164C	B61
1096112	MCGNR164D	B61
1096113	MCGNL124B	B61
1096114	MCGNL164C	B61
1096115	MCGNL164D	B61
1096116	MCRNR124B	B65
1096117	MCRNR164C	B65
1096118	MCRNR164D	B65
1096119	MCRNR165D	B65
1096120	MCRNR166D	B65
1096121	MCRNR204D	B65
1096122	MCRNR206D	B65
1096123	MCRNR246E	B65
1096124	MCRNL124B	B65
1096125	MCRNL164C	B65
1096126	MCRNL164D	B65
1096127	MCRNL165D	B65
1096128	MCRNL166D	B65
1096129	MCRNL204D	B65
1096130	MCRNL206D	B65
1096131	MCRNL246E	B65
1096132	MCKNR124B	B62
1096133	MCKNR164C	B62
1096134	MCKNR164D	B62
1096135	MCKNR204D	B62
1096136	MCKNR206D	B62
1096137	MCKNL124B	B62
1096138	MCKNL164C	B62
1096139	MCKNL164D	B62
1096140	MCKNL204D	B62
1096141	MCKNL206D	B62
1096142	MCMNN124B	B64
1096143	MCMNN164C	B64
1096144	MCMNN164D	B64
1096145	MCMNN166D	B64
1096146	MCMNN204D	B64
1096147	MCMNN206D	B64
1096149	MSRNR124B	B112
1096150	MSRNR164C	B112
1096151	MSRNR164D	B112
1096152	MSRNR205D	B112
1096153	MSRNR206D	B112
1096154	MSRNR246D	B112
1096155	MSRNR246E	B112
1096156	MSRNR856D	B112
1096159	MSRNL124B	B112
1096160	MSRNL164C	B112
1096161	MSRNL164D	B112
1096162	MSRNL205D	B112
1096163	MSRNL206D	B112
1096164	MSRNL246D	B112
1096165	MSRNL246E	B112
1096169	MSKNR124B	B111
1096170	MSKNR164C	B111
1096171	MSKNR164D	B111
1096180	MSDNN083	B111
1096181	MSDNN103	B111
1096182	MSDNN123	B111
1096183	MSDNN124	B111
1096184	MSDNN164	B111
1096185	MSDNN854	B111
1096186	MSDNN855	B111
1096187	MSDNN856	B111
1096188	MTGNR123B	B135
1096189	MTGNR124B	B135
1096192	MTGNR164C	B135
1096193	MTGNR164D	B135
1096194	MTGNR204D	B135
1096195	MTGNR205D	B135
1096197	MTGNR082B	B135
1096199	MTGNR103B	B135
1096200	MTGNL123B	B135
1096201	MTGNL124B	B135
1096204	MTGNL164C	B135
1096205	MTGNL164D	B135
1096206	MTGNL204D	B135
1096207	MTGNL205D	B135
1096211	MTGNL103B	B135
1096212	MTFNR123B	B134
1096216	MTFNR164C	B134
1096217	MTFNR164D	B134
1096218	MTFNR204D	B134
1096219	MTFNR205D	B134
1096221	MTFNR246E	B134
1096226	MTFNL123B	B134
1096230	MTFNL164C	B134
1096231	MTFNL164D	B134
1096232	MTFNL204D	B134
1096234	MTFNL245D	B134
1096235	MTFNL246E	B134
1096240	MDJNR123B	B89
1096241	MDJNR124B	B89
1096242	MDJNR163C	B89
1096243	MDJNR163D	B89
1096244	MDJNR164C	B89
1096245	MDJNR164D	B89
1096246	MDJNR165D	B89
1096247	MDJNR203D	B89
1096248	MDJNR205D	B89
1096250	MDJNR245D	B89
1096251	MDJNR854D	B89
1096252	MDJNL123B	B89
1096253	MDJNL124B	B89
1096254	MDJNL163C	B89
1096255	MDJNL163D	B89
1096256	MDJNL164C	B89
1096257	MDJNL164D	B89
1096259	MDJNL203D	B89
1096260	MDJNL204D	B89
1096261	MDJNL205D	B89
1096263	MDJNL245D	B89
1096265	MDQNR124B	B90
1096266	MDQNR164C	B90
1096267	MDQNR164D	B90
1096268	MDQNR204D	B90
1096269	MDQNR244D	B90
1096270	MDQNR244E	B90
1096271	MDQNL124B	B90
1096272	MDQNL164C	B90
1096273	MDQNL164D	B90
1096274	MDQNL204D	B90
1096275	MDQNL244D	B90
1096276	MDQNL244E	B90
1096277	MDPNN123B	B90
1096279	MDPNN163D	B90
1096280	MDPNN164D	B90
1096282	MDPNN205D	B90
1096284	MDPNN245D	B90
1096286	MVJNR123B	B152
1096287	MVJNR124B	B152
1096288	MVJNR163C	B152
1096289	MVJNR163D	B152
1096290	MVJNR164C	B152
1096291	MVJNR164D	B152
1096292	MVJNR203D	B152
1096293	MVJNR204D	B152
1096294	MVJNR244D	B152
1096295	MVJNL123B	B152
1096297	MVJNL163C	B152
1096298	MVJNL163D	B152
1096299	MVJNL164C	B152
1096300	MVJNL164D	B152
1096301	MVJNL203D	B152
1096302	MVJNL204D	B152
1096303	MVJNL244D	B152
1096304	MRGNR123B	B98
1096305	MRGNR124B	B98
1096306	MRGNR164C	B98
1096307	MRGNR164D	B98
1096308	MRGNR204D	B98
1096309	MRGNR206D	B98
1096314	MRGNL164D	B98
1096315	MRGNL204D	B98
1096316	MRGNL206D	B98
1096318	MTCNN083	B133
1096319	MTCNN124	B133
1096320	MTCNN443	B133
1096321	MTCNN644	B133
1096324	MTRNR164D	B138
1096336	MTJNRS123	B137
1096337	MTJNRS124	B137
1096338	MTJNRS163	B137
1096339	MTJNRS164	B137
1096340	MTJNRS165	B137
1096341	MTJNRS204	B137
1096342	MTJNRS205	B137
1096343	MTJNLS123	B137
1096344	MTJNLS124	B137
1096345	MTJNLS163	B137
1096346	MTJNLS164	B137
1096347	MTJNLS165	B137
1096348	MTJNLS204	B137
1096349	MTJNLS205	B137
1096350	MTENNS082	B134
1096351	MTENNS103	B134
1096352	MTENNS123	B134
1096353	MTENNS163	B134
1096354	MTENNS164	B134
1096355	MTENNS205	B134
1096356	MTENNS246	B134
1096367	A40VMCLNR4	B71
1096368	A40MCLNL4	B71
1096369	A16MCLNR4D	B69
1096370	A20MCLNR4D	B69
1096371	A24MCLNR4D	B69
1096372	A32MCLNR4D	B69
1096373	A32MCLNR5D	B69
1096381	A20MTUNR3D	B139
1096385	A16MTFNR3	B139
1096386	A20UMTFNR3	B139
1096387	A24UMTFNR3	B139
1096388	A28MTFNR3	B139
1096389	A24UMTFNR4	B139
1096390	A28MTFNR4	B139
1096391	A32MTFNR4	B139
1096394	A16MTFNL3	B139
1096403	A20MSKNR4	B114
1096408	A40MSKNR6	B114
1096415	A16MCLNR3	B71
1096418	A20UMCLNR4	B71
1096419	A24UMCLNR4	B71
1096420	A28UMCLNR4	B71
1096421	A32VMCLNR4	B71
1096422	A24MCLNR5	B71
1096423	A32MCLNR5	B71
1096424	A32VMCLNR6	B71
1096426	A40VMCLNR6	B71
1096427	A16MCLNL3	B71
1096430	A16TMCLNL4	B71
1096431	A20UMCLNL4	B71
1096432	A24UMCLNL4	B71
1096433	A28UMCLNL4	B71
1096434	A32VMCLNL4	B71
1096435	A24MCLNL5	B71
1096436	A32MCLNL5	B71
1096437	A32VMCLNL6	B71
1096440	A20MCKNR4	B70
1096441	A24UMCKNR4	B70
1096442	A20MCKNL4	B70
1096443	A24MCKNL4	B70
1096444	A16TMDUNR3	B93
1096447	A20UMDUNR4	B93
1096448	A24UMDUNR4	B93
1096449	A28MDUNR4	B93
1096450	A32VMDUNR4	B93
1096455	A16TMDUNL3	B93
1096458	A20UMDUNL4	B93
1096459	A24UMDUNL4	B93
1096460	A28MDUNL4	B93
1096461	A32VMDUNL4	B93
1096466	A20UMVUNR3	B154
1096467	A24UMVUNR3	B154
1096468	A20UMVUNL3	B154
1096469	A24UMVUNL3	B154
1096470	A20UMDQNR4	B93
1096471	A24UMDQNR4	B93
1096472	A20MDQNL4	B93
1096473	A24MDQNL4	B93
1096481	H16MDUNL3	B96
1096482	H16MWLNL3	B163
1096484	H16MDUNR3	B96
1096643	MCLNRC164D	B66, B371
1096646	MRGNRC244D	B99, B371
1096647	MRGNRC164D	B99, B371
1096648	MRGNRC204D	B99, B371
1096672	MRGNLC244D	B99, B371
1096673	MRGNLC164D	B99, B371
1096674	MRGNLC204D	B99, B371
1096690	NKPCN1205B	E42
1096691	CSSPL164D	B173, B378
1096693	CSSPL856D	B173, B378
1096696	CTGPR082B	B182, B382
1096698	CCLNLP163D	B372
1096699	CCLNRP163D	B372
1096701	CCRNRP163D	B373
1096703	CRGNRP163D	B374
1096705	CRGNRP164D	B374
1096706	CRGNLP204D	B374
1096707	CRGNRP204D	B374
1096717	CCLNL164	B372
1096722	CCLNR164	B372
1096728	CRGNL123	B373
1096729	CRGNL163	B373
1096730	CRGNL164	B373
1096733	CRGNR123	B373
1096734	CRGNR163	B373
1096735	CRGNR164	B373
1096739	CSDNN164	B374
1096750	CSKNR856	B375
1096772	CSDNN124	B374
1096798	CTANR123	B375
1096887	CTGNR164	B375
1096898	CCLPL124B	B165, B376
1096899	CCLPL164C	B165, B376
1096902	CCLPR084V	B165, B376
1096903	CCLPR124B	B165, B376
1096904	CCLPR164C	B165, B376
1096909	CSDPN103	B172, B376
1096910	CSDPN124	B172, B376
1096911	CSDPN164	B172, B376
1096912	CSDPN644	B172, B376
1096914	CSDPN856	B172, B376
1096917	CSKPL164D	B172, B377
1096920	CSKPR164D	B172, B377
1096925	CSRPL124B	B173, B377
1096926	CSRPL164D	B173, B377
1096927	CSRPL856D	B173, B377
1096928	CSRPL866E	B173, B377
1096932	CSRPR164D	B173, B377
1096934	CSRPR866E	B173, B377
1096935	CSSPL854D	B173, B378
1096937	CSSPR854D	B173, B378
1096941	CTAPL123B	B179, B378
1096944	NDLPR164D	E40
1096946	CTAPL854D	B179, B378
1096948	CTAPR082B	B179, B378

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1096949	CTAPR102B	B179, B378
1096950	CTAPR123B	B179, B378
1096951	CTAPR163D	B179, B378
1096952	CTAPR854D	B179, B378
1096955	CTBPL123B	B179, B379
1096959	CTBPR123B	B179, B379
1096960	CTBPR163D	B179, B379
1096963	CTCPL163C	B180, B379
1096965	CTCPL164D	B180, B379
1096966	CTCPL204D	B180, B379
1096968	CTCPL244D	B180, B379
1096971	CTCPN124	B180, B380
1096972	CTCPN443	B180, B380
1096973	CTCPN644	B180, B380
1096974	CTCPN664	B180, B380
1096976	CTCPR123B	B180, B379
1096977	CTCPR163C	B180, B379
1096978	CTCPR164C	B180, B379
1096979	CTCPR164D	B180, B379
1096980	CTCPR204D	B180, B379
1096982	CTCPR244D	B180, B379
1096985	CTEPR123B	B181, B380
1096989	CTEPL854D	B181, B380
1096992	CTEPR163D	B181, B380
1096993	CTEPR854D	B181, B380
1096997	CTFPL123B	B181, B381
1096999	CTFPL163D	B181, B381
1097001	CTFPL164D	B181, B381
1097004	CTFPL854D	B181, B381
1097008	CTFPR082V	B181, B381
1097011	CTFPR123B	B181, B381
1097013	CTFPR163D	B181, B381
1097014	CTFPR164C	B181, B381
1097015	CTFPR164D	B181, B381
1097016	CTFPR204D	B181, B381
1097018	CTFPR854D	B181, B381
1097021	CTGPL102B	B182, B382
1097022	CTGPL123B	B182, B382
1097023	CTGPL163C	B182, B382
1097024	CTGPL163D	B182, B382
1097026	CTGPL164D	B182, B382
1097027	CTGPL204D	B182, B382
1097033	NDLPL164D	E40
1097035	CTGPR102B	B182, B382
1097036	CTGPR123A	B182, B382
1097037	CTGPR123B	B182, B382
1097038	CTGPR163C	B182, B382
1097039	CTGPR163D	B182, B382
1097041	CTGPR164C	B182, B382
1097042	CTGPR164D	B182, B382
1097043	CTGPR204D	B182, B382
1097048	NKLCR1605C	E41
1097049	NKLCL1605C	E41
1097118	NVLCR123B	E43
1097119	NVLCR203D	E43
1097120	NVLCR243D	E43
1097121	NVLCR163D	E43
1097122	NVLCL123B	E43
1097123	NVLCL203D	E43
1097124	NVLCL243D	E43
1097125	NVLCL163D	E43
1097128	NVVCN163D	E43
1097182	NKLCL1205A	E41
1097185	NKLCL1205B	E41
1097186	NKLNL121B	E41
1097187	NKLNL161C	E41
1097189	NKLCL0805V	E41
1097190	NKLCL1005B	E41
1097191	NKLCRF1005B	E42
1097231	NEL122B	C187, D26
1097232	NEL162C	C187, D26
1097233	NEL123B	C187, D26
1097234	NEL163C	C187, D26
1097235	NEL203D	C187, D26
1097236	NEL243D	C187, D26
1097237	NEL163D	C187, D26
1097238	NEL853D	C187, D26
1097239	NEL164C	C187, D26
1097240	NEL204D	C187, D26
1097241	NEL244D	C187, D26
1097242	NEL164D	C187, D26
1097243	NEL206D	C187, D26
1097246	NEL205D	C187, D26
1097247	NEL082V	C187, D26
1097248	NEL102B	C187, D26
1097249	NRL123B	C189
1097250	NRL163C	C189
1097251	NRL203D	C189
1097253	NRL163D	C189
1097254	NSL122B	C182, D27
1097255	NSL162C	C182, D27
1097256	NSL123B	C182, D27
1097257	NSL163C	C182, D27
1097258	NSL203D	C182, D27
1097259	NSL243D	C182, D27
1097260	NSL163D	C182, D27
1097261	NSL123A	C182, D27
1097262	NSL853D	C182, D27
1097263	NSL164C	C184, D28
1097264	NSL204D	C184, D28
1097265	NSL244D	C184, D28
1097266	NSL164D	C184, D28
1097267	NSL243E	C182, D27
1097268	NSL244E	C184, D28
1097269	NSL854D	C184, D28
1097271	NSL204C	C184, D28
1097272	NSL205D	C182, D27
1097273	NSL206D	C184, D28
1097274	NSL246D	C184, D28
1097275	NSL166D	C184, D28
1097278	NSL082V	C182, D27
1097279	NSL102B	C182, D27
1097314	NDPPN164D	E40
1097454	NKLCRF0805D	E42
1097455	NKLCLF0805D	E42
1097508	NKLCR1205A	E41
1097511	NKLCR1205B	E41
1097512	NKLNR121B	E41
1097513	NKLNR161C	E41
1097515	NKLCR0805V	E41
1097516	NKLCR1005B	E41
1097559	NER122B	C187, D26
1097560	NER162C	C187, D26
1097561	NER123B	C187, D26
1097562	NER163C	C187, D26
1097563	NER203D	C187, D26
1097564	NER243D	C187, D26
1097565	NER163D	C187, D26
1097566	NER853D	C187, D26
1097567	NER164C	C187, D26
1097568	NER204D	C187, D26
1097569	NER244D	C187, D26
1097570	NER164D	C187, D26
1097571	NER206D	C187, D26
1097575	NER205D	C187, D26
1097577	NER082V	C187, D26
1097578	NER102B	C187, D26
1097579	NRR123B	C189
1097580	NRR163C	C189
1097581	NRR203D	C189
1097582	NRR243D	C189
1097583	NRR163D	C189
1097584	NSR122B	C182, D27
1097585	NSR162C	C182, D27
1097586	NSR123B	C182, D27
1097587	NSR163C	C182, D27
1097588	NSR203D	C182, D27
1097589	NSR243D	C182, D27
1097590	NSR123A	C182, D27
1097591	NSR853D	C182, D27
1097592	NSR164C	C184, D28
1097593	NSR204D	C184, D28
1097594	NSR244D	C184, D28
1097595	NSR164D	C184, D28
1097596	NSR243E	C182, D27
1097597	NSR244E	C184, D28
1097598	NSR854D	C184, D28
1097599	NSR864E	C184, D28
1097600	NSR204C	C184, D28
1097601	NSR205D	C182, D27
1097602	NSR206D	C184, D28
1097603	NSR246D	C184, D28
1097604	NSR166D	C184, D28
1097605	NSR168D	C184, D28
1097608	NSR082V	C182, D27
1097609	NSR102B	C182, D27
1097644	NSRDH122B	C186, D29
1097645	NSRDH162C	C186, D29
1097646	NSRDH163C	C186, D29
1097647	NSRDH203D	C186, D29
1097648	NSRDH163D	C186, D29
1097649	NSRDH123A	C186, D29
1097650	NSRDH204D	C186, D29
1097673	NSUR124C	D29
1097676	NSUR164D	D29
1097680	NSUL164D	D29
1097681	NSLDH203D	C186, D29
1098328	SCSPR06CA05	B222
1098380	NER12CA2	C196, D41
1098436	MSRNR10CA3	B116
1098465	MSYNR25CA19	B119
1098529	MTUNL12CA3	B142
1098535	MTUNL16CA3	B142
1098536	MTUNR20CA4	B142
1098541	SCLPR06CA05	B220
1098542	SCLPR08CA06	B220
1098543	SCLPR10CA09	B220
1098544	SCLCR12CA12	B198
1098545	SCLCR16CA12	B198
1098548	SCSPL06CA05	B222
1098549	SCSPL08CA06	B222
1098551	SCFPR06CA05	B217
1098552	SCKPR08CA06	B219
1098554	SCGPR08CA06	B218
1098555	SCRPR08CA06	B221
1098556	SCTPR06CA05	B223
1098557	SCTPR08CA06	B223
1098558	STFPL12CA16	B276
1098559	STFPL10CA11	B276
1098561	STFPL08CA09	B276
1098562	STFPR12CA16	B276
1098563	STFPR10CA11	B276
1098565	STFPR08CA09	B276
1098566	STGPR12CA16	B277
1098567	STGPR10CA11	B277
1098570	SSKPR10CA09	B254
1098572	SSSPR10CA09	B255
1098574	SSRPR10CA09	B254
1098624	NEL12CA2	C196, D41
1098626	NEL25CA3	C196, D41
1098691	MSYNL20CA15	B119
1098711	SRGCR08CA06	B245
1098713	SRGCR12CA10	B245
1098719	SSKCR12CA12	B249
1098720	SSKCR16CA12	B249
1098721	SSKCL12CA12	B249
1098723	SSRCR12CA12	B250
1098725	SSRCL12CA12	B250
1098728	SDUPR10CA07	B237
1098730	SCLPL08CA06	B220
1098731	SCLPL10CA09	B220
1098732	SCLCL12CA12	B198
1098736	SCTPL08CA06	B223
1098737	SSSCR12CA12	B251
1098739	SSSCL12CA12	B251
1098741	STTPR12CA16	B278
1098742	STTPR10CA11	B278
1098744	STTPR08CA09	B278
1098749	STWPR12CA16	B279
1098750	STWPR10CA11	B279
1098757	SDJPR10CA07	B236
1098758	SDJPL10CA07	B236
1098760	STGPL10CA11	B277
1098762	STGPL08CA09	B277
1098763	SCKPL08CA06	B219
1098764	SSSPL10CA09	B255
1098766	SCFPL08CA06	B217
1098786	NASR1616K3Q	C185
1098788	NASR1010M2Q	C185
1098789	NASR1212M2Q	C185
1098790	NSR1010E2	C183
1098791	NSR1212F2	C183
1098792	NSR1616H2	C183
1098793	NSR2020K2	C183
1098794	NSR2525M2	C183
1098795	NSR2020K3	C183
1098796	NSR2525M3	C183
1098797	NSR3225P3	C183
1098798	NSR3232P3	C183
1098799	NSR2525M4	C183
1098800	NSR3225P4	C183
1098801	NSR3232P4	C183
1098803	NER1616H2	C188
1098804	NER2020K2	C188
1098805	NER2525M2	C188
1098806	NER2525M3	C188
1098807	NER3225P3	C188
1098808	NER2525M4	C188
1098809	NER3225P4	C188
1098810	NER3232P4	C188
1098812	NRR2020K3	C189
1098813	NRR2525M3	C189
1098814	NRR3225P3	C189
1098857	NASL1616K3Q	C185
1098859	NASL1010M2Q	C185
1098860	NASL1212M2Q	C185
1098861	NSL1010E2	C183
1098862	NSL1212F2	C183
1098863	NSL1616H2	C183
1098864	NSL2020K2	C183
1098865	NSL2525M2	C183
1098866	NSL2020K3	C183
1098867	NSL2525M3	C183
1098868	NSL3225P3	C183
1098869	NSL3232P3	C183
1098870	NSL2525M4	C183
1098871	NSL3225P4	C183
1098872	NSL3232P4	C183
1098874	NEL1616H2	C188
1098875	NEL2020K2	C188
1098876	NEL2525M2	C188
1098877	NEL2525M3	C188
1098878	NEL3225P3	C188
1098879	NEL2525M4	C188
1098880	NEL3225P4	C188
1098881	NEL3232P4	C188
1098883	NRL2020K3	C189
1098884	NRL2525M3	C189
1098885	NRL3225P3	C189
1098943	A10KNNTOR1	C190
1098944	A12MNNTOR1	C190
1098945	A12MNNTOR2	C192
1098946	A12MNNTOL2	C192
1098947	A16MNNTOR2	C192
1098948	A16MNNTOL2	C192
1098949	A20QNNTOR2	C192
1098950	A20QNNTOL2	C192
1098951	A25RNNTOR2	C192
1098952	A25RNNTOL2	C192
1098953	A25RNNTOR3	C192
1098954	A25RNNTOL3	C192
1098955	A32SNNTOR3	C192
1098956	A32SNNTOL3	C192
1098957	A40TNNTOR3	C192
1098958	A40TNNTOL3	C192
1099001	A40TNNTOR4	C192
1099002	A40TNNTOL4	C192
1099003	A50UNNTOR4	C192
1099162	KRCSCFPR061A	K86
1099163	KRCSCFPR062A	K86
1099164	KRCSCFPR063A	K86
1099165	KRCSCFPR061B	K86
1099166	KRCSCFPR062B	K86
1099167	KRCSCFPR063B	K86
1099168	KRCSCFPR061C	K86
1099169	KRCSCFPR062C	K86
1099170	KRCSCFPR063C	K86
1099171	KRCSCFPR061D	K86
1099172	KRCSCFPR062D	K86
1099173	KRCSCFPR063D	K86
1099174	KRCSCFPR061E	K89, K108–109
1099175	KRCSCFPR062E	K89, K108–109
1099176	KRCSCFPR063E	K89, K108–109
1099177	KRCSCFPR061F	K89, K110–114
1099178	KRCSCFPR062F	K89, K110–114
1099179	KRCSCFPR063F	K89, K110–114
1099379	CM180	E42
1099380	CM181	E42

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1099381	CM182	C185, D25
1099382	CM183	C185, D25
1099433	SM427 K9	D38
1099435	SM434 K9	B374
1099437	SM437 K9	B170, B374, B393
1099445	SKSN566K K9	B115–117, B119
1099450	ITSN333 K9	B135–136
1099451	ICSN332 K9	B59, B63
1099452	IDSN322 K9	B87, B89–90, B92, B96
1099453	IDSN543 K9	B87
1099454	IVSN433 K9	B152–155
1099461	SM416 K9	C184, D28
1099463	SM419 K9	C184, D28
1099469	ITSN443 K9	B131
1099614	MS1933	B214–215, B217, B220, B222–223, B271–272
1099615	MS1939	B197, B212–215, B287, B289
1099640	MS1034	C190
1099644	MS1157	B198, B249–251
1099645	MS1160	C34–45, C52–57, C122–129, C134
1099646	MS1200	C183, C185, C188, C192–193, D30
1099649	KLM33	B72, B115–119
1099650	KLM54	B115–117, B119
1099651	FT10	K42
1099661	KL68L	B134, B137
1099675	MS-1896	K85
1099676	KT30	V121–123, V132
1100493	MCLNR12CA4	B74
1102784	E12STFPR3 KWH	B272
1104600	TRAOR242E	E70
1105612	191.924	H122, J25, J27, J29, J31, J33, J35, J37, J39, J49–50, J52–53, J84–85, J114, V156
1106230	LSASR83	D71
1106359	TRAOL2415E	E70
1106668	MS1970	C34–41, C46–51, C122–126, C129–133
1106715	A2732SVSPRW4	B285
1107188	HSK100AKR50085M	K92
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	C177
1113182	NBD3R K313	C177
1113183	NBD3L K313	C177
1113194	NB2L K313	C176
1113195	NB3L K313	C176
1113196	NB4L K313	C176
1113197	NB2R K313	C176
1113198	NB3R K313	C176
1113199	NB4R K313	C176
1113205	NT2L K313	D17
1113208	NT2R K313	D17
1113209	NT3R K313	D17
1113216	NR3031R K313	C172
1113217	NR3047R K313	C172
1113218	NR3062R K313	C172
1113219	NR3078R K313	C172
1113221	NR4094R K313	C172
1113224	NR3031L K313	C172
1113225	NR3047L K313	C172
1113226	NR3062L K313	C172
1113231	NR3094L K313	C172
1113233	NG2031R K313	C170
1113234	NG2041R K313	C170
1113237	NG2062R K313	C170
1113238	NG2094R K313	C170
1113240	NG2031L K313	C170
1113244	NG2062L K313	C170
1113245	NG2094L K313	C170
1113248	NG3125R K313	C170
1113252	NG3189R K313	C170
1113253	NG3047R K313	C170
1113254	NG3062R K313	C170
1113257	NG3094R K313	C170
1113261	NG3125L K313	C171
1113265	NG3047L K313	C170
1113266	NG3062L K313	C170
1113268	NG3094L K313	C170
1113269	NG4125R K313	C170
1113270	NG4189R K313	C170
1113272	NG4125L K313	C171
1113276	NF3125R K313	C175
1113277	NF3125L K313	C175
1113477	NJF3009R18 K68	D15
1113486	NA3L4 K68	D11
1113499	NTF2L K68	D21
1113500	NTF3L K68	D21
1113501	NTF2R K68	D21
1113502	NTF3R K68	D21
1113504	NT2L K68	D17
1113505	NT3L K68	D17
1113506	NT4L K68	D17
1113507	NT2R K68	D17
1113508	NT3R K68	D17
1113509	NT4R K68	D17
1113510	NTP2L K68	D22
1113511	NTP3L K68	D22
1113513	NTP2R K68	D22
1113514	NTP3R K68	D22
1113559	NJ3010R16 K68	D15
1114462	NGD3189R K313	C171
1114463	NGD4250R K313	C171
1114464	NGD4250L K313	C171
1114465	NGD3189L K313	C171
1114470	NRP3047R K313	C169
1114483	NGD3125RK K313	C165
1114484	NGD3062RK K313	C165
1114486	NGD3094RK K313	C165
1114487	NGD3125LK K313	C165
1114490	NGD3094LK K313	C165
1114624	NTK2R K68	D21
1114625	NTK3R K68	D21
1114626	NTK2L K68	D21
1114627	NTK3L K68	D21
1114680	NJP3014R12 K68	D16
1116320	TRAOL1615D	E70
1116889	CKM34	B72–74, B94–95, B115–119, B140–142, B174–176, B186–187, B394–398
1120731	AFB31115SCFCR09	K134
1121036	EB43040450	K143
1121195	112.244	E16
1121205	552.232	B383–384
1121232	552.221	B383, B391
1121302	552.230	B391
1121703	EB33040350	K143
1121711	BT50BT13088	K142
1121716	880.252.550	K137–138
1122168	PKG1565	K141–143
1122180	191.726	H122–123, J49, J52–53
1122185	CV50BT13069	K142
1122328	192.759	J92
1122397	CPGM2151 K313	B205
1123620	TRAOR202D	E70
1124019	26X2R043B25STN16D	W43
1124104	MS1163	C65–73, C143–151
1124195	SPMT3252LF K68	B252
1124300	TNMA432 K68	B122
1124975	PKG0002	K145
1125085	EB18030200	K143
1125092	RS1606	K129
1125110	AFB09075SCFCR06	K134
1125440	TNMA332 K68	B122
1125685	NPL13M10N K68	E35
1126021	170.270	H72, H81, H85–86, H88
1126032	170.271	H84, H88
1126040	170.272	H72, H81, H85–86, H88
1126049	170.273	H88
1126066	170.274	H72, H81, H85–86, H88
1126072	170.275	H88
1126079	170.276	H72, H81, H85–86, H88
1126088	170.277	H88
1126361	FT6	K79, T24
1126830	EB28035300	K143
1126838	AFB27115SCFCR09	K134
1127019	MS1162	C52–57, C65–73, C143–151, S94, S98, S100, V87–88, V91
1127184	PKG7001	K128
1127271	AFB34115SCFCR09	K134
1127907	B510S08000 AS3	J86
1127915	B510S25000 AS3	J86
1127923	B510S30000 AS3	J86
1128324	AFB24115SCFCR09	K134
1128691	NPR13M10N K68	E35
1129375	5.34050-028450	J88
1129376	5.34050032350	J88
1129377	5.34050-032500	J88
1129378	5.34050-040450	J88
1129379	5.34050-040600	J88
1129380	5.34050-048450	J88
1129381	5.34050-048600	J88
1129382	5.34050-058450	J88
1129383	5.34050-058600	J88
1130286	364.010	H72–73, H75, H77, H79, H81–82, H84–86, H122
1130295	364.011	H72–75, H77–79, H81–82, H84–86, H122
1130302	11X1R020B20STN11N	W40
1130303	364.012	H72, H74–76, H78–86, H122–123
1130313	364.013	H72, H74, H76, H78, H80–81, H83–86, H123
1130686	17X1R022B16STN16N	W40
1130740	20X1R043B20STN16N	W40
1130837	22X1R025B25STN16L	W41
1130969	30X1R052B25STN27N	W40
1130977	30X1R092B25STN27L	W41
1131036	B510S08000 A30	J86
1131051	B510S15000 A30	J86
1131060	B510S20000 A30	J86
1131069	37X1R058B32STN27N	W40
1131070	B510S25000 A30	J86
1131086	37X1R098B32STN27L	W41
1131090	B510S30000 A30	J86
1131111	KM40FBH01660	K128
1131118	42X2R045B32STN27D	W43
1131119	B510S10000 AS3	J86
1131128	B510S15000 AS3	J86
1131134	B510S20000 AS3	J86
1131459	MS1488	D31, D33, D39–40
1131479	191.282	K76
1131602	191.375	J49, J52
1131646	191.405	B72, B115–119, B175–176, B186, B217, B220, B236–237, B254–255, B276–279, B395–397
1131653	191.406	B72–74, B94, B115–119, B140–142, B174, B186–187, B198, B245, B249–251, B276–279, B394, B397–398, C196, D41
1131658	191.407	B72–74, B94–95, B115–117, B119, B140–142, B186, B198, B249, B397
1131977	SN2TPKG	W40, W42–43
1132036	KM50FBH01670	K128
1132063	191.698	H122, J25, J27, J29, J31, J33, J35, J37, J39, J49–50, J52–53, J84–85
1132119	191.725	I14–15, V155–156
1132130	191.727	J87–90
1132138	191.728	J87, J89–92
1132154	191.729	J91–92
1132436	191.848	J49–50, J52–53, J84–85, V44–47
1132523	191.916	C42–45, H122–123, J25, J27, J29, J31, J33, J35, J37, J39, J85, J114
1132599	ISSN846 K9	B111–112
1132616	9X1R012B12STN10M	W40
1132781	15X1R022B16STN16T	W42
1132857	EB23035250	K143
1132931	192.057	I27
1132990	DCMT2151LF K313	B225
1133075	192.111	J84–85
1133083	192.112	J84–85
1133110	192.126	J92
1133202	PKG3242	K134, K136
1133229	192.156	J87–90
1133236	192.157	J87–91
1133280	EB13030150	K143
1133349	SN3TPKG	D74–75, W40–43
1133581	DV50BT13069	K142
1133669	R31FBHS06	K140
1133883	AFB13085SCFCR06	K134
1133894	AFB17100SCFCR06	K134
1133903	PKG2025	K134, K136
1133914	RS1608	K129
1134129	840.142.550	K122–123
1134246	192.416	J10–15, J75
1134271	192.419	J87–90
1134279	192.420	J87–90
1134285	SNMA432 K68	B100
1134298	192.421	J87–91
1134307	192.422	J87–90
1134316	192.423	J87–91
1134324	192.424	J87, J89–92
1134333	192.425	J87, J89–92
1134342	192.426	J91–92
1134353	5.34032-028115	J88
1134361	5.34032-028200	J88
1134385	192.432	H122, I14–15, J10–15, J25, J27, J29, J31, J33, J35, J37, J39, J75, J84–85, J114
1134388	5.34032-032125	J88
1134393	192.433	J25, J27, J29, J31, J33, J35, J37, J39
1134415	5.34050-028300	J88
1134425	5.34050-032200	J88
1134434	5.34050-040148	J88
1134440	5.34050-040300	J88
1134457	5.34050-048168	J88
1134464	5.34050-048300	J88
1134472	5.34050-058186	J88
1134482	5.34050-058300	J88
1134503	5.34128R028150	J87
1134512	5.34132R032100	J87
1134523	5.34132R032200	J87
1134530	5.34140R040200	J87
1134547	5.34148R048200	J87
1134555	5.34158R058300	J87
1134564	5.34170R070186	J87
1134570	5.34170R070300	J87
1134581	5.34170R070500	J87
1134588	5.34180R080204	J87
1134597	5.34180R080300	J87
1134609	5.36050154040	J91
1134614	5.34180R080500	J87
1134624	5.34240R032100	J87
1134631	5.34248R040100	J87
1134639	5.34258R048100	J87
1134650	5.34280R040080	J87
1134657	5.34280R058080	J87
1134666	5.34280R070150	J87
1134674	5.34350-090100	J92
1134725	192.530	U13
1134879	193.113	I27
1134964	192.592	J75, J84
1134971	192.593	J84–85
1135110	193.114	I27
1135177	NPL5M05 K68	E36
1135184	NPR5M02 K68	E36
1135192	NPL5M02 K68	E36
1135217	NPR13M05N K68	E35
1135224	NPR5M05 K68	E36
1135346	PKG156502	K143–144
1135358	PKG7994	K145
1135369	R40FBHS06	K140
1135375	EBUFF0975	K145

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1135387	192.718	I14–15
1135404	192.720	I14–15
1135473	192.730	J92
1135481	192.731	J92
1135617	840.142.720	K122–123
1135623	840.142.940	K122–123
1135642	RS1610	K129
1135662	RS1612	K129
1135739	NPL13M05N K68	E35
1135802	KM63BT13065	K141
1135826	19X1R023B20STN16T	W42
1135984	170.008	J90–92
1136105	192.888	I14–15
1136108	112.403	E15–16
1136114	192.889	I14–15
1136116	112.404	E15–17, E20, E22
1136144	112.505	E16
1136174	114.114	E17, E20, E22
1136242	192.902	J75, J84–85
1136247	118.204	E18–19
1136251	192.903	J84–85
1136295	118.314	E18–19
1136414	192.932	V58
1136436	193.115	I27
1136445	193.116	I27
1136625	121.612	E15–16, E18, S64, S67
1136633	121.616	E15–17, E19–20, E22, E55, E61, S70
1136675	121.808	K48–50
1136703	121.812	E17, K48–50
1136713	121.816	E17–23
1136743	121.825	E19, E21, E23
1136819	199.123	H87
1136858	5.36050-154050	J91
1136949	360.510	I25–26
1136955	360.511	I25–26
1137111	125.625	K48–50
1137209	125.820	J84–85
1137229	125.830	J84–85
1137405	128.508	H87
1137412	128.510	H87
1137420	128.610	J75
1137479	R51FBHS06	K140
1137487	R24FBHS06	K140
1137505	R67FBHS09	K140
1137520	129.612	J84–85
1137528	129.616	J84–85
1137713	360.550	I25–27
1137720	360.551	H87, I25–27
1137835	AFB21110SCFCR09	K134
1137910	STCM25	V148–149
1137929	STN10100ISOI KC620M	W45
1137965	STN1611BSW KC610M	W46
1138019	STN1614BSW KC610M	W46
1138033	STN16150ISOE KC610M	W45
1138041	STN16150ISOE KC620M	W45
1138136	STN27200ISOE KC610M	W45
1138273	170.000	K76
1138297	170.002	K51
1138307	170.003	E15–20, E22, E55, E61, I14, K51, S64, S67, S70, S121–123
1138315	170.004	E17–23, J90, K48–51
1138323	170.005	I14, J91, K48–50
1138331	170.006	J90–91, K48–50
1138413	170.023	J10–15, J25, J27, J29, J31, J33, J35, J37, J39
1138430	170.024	I25–27, J25, J27, J29, J31, J33, J35, J37, J39, J49–50, J52–53, J114
1138438	170.025	I14–15, I25–27, J25, J27, J29, J31, J33, J35, J37, J39, J49–50, J52–53, J114, S4–5, S8–10, S14, S17, S20, V44–47, V51–54, V62
1138446	170.026	J49, J52–53, V58
1138455	170.027	J10–15
1138465	170.028	I14–15, J10–15, J25, J27, J29, J31, J33, J35, J37, J39, J114
1138748	170.135	K51
1138755	170.136	K51
1139210	190.076	I27
1139321	190.116	J75
1139429	190.195	I27
1139563	360.513	I25–26
1139601	B510S10000 A30	J86
1139637	190.371	I27
1140602	EB38040400	K143
1146699	CKM35	B74, B115, B140–142, B186, B397
1147002	ICSN846 K9	B63–64
1147269	MS1454	B203, K79
1150356	460.716	J92
1150624	5.34280R048080	J87
1150802	A20NVJCR3	E47
1151411	MS1276	J91
1152199	SPG422 K68	B171
1152584	E08KCTFPR2 KWH	B184, B392
1152586	E08RCTFPR2 KWH	B184, B392
1152588	E10MCTFPR2 KWH	B184, B392
1152590	E10SCTFPR2 KWH	B184, B392
1152592	E12QCTFPR3 KWH	B184, B392
1152593	E12QCTFPL3 KWH	B184, B392
1152594	E12SCTFPR3 KWH	B184, B392
1152595	E12SCTFPL3 KWH	B184, B392
1152598	E16TCTFPR3 KWH	B184, B392
1152600	E08NKLCR05 KWH	E45
1152601	E08NKLCL05 KWH	E45
1152602	E10NKLCR05 KWH	E45
1152603	E10NKLCL05 KWH	E45
1152604	E12NKLCR05 KWH	E45
1152605	E12NKLCL05 KWH	E45
1152606	E10NER2 KWH	C193, D36
1152607	E10NEL2 KWH	C193, D36
1152608	E12NER2 KWH	C193, D36
1152609	E12NEL2 KWH	C193, D36
1152610	E16NER3 KWH	C193, D36
1152611	E16NEL3 KWH	C193, D36
1152668	E12CTLNR2 KWH	B392
1152676	E06LSER2 KWH	D75
1152677	E06LSEL2 KWH	D75
1152678	E08LSER2 KWH	D75
1152679	E08LSEL2 KWH	D75
1152680	E10LSER3 KWH	D75
1152681	E10LSEL3 KWH	D75
1152682	E12LSER3 KWH	D75
1152683	E12LSEL3 KWH	D75
1152684	E16LSER3 KWH	D75
1152686	E16LSER4 KWH	D75
1152688	E08NER2 KWH	C193, D36
1152689	E08NEL2 KWH	C193, D36
1152690	E16NKLNR1 KWH	E45
1152692	E12SCLPR3AP5 KWH	B216
1152693	E16SCLPR3AP5 KWH	B216
1152694	E12SCLPL3AP5 KWH	B216
1152695	E16SCLPL3AP5 KWH	B216
1152698	E08NELR05 KWH	E44
1152704	E12STLPR3 KWH	B275
1152705	E12STLPL3 KWH	B275
1152706	E16STLPR3 KWH	B275
1152707	E05STFPR18	B272
1152708	E05STFPL18 KWH	B272
1152709	E06STFPR2 KWH	B272
1152710	E06STFPL2 KWH	B272
1152711	E08STFPR2 KWH	B272
1152712	E08STFPL2 KWH	B272
1152713	E10STFPR2 KWH	B272
1152714	E10STFPL2 KWH	B272
1152715	E12STFPL3 KWH	B272
1152716	E16STFPR3 KWH	B272
1152722	E05KSCLPR18 KWH	B214
1152723	E05KSCLPL18 KWH	B214
1152724	E06SCLPR2 KWH	B214
1152725	E06SCLPL2 KWH	B214
1152726	E08SCLPR2 KWH	B214
1152727	E08SCLPL2 KWH	B214
1152728	E10SCLPR2 KWH	B214
1152729	E10SCLPL2 KWH	B214
1152730	E12SCLPR2 KWH	B214
1152731	E12SCLPL2 KWH	B214
1152732	E10SCLPR3 KWH	B214
1152733	E10SCLPL3 KWH	B214
1152734	E12SCLPR3 KWH	B214
1152735	E12SCLPL3 KWH	B214
1152736	E16SCLPR3 KWH	B214
1152737	E16SCLPL3 KWH	B214
1152738	E06SDUPR2 KWH	B234
1152739	E06SDUPL2 KWH	B234
1152740	E08SDUPR2 KWH	B234
1152741	E08SDUPL2 KWH	B234
1152742	E10SDUPR2 KWH	B234
1152743	E10SDUPL2 KWH	B234
1152744	E12SDUPR2 KWH	B234
1152746	E12SSDUPR3 KWH	B234
1152747	E12SSDUPL3 KWH	B234
1152748	E16TSDUPR3 KWH	B234
1152749	E16TSDUPL3 KWH	B234
1152750	E03HSWLPR15 KWH	B290
1152752	E04HSWLPR15 KWH	B290
1152753	E04HSWLPL15 KWH	B290
1152754	E05SWLPR15 KWH	B290
1152755	E05SWLPL15 KWH	B290
1152756	E06SWLPR2 KWH	B290
1152757	E06SWLPL2 KWH	B290
1152758	E08SWLPR2 KWH	B290
1152759	E08SWLPL2 KWH	B290
1152760	E10SWLPR3 KWH	B290
1152761	E10SWLPL3 KWH	B290
1152762	E12SWLPR3 KWH	B290
1152764	E16SWLPR3 KWH	B290
1152766	E16STLPL3 KWH	B275
1152767	E06STLPR2 KWH	B275
1152768	E06STLPL2 KWH	B275
1152769	E08STLPR2 KWH	B275
1152770	E08STLPL2 KWH	B275
1152771	E10STLPR2 KWH	B275
1152772	E10STLPL2 KWH	B275
1152777	C6420W KWH	B408
1152778	C6424W KWH	B408
1152779	C6428W KWH	B408
1152780	C6432W KWH	B408
1152782	C6440W KWH	B408
1152783	C11816W KWH	B407
1152784	C11820W KWH	B407
1152787	C11932W KWH	B409
1152789	C11940W KWH	B409
1152790	C6420 KWH	B408
1152834	E16RNNTOR2 KWH	C193
1152835	E16RNNTOL2 KWH	C193
1152836	E20SNNTOR2 KWH	C193
1153403	HSK63AKR32075M	K92
1153604	HSK63AKR50080M	K92
1153606	HSK100AKR32075M	K92
1153612	HSK100AKR80090M	K92
1156428	SNMA643 K68	B100
1156449	4111593VRS	B168, B386
1159961	CNMG432 K313	B47
1159964	CNMG432P K313	B52
1159971	SNMG432 K313	B100
1159980	VNMG332P K313	B147
1160004	RNMA43 K68	B97
1160005	RNMA54 K68	B97
1160013	CNMA432 K68	B47
1160018	CNMG431 K68	B47
1160019	CNMG432 K68	B47
1160020	CNMG433 K68	B47
1160025	CNMG643 K68	B47
1160027	DNMG432 K68	B78
1160039	SNMG433 K68	B100
1160060	TNMG433 K68	B122
1160068	VNMG332 K68	B145
1160069	VNMG333 K68	B145
1160070	VNMG432 K68	B145
1160071	VNMG433 K68	B145
1160077	VNGA331 K68	B144
1160078	VNGA332 K68	B144
1161093	VNGG332LF K313	B144
1161095	CNMP431 K313	B56
1161096	CNMP432 K313	B56
1161098	CNMP643 K313	B56
1161105	VNGP331K K313	B145
1161106	VNGP332K K313	B145
1161107	SNMP643 K313	B108
1161108	TNMP331 K313	B129
1161109	TNMP332 K313	B129
1161112	CNGP431 K313	B46
1161113	CNGP432 K313	B46
1161114	CNGP433 K313	B46
1161116	CNGP543K K313	B47
1161118	DNGP431 K313	B77
1161119	DNGP432 K313	B77
1161121	DNGP441 K313	B77
1161124	VNMP331 K313	B149
1161125	VNMP332 K313	B149
1161127	VNGP432 K313	B144
1161146	CNMP431 K68	B56
1161147	CNMP432 K68	B56
1161148	CNMP433 K68	B56
1161155	CNMS432 K68	B57
1161157	CNMS642 K68	B57
1161158	CNMS643 K68	B57
1161159	DNMP431 K68	B85
1161160	DNMP432 K68	B85
1161161	DNMP433 K68	B85
1161168	DNMS432 K68	B86
1161172	SNMP643 K68	B108
1161173	SNMS432 K68	B108
1161175	SNMS643 K68	B108
1161182	TNMP434 K68	B129
1161186	CNGP431 K68	B46
1161187	CNGP432 K68	B46
1161191	TNMS331 K68	B130
1161192	TNMS332 K68	B130
1161194	TNMS432 K68	B130
1161199	VNMP331 K68	B149
1161200	VNMP332 K68	B149
1161201	VNMP331K K68	B149
1161202	VNMP332K K68	B149
1161203	VNMS331 K68	B149
1161204	VNMS332 K68	B149
1162181	CCGT21505HP K313	B189
1162182	CCGT2151HP K313	B189
1162183	CCGT32505HP K313	B189
1162184	CCGT3251HP K313	B189
1162185	CCGT431HP K313	B189
1162186	CCGT432HP K313	B189
1162187	CCMT2151LF K313	B191
1162189	CCMT32505LF K313	B191
1162190	CCMT3251LF K313	B191
1162191	CCMT3252LF K313	B191
1162192	CDHB120605 K313	B199
1162194	CPGT32505HP K313	B205
1162195	CPGT3251HP K313	B205
1162199	CPMT2151LF K313	B207
1162200	CPMT2152LF K313	B207
1162204	DCGT21505HP K313	B224
1162205	DCGT2151HP K313	B224
1162206	DCGT32505HP K313	B224
1162207	DCGT3251HP K313	B224
1162208	DCGT3252HP K313	B224
1162209	DCMT21505LF K313	B225
1162211	DCMT3251LF K313	B225
1162212	DCMT3252LF K313	B225
1162216	DPGT3251HP K313	B231
1162223	TPMT2151LF K313	B268
1162225	VBGT221LF K313	B280
1162226	VBGT3305LF K313	B280
1162228	VBGT331HP K313	B280
1162229	VBGT332HP K313	B280
1162230	VBMT221LF K313	B281
1162233	VBMT3305LF K313	B281
1162234	VBMT331LF K313	B281
1162235	VBMT332LF K313	B281
1162241	RCGT0803M0HP K313	B238
1162242	RCGT10T3M0HP K313	B238
1162243	RCGT1204M0HP K313	B238
1162245	RCMT325 K313	B240
1162246	RCMT0602M0 K313	B240
1162247	RCMT0803M0 K313	B240
1162249	RCMT1204M0 K313	B240
1162250	RCMT1605M0 K313	B240
1162251	RCMT2006M0 K313	B240
1162254	TCGT2151HP K313	B256
1162255	TCGT3251HP K313	B256
1162256	TCGT3252HP K313	B256
1162272	CPMT2151LF K68	B207
1162274	CPMT3252LF K68	B207

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1162288	VBGT2205LF K68	B280
1162289	VBGT331HP K68	B280
1162296	RCGT0803M0HP K68	B238
1162297	RCMT0602M0 K68	B240
1162586	SPU422 K68	B171
1162732	TPU221 K68	B178
1162733	TPU222 K68	B178
1162734	TPU321 K68	B178
1162735	TPU322 K68	B178
1162737	TPU432 K68	B178
1162738	TPU433 K68	B178
1163009	CPGM3251 K313	B205
1163010	CPGM3252 K313	B205
1163033	TD6P K68	B266
1163051	CPGM21505 K68	B205
1163052	CPGM2151 K68	B205
1163054	CPGM32505 K68	B205
1163055	CPGM3251 K68	B205
1163056	CPGM3252 K68	B205
1163276	NPR508 K313	E35
1163277	NPL508 K313	E35
1163280	NPR505 K313	E35
1163281	NPR51 K313	E35
1163283	NPL505 K313	E35
1163284	NPL51 K313	E35
1163285	NPL52 K313	E35
1163286	VPGR331 K313	B369, E38
1163287	VPGR332 K313	B369, E38
1163311	NPR505 K68	E35
1163312	NPR51 K68	E35
1163313	NPR52 K68	E35
1163314	NPL505 K68	E35
1163315	NPL51 K68	E35
1163316	NPL52 K68	E35
1163317	NPR1305 K68	E34
1163323	NPL132F K68	E34
1163325	VPGR3305 K68	E38
1163326	VPGR331 K68	E38
1163327	VPGR332 K68	E38
1163328	VPGR333 K68	B369, E38
1163336	NPGR51R K68	E33
1163338	NPGR51L K68	E33
1163341	DPGR432 K68	E32
1163532	RCMK23 K313	E69
1163533	RCMK35 K313	E69
1163535	RCMK152 K313	E69
1164694	SPU421 K68	B171
1173988	HSK100AKR63100M	K92
1175211	3.77000R028V	J84
1175212	3.77000R031V	J84
1175225	193.281	J10–15, J25, J27, J33, J35
1176134	B105A08200 K10	G25
1176636	TRAOL202D	E70
1176804	STN22300ISOIC KC610M	W45
1176808	STN27350ISOIC KC610M	W45
1176964	15X1R020B16STN16C	W42
1176967	25X1R040B25STN27C	W42
1176970	10X1R015B20STN11T	W42
1178986	35X1R055B32STNB38N	W41
1180107	RNMG64 K313	B97
1180737	TPG433T0820 KY3500	B320
1180917	SDET43PDSR8GB KC725M	T116, T123, U39
1181980	DNGA442T0820 KY3500	B314
1181982	SNGA643T0820 KY3500	B314
1181984	TNGA332T0820 KY3500	B314
1181985	TNGA333T0820 KY3500	B314
1181986	WNGA432T0820 KY3500	B315
1181987	WNGA433T0820 KY3500	B315
1181988	WNGA434T0820 KY3500	B315
1181989	CNGA432T0820 KY3500	B313
1181990	CNGA433T0820 KY3500	B313
1181991	CNGA434T0820 KY3500	B313
1181992	CNGA543T0820 KY3500	B313
1181993	CNGA544T0820 KY3500	B313
1181994	CNGA643T0820 KY3500	B313
1181995	CNGA644T0820 KY3500	B313
1181996	SNGA432T0820 KY3500	B314
1181997	SNGA433T0820 KY3500	B314
1181998	SNGA434T0820 KY3500	B314
1181999	SNGA543T KY3500	B314
1182000	SNGA544T KY3500	B314
1182002	DNGA432T0820 KY3500	B314
1182003	DNGA433T0820 KY3500	B314
1182004	DNGA434T0820 KY3500	B314
1182005	DNGA443T0820 KY3500	B314
1182006	VNGA332T0820 KY3500	B315
1182008	TNGA334T0820 KY3500	B314
1182363	NT1L K68	D23
1182370	NTB3RB K68	D18
1182373	NTB3LB K68	D18
1182375	NTB2RA K68	D17
1182379	NTB3LA K68	D17
1182853	SPG422 K313	B171
1182856	SPG633 K313	B171
1182877	SNG322T0820 KY3500	B318
1182878	SNG432T0820 KY3500	B318
1182879	SNG433T0820 KY3500	B318
1182880	SNG434T0820 KY3500	B318
1182882	SNG438T0820 KY3500	B318
1182884	SNG454T0820 KY3500	B318
1182886	SNG634T0820 KY3500	B318
1182921	SPG321 K68	B171
1182922	SPG322 K68	B171
1182925	SPG421 K68	B171
1182926	SPG423 K68	B171
1182929	SPG632 K68	B171
1183203	TPG221 K313	B177
1183205	TPG321 K313	B177
1183206	TPG322 K313	B177
1183207	TPG323 K313	B177
1183209	TPG3205 K313	B177
1183210	TPG431 K313	B177
1183211	TPG432 K313	B177
1183232	TNG332T0820 KY3500	B319
1183236	TNG434T0820 KY3500	B319
1183237	TPG322T0820 KY3500	B320
1183238	TPG323T0820 KY3500	B320
1183239	TPG432T0820 KY3500	B320
1183254	TPG221 K68	B177
1183255	TPG222 K68	B177
1183257	TPG321 K68	B177
1183258	TPG322 K68	B177
1183260	TPG324 K68	B177
1183262	TPG3205 K68	B177
1183264	TPG431 K68	B177
1183265	TPG432 K68	B177
1183266	TPG433 K68	B177
1183267	TPG434 K68	B177
1183421	CPG421 K313	B164
1183422	CPG422 K313	B164
1183435	CNG432T0820 KY3500	B316
1183436	CNG433T0820 KY3500	B316
1183437	CNG434T0820 KY3500	B316
1183439	CNG453T0820 KY3500	B316
1183457	CPG421 K68	B164
1183458	CPG422 K68	B164
1183542	RPG42 K313	B166
1183544	RCGV45 K313	B166
1183553	DNGX120708T02020 KY3500	B317
1183554	DNGX120712T02020 KY3500	B317
1183555	DNGX120716T02020 KY3500	B317
1183557	SNGX453T0820 KY3500	B318
1183558	SNGX454T0820 KY3500	B318
1183560	RNG65T0820 KY3500	B318
1183562	DNGX452T0820 KY3500	B317
1183563	DNGX453T0820 KY3500	B317
1183564	DNGX454T0820 KY3500	B317
1183567	ENGX454T0820 KY3500	B317
1183572	SNGX556T0820 KY3500	B318
1183574	RNG43T0820 KY3500	B318
1183575	RNG45T0820 KY3500	B318
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
1185809	S447	T64
1185937	DFT370R4WD40M	J50
1185959	DFT410R4WD40M	J50
1186677	SNGX554T0820 KY3500	B318
1190977	1.78025R300	E19
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	I26
1191055	3.37101R832	I14
1191056	3.37111R332	I14
1191057	3.37111R832	I14
1191058	3.37120R732	I26
1191059	3.37121R832	I14
1191060	3.37131R332	I14
1191061	3.37140R732	I26
1191062	3.37141R832	I14
1191063	3.37151R332	I14
1191072	3.42805R001 CS5	I30
1191073	3.42807R001 CS5	I30
1191074	CBTF200R2WD20N3M	J114
1191075	CBTF220R2WD20N3M	J114
1191076	CBTF260R2WD20N2M	J114
1191103	DFT260R4WD32M	J50
1191130	3.76055R032V	J82–83
1191131	3.76063R032V	J82–83
1191132	3.76073R040V	J82–83
1191133	3.76084R048V	J82–83
1191134	3.76102R058V	J82–83
1191135	3.77000R024V	J84
1191136	3.77000R025V	J84
1191137	3.77000R026V	J84
1191138	3.77000R027V	J84
1191139	3.77000R029V	J84
1191140	3.77000R038V	J84
1191141	3.77000R039V	J84
1191142	3.77000R081V	J84
1191143	3.77000R082V	J84
1191300	SPHX15T6ZCSRGP K110M	S71
1191346	SNHX1102PZTNGP K110M	U15
1191347	SNHX1203PZTNGP K110M	U15
1191395	9X1R017B20STN10M	W40
1191414	B105A03000 K10	G24
1191415	B105A03100 K10	G24
1191416	B105A03200 K10	G24
1191417	B105A03300 K10	G24
1191418	B105A03500 K10	G24
1191419	B105A04000 K10	G24
1191420	B105A04200 K10	G24
1191421	B105A04500 K10	G24
1191422	B105A05000 K10	G24
1191423	B105A05100 K10	G24
1191424	B105A05500 K10	G24
1191425	B105A05700 K10	G24
1191426	B105A05800 K10	G24
1191427	B105A06000 K10	G24
1191428	B105A06300 K10	G24
1191429	B105A06400 K10	G24
1191430	B105A06500 K10	G24
1191431	B105A06700 K10	G25
1191432	B105A06800 K10	G25
1191433	B105A07000 K10	G25
1191434	B105A07100 K10	G25
1191435	B105A07500 K10	G25
1191436	B105A07800 K10	G25
1191437	B105A08000 K10	G25
1191438	B105A08400 K10	G25
1191439	B105A08500 K10	G25
1191440	B105A08700 K10	G25
1191441	B105A08800 K10	G25
1191442	B105A09000 K10	G25
1191443	B105A09500 K10	G25
1191444	B105A09700 K10	G25
1191445	B105A09800 K10	G25
1191446	B105A10000 K10	G25
1191448	B105A10200 K10	G25
1191449	B105A10300 K10	G25
1191450	B105A10500 K10	G25
1191451	B105A10700 K10	G25
1191452	B105A11000 K10	G25
1191453	B105A11800 K10	G25
1191454	B105A12000 K10	G25
1191455	B105A12500 K10	G25
1191456	B105A12700 K10	G25
1191457	B105A12800 K10	G25
1191458	B105A13000 K10	G25
1191459	B105A13800 K10	G25
1191460	B105A14000 K10	G25
1191461	B105A14200 K10	G26
1191462	B105A14500 K10	G26
1191463	B105A15000 K10	G26
1191464	B105A15100 K10	G26
1191465	B105A15800 K10	G26
1191466	B105A16000 K10	G26
1191467	B105A16500 K10	G26
1191468	B105A18000 K10	G26
1191469	B105A20000 K10	G26
1191470	B105A20500 K10	G26
1191612	B411A05000 KF1	G94
1191613	B411A06000 KF1	G94
1191614	B411A08000 KF1	G94
1191616	B411A10000 KF1	G95
1191617	B411A12000 KF1	G95
1191618	B411A14000 KF1	G95
1191619	B411A16000 KF1	G95
1191620	B501Z06000 K10	G144
1191628	B505Z04000 K10	G144
1191629	B505Z06000 K10	G144
1191630	B505Z10000 K10	G144
1191631	B505Z12000 K10	G144
1191632	B505Z16000 K10	G144
1191633	B505Z20000 K10	G144
1191970	DV50BKR32040M	K91
1191971	DV50BKR50040M	K91
1192275	KR32KR32038100M	K93
1192276	KR32KR32047100M	K93
1192280	KR50KR50065100M	K93
1192281	KR50SVS4B094M	K83
1192295	KRDCKR32M	K91–93
1192296	KRDCKR50M	K91–93
1192326	LSSR204D	D71
1192442	S2020LSER3	D74
1192530	SPHX060204R21 KM1	J116
1192534	SPHX070304R21 KM1	J116
1192535	SPHX070304R22 KM1	J117
1192538	SPHX090304R21 KM1	J116
1192539	SPHX090304R22 KM1	J117
1192616	TRAOL163D	E70
1192617	TRAOL2015D	E70
1192618	TRAOR243E	E70
1192621	TRTOR1615D	E71
1196489	MS1438	B290–291
1197315	KM80BT13070	K141
1197539	SPHX1205ZCERGP KCK15	S65
1197540	SPHX1205ZCELGP KCK15	S65
1197721	410.081	E15, S64, S67
1197803	3.37530R010	I27
1198114	SNHX12L5PZTNGP K110M	U15
1198117	SNHX12L5PZFNGE K110M	U14
1198178	SCMT325211 KT315	B246
1198179	DCMT2150511 KT315	B224
1198180	VBMT220511 KT315	B280
1198181	SCMT325111 KT315	B246
1198182	SCMT43111 KT315	B246
1198183	VBMT33111 KT315	B280
1198184	VBMT33211 KT315	B280
1198185	TCMT215111 KT315	B256
1198186	TCMT325111 KT315	B256
1198187	CCMT215111 KT315	B190
1198188	CCMT325111 KT315	B190
1198189	CCMT325211 KT315	B190
1198191	DCMT215111 KT315	B224
1198192	DCMT325111 KT315	B224
1198564	B411A03200 KF1	G94
1198566	B411A03300 KF1	G94
1198568	B411A03800 KF1	G94

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1198570	B411A04000 KF1	G94
1198572	B411A04200 KF1	G94
1198574	B411A04500 KF1	G94
1198576	B411A04600 KF1	G94
1198578	B411A04650 KF1	G94
1198580	B411A04800 KF1	G94
1198582	B411A04900 KF1	G94
1198586	B411A05100 KF1	G94
1198588	B411A05200 KF1	G94
1198590	B411A05500 KF1	G94
1198592	B411A05550 KF1	G94
1198594	B411A05800 KF1	G94
1198597	B411A06300 KF1	G94
1198599	B411A06400 KF1	G94
1198602	B411A06500 KF1	G94
1198606	B411A06600 KF1	G94
1198608	B411A06800 KF1	G94
1198610	B411A07000 KF1	G94
1198613	B411A07400 KF1	G94
1198617	B411A07500 KF1	G94
1198620	B411A07800 KF1	G94
1198625	B411A08400 KF1	G94
1198628	B411A08500 KF1	G94
1198630	B411A09000 KF1	G95
1198632	B411A09300 KF1	G95
1198635	B411A09500 KF1	G95
1198637	DNMG33233 KT315	B78
1198640	B411A09800 KF1	G95
1198644	B411A10200 KF1	G95
1198645	DNMG33133 KT315	B78
1198648	B411A10500 KF1	G95
1198650	B411A11000 KF1	G95
1198652	B411A11200 KF1	G95
1198656	B411A11500 KF1	G95
1198658	B411A11800 KF1	G95
1198663	B411A12500 KF1	G95
1198665	B411A13000 KF1	G95
1198667	B411A13500 KF1	G95
1198670	B411A13800 KF1	G95
1198679	B411A14500 KF1	G95
1198682	B411A15000 KF1	G95
1198684	B411A15500 KF1	G95
1198686	CNMG43233 KT315	B48
1198689	DNMG44133 KT315	B78
1198691	B411A16500 KF1	G95
1198693	DNMG44233 KT315	B78
1198694	B411A17000 KF1	G95
1198697	B411A17500 KF1	G95
1198701	B411A18000 KF1	G95
1198703	B411A19000 KF1	G95
1198704	B411A19500 KF1	G95
1198707	B411A20000 KF1	G95
1198711	B411A21000 KF1	G95
1198714	B411A22000 KF1	G95
1198716	B411A23000 KF1	G95
1198718	B411A24000 KF1	G95
1198721	B411A25000 KF1	G95
1198724	B501Z04000 K10	G144
1198733	B501Z10000 K10	G144
1198743	B505Z08000 K10	G144
1198753	B501Z12000 K10	G144
1199223	B105A12100 K10	G25
1199225	B105A08300 K10	G25
1199228	B105A04700 K10	G24
1199229	B105A06100 K10	G24
1199238	B105A08100 K10	G25
1199243	B105A10100 K10	G25
1199251	B105A10800 K10	G25
1199306	B105A07600 K10	G25
1199308	B105A11100 K10	G25
1199311	B105A09100 K10	G25
1199316	B105A11700 K10	G25
1199334	B105A03700 K10	G24
1199337	B105A03800 K10	G24
1199348	B105A04650 K10	G24
1199351	B105A04800 K10	G24
1199360	B105A05200 K10	G24
1199365	B105A05550 K10	G24
1199380	B105A06600 K10	G25
1199387	B105A07400 K10	G25
1199406	B105A09300 K10	G25
1199421	B105A11200 K10	G25
1199424	B105A11500 K10	G25
1199434	B105A13100 K10	G25
1199438	B105A13500 K10	G25
1199455	B105A15500 K10	G26
1199469	B105A17000 K10	G26
1199472	B105A17500 K10	G26
1199480	B105A18500 K10	G26
1199488	B105A19000 K10	G26
1199492	B105A19500 K10	G26
1199675	B105A21000 K10	G26
1199682	B105A04100 K10	G24
1199685	B105A08600 K10	G25
1201617	B105A03400 K10	G24
1201621	B105A03600 K10	G24
1201661	B105A04900 K10	G24
1201677	B105A05600 K10	G24
1201708	B105A06200 K10	G24
1201713	B105A06350 K10	G24
1201892	B105A10400 K10	G25
1202275	B411A08800 KF1	G95
1208579	3.41020R901 CS5	I16
1208588	3.41020R902 CS5	I16
1208594	3.41020R903 CS5	I16
1208601	3.41220R901 CS5	I16
1208606	3.41220R902 CS5	I16
1208615	3.41220R903 CS5	I16
1208627	3.41020R900 KMF	I17
1208635	3.42805R001 KMF	I30
1208642	3.42807R001 KMF	I30
1208648	3.41220R900 KMF	I17
1208764	SPHX060204R22 KM1	J117
1208782	SPHX120404R21 KM1	J116
1208789	SPHX120404R22 KM1	J117
1208830	SPHX150504R21 KM1	J116
1208833	SPHX150504R22 KM1	J117
1221501	SPHX120508PCSRGP KCK15	S68
1223594	SPHX1205PCERGPB KCK15	S68
1229047	KSSR150SP10T30F2	T109
1229078	KSSR200SP10T30F3	T109
1229079	KSSR250SP10T30F4	T109
1229080	KSSR300SP10T30F4	T109
1229081	KSSR400SP10T30F5	T109
1229091	KISR075SP10T30F	T108
1229092	KISR100SP10T30F	T108
1229095	KISR125SP10T30F	T108
1229096	KISR150SP10T30F	T108
1229112	KISBR150SP10T30F	T107
1229113	KISBR200SP10T30F	T107
1230196	B105A04300 K10	G24
1230373	CKM36	B72, B94–95, B115–119
1232019	SDJCRF083D	B228
1232519	3.76068R040V	J82–83
1236002	A08RSVMBR2E	B284
1236006	A10SSVMBR2E	B284
1236007	A12SSVMBR3E	B284
1236018	A16TSVMBR3E	B284
1242260	PT00163	E60
1243476	114.111	E17
1243527	132.151	E16
1243529	132.156	E16
1243735	192.158	J92
1243752	3.77000R083V	J84
1243753	3.77000R084V	J84
1243754	3.77000R086V	J84
1243769	302.009	J90
1243770	302.010	J90
1243771	302.011	J90
1243777	360.630	I26, I29
1243778	360.631	I26, I29
1243779	360.632	I26, I29
1243780	360.633	I26, I29
1243781	360.634	I26
1243782	360.635	I26, I29
1243783	360.636	I26, I29
1244281	1.78025R300Z	E21, E23
1245236	1.18025L310	E16
1245237	1.18025R315	E16
1245244	1.10820R310	E15
1245245	1.10825L310	E15
1245247	1.10825R310	E15
1245248	1.10825R700	E15
1245255	1.18016R110	E16
1245256	1.18020L110	E16
1245257	1.18020R110	E16
1245258	1.18020R310	E16
1245259	1.18025R310	E16
1245260	1.18032L315	E16
1245261	1.18032R315	E16
1245277	1.17125L330	E16
1245287	1.18016L110	E16
1245292	1.18025L330	E17
1245326	1.18025L315	E16
1245338	1.38020R021	E17
1245339	1.38025L021	E17
1245340	1.38025R021	E17
1245357	1.77132R400	E18
1245364	1.78032R400	E19
1245371	1.77120L100	E18
1245372	1.77120R100	E18
1245374	1.77125R300	E18
1245382	1.77225R301	E19
1245388	1.77725R301	E18
1245392	1.78012R103	E19
1245394	1.78016R100	E19
1245397	1.78020R100	E19
1245398	1.78025L300	E19
1245712	302.014	J92
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	I26
1245736	3.37080R720	I26
1245737	3.37160R732	I26
1245738	3.37180R732	I26
1245739	3.37526R006	I27
1245740	3.37528R008	I27
1245741	3.37532R012	I27
1245742	3.37534R014	I27
1245743	3.37538R016	I27
1245744	3.37540R018	I27
1245745	3.37542R020	I27
1245746	3.76063R040V	J82–83
1245747	3.76078R048V	J82–83
1245748	3.76096R058V	J82–83
1245749	3.76045R028V	J82–83
1245750	3.76050R028V	J82–83
1245751	3.76058R032V	J82–83
1245752	3.76078R040V	J82–83
1245753	3.76090R048V	J82–83
1245754	3.76096R048V	J82–83
1245755	3.76108R058V	J82–83
1245756	3.76115R070V	J82–83
1245757	3.76122R070V	J82–83
1245758	3.76130R070V	J82–83
1245759	3.76140R080V	J82–83
1245760	3.76150R080V	J82–83
1245761	3.76158R080V	J82–83
1245762	3.76162R080V	J82–83
1245818	3.77000R023V	J84
1245819	3.77000R030V	J84
1245820	3.77000R048V	J84
1245821	3.77000R049V	J84
1245822	3.77000R050V	J84
1245823	3.77000R051V	J84
1245824	3.77000R052V	J84
1245825	3.77000R053V	J84
1245826	3.77000R073V	J84
1245827	3.77000R074V	J84
1245828	3.77000R075V	J84
1245829	3.77000R076V	J84
1245830	3.77000R077V	J84
1245831	3.77000R078V	J84
1245832	3.77000R079V	J84
1245833	3.77000R080V	J84
1245834	3.77000R085V	J84
1245835	3.77000R087V	J84
1245836	3.77000R088V	J84
1245980	KSEM160R3WN20M	H73
1245983	KSEM160R5WN20M	H73
1245986	KSEM165R3WN20M	H73
1245988	KSEM165R5WN20M	H73
1245991	KSEM170R3WN20M	H73
1245993	KSEM170R5WN20M	H73
1245995	KSEM175R3WN20M	H73
1245997	KSEM175R5WN20M	H73
1245999	KSEM180R3WN20M	H73
1246001	KSEM180R5WN20M	H73
1246003	KSEM185R3WN25M	H73
1246005	KSEM185R5WN25M	H73
1246007	KSEM190R3WN25M	H73
1246008	KSEM190R5WN25M	H73
1246011	KSEM195R3WN25M	H73
1246013	KSEM195R5WN25M	H73
1246014	KSEM200R3WN25M	H73
1246017	KSEM200R5WN25M	H73
1246018	KSEM205R3WN25M	H73
1246021	KSEM205R5WN25M	H73
1246022	KSEM210R3WN25M	H73
1246024	KSEM210R5WN25M	H73
1246026	KSEM215R3WN25M	H73
1246028	KSEM215R5WN25M	H73
1246031	KSEM220R3WN25M	H73
1246032	KSEM220R5WN25M	H73
1246034	KSEM225R3WN25M	H74
1246036	KSEM225R5WN25M	H74
1246037	KSEM230R3WN25M	H74
1246040	KSEM230R5WN25M	H74
1246041	KSEM235R3WN25M	H74
1246044	KSEM235R5WN25M	H74
1246046	KSEM240R3WN25M	H74
1246048	KSEM240R5WN25M	H74
1246051	KSEM245R3WN32M	H74
1246053	KSEM245R5WN32M	H74
1246055	KSEM250R3WN32M	H74
1246057	KSEM250R5WN32M	H74
1246059	KSEM255R3WN32M	H74
1246061	KSEM255R5WN32M	H74
1246063	KSEM260R3WN32M	H74
1246065	KSEM260R5WN32M	H74
1246067	KSEM265R3WN32M	H74
1246069	KSEM265R5WN32M	H74
1246071	KSEM270R3WN32M	H74
1246073	KSEM270R5WN32M	H74
1246075	KSEM275R3WN32M	H74
1246077	KSEM275R5WN32M	H74
1246079	KSEM280R3WN32M	H74
1246081	KSEM280R5WN32M	H74
1246083	KSEM285R5WN32M	H74
1246085	KSEM290R3WN32M	H74
1246088	KSEM290R5WN32M	H74
1246089	KSEM295R3WN32M	H74
1246092	KSEM295R5WN32M	H74
1246093	KSEM300R3WN32M	H74
1246095	KSEM300R5WN32M	H74
1246098	KSEM305R3WN32M	H74
1246099	KSEM305R5WN32M	H74
1246102	KSEM310R3WN32M	H74
1246103	KSEM310R5WN32M	H74
1246106	KSEM315R3WN32M	H74
1246107	KSEM315R5WN32M	H74
1246109	KSEM320R3WN32M	H74
1246112	KSEM320R5WN32M	H74
1246166	CBTF300R2WD20N3M	J114
1246168	CBTF420R2WD32N3M	J114
1246170	CBTF180R2WD20N3M	J114
1246187	CBTF330R2WD20N3M	J114
1246188	CBTF360R2WD32N3M	J114
1246195	CBTF400R2WD32N3M	J114
1246203	CBTF240R2WD20N2M	J114

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1246205	CBTF280R2WD20N3M	J114
1246207	CBTF320R2WD20N3M	J114
1246216	CBTF460R2WD32N3M	J114
1246234	DFT250R4WD32M	J50
1246238	DFT270R4WD32M	J50
1246239	DFT280R4WD32M	J50
1246242	DFT290R4WD32M	J50
1246243	DFT300R4WD32M	J50
1246245	DFT310R4WD32M	J50
1246247	DFT320R4WD32M	J50
1246248	DFT250R4WD40M	J50
1246249	DFT260R4WD40M	J50
1246250	DFT270R4WD40M	J50
1246251	DFT280R4WD40M	J50
1246253	DFT290R4WD40M	J50
1246256	DFT300R4WD40M	J50
1246258	DFT310R4WD40M	J50
1246260	DFT320R4WD40M	J50
1246262	DFT330R4WD40M	J50
1246263	DFT340R4WD40M	J50
1246266	DFT350R4WD40M	J50
1246267	DFT360R4WD40M	J50
1246271	DFT380R4WD40M	J50
1246273	DFT390R4WD40M	J50
1246275	DFT400R4WD40M	J50
1246278	DFT420R4WD40M	J50
1246279	DFT430R4WD40M	J50
1246282	DFT440R4WD40M	J50
1246284	DFT450R4WD40M	J50
1246285	DFT460R4WD40M	J50
1246288	DFT470R4WD40M	J50
1246289	DFT480R4WD40M	J50
1246688	KBFI4	I15
1246691	KBFI5B	I15
1246696	KBFI6B	I15
1246700	KBFI7	I15
1246703	KBFI8	I15
1246704	KBFI9	I15
1246707	KBFI10	I15
1246708	KBFI11	I15
1246710	KBFI12	I15
1246714	KBFI13	I15
1246716	KBFI15	I15
1246718	KBFI16	I15
1246720	KBFI18	I15
1247650	KAP1250632	U7–8
1247652	KAP1250634	U7–8
1247660	KAP1871004	U7–8
1247663	KAP2251254	U7–8
1247666	KAP3121254	U7–8
1247668	KAP3502004	U7–8
1247669	KAP5502004	U8
1247675	KAP1250764	U7–8
1247681	KS426SNH1102	U13
1247684	KS526SNH1102	U13
1247686	KS33SNH1103	U13
1247688	KS43SNH1103	U13
1247691	KS53SNH1103	U13
1247694	KS63SNH1103	U13
1247698	KVNS020630D	U7
1247704	KVNS021180D	U7
1247710	KVNS030630D	U7
1247712	KVNS030870D	U7
1247716	KVNS031180D	U7
1247718	KVNS031580D	U7
1247721	KVNS031970D	U8
1247722	KVNS032360D	U8
1247725	KVNS040630D	U7
1247727	KVNS040870D	U7
1247730	KVNS041180D	U7
1247732	KVNS041580D	U7
1247735	KVNS042360D	U8
1247738	KVNS050630D	U7
1247740	KVNS050870D	U7
1247742	KVNS051180D	U7
1247746	KVNS051580D	U7
1247753	KVNS060870D	U7
1247757	KVNS061180D	U7
1247768	KVNS081180D	U7
1247778	KVNS101180D	U7
1247785	KVNS102360D	U8
1249028	5.34280R028080	J87
1251261	WXXNL4455X-FL	E60
1251262	WXXNR4455X-FL	E60
1253759	TRAOR1615D	E70
1255899	170.285	H88
1255900	170.286	H88
1255901	170.287	H88
1255902	170.288	H88
1255968	B105A05400 K10	G24
1258625	B105A03900 K10	G24
1260086	CC09	B200–204
1260087	CC11	B200–203
1261328	CSKPR12CA4	B174, B394
1261379	CSSPR10CA3	B176, B396
1263816	DV40BKR50060M	K91
1263825	DV40BT13069	K142
1264135	DV50BKR63060M	K91
1264136	DV50BKR80070M	K91
1270619	EB48040500	K143
1270620	EB53050550	K143
1270621	EB58050600	K143
1270939	E03HSCFDR12	B200
1270940	E03HSCLDL12A	B202
1270941	E03HSCLDR12A	B202
1270944	E03HSTLDR128	B265
1270946	E03MSCFDR12	B200
1270947	E03MSCLDR12A	B202
1270950	E03MSTLDR128	B265
1270952	E04HSCFDR12	B200
1270953	E04HSCLDL12	B202
1270954	E04HSCLDR12	B202
1270956	E04HSTFDR128	B264
1270958	E04HSTLDR128	B265
1270960	E04MSCFDR12	B200
1270961	E04MSCLDL12	B202
1270962	E04MSCLDR12	B202
1270964	E04MSTLDL128	B265
1270965	E04MSTLDR128	B265
1270968	E05HSTFDR128	B264
1270970	E05HSTLDR128	B265
1270971	E05MSTFDR128	B264
1270973	E05MSTLDR128	B265
1270981	E06MSTLDL07	B265
1270982	E06MSTLDR07	B265
1270991	E08MSTLDL07	B265
1270992	E08MSTLDR07	B265
1271036	E25MSC7DR12	B204
1271038	E03HSCLDR12	B202
1271040	E03MSCLDR12	B202
1271092	FC11	B265
1271093	FC14	B264–265
1274022	ICSN643 K9	B58–60
1274659	IRSN84 K9	B98
1274800	ISSN443 K9	B109–110
1274807	ISSN643 K9	B109–110
1279732	KRCSTFPR113F	K90
1279733	KRDCKR63M	K91–93
1279734	KRDCKR80M	K91–93
1279736	KRDE070019M	K89, K108
1279739	KRDE083019M	K89, K108
1279740	KRDE096019M	K89, K109
1279741	KRDE101023M	K89, K110
1279742	KRDE120023M	K89, K110–111
1279743	KRDE139026M	K89, K111
1279745	KRDE156026M	K89, K112
1279746	KRDE175026M	K89, K113
1279748	KRDE193026M	K89, K114
1279772	KR32KR32038050M	K93
1279775	KR32KR32047050M	K93
1279785	KR50KR50065050M	K93
1279787	KR50SVS5B094M	K83
1279791	KR63KR63085050M	K93
1279792	KR63KR63085100M	K93
1279793	KR63SVS6B126M	K83
1279797	KR80KR80095050M	K93
1279798	KR80KR80095100M	K93
1279856	KSEM165R7WN20M	H75
1279857	KSEM170R7WN20M	H75
1279858	KSEM175R7WN20M	H75
1279859	KSEM180R7WN20M	H75
1279863	KSEM185R7WN25M	H75
1279864	KSEM190R7WN25M	H75
1279866	KSEM195R7WN25M	H75
1279867	KSEM200R7WN25M	H75
1279868	KSEM205R7WN25M	H75
1279872	KSEM210R7WN25M	H75
1279873	KSEM215R7WN25M	H75
1279874	KSEM220R7WN25M	H75
1279878	KSEM225R7WN25M	H75
1279881	KSEM230R7WN25M	H75
1279882	KSEM235R7WN25M	H75
1279889	KSEM245R7WN32M	H75
1279891	KSEM250R7WN32M	H75
1279892	KSEM255R7WN32M	H75
1279893	KSEM260R7WN32M	H76
1279894	KSEM265R7WN32M	H76
1279895	KSEM270R7WN32M	H76
1279896	KSEM275R7WN32M	H76
1279898	KSEM280R7WN32M	H76
1279902	KSEM285R3WN32M	H74
1279903	KSEM285R7WN32M	H76
1279905	KSEM290R7WN32M	H76
1279906	KSEM295R7WN32M	H76
1279908	KSEM300R7WN32M	H76
1279911	KSEM305R7WN32M	H76
1279913	KSEM310R7WN32M	H76
1279914	KSEM315R7WN32M	H76
1279915	KSEM320R7WN32M	H76
1280494	K067TM2RW075STN11D	W43
1280517	K102TM2RW100STN16D	W43
1280598	K165TM2RW125STN27D	W43
1281796	LSASL103	D71
1281797	LSASL123	D71
1281798	LSASL163	D71
1281799	LSASL164	D71
1281800	LSASL83	D71
1281801	LSASR103	D71
1281802	LSASR123	D71
1281803	LSASR163	D71
1281804	LSASR164	D71
1281805	LSASR203	D71
1281812	LSSL123D	D71
1281813	LSSL163D	D71
1281814	LSSL164D	D71
1281815	LSSRDH123C	D72
1281816	LSSRDH164D	D72
1281817	LSSR123D	D71
1281818	LSSR163D	D71
1281819	LSSR164D	D71
1281820	LSSR203D	D71
1282100	MCLNR16CA4	B74
1282677	KSEM240R7WN25M	H75
1282803	MSRNL12CA4	B116
1282807	MSSNR12CA4	B117
1287636	SN5TM	W40–43
1288604	STN1616UNI KC610M	W44
1288861	A03XSCFDR12	B200
1288862	A03XSCLDL12	B201
1288863	A03XSCLDR12	B201
1288867	A03GSTLDR128	B265
1288869	A04FSCFDR12	B200
1288870	A04FSCLDL12	B201
1288871	A04FSCLDR12	B201
1288873	A04HSTFDR128	B264
1288875	A04HSTLDR128	B265
1288881	A05HSTLDR128	B265
1288895	S0612LSEL2	D74
1288896	S0612LSER2	D74
1288907	S0812LSEL2	D74
1288908	S0812LSER2	D74
1288920	S1012LSEL3	D74
1288921	S1012LSER3	D74
1288936	S1212LSEL3	D74
1288937	S1212LSER3	D74
1288958	S1620LSEL3	D74
1288960	S1620LSEL4	D74
1288961	S1620LSER3	D74
1288962	S1620LSER4	D74
1288982	S2020LSER4	D74
1289015	A03XSC7DL12	B204
1289016	A03XSC7DR12	B204
1289024	A03XSCLDR12A	B201
1291027	TRAOL162D	E70
1291029	TRAOL164D	E70
1291030	TRAOL203D	E70
1291031	TRAOL204D	E70
1291032	TRAOL242E	E70
1291033	TRAOL243E	E70
1291034	TRAOL244E	E70
1291035	TRAOR162D	E70
1291037	TRAOR163D	E70
1291038	TRAOR164D	E70
1291039	TRAOR2015D	E70
1291040	TRAOR203D	E70
1291041	TRAOR204D	E70
1291042	TRAOR2415E	E70
1291043	TRAOR244E	E70
1291085	TRHOR1615D	E70
1291086	TRHOR162D	E70
1291089	TRHOR2015D	E70
1291123	TRTOR162D	E71
1291126	TRTOR2015D	E71
1291127	TRTOR202D	E71
1291909	VBMT22111 KT315	B280
1294964	11X1R012B12STN11N	W40
1298873	4111492VRS	B168, B386
1298876	4111573VRS	B168, B386
1298879	4111603VRS	B168, B386
1298882	4111654VRS	B168, B386
1298883	4111664VRS	B168, B386
1298884	4111674VRS	B168, B386
1300343	5.34270R058100	J87
1300344	5.34280R032080	J87
1309256	D48TTB42	B409
1310704	DPGT2151LF KC5010	B231
1310705	DPGT32505LF KC5010	B231
1310707	DPGT3250LF KC5010	B231
1310718	CCGT21505LF KC5010	B189
1310719	DPGT3251HP KC5010	B231
1310720	DPGT3251LF KC5010	B231
1310721	CCGT2150LF KC5010	B189
1310723	DPGT3252HP KC5010	B231
1310724	CCGT2151HP KC5010	B189
1310725	DPGT3252LF KC5010	B231
1310726	CCGT2151LF KC5010	B189
1310728	CCGT2152LF KC5010	B189
1310730	CCGT32505HP KC5010	B189
1310733	CCGT32505LF KC5010	B189
1310735	CCGT3250LF KC5010	B189
1310737	CCGT3251HP KC5010	B189
1310739	CCGT3251LF KC5010	B189
1310740	CCGT3252LF KC5010	B189
1310746	CCGT4305HP KC5010	B189
1310750	CCGT431HP KC5010	B189
1310777	CNGP432K KC5010	B47
1310793	TPGT21505HP KC5010	B267
1310800	TPGT3251HP KC5010	B267
1310802	TPGT3252HP KC5010	B267
1310803	CPGM2151 KC5010	B205
1310805	TPGT3252LF KC5010	B267
1310838	CPGT21505LF KC5010	B206
1310839	CPGT2150LF KC5010	B206
1310841	VBMT2205LF KC5010	B281
1310842	CPGT2151LF KC5010	B206
1310844	CPGT32505HP KC5010	B205
1310845	VBMT221LF KC5010	B281
1310846	CPGT32505LF KC5010	B206
1310849	VBMT331LF KC5010	B281
1310850	CPGT3251HP KC5010	B205
1310878	CPGT3251LF KC5010	B206
1310880	DCGT32505HP KC5010	B224
1310881	DCGT3251HP KC5010	B224
1310882	DCGT3252HP KC5010	B224
1310885	DCMT2151LF KC5010	B225
1310887	DCMT32505LF KC5010	B225
1310890	DCMT3251LF KC5010	B225
1310939	TPGT2151HP KC5010	B267
1310943	TPGT2151LF KC5010	B267
1310944	DPGT21505HP KC5010	B231
1310945	DPGT2151HP KC5010	B231
1310946	TPGT3251LF KC5010	B267
1310947	DPGT21505LF KC5010	B231
1310948	VBMT332LF KC5010	B281
1310950	WNGP432K KC5010	B156
1310951	DCMT21505LF KC5010	B225
1310954	CCGT432HP KC5010	B189
1310955	CNMG432 KC5010	B47

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1310956	CNMG432MG KC5010	B57
1311193	KSEM160R7WN20M	H75
1312498	364.015	H72, H74, H81, H83, H85–86, H123
1314840	DCMT3252LF KC5010	B225
1315965	MS1489	D31–33, D39
1316525	3.42805R001 KC7215	I30
1316526	3.42807R001 KC7215	I30
1319470	IWSN322 K9	B163
1319576	S316	B409
1321012	410.083	S121–123
1322363	ODG1063ISGB KC735M	U9
1322365	ODG2087ISGB KC735M	U9
1322366	ODG3125ISGB KC735M	U9
1322367	ODG4158ISGB KC735M	U9
1322368	ODC2087IEGD KMF	U9
1322370	ODC3125IEGD KMF	U9
1322371	ODC4158IEGD KMF	U9
1322958	SPHX1205ZCTRGPK KY3500	S65
1324700	193.297	C130–131
1328560	A06MSCFCR2	B196
1328572	A08RSCFCR2	B196
1328575	A10SSCFCR2	B196
1328577	A10SSCFCL2	B196
1328578	A12SSCFCR3	B196
1328579	A12SSCFCL3	B196
1328580	A16TSCFCR3	B196
1328582	A06MSCLCR2	B197
1328583	A06MSCLCL2	B197
1328584	A08RSCLCR2	B197
1328585	A08RSCLCL2	B197
1328586	A10SSCLCR2	B197
1328587	A10SSCLCL2	B197
1328588	A10SSCLCR3	B197
1328589	A10SSCLCL3	B197
1328590	A12SSCLCR3	B197
1328591	A12SSCLCL3	B197
1328592	A16TSCLCR3	B197
1328593	A16TSCLCL3	B197
1328594	A06MSTFCR2	B261
1328596	A08RSTFCR2	B261
1328598	A08RSTFCL2	B261
1328599	A10SSTFCR2	B261
1328601	A12SSTFCR3	B261
1328602	A12SSTFCL3	B261
1328603	A16STFCR3	B261
1328604	A16STFCL3	B261
1328605	A06MSTLCR2	B262
1328606	A06MSTLCL2	B262
1328607	A08RSTLCR2	B262
1328608	A08RSTLCL2	B262
1328610	A10SSTLCR2	B262
1328611	A10SSTLCL2	B262
1328612	A12SSTLCR3	B262
1328613	A12SSTLCL3	B262
1328614	A16STLCR3	B262
1328615	A16STLCL3	B262
1328616	A06MSDUCR2	B230
1328617	A06MSDUCL2	B230
1328619	A08RSDUCR2	B230
1328621	A08RSDUCL2	B230
1328623	A10SSDUCR2	B230
1328624	A10SSDUCL2	B230
1328625	A12SSDUCR3	B230
1328626	A12SSDUCL3	B230
1328628	A16TSDUCR3	B230
1328629	A16TSDUCL3	B230
1328630	A08RSDXCR2	B230
1328632	A08RSDXCL2	B230
1328637	A12SSDXCR3	B230
1328639	A16TSDXCR3	B230
1328640	A16TSDXCL3	B230
1328642	A06MSWLCR2	B287
1328644	A08RSWLCR2	B287
1328646	A10SSWLCR3	B287
1329168	S424	S10, S14, S45, T7, V38, V70
1329354	KSEM0906R5SS100	H78
1329355	KSEM0875R5SS125	H77
1329703	KSEM0750R5SS075	H77
1329704	KSEM1031R5SS125	H78
1329705	KSEM1000R5SS125	H78
1329706	KSEM0984R5SS100	H78
1329707	KSEM1000R5SS100	H78
1329708	KSEM0969R5SS100	H78
1329709	KSEM0938R5SS100	H78
1329710	KSEM0875R5SS100	H77
1329731	KSEM0844R5SS100	H77
1329732	KSEM0813R5SS100	H77
1329733	KSEM0781R5SS100	H77
1329734	KSEM0750R5SS100	H77
1329735	KSEM0719R5SS075	H77
1329737	KSEM0656R5SS075	H77
1329932	KSEM1250R5SS125	H78
1329933	KSEM1250R5SS150	H78
1329934	KSEM1156R5SS125	H78
1329935	KSEM1188R5SS125	H78
1329936	KSEM1219R5SS125	H78
1329937	KSEM1125R5SS125	H78
1329938	KSEM1094R5SS125	H78
1330471	KSEM0625R5SS075	H77
1330472	KSEM1063R5SS125	H78
1339151	MCKNR165D	B62
1339367	MSSNR10CA3	B117
1500650	KRCSCFPR062L	K86
1501356	KRCSCFPR061L	K86
1501357	KRCSCFPR063L	K86
1503488	KSEM0688R5SS075	H77
1504247	SPHX1205ZCTRGP4SK KY3500	S65
1505110	KSEM0625R3SSF075	H82
1505111	KSEM0688R3SSF075	H82
1505112	KSEM0750R3SSF075	H82
1505113	KSEM0750R3SSF100	H82
1505115	KSEM0813R3SSF100	H82
1505116	KSEM0875R3SSF100	H82
1505117	KSEM0875R3SSF125	H82
1505119	KSEM0938R3SSF100	H82
1505120	KSEM0984R3SSF100	H82
1505122	KSEM1000R3SSF100	H83
1505123	KSEM1000R3SSF125	H83
1505125	KSEM1063R3SSF125	H83
1505127	KSEM1125R3SSF125	H83
1505128	KSEM1188R3SSF125	H83
1505130	KSEM1250R3SSF125	H83
1505132	KSEM1250R3SSF150	H83
1505138	KSEM0625R5SSF075	H82
1505171	KSEM0688R5SSF075	H82
1505174	KSEM0750R5SSF075	H82
1505177	KSEM0750R5SSF100	H82
1505179	KSEM0813R5SSF100	H82
1505180	KSEM0875R5SSF100	H82
1505181	KSEM0875R5SSF125	H82
1505183	KSEM0938R5SSF100	H82
1505184	KSEM0969R5SSF100	H82
1505188	KSEM1000R5SSF100	H83
1505189	KSEM1000R5SSF125	H83
1505190	KSEM1063R5SSF125	H83
1505191	KSEM1125R5SSF125	H83
1505194	KSEM1188R5SSF125	H83
1505196	KSEM1250R5SSF125	H83
1505198	KSEM1250R5SSF150	H83
1505208	KSEM0984R5SSF100	H82
1505366	SPHX1205ZCTR-GP1WK KY3500	S66
1505370	SPHX1205PCTRGPBK KY3500	S68
1505394	SPHX1205PCTRGP4SBK KY3500	S68
1505400	SPHX1205PCTR-GP1WBK KY3500	S69
1505865	SPHX1205PCSRGPB KC725M	S68
1505881	SPHX1205ZCERGP4S KCK15	S65
1505883	479.100	S64, S67, S70
1505923	SPHX1205PCERGP4SB KCK15	S68
1510773	170.281	H84, H88
1510776	170.282	H84, H88
1510779	170.283	H84, H88
1510781	170.284	H84, H88
1511189	VPGR331 KT315	E38
1514498	50A05RP90SP12CUFP	S67
1515716	KSEM0813R8SSF100	H84
1515717	KSEM0750R8SSF100	H84
1515718	KSEM0875R8SSF100	H84
1516937	SPHX1205ZCER-GP1W KCK15	S66
1517181	KSEM1063R8SSF125	H84
1517211	KSEM1250R8SSF150	H84
1517212	KSEM1000R8SSF125	H84
1517234	KSEM0750R8SSF075	H84
1517235	KSEM0938R8SSF100	H84
1517236	KSEM0984R8SSF100	H84
1517238	KSEM0625R8SSF075	H84
1517239	KSEM0875R8SSF125	H84
1517240	KSEM1250R8SSF125	H84
1517254	KSEM1188R8SSF125	H84
1517255	KSEM1125R8SSF125	H84
1517256	KSEM1000R8SSF100	H84
1517257	KSEM0688R8SSF075	H84
1517764	SPHX1205PCER-GP1WB KCK15	S69
1519227	KSEM0625R7SS075	H79
1519229	KSEM0656R7SS075	H79
1519230	KSEM0688R7SS075	H79
1519262	KSEM0719R7SS075	H79
1519263	KSEM0750R7SS075	H79
1519264	KSEM0750R7SS100	H79
1519265	KSEM0781R7SS100	H79
1519267	KSEM0813R7SS100	H79
1519269	KSEM0844R7SS100	H79
1519270	KSEM0875R7SS100	H79
1519271	KSEM0875R7SS125	H79
1519272	KSEM0906R7SS100	H79
1519274	KSEM0938R7SS100	H79
1519275	KSEM0969R7SS100	H79
1519276	KSEM0984R7SS100	H79
1519277	KSEM1000R7SS100	H79
1519280	KSEM1000R7SS125	H79
1519282	KSEM1031R7SS125	H80
1519285	KSEM1063R7SS125	H80
1519286	KSEM1094R7SS125	H80
1519288	KSEM1125R7SS125	H80
1519289	KSEM1156R7SS125	H80
1519292	KSEM1188R7SS125	H80
1519294	KSEM1219R7SS125	H80
1519296	KSEM1250R7SS125	H80
1519297	KSEM1250R7SS150	H80
1520056	ODG1063ISGD KC735M	U9
1520057	ODG2087ISGD KC735M	U9
1520058	ODG3125ISGD KC735M	U9
1520059	ODG4158ISGD KC735M	U9
1520076	ODC1063IEGD KMF	U9
1522026	DFT1813R4SSF150	J53
1522027	DFT1625R4SSF150	J53
1522028	DFT1563R4SSF150	J53
1522029	DFT1875R4SSF150	J53
1522030	DFT1688R4SSF150	J53
1522062	KRBB16SCLDRS406A	K79, K102
1522063	KRBB16SCFPR06085A	K79, K102
1522064	KRBB16SCFPR0611A	K79, K102
1522068	KRBB16SCFPR06135A	K79, K102
1522069	KRBB16SCFPR0616A	K79, K103
1522070	KRBB16SCFPR0619A	K79, K103
1522071	KRBB16SCFPR0622A	K79, K103
1522101	DFT1438R4SSF150	J53
1522102	DFT1750R4SSF150	J53
1522103	DFT1531R4SSF150	J53
1522104	DFT1938R4SSF150	J53
1522105	DFT1375R4SSF150	J53
1522106	DFT1500R4SSF150	J53
1522107	DFT1250R4SSF150	J53
1522108	DFT1000R4SSF150	J53
1522109	DFT1125R4SSF150	J53
1522110	DFT1625R4SSF125	J53
1522111	DFT1563R4SSF125	J53
1522112	DFT1531R4SSF125	J53
1522113	DFT1500R4SSF125	J53
1522114	DFT1469R4SSF125	J53
1522115	DFT1438R4SSF125	J53
1522117	DFT1375R4SSF125	J53
1522118	DFT1406R4SSF125	J53
1522119	DFT1313R4SSF125	J53
1522120	DFT1281R4SSF125	J53
1522121	DFT1250R4SSF125	J53
1522123	DFT1219R4SSF125	J53
1522124	DFT1188R4SSF125	J53
1522125	DFT1156R4SSF125	J53
1522126	DFT1125R4SSF125	J53
1522127	DFT1063R4SSF125	J53
1522129	DFT1094R4SSF125	J53
1522130	DFT1031R4SSF125	J53
1522133	DFT1000R4SSF100	J53
1522135	DFT0984R4SSF100	J53
1522242	DFT1000R4SSF125	J53
1522248	DFT2000R4SSF150	J53
1522249	DFT2125R4SSF150	J53
1522250	DFT2000R4SSF200	J53
1522321	DFT2125R4SSF200	J53
1522517	DFT1688R4SSF125	J53
1522848	TPGT18151LF KC5010	B267
1522850	TPGT32505HP KC5010	B267
1522905	CPGT21505HP KC5010	B205
1522907	CPGT2151HP KC5010	B205
1522942	TCGT2151HP KC5010	B256
1522943	TCGT32505HP KC5010	B256
1522945	TCGT3251HP KC5010	B256
1522946	TCGT2151LF KC5010	B256
1522947	TCGT32505LF KC5010	B256
1522948	TCGT3251LF KC5010	B256
1522949	TCGT3252LF KC5010	B256
1523196	TCGT21505HP KC5010	B256
1523329	TPGT181505LF KC5010	B267
1523354	TCGT3252HP KC5010	B256
1523501	RCGK152HP K313	E69
1527051	SCMT43211 KT315	B246
1527689	DFT0906R2SSF125	J51
1527992	DCMT325211 KT315	B224
1527995	TCMT325211 KT315	B256
1528316	DFT0938R2SSF125	J51
1528317	DFT0969R2SSF125	J51
1528318	DFT0984R2SSF125	J51
1528319	DFT1000R2SSF125	J51
1528320	DFT1031R2SSF125	J51
1528328	DV50BKR32041M	K91
1528341	DFT1063R2SSF125	J51
1528342	DFT1094R2SSF125	J51
1528343	DFT1125R2SSF125	J51
1528344	DFT1156R2SSF125	J51
1528345	DFT1188R2SSF125	J51
1528346	DFT1219R2SSF125	J51
1528347	DFT1250R2SSF125	J51
1528348	DFT1281R2SSF125	J51
1528349	DFT1313R2SSF125	J51
1528350	DFT1375R2SSF125	J51
1528361	DFT1406R2SSF125	J51
1528362	DFT1438R2SSF125	J51
1528363	DFT1469R2SSF125	J51
1528364	DFT1500R2SSF125	J51
1528365	DFT1531R2SSF125	J51
1528366	DFT1563R2SSF125	J51
1528367	DFT1625R2SSF125	J51
1528368	DFT1688R2SSF125	J51
1528369	DFT1000R2SSF150	J51
1528370	DFT1219R2SSF150	J51
1528391	DFT1250R2SSF150	J51
1528392	DFT1281R2SSF150	J51
1528393	DFT1313R2SSF150	J51
1528394	DFT1375R2SSF150	J51
1528395	DFT1406R2SSF150	J51
1528396	DFT1438R2SSF150	J51
1528397	DFT1469R2SSF150	J51
1528398	DFT1500R2SSF150	J51
1528399	DFT1531R2SSF150	J51
1528400	DFT1563R2SSF150	J51
1528401	DFT1625R2SSF150	J51
1528402	DFT1688R2SSF150	J51
1528403	DFT1750R2SSF150	J51
1528404	DFT1813R2SSF150	J51
1528405	DFT1875R2SSF150	J51
1528406	DFT1938R2SSF150	J52
1528407	DFT2000R2SSF150	J52
1528408	DFT2125R2SSF150	J52
1528409	DFT2000R2SSF200	J52
1528410	DFT2125R2SSF200	J52
1528421	DFT2250R2SSF200	J52
1528422	DFT2375R2SSF200	J52
1528423	DFT2500R2SSF200	J52
1528424	DFT2750R2SSF200	J52
1528426	DFT3000R2SSF200	J52
1528427	DFT3250R2SSF200	J52
1530058	193.300	S64, S70
1531202	KSEM0634R7SS075	H79
1531204	KSEM0884R7SS100	H79

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1531205	KSEM1011R7SS125	H79
1532254	250C20RP70SP12C4WUFP	S64
1532255	200C16RP70SP12C4WUFP	S64
1532257	125B10RP70SP12C2WUFP	S64
1532258	100B08RP70SP12C2WUFP	S64
1533937	KSEM0759R7SS075	H79
1533938	KSEM0634R5SS075	H77
1533939	KSEM0759R5SS075	H77
1533940	KSEM0884R5SS100	H77
1533981	KSEM1011R5SS125	H78
1535836	SDET433PDER8GB KC725M	T116, T123, U39
1536224	SDET43PDER8GB KC520M	T116, T123, U39
1539005	DV40BKR32041M	K91
1539678	KHSST08003	M124
1540114	KHSST08039	M124
1540142	KHSST08015	M124
1540362	KHSST08043	M36
1540367	KHSST08044	M40
1540369	KHSST08061	M36
1540411	KHSST08067	M124
1540415	KHSST08082	M124
1540432	KHSST08083	M127
1540437	KHSST08087	M124
1540438	CCLNR164DMX5	B383
1540440	KHSST08088	M127
1540442	KHSST08090	M36
1540443	CCLNL164DMX5	B383
1540445	CCLNR204DMX5	B383
1540447	CCLNL204DMX5	B383
1540453	KHSST08091	M40
1540467	KHSST08101	M124
1540473	KHSST08104	M36
1540474	KHSST08112	M124
1540475	KHSST08116	M124
1540476	KHSST08117	M127
1540479	KHSST08119	M36
1540492	CSDNN164DMX5	B383
1540495	CSKNR164DMX5	B384
1540519	KHSST08140	M124
1540523	KHSST08148	M124
1540524	KHSST08149	M127
1540531	A24CCLNR4MX5	B391
1540552	A32CCLNR4MX5	B391
1541345	KHSST08205	M36
1541367	DFT250R2WD32M	J48
1541368	DFT260R2WD32M	J48
1541369	DFT270R2WD32M	J48
1541370	DFT280R2WD32M	J48
1541374	CSKNL164DMX5	B384
1541381	DFT290R2WD32M	J48
1541382	DFT300R2WD32M	J48
1541383	DFT310R2WD32M	J48
1541384	DFT320R2WD32M	J48
1541385	DFT330R2WD32M	J48
1541386	DFT340R2WD32M	J48
1541387	DFT350R2WD32M	J48
1541388	DFT360R2WD32M	J48
1541389	DFT370R2WD32M	J48
1541390	DFT380R2WD32M	J48
1541391	DFT390R2WD32M	J48
1541392	DFT400R2WD32M	J48
1541393	DFT410R2WD32M	J48
1541394	DFT420R2WD32M	J48
1541395	DFT430R2WD32M	J48
1541396	DFT440R2WD32M	J48
1541498	KHSST08193	M127
1541500	KHSST08197	M127
1541511	KHSST08151	M124
1541532	KHSST08152	M127
1541538	KHSST08156	M36
1541545	KHSST08157	M36
1541552	KHSST08159	M40
1541555	KHSST08160	M40
1541574	KHSST08173	M127
1541576	KHSST08175	M36
1541592	KHSST08203	M36
1541605	KHSST08172	M124
1541608	KHSST08192	M124
1541621	KHSST08218	M124
1541624	KHSST08234	M124
1541627	KHSST08239	M127
1541629	KHSST08243	M36
1541632	KHSST08245	M36
1541651	KHSST08235	M127
1541654	KHSST08238	M124
1541742	A24CCLNL4MX5	B391
1541743	A32CCLNL4MX5	B391
1541847	DFT250R2WD40M	J48
1541848	DFT260R2WD40M	J48
1541849	DFT270R2WD40M	J48
1541850	DFT280R2WD40M	J48
1541851	DFT290R2WD40M	J48
1541852	DFT300R2WD40M	J48
1541853	DFT310R2WD40M	J48
1541854	DFT320R2WD40M	J48
1541855	DFT330R2WD40M	J48
1541856	DFT340R2WD40M	J48
1541857	DFT350R2WD40M	J48
1541858	DFT360R2WD40M	J48
1541859	DFT370R2WD40M	J48
1541860	DFT480R2WD40M	J48
1541871	DFT380R2WD40M	J48
1541872	DFT390R2WD40M	J48
1541873	DFT400R2WD40M	J48
1541874	DFT410R2WD40M	J48
1541875	DFT420R2WD40M	J48
1541876	DFT430R2WD40M	J48
1541877	DFT440R2WD40M	J48
1541878	DFT450R2WD40M	J48
1541879	DFT460R2WD40M	J48
1541880	DFT470R2WD40M	J48
1541901	DFT490R2WD40M	J48
1541902	DFT500R2WD40M	J48
1541903	DFT510R2WD40M	J48
1541904	DFT520R2WD40M	J48
1541905	DFT530R2WD40M	J48
1541906	DFT540R2WD40M	J48
1541931	DFT450R2WD50M	J48
1541932	DFT460R2WD50M	J48
1541933	DFT470R2WD50M	J48
1541934	DFT480R2WD50M	J48
1541935	DFT490R2WD50M	J48
1541936	DFT500R2WD50M	J48
1541951	DFT510R2WD50M	J48
1541952	DFT520R2WD50M	J48
1541953	DFT530R2WD50M	J48
1541954	DFT670R2WD50M	J49
1542020	KHSST08334	M36
1542043	DFT540R2WD50M	J48
1542044	KHSST08246	M40
1542071	DFT550R2WD50M	J48
1542072	DFT560R2WD50M	J48
1542073	KHSST08261	M124
1542074	DFT570R2WD50M	J48
1542075	KHSST08262	M127
1542076	DFT580R2WD50M	J48
1542079	KHSST08268	M124
1542080	KHSST08269	M127
1542081	DFT600R2WD50M	J48
1542082	KHSST08272	M124
1542083	DFT610R2WD50M	J49
1542084	KHSST08273	M127
1542089	KHSST08280	M36
1542090	DFT620R2WD50M	J49
1542092	DFT630R2WD50M	J49
1542093	DFT640R2WD50M	J49
1542096	DFT650R2WD50M	J49
1542097	DFT660R2WD50M	J49
1542099	DFT680R2WD50M	J49
1542105	DFT690R2WD50M	J49
1542107	DFT700R2WD50M	J49
1542112	KHSST08282	M36
1542133	KHSST08294	M124
1542134	KHSST08295	M127
1542137	KHSST08296	M36
1542145	KHSST08316	M125
1542146	KHSST08317	M128
1542148	KHSST08320	M125
1542149	KHSST08321	M128
1542153	KHSST08324	M125
1542156	KHSST08327	M128
1542157	KHSST08331	M36
1542158	KHSST08332	M36
1542159	KHSST08333	M40
1542228	KHSST08336	M36
1542250	KHSST08353	M125
1542251	KHSST08354	M128
1542252	KHSST08355	M125
1542254	KHSST08356	M128
1542258	KHSST08364	M36
1542454	KHSST08380	M125
1542455	KHSST08381	M128
1542465	KHSST08391	M36
1542493	KHSST08392	M128
1542494	KHSST08393	M36
1542567	KHSST08409	M125
1542570	KHSST08411	M125
1542586	KHSST08419	M36
1542589	KHSST08434	M125
1542590	KHSST08435	M128
1542598	KHSST08443	M36
1542599	KHSST08444	M36
1542610	KHSST08459	M125
1542611	KHSST08460	M128
1542612	KHSST08461	M125
1542613	KHSST08467	M36
1542625	KHSST08477	M125
1542628	KHSST08478	M128
1542654	KHSST08484	M36
1542699	KHSST08493	M125
1542702	KHSST08494	M128
1542752	KHSST08498	M36
1542757	KHSST08508	M125
1542759	KHSST08510	M125
1542781	DFT710R2WD50M	J49
1542782	DFT720R2WD50M	J49
1542787	KHSST08703	M157
1542790	KHSST08704	M157
1542871	KHSST08516	M36
1542879	KHSST08530	M125
1542880	KHSST08531	M128
1542881	KHSST08537	M36
1542883	KHSST08545	M125
1542884	KHSST08546	M128
1542886	KHSST08553	M125
1542887	KHSST08554	M128
1542891	KHSST08561	M125
1542893	KHSST08562	M128
1542894	KHSST08566	M36
1542895	KHSST08574	M125
1542896	KHSST08575	M128
1542897	KHSST08578	M36
1542912	KHSST08595	M125–126
1542913	KHSST08596	M128
1542914	KHSST08599	M36
1542915	KHSST08608	M126
1542917	KHSST08609	M128
1542920	KHSST08616	M126
1542921	KHSST08617	M128–129
1542924	KHSST08630	M126
1542925	KHSST08631	M129
1542941	KHSST08705	M157
1542943	KHSST08709	M157
1542945	KHSST08712	M157
1542947	KHSST08715	M157
1542952	KHSST08724	M157
1543065	551.326	B383–384, B391
1543077	554.260	B383–384, B391
1543235	DFT730R2WD50M	J49
1543236	DFT740R2WD50M	J49
1543237	DFT750R2WD50M	J49
1543238	DFT760R2WD50M	J49
1543239	DFT770R2WD50M	J49
1543240	DFT780R2WD50M	J49
1543311	DFT790R2WD50M	J49
1543312	DFT800R2WD50M	J49
1543313	DFT810R2WD50M	J49
1543314	DFT820R2WD50M	J49
1543707	KHSST27709	M130
1543711	KHSST27710	M131
1543717	KHSST27711	M41
1543733	KHSST27719	M41
1543736	KHSST27721	M130
1543737	KHSST27722	M131
1543738	KHSST27723	M41
1543744	KHSST27729	M130
1543746	KHSST27730	M131
1543749	KHSST27731	M41
1543826	KHSST27773	M130
1543830	KHSST27781	M130
1544072	KHSST27737	M130
1544075	KHSST27738	M131
1544079	KHSST27739	M41
1544083	KHSST27741	M130
1544086	KHSST27742	M131
1544092	KHSST27743	M41
1544096	KHSST27749	M130
1544097	KHSST27750	M131
1544101	KHSST27751	M41
1544107	KHSST27757	M130
1544108	KHSST27758	M131
1544109	KHSST27759	M41
1544112	KHSST27765	M130
1544113	KHSST27766	M131
1544114	KHSST27767	M41
1544146	KHSST27787	M41
1544148	KHSST27793	M130
1544150	KHSST27796	M130
1544152	KHSST27798	M41
1544153	KHSST27800	M130
1544155	KHSST27809	M130
1544236	KHSST09000	M124
1544245	KHSST09003	M127
1544247	KHSST09004	M124
1544263	KHSST09008	M124
1544266	KHSST09009	M127
1544268	KHSST09010	M124
1544364	DFT590R2WD50M	J48
1544512	KHSST09011	M127
1544513	KHSST09012	M124
1544514	KHSST09013	M127
1544515	KHSST09014	M124
1544516	KHSST09015	M127
1544520	KHSST09018	M125
1544531	KHSST09019	M128
1544533	KHSST09021	M128
1544534	KHSST09022	M125
1544537	KHSST09025	M128–129
1544538	KHSST09026	M125
1544539	KHSST09027	M128
1544540	KHSST09028	M125
1544562	KHSST09029	M128
1544563	KHSST09030	M125
1544574	KHSST09035	M128
1544579	KHSST09039	M128
1544601	KHSST09041	M128
1544603	KHSST09042	M126
1544748	KHSST09043	M128
1544769	KHSST09047	M129
1544771	KHSST09048	M126
1544781	KHSST09054	M130
1544798	KHSST09101	M36
1544800	KHSST09103	M36
1544801	KHSST09104	M36
1544802	KHSST09105	M36
1544804	KHSST09106	M36
1544807	KHSST09108	M36
1544808	KHSST09109	M36
1544811	KHSST09111	M36
1544812	KHSST09112	M36
1544813	KHSST09113	M36
1544816	KHSST09114	M36
1544817	KHSST09115	M36
1544820	KHSST09116	M36
1544852	KHSST09119	M36
1544853	KHSST09120	M36
1544854	KHSST09121	M36
1544855	KHSST09122	M36
1544856	KHSST09123	M36
1545009	KHSST09133	M41
1545192	KHSST09124	M36
1545200	KHSST09125	M36
1545203	KHSST09126	M36
1545209	KHSST09127	M36
1545210	KHSST09128	M36
1545211	KHSST09129	M41

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1545213	KHSST09130	M41
1545215	KHSST09131	M41
1545216	KHSST09132	M41
1545225	KHSST09135	M41
1545228	KHSST09137	M157
1545233	KHSST09140	M157
1545236	KHSST09143	M157
1545242	KHSST09147	M157
1545250	KHSST09151	M157
1546392	SMYE5 K9	D78
1546393	SMYI5 K9	D76, D78–79
1549256	SN3TM	W40, W42
1551609	KSEM160R10WN20M	H75
1551610	KSEM165R10WN20M	H75
1551831	KSEM170R10WN20M	H75
1551833	KSEM175R10WN20M	H75
1551834	KSEM180R10WN20M	H75
1551835	KSEM185R10WN25M	H75
1551836	KSEM190R10WN25M	H75
1551837	KSEM195R10WN25M	H75
1551838	KSEM200R10WN25M	H75
1551839	KSEM210R10WN25M	H75
1551840	KSEM220R10WN25M	H75
1551841	KSEM230R10WN25M	H75
1551842	KSEM240R10WN25M	H75
1551843	KSEM250R10WN32M	H75
1551844	KSEM260R10WN32M	H76
1551845	KSEM265R10WN32M	H76
1551846	KSEM270R10WN32M	H76
1551847	KSEM280R10WN32M	H76
1551848	KSEM290R10WN32M	H76
1551849	KSEM300R10WN32M	H76
1551850	KSEM310R10WN32M	H76
1551861	KSEM320R10WN32M	H76
1553521	SPHX1205ZCTLGPK KY3500	S65
1556483	LNEQ1245R04 KC520M	U20
1556531	LNEU1245R04 KC520M	U19
1556533	LNEU1245R08 KC520M	U19
1556535	LNEU1245R16 KC520M	U19
1556536	LNEU1245R32 KC520M	U19
1556542	LNEU1255R08 KC520M	U19
1558021	A32CRGNR4MN5	B391
1560389	CCGT2151HP KC5410	B189
1560390	CCGT32505HP KC5410	B189
1560600	CCGT21505HP KC5410	B189
1560651	CCGT3251HP KC5410	B189
1560653	CCGT431HP KC5410	B189
1560655	CCGT432HP KC5410	B189
1560692	CPGT2151LF KC5410	B206
1560693	CPGT32505HP KC5410	B205
1560694	CPGT3251HP KC5410	B205
1560698	CPGT3251LF KC5410	B206
1560699	DCGT32505HP KC5410	B224
1560714	DCGT3251HP KC5410	B224
1560715	DCGT3252HP KC5410	B224
1560717	DNGP4305 KC5410	B77
1560721	DPGT2151HP KC5410	B231
1560723	DPGT3251HP KC5410	B231
1560751	RCGK23HP KC5410	E69
1560752	RCGK35HP KC5410	E69
1560753	RCGK46HP KC5410	E69
1560756	TPGT2151HP KC5410	B267
1560757	TPGT3251HP KC5410	B267
1560759	TPGT3252HP KC5410	B267
1560781	VPGR331 KC5410	E38
1560783	VPGR332 KC5410	E38
1560784	WNGP432K KC5410	B156
1560790	CNMP431 KC5410	B56
1560795	CNMP432 KC5410	B56
1560797	CNMS432 KC5410	B57
1560799	CNMS542 KC5410	B57
1560801	CNMS642 KC5410	B57
1560803	DNMS432 KC5410	B86
1560808	SNMS643 KC5410	B108
1560829	TNMS432 KC5410	B130
1560833	VNMS331 KC5410	B149
1560834	VNMS332 KC5410	B149
1566071	46X1R100B40STNB38L	W41
1581442	H16SCLCR3	B198
1581444	H16STFPR2	B279
1581617	551.343	B391
1581689	H16SDUPR3	B237
1582600	KR50SVU65110MCLB	K88
1582734	3.76180R110	J82–83
1582739	3.76195R110	J82–83
1582742	3.76213R125	J82–83
1582745	3.76230R160	J82–83
1582750	3.76260R160	J82–83
1592413	KSEM160R1WN20M	H72
1592414	KSEM181R1WN25M	H72
1592416	KSEM200R1WN25M	H72
1592417	KSEM221R1WN25M	H72
1592418	KSEM241R1WN32M	H72
1592419	KSEM261R1WN32M	H72
1592420	KSEM281R1WN32M	H72
1592461	KSEM301R1WN32M	H72
1592463	KSEM321R1WD50M	H72
1592464	KSEM361R1WD50M	H72
1592465	KSEM181R5WN25M	H73
1592466	KSEM221R5WN25M	H73
1592467	KSEM241R5WN32M	H74
1592468	KSEM261R5WN32M	H74
1592469	KSEM281R5WN32M	H74
1592491	KSEM301R5WN32M	H74
1592492	KSEM321R5WD50M	H74
1592493	KSEM330R5WD50M	H74
1592494	KSEM340R5WD50M	H74
1592496	KSEM350R5WD50M	H74
1592498	KSEM360R5WD50M	H74
1592502	KSEM361R5WD50M	H74
1592504	KSEM370R5WD50M	H74
1592505	KSEM380R5WD50M	H74
1592507	KSEM390R5WD50M	H74
1592509	KSEM400R5WD50M	H74
1597226	SDCW43PDSR8GN KY3500	T117, T124
1597228	SDCW433PDSR8GN KY3500	T117, T124
1599327	KSEM225R10WN25M	H75
1600245	KGMSR1650N	C143
1600246	KGMSL1650N	C143
1600249	KGMSR2525M50	C144
1600250	KGMSL2525M50	C144
1600263	KGMER1650N	C145
1600264	KGMEL1650N	C145
1600270	KGMER2525M50	C145
1600271	KGMEL2525M50	C145
1600515	DFT0875R2SSF125	J51
1601557	CNMG431FF KC5010	B48
1601631	CNMG431FF KT315	B48
1601632	CNMG432FF KC5010	B48
1601636	CNMG432FF KT315	B48
1601637	DNMG442FF KC5010	B79
1601651	DNMG442FF KT315	B79
1601652	WNMG432FF KC5010	B157
1601656	TNMG332FF KC5010	B123
1601886	TNMG332FF KT315	B123
1601888	VNMG331FF KC5010	B146
1601890	VNMG332FF KC5010	B146
1601953	VNMG332FF KT315	B146
1602247	VNMG331FF KT315	B146
1602250	WNMG332FF KC5010	B157
1602304	WNMG332FF KT315	B157
1602579	TNMG331FF KT315	B123
1602604	TNMG331FF KC5010	B123
1604140	SEF040060RSS075M	I26
1604271	SEF060080RSS075M	I26
1604272	SEF080100RSS100M	I26
1604273	SEF100120RSS125M	I26
1604274	SEF120140RSS125M	I26
1604275	SEF140160RSS125M	I26
1604276	SEF160180RSS125M	I26
1604277	SEF156187RSS075	I25
1604278	SEF218250RSS075	I25
1604279	SEF265312RSS075	I25
1604280	SEF328375RSS075	I25
1604301	SEF390437RSS100	I25
1604302	SEF453500RSS100	I25
1604303	SEF500562RSS100	I25
1604304	SEF562625RSS125	I25
1604305	SEF625687RSS125	I25
1604306	SEF687750RSS125	I25
1604705	DNMG432FF KT315	B79
1604706	DNMG432FF KC5010	B79
1605207	CNMG431FN KT315	B49
1605242	CNMG432FN KT315	B49
1605250	CNMG433FN KT315	B49
1605279	DNMG432FN KT315	B79
1605334	DNMG442FN KT315	B79
1606050	50HC040M	G79
1606061	50HC060M	G79
1606062	50HC080M	G79
1606064	50HC100M	G79
1606360	SNMG432FN KT315	B101
1606485	TNMG332FN KT315	B123
1606537	H16SDUPL3	B237
1606718	WNMG432FN KT315	B157
1606881	KSEM0641R5SS075	H77
1606882	KSEM0672R5SS075	H77
1606883	KSEM0703R5SS075	H77
1606884	KSEM0734R5SS075	H77
1606885	KSEM0766R5SS100	H77
1606886	KSEM0797R5SS100	H77
1606887	KSEM0859R5SS100	H77
1606888	KSEM0922R5SS100	H78
1606889	KSEM1047R5SS125	H78
1606890	KSEM1109R5SS125	H78
1606901	KSEM1172R5SS125	H78
1606902	KSEM1203R5SS125	H78
1606903	KSEM1281R5SS150	H78
1606904	KSEM1297R5SS150	H78
1606905	KSEM1313R5SS150	H78
1606906	KSEM1328R5SS150	H78
1606907	KSEM1344R5SS150	H78
1606908	KSEM1375R5SS150	H78
1606909	KSEM1406R5SS150	H78
1606910	KSEM1422R5SS150	H78
1606911	KSEM1438R5SS150	H78
1606912	KSEM1469R5SS150	H78
1606913	KSEM1500R5SS150	H78
1606914	KSEM1514R5SS150	H78
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	DNMG331FF KC5010	B79
1608500	DNMG331FF KT315	B79
1608944	DNMG332FF KT315	B79
1608949	TNMG331FN KT315	B123
1610085	TNMG333FN KT315	B123
1610089	DNMG331FN KT315	B79
1610905	VPGR332 KT315	E38
1610983	DNMG332FN KT315	B79
1610985	DNMG441FF KC5010	B79
1610988	DNMG441FF KT315	B79
1611279	DNMG441FN KT315	B79
1611325	DNMG443FN KT315	B79
1611330	WNMG331FN KT315	B157
1611335	WNMG332FN KT315	B157
1611338	WNMG431FF KC5010	B157
1611360	KSEM181R10WN25M	H75
1611414	WNMG431FN KT315	B157
1611417	SNMG432FF KC5010	B101
1611434	KSEM205R10WN25M	H75
1611435	KSEM215R10WN25M	H75
1611436	KSEM221R10WN25M	H75
1611437	KSEM235R10WN25M	H75
1611438	KSEM241R10WN32M	H75
1611439	KSEM245R10WN32M	H75
1611440	KSEM255R10WN32M	H75
1611441	KSEM261R10WN32M	H76
1611442	KSEM275R10WN32M	H76
1611443	KSEM281R10WN32M	H76
1611444	KSEM285R10WN32M	H76
1611445	KSEM295R10WN32M	H76
1611446	KSEM301R10WN32M	H76
1612009	RCGT86ELF KC725M	V92
1612562	DNMG431FF KC5010	B79
1612565	DNMG431FF KT315	B79
1612950	DNMG431FN KT315	B79
1613451	360.516	I25
1613623	KSEM0634R3SSF075	H82
1613627	KSEM0641R3SSF075	H82
1613628	KSEM0672R3SSF075	H82
1613632	KSEM0703R3SSF075	H82
1613633	KSEM0734R3SSF075	H82
1613634	KSEM0759R3SSF100	H82
1613635	KSEM0766R3SSF100	H82
1613636	KSEM0781R3SSF100	H82
1613637	KSEM0797R3SSF100	H82
1613638	KSEM0859R3SSF100	H82
1613639	KSEM0884R3SSF100	H82
1613640	KSEM0906R3SSF100	H82
1613651	KSEM0922R3SSF100	H82
1613652	KSEM0969R3SSF100	H82
1613653	KSEM1011R3SSF100	H83
1613654	KSEM1031R3SSF125	H83
1613655	KSEM1047R3SSF125	H83
1613656	KSEM1094R3SSF125	H83
1613657	KSEM1109R3SSF125	H83
1613658	KSEM1156R3SSF125	H83
1613659	KSEM1203R3SSF125	H83
1616097	KSEM1281R3SSF150	H83
1616099	KSEM1297R3SSF150	H83
1616100	KSEM1313R3SSF150	H83
1616101	KSEM1328R3SSF150	H83
1616102	KSEM1344R3SSF150	H83
1616105	KSEM1375R3SSF150	H83
1616106	KSEM1406R3SSF150	H83
1616107	KSEM1422R3SSF150	H83
1616110	KSEM1438R3SSF150	H83
1616132	KSEM1469R3SSF150	H83
1616135	KSEM1500R3SSF150	H83
1616141	KSEM1514R3SSF150	H83
1617400	KGMSR2050N	C143
1617589	DNMG433FN KT315	B79
1617591	KGMSL2050N	C143
1617592	KGMER2050N	C145
1617593	KGMEL2050N	C145
1620372	NPGR51R KT315	E33
1620373	TPMT2151LF KT315	B268
1620374	CPMT2152LF KT315	B207
1621083	KGMSR3232P50	C144
1621084	KGMSL3232P50	C144
1621085	KGMER3232P50	C145
1621086	KGMEL3232P50	C145
1621087	MS2002	C65–73, C143–151
1623193	CCGT2152HP KC5410	B189
1623194	CCGT3252HP KC5410	B189
1623200	DCGT21505HP KC5410	B224
1623271	DCGT2151HP KC5410	B224
1623272	TCGT21505HP KC5410	B256
1623273	TCGT2151HP KC5410	B256
1623274	TCGT3251HP KC5410	B256
1623275	TCGT3252HP KC5410	B256
1623278	VBGT331HP KC5410	B280
1623279	VBGT332HP KC5410	B280
1624156	CNMG321FF KC5010	B48
1624159	CNMG322FF KC5010	B48
1624223	SNMG321FF KC5010	B101
1624227	SNMG322FF KC5010	B101
1624229	SNMG322FF KT315	B101
1624233	TNMG222FF KC5010	B123
1624424	CNMG321FN KT315	B49
1624431	VNMG331FN KT315	B146
1624432	VNMG332FN KT315	B146
1624878	EBURF1975PKG	K145
1679773	LT11NRA60CB KC5025	D61
1679775	LT11NR075ISOCB KC5025	D64
1679776	LT11NR10ISOCB KC5025	D64
1679777	LT11NR125ISOCB KC5025	D64
1679778	LT11NR15ISOCB KC5025	D64
1679779	LT16ERAG60CB KC5010	D51

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1679780	LT16ERAG60CB KC5025	D51
1690871	LT16ER05ISOCB KC5010	D54
1690872	LT16ER05ISOCB KC5025	D54
1690873	LT16ER075ISOCB KC5010	D54
1690874	LT16ER075ISOCB KC5025	D54
1690875	LT16ER10ISOCB KC5010	D54
1690876	LT16ER10ISOCB KC5025	D54
1690877	LT16ER125ISOCB KC5010	D54
1690878	LT16ER125ISOCB KC5025	D54
1690879	LT16ER15ISOCB KC5010	D54
1690880	LT16ER15ISOCB KC5025	D54
1692101	LT16ER175ISOCB KC5010	D54
1692102	LT16ER175ISOCB KC5025	D54
1692103	LT16ER20ISOCB KC5010	D54
1692109	LT16ER20ISOCB KC5025	D54
1698205	LT16ER25ISOCB KC5025	D54
1698206	LT16ER30ISOCB KC5010	D54
1698207	LT16ER30ISOCB KC5025	D54
1698208	LT16NRAG60CB KC5025	D61
1698209	LT16NRG60CB KC5025	D61
1698210	LT16NR10ISOCB KC5025	D64
1712545	840.142.250	K122–124
1712546	840.142.320	K122–123
1712547	840.142.420	K122–123
1712552	LT16NR15ISOCB KC5025	D64
1712554	LT16NR20ISOCB KC5025	D64
1712555	LT16NR25ISOCB KC5025	D64
1712556	LT11NR16UNCB KC5025	D68
1712557	LT11NR18UNCB KC5025	D68
1712558	LT11NR20UNCB KC5025	D68
1712559	LT11NR24UNCB KC5025	D68
1712561	LT11NR32UNCB KC5025	D68
1712563	LT16ER8UNCB KC5010	D58
1712564	LT16ER8UNCB KC5025	D58
1712566	LT16ER10UNCB KC5025	D58
1712567	LT16ER12UNCB KC5010	D58
1712568	LT16ER12UNCB KC5025	D58
1712569	LT16ER14UNCB KC5010	D58
1712570	LT16ER14UNCB KC5025	D58
1712586	SPHX1205ZCERGP KC520M	S65
1712601	LT16ER16UNCB KC5010	D58
1712602	LT16ER16UNCB KC5025	D58
1712603	LT16ER18UNCB KC5010	D58
1712604	LT16ER18UNCB KC5025	D58
1712605	LT16ER20UNCB KC5010	D58
1712606	LT16ER20UNCB KC5025	D58
1712607	LT16ER24UNCB KC5010	D58
1712608	LT16ER24UNCB KC5025	D58
1712609	LT16ER28UNCB KC5010	D58
1712610	LT16ER28UNCB KC5025	D58
1712611	LT16ER32UNCB KC5010	D58
1712612	LT16ER32UNCB KC5025	D58
1712614	LT16ER11WCB KC5025	D59
1712615	LT16ER14WCB KC5010	D59
1712616	LT16ER14WCB KC5025	D59
1712617	LT16ER14NPTCB KC5010	D55
1712618	LT16ER14NPTCB KC5025	D55
1712620	LT16ER115NPTFCB KC5025	D56
1712661	LT16NR8UNCB KC5025	D68
1712663	LT16NR10UNCB KC5025	D68
1712664	LT16NR12UNCB KC5025	D68
1712665	LT16NR14UNCB KC5025	D68
1712666	LT16NR16UNCB KC5025	D68
1712667	LT16NR18UNCB KC5025	D68
1712668	LT16NR20UNCB KC5025	D68
1712669	LT16NR11WCB KC5025	D69
1712670	LT16NR14WCB KC5025	D69
1712671	LT16NR115NPTCB KC5025	D65
1712672	LT16NR14NPTCB KC5025	D65
1712711	SPHX1205ZCER-GP1W KC520M	S66
1712714	SPHX1205PCERGPB KC520M	S68
1712730	NG2M150LK KC5025	C163
1712734	NG2M150RK KC5025	C162
1712949	SPHX1205PCERGP4SB KC520M	S68
1712981	SPHX1205PCER-GP1WB KC520M	S69
1713203	DFT090508MD KC7140	J101
1713307	RCGT0803M0HP KC5410	B238
1713308	RCGT10T3M0HP KC5410	B238
1713310	RCGT0803M0HP KC5010	B238
1713351	RCGT10T3M0HP KC5010	B238
1713352	RCGT1204M0HP KC5010	B238
1713356	CPGT3252LF KC5010	B206
1713359	VBGT220LF KC5010	B280
1713402	840.142.200	K122–124
1713440	DFT070408MD KC7140	J101
1713512	DFT06T308MD KC7140	J101
1713513	DFT05T308MD KC7140	J101
1713515	DFT030304MD KC7140	J101
1713517	DFT030204MD KC7140	J101
1715069	DFR0500R3SSF075	J14
1715070	DFR0531R3SSF075	J14
1715091	DFR0563R3SSF075	J14
1715092	DFR0594R3SSF075	J14
1715093	DFR0625R3SSF075	J14
1715530	841.142.250	K122–124
1721296	SPHX1205PCELGPB KCK15	S68–69
1723607	NG3094RK KC5010	C162
1723608	SPGT3252LF KC5410	B252
1723693	LT16ER15ISO KC5010	D54
1723694	LT16ER125ISO KC5010	D54
1723695	LT16ER175ISO KC5010	D54
1723696	LT16ER20ISO KC5010	D54
1723697	LT16ER25ISO KC5010	D54
1723698	LT16ER30ISO KC5010	D54
1723726	LT16EL15ISO KC5010	D54
1724012	LT11NR15ISO KC5010	D63
1724013	LT16NR10ISO KC5010	D63
1724014	LT16NR15ISO KC5010	D63
1724031	LT16NR20ISO KC5010	D63
1724040	LT16NR30ISO KC5010	D63
1724291	LT16ER32UN KC5010	D57
1724292	LT16ER28UN KC5010	D57
1724293	LT16ER24UN KC5010	D57
1724294	LT16ER20UN KC5010	D57
1724295	LT16ER18UN KC5010	D57
1724296	LT16ER16UN KC5010	D57
1724297	LT16ER14UN KC5010	D57
1724298	LT16ER12UN KC5010	D57
1724299	LT11NR16UN KC5010	D67
1724300	LT16EL05ISO KC5025	D54
1724331	LT16NR12UN KC5010	D67
1724333	LT16EL075ISO KC5025	D54
1724334	LT16ER20UNJ KC5010	D58
1724335	LT16EL10ISO KC5025	D54
1724337	LT16ER18UNJ KC5010	D58
1724338	LT16ER16UNJ KC5010	D58
1724339	80A08RP90SP12C2WUFP	S67
1724340	LT16ER14UNJ KC5010	D58
1724351	100B12RP90SP12C3WUFP	S67
1724352	LT16EL125ISO KC5025	D54
1724353	125B15RP90SP12C3WUFP	S67
1724354	LT16ER12UNJ KC5010	D58
1724356	LT16ER19W KC5010	D59
1724358	LT16EL15ISO KC5025	D54
1724360	LT16ER14W KC5010	D59
1724372	LT16EL175ISO KC5025	D54
1724373	LT16ER11W KC5010	D59
1724377	LT16EL20ISO KC5025	D54
1724378	50A05RP70SP12CUFP	S64
1724379	63A07RP70SP12CUFP	S64
1724380	80A08RP70SP12C2WUFP	S64
1724391	100B12RP70SP12C3WUFP	S64
1724392	LT16NR11W KC5010	D69
1724394	LT16EL25ISO KC5025	D54
1724395	160B18RP70SP12C3WUFP	S64
1724398	LT16ER18NPT KC5010	D55
1724400	LT16EL30ISO KC5025	D54
1724401	LT16ER14NPT KC5010	D55
1724402	LT16ER115NPT KC5010	D55
1724403	LT11NR14NPT KC5010	D64
1724405	LT16NR115NPT KC5010	D64
1724406	LT16ERA60 KC5010	D51
1724407	50A04RP90SP12CUFP	S67
1724408	LT22EL35ISO KC5025	D54
1724409	63A05RP90SP12CUFP	S67
1724411	LT16ERAG60 KC5010	D51
1724412	LT16ERG60 KC5010	D51
1724414	LT11NRA60 KC5010	D60
1724415	LT16NRA60 KC5010	D60
1724417	80A06RP90SP12C1WUFP	S67
1724418	LT16NRAG60 KC5010	D60
1724419	100B08RP90SP12C2WUFP	S67
1724420	LT16NRG60 KC5010	D60
1724421	125B10RP90SP12C2WUFP	S67
1724424	160B12RP90SP12C3WUFP	S67
1724426	LT16ERAG55 KC5010	D51
1724429	50A04RP70SP12CUFP	S64
1724432	80A06RP70SP12C1WUFP	S64
1724434	160B12RP70SP12C3WUFP	S64
1724437	LT11NL10ISO KC5025	D63
1724439	LT11NL15ISO KC5025	D63
1724494	LT16NL10ISO KC5025	D63
1724495	LT16ER10ISO KC5010	D54
1724497	LT16NL15ISO KC5025	D63
1724499	LT16NL20ISO KC5025	D63
1724524	LT16ER05ISO KC5025	D54
1724525	LT16NL25ISO KC5025	D63
1724526	LT16NL30ISO KC5025	D63
1724527	LT16ER075ISO KC5025	D54
1724562	LT16ER48UN KC5025	D57
1724563	LT16ER40UN KC5025	D57
1724564	LT16ER36UN KC5025	D57
1724565	LT16ER32UN KC5025	D57
1724566	LT16ER28UN KC5025	D57
1724591	S446	S67, S121–122, V58, V70, V77, V83, V149
1724734	LT16ER24UN KC5025	D57
1724735	LT16ER20UN KC5025	D57
1724736	LT16ER18UN KC5025	D57
1724737	LT16ER16UN KC5025	D57
1724738	LT16ER14UN KC5025	D57
1724834	LT16ER12UN KC5025	D57
1724835	LT16ER10UN KC5025	D57
1724836	LT16ER8UN KC5025	D57
1724878	NG3047RK KC5010	C162
1725015	LT16EL28UN KC5025	D57
1725017	LT16EL24UN KC5025	D57
1725018	LT16EL20UN KC5025	D57
1725053	LT16EL18UN KC5025	D57
1725054	LT16EL16UN KC5025	D57
1725055	LT16EL14UN KC5025	D57
1725056	LT16EL12UN KC5025	D57
1725058	LT16EL8UN KC5025	D57
1725060	LT11NR40UN KC5025	D67
1725108	LT16ER10ISO KC5025	D54
1725109	LT16ER125ISO KC5025	D54
1725110	LT16ER15ISO KC5025	D54
1725221	LT16ER175ISO KC5025	D54
1725222	LT16ER20ISO KC5025	D54
1725223	LT16ER25ISO KC5025	D54
1725224	LT16ER30ISO KC5025	D54
1725225	LT22ER35ISO KC5025	D54
1725461	LT22ER40ISO KC5025	D54
1725462	LT22ER45ISO KC5025	D54
1725463	LT22ER50ISO KC5025	D54
1725464	LT11NR05ISO KC5025	D63
1725465	LT11NR075ISO KC5025	D63
1725466	LT11NR10ISO KC5025	D63
1725467	LT11NR125ISO KC5025	D63
1725468	LT11NR15ISO KC5025	D63
1725469	LT11NR175ISO KC5025	D63
1725471	LT11NR20ISO KC5025	D63
1725472	LT16NR05ISO KC5025	D63
1725474	LT16NR075ISO KC5025	D63
1725475	LT16NR10ISO KC5025	D63
1725476	LT16NR125ISO KC5025	D63
1725477	LT16NR15ISO KC5025	D63
1725478	LT16NR175ISO KC5025	D63
1725511	LT16NR20ISO KC5025	D63
1725512	LT16NR25ISO KC5025	D63
1725513	LT16NR30ISO KC5025	D63
1725515	LT22NR35ISO KC5025	D63
1725516	LT22NR40ISO KC5025	D63
1725519	LT22NR45ISO KC5025	D63
1725520	LT22NR50ISO KC5025	D63
1727704	LT16NR8UN KC5025	D67
1729874	KSEM0625R10SS075	H79
1729875	KSEM0634R10SS075	H79
1729876	KSEM0656R10SS075	H79
1729877	KSEM0688R10SS075	H79
1729878	KSEM0719R10SS075	H79
1729879	KSEM0750R10SS075	H79
1729880	KSEM0750R10SS100	H79
1729921	KSEM0759R10SS100	H79
1729922	KSEM0781R10SS100	H79
1729924	KSEM0813R10SS100	H79
1729925	KSEM0844R10SS100	H79
1729926	KSEM0875R10SS100	H79
1729927	KSEM0884R10SS100	H79
1729928	KSEM0906R10SS100	H79
1729929	KSEM0938R10SS100	H79
1729952	KSEM0969R10SS100	H79
1729953	KSEM0984R10SS100	H79
1729954	KSEM1000R10SS100	H79
1729955	KSEM1000R10SS125	H79
1729956	KSEM1011R10SS125	H79
1729957	KSEM1031R10SS125	H80
1729958	KSEM1063R10SS125	H80
1729959	KSEM1094R10SS125	H80
1729960	KSEM1125R10SS125	H80
1730118	KSEM1156R10SS125	H80
1730120	KSEM1188R10SS125	H80
1730124	KSEM1219R10SS125	H80
1730131	KSEM1250R10SS125	H80
1730132	KSEM1250R10SS150	H80
1730321	DFR020204LD KC7140	J97
1732924	MS1944	C38–41, C122–125, C127–128
1743686	LT16EL8APIRD KC5025	D53
1743696	LT16EL16UNJ KC5025	D58
1743701	LT16ELA60 KC5025	D51
1743702	LT16ELAG60 KC5025	D51
1743703	LT16ELG60 KC5025	D51
1743704	LT22ELN60 KC5025	D51
1743706	LT16ELAG55 KC5025	D51
1743715	LT16EL14W KC5025	D59
1743717	LT16EL11W KC5025	D59
1743734	LT16ER32UNJ KC5025	D58
1743735	LT16ER28UNJ KC5025	D58
1743736	LT16ER24UNJ KC5025	D58
1743737	LT16ER20UNJ KC5025	D58
1743738	LT16ER18UNJ KC5025	D58
1743739	LT16ER16UNJ KC5025	D58
1743740	LT16ER14UNJ KC5025	D58
1743741	LT16ER12UNJ KC5025	D58
1743744	LT16ERA60 KC5025	D51
1743745	LT16ERAG60 KC5025	D51
1743746	LT16ERG60 KC5025	D51
1743747	LT22ERN60 KC5025	D51
1743748	LT16ERA55 KC5025	D51
1743749	LT16ERAG55 KC5025	D51
1743750	LT16ERG55 KC5025	D51
1743751	LT22ERN55 KC5025	D51
1743752	LT16ER28W KC5025	D59
1743753	LT16ER24W KC5025	D59
1743754	LT16ER20W KC5025	D59
1743755	LT16ER19W KC5025	D59
1743756	LT16ER18W KC5025	D59
1743757	LT16ER16W KC5025	D59
1743758	LT16ER14W KC5025	D59
1743759	LT16ER12W KC5025	D59
1743760	LT16ER11W KC5025	D59
1743761	LT16ER10W KC5025	D59
1743762	LT16ER9W KC5025	D59
1743763	LT16ER8W KC5025	D59
1743764	LT22ER7W KC5025	D59
1743765	LT22ER6W KC5025	D59
1743767	LT16ER14BSPT KC5025	D53
1743768	LT16ER11BSPT KC5025	D53
1743769	LT16ER27NPT KC5025	D55
1743770	LT16ER18NPT KC5025	D55
1743771	LT16ER14NPT KC5025	D55
1743772	LT16ER115NPT KC5025	D55
1743773	LT16ER8NPT KC5025	D55
1743774	LT16ER14NPTF KC5025	D55
1743775	LT16ER115NPTF KC5025	D55
1743776	LT16ER16ACME KC5025	D52
1743778	LT16ER12ACME KC5025	D52
1743779	LT16ER10ACME KC5025	D52
1743780	LT16ER8ACME KC5025	D52
1743781	LT22ER6ACME KC5025	D52
1743782	LT22ER5ACME KC5025	D52
1743783	LT16ER16STACME KC5025	D56
1743785	LT16ER12STACME KC5025	D56
1743786	LT16ER10STACME KC5025	D56
1743787	LT16ER8STACME KC5025	D56

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1743788	LT16ER6STACME KC5025	D56
1743789	LT22ER5STACME KC5025	D56
1743791	LT16ER2TR KC5025	D57
1743792	LT16ER3TR KC5025	D57
1743793	LT22ER4TR KC5025	D57
1743794	LT22ER5TR KC5025	D57
1743796	LT16ER8RD KC5025	D56
1743797	LT22ER6RD KC5025	D56
1743798	LT16ER10APIRD KC5025	D53
1743799	LT16ER8APIRD KC5025	D53
1743800	LT22ER4API382 KC5025	D52
1743803	LT22ER4API502 KC5025	D52
1743805	LT22ER5BUT75 KC5025	D53
1743810	LT11NL32UN KC5025	D67
1743824	LT16NL16UN KC5025	D67
1743826	LT16NL12UN KC5025	D67
1743827	LT16NL10UN KC5025	D67
1743829	LT11NLA60 KC5025	D60
1743830	LT16NLA60 KC5025	D60
1743831	LT16NLAG60 KC5025	D60
1743832	LT16NLG60 KC5025	D60
1743833	LT22NLN60 KC5025	D60
1743847	LT16NL11W KC5025	D69
1743899	LT11NR32UN KC5025	D67
1743900	LT11NR28UN KC5025	D67
1743901	LT11NR24UN KC5025	D67
1743902	LT11NR20UN KC5025	D67
1743903	LT11NR18UN KC5025	D67
1743904	LT11NR16UN KC5025	D67
1743908	LT16NR32UN KC5025	D67
1743909	LT16NR28UN KC5025	D67
1743910	LT16NR24UN KC5025	D67
1743921	LT16NR20UN KC5025	D67
1743922	LT16NR18UN KC5025	D67
1743923	LT16NR16UN KC5025	D67
1743924	LT16NR14UN KC5025	D67
1743925	LT16NR12UN KC5025	D67
1743926	LT16NR10UN KC5025	D67
1743927	LT11NRA60 KC5025	D60
1743928	LT16NRA60 KC5025	D60
1743929	LT16NRAG60 KC5025	D60
1743930	LT16NRG60 KC5025	D60
1743931	LT22NRN60 KC5025	D60
1743932	LT11NRA55 KC5025	D60
1743933	LT16NRA55 KC5025	D60
1743934	LT16NRAG55 KC5025	D60
1743935	LT16NRG55 KC5025	D60
1743936	LT22NRN55 KC5025	D60
1743937	LT11NR19W KC5025	D69
1743938	LT11NR14W KC5025	D69
1743939	LT16NR20W KC5025	D69
1743940	LT16NR19W KC5025	D69
1743942	LT16NR16W KC5025	D69
1743943	LT16NR14W KC5025	D69
1743944	LT16NR12W KC5025	D69
1743945	LT16NR11W KC5025	D69
1743946	LT16NR10W KC5025	D69
1743948	LT16NR8W KC5025	D69
1743949	LT22NR7W KC5025	D69
1743962	LT11NR14BSPT KC5025	D62
1743963	LT16NR14BSPT KC5025	D62
1743964	LT16NR11BSPT KC5025	D62
1743966	LT11NR18NPT KC5025	D64
1743967	LT11NR14NPT KC5025	D64
1743970	LT16NR14NPT KC5025	D64
1743971	LT16NR11SNPT KC5025	D64
1743972	LT16NR8NPT KC5025	D64
1743973	LT11NR14NPTF KC5025	D65
1743974	LT16NR14NPTF KC5025	D65
1743978	LT16NR12ACME KC5025	D61
1743979	LT16NR10ACME KC5025	D61
1743980	LT16NR8ACME KC5025	D61
1743981	LT22NR6ACME KC5025	D61
1743982	LT22NR5ACME KC5025	D61
1743983	LT16NR16STACME KC5025	D66
1743984	LT16NR14STACME KC5025	D66
1743985	LT16NR12STACME KC5025	D66
1743986	LT16NR10STACME KC5025	D66
1743987	LT16NR8STACME KC5025	D66
1743988	LT16NR6STACME KC5025	D66
1743991	LT16NR2TR KC5025	D66
1743992	LT16NR3TR KC5025	D66
1743993	LT22NR4TR KC5025	D66
1743994	LT22NR5TR KC5025	D66
1743996	LT16NR8RD KC5025	D65
1743997	LT22NR6RD KC5025	D65
1743998	LT16NR10APIRD KC5025	D62
1743999	LT16NR8APIRD KC5025	D62
1744000	LT22NR4API382 KC5025	D62
1744002	LT22NR5API403 KC5025	D62
1744003	LT22NR4API502 KC5025	D62
1744005	LT22NR5BUT75 KC5025	D63
1744006	LT22NR5BUT1 KC5025	D63
1744444	KUAM33	B119, B142, C196, D41
1744665	NG3094R KC5010	C170
1745243	193.326	S123
1746442	CTFPR12CA3	B186, B397
1747635	DCGT21505HP KC5010	B224
1748698	NG3062RK KC5010	C162
1749102	KSEM321R3WD50M	H74
1749103	KSEM330R3WD50M	H74
1749106	KSEM340R3WD50M	H74
1749109	KSEM350R3WD50M	H74
1749110	KSEM360R3WD50M	H74
1749131	KSEM361R3WD50M	H74
1749132	KSEM370R3WD50M	H74
1749133	KSEM380R3WD50M	H74
1749207	CV50RMHTS27M394	J90
1749208	CV50RMHTS32M394	J90
1749210	CV50RMHTS40M413	J90
1749263	CV50BHTS13M295	J90
1749264	CV50BHTS16M295	J90
1749266	CV50BHTS22M295	J90
1749273	CV50RMHTS50M413	J90
1749281	BT50BHTS22075M	J91
1749285	BT50BHTS32080M	J91
1749286	BT50BHTS40080M	J91
1749287	BT50BHTS50080M	J91
1749428	CV50BHTS27M295	J90
1749429	CV50BHTS32M314	J90
1749430	CV50BHTS40M314	J90
1749461	CV50BHTS50M314	J90
1749491	CV50RMHTS13M394	J90
1749492	CV50RMHTS16M394	J90
1749493	CV50RMHTS22M394	J90
1749607	KSEM390R3WD50M	H74
1749610	KSEM400R3WD50M	H74
1749648	DFR020204GD KC7140	J97
1749718	420.060	S121–123
1750433	B411A07700 KF1	G94
1753934	B411A08700 KF1	G95
1754251	DFR165R2WD32M	J10
1756488	MSSNR246D	B113
1756489	MSSNL246D	B113
1756550	KM63XMZKGMSR50Y	C148
1756574	KM63XMZKGMSLF50Y	C148
1762261	B411A05600 KF1	G94
1762299	NG3062LK KC5010	C163
1762381	NG3125RK KC5010	C162
1763116	HSK63ASVS4B139M	K84
1763118	HSK63ASVS5B139M	K84
1763375	KM50SVS4B125M	K84
1763376	KM63SVS4B110M	K84
1763378	KM50SVS5B125M	K84
1763379	KM63SVS5B110M	K84
1763382	KM80SVS6B150M	K84
1764146	NG4250LK KC5010	C164
1764148	NG4250LK KC5025	C164
1764575	NTP3L KC5010	D22
1764576	NTP3L KC5025	D22
1765641	NTC3R8E KC5010	D20
1765732	NTC3R8E KC5025	D20
1765733	NTC3R12E KC5010	D20
1765734	NTC3R12E KC5025	D20
1770917	NT3LCK KC5010	D19
1770928	KBFI14	I15
1770929	KBFI17	I15
1771602	NG3125RK KT315	C162
1771940	SDACR083D	B227
1771941	SDACL083D	B227
1771942	SDPCN062D	B229
1772113	SDPCN082D	B229
1772114	SDPCN083D	B229
1772115	SDPCN103B	B229
1772116	STACR062D	B259
1772118	STACR082D	B259
1772122	STACR103B	B259
1772124	STJCRF062D	B261
1772126	STJCRF082D	B261
1772128	STJCRF102B	B261
1772144	SWLCRF082D	B287
1772747	KSEM125R5WN16M	H73
1772748	KSEM140R5WN16M	H73
1772749	KSEM150R5WN20M	H73
1773924	360.637	I26, I29
1774499	KSEM125R3WN16M	H73
1775033	NG3125RK KC5025	C162
1775034	NG3125LK KC5010	C164
1775035	NG3125LK KC5025	C164
1775036	NG3047RK KC5025	C162
1775037	NG3062RK KC5025	C162
1775478	CM72LP	C182–184, C186–189, C191–192, C194–196, D26–30, D35, D38, D41
1775479	CM73LP	C182–184, C186–189, C191–192, C194–195, D26–30, D35, D37–38
1775726	KIPR125RP43555	V156
1775728	KIPR150RP43655	V156
1776260	ODG5197ISGB KC735M	U10
1776261	ODG6236ISGB KC735M	U10
1777860	CNMG432MP KC5025	B51
1779085	KHSST09608	M36
1779088	KHSST09609	M36
1779090	KHSST09611	M36
1779105	KHSST09615	M36
1781755	TK01338D	E60
1781756	TK01339D	E60
1782505	VPGR3305 KC5410	E38
1782830	VPGP443K KC5410	B145
1782831	TPGT18151LF KC5410	B267
1782896	RCMT43 KC5010	B240
1782902	CNMG431FW KT315	B49
1783133	CNMG432FW KT315	B49
1783134	CNMG433FW KT315	B49
1783135	DNMG331FW KT315	B80
1783136	DNMG332FW KT315	B80
1783137	DNMG431FW KT315	B80
1783138	DNMG432FW KT315	B80
1783141	WNMG331FW KT315	B158
1783142	WNMG332FW KT315	B158
1783143	WNMG431FW KT315	B158
1783144	WNMG432FW KT315	B158
1783152	CNMG431FW KC5010	B49
1783233	CNMG432FW KC5010	B49
1783234	CNMG433FW KC5010	B49
1783237	DNMG431FW KC5010	B80
1783273	WNMG332FW KC5010	B158
1783275	WNMG432FW KC5010	B158
1785086	NG2M300RK KC5025	C162
1785245	KSEM0500R3SSF075	H82
1785246	KSEM0509R3SSF075	H82
1785247	KSEM0516R3SSF075	H82
1785248	KSEM0531R3SSF075	H82
1785249	KSEM0547R3SSF075	H82
1785250	KSEM0563R3SSF075	H82
1785251	KSEM0578R3SSF075	H82
1785252	KSEM0594R3SSF075	H82
1785283	KSEM0609R3SSF075	H82
1785284	KSEM0500R5SSF075	H82
1785285	KSEM0509R5SSF075	H82
1785286	KSEM0516R5SSF075	H82
1785287	KSEM0531R5SSF075	H82
1785288	KSEM0547R5SSF075	H82
1785289	KSEM0563R5SSF075	H82
1785290	KSEM0578R5SSF075	H82
1785291	KSEM0594R5SSF075	H82
1785292	KSEM0609R5SSF075	H82
1785474	DCGT2151HP KC5010	B224
1785475	DCGT2152HP KC5010	B224
1785477	CCGT2152HP KC5010	B189
1785478	CPGT2152HP KC5010	B205
1785479	CCGT3252HP KC5010	B189
1785480	CPGT3252HP KC5010	B205
1785481	TCGT2152HP KC5010	B256
1785482	TPGT2152HP KC5010	B267
1785501	NG2M300LK KC5025	C163
1785713	VBGT331HP KC5010	B280
1785714	VBGT332HP KC5010	B280
1785715	CNGP430 KC5410	B46
1785716	CNGP4305 KC5410	B46
1785717	CNGP431 KC5410	B46
1785718	CNGP432 KC5410	B46
1785719	CNGP433 KC5410	B46
1785733	DNGP431 KC5410	B77
1785734	DNGP432 KC5410	B77
1785735	DNGP441 KC5410	B77
1785740	TNGP331 KC5410	B121
1785741	TNGP332 KC5410	B121
1785746	VNGP330 KC5410	B144
1785747	VNGP3305 KC5410	B144
1785748	CPGT21505HP KC5410	B205
1785749	CPGT2151HP KC5410	B205
1785750	CPGT2152HP KC5410	B205
1785752	CPGT3252HP KC5410	B205
1785753	DCGT2152HP KC5410	B224
1785756	TPGT2152HP KC5410	B267
1786055	KSEM0500R5SS050	H77
1786056	KSEM0500R5SS075	H77
1786058	KSEM0509R5SS075	H77
1786059	KSEM0516R5SS075	H77
1786060	KSEM0531R5SS075	H77
1786061	KSEM0547R5SS075	H77
1786062	KSEM0563R5SS075	H77
1786094	KSEM0578R5SS075	H77
1786095	KSEM0594R5SS075	H77
1786097	KSEM0609R5SS075	H77
1787513	WNGX453T0820 KY3500	B319
1791528	410.084	E18–19, E21, E23, S70
1792224	KSEM0625R1SSF075	H81
1792225	KSEM0709R1SSF075	H81
1792226	KSEM0788R1SSF100	H81
1792227	KSEM0867R1SSF100	H81
1792228	KSEM0945R1SSF100	H81
1792229	KSEM1024R1SSF125	H81
1792230	KSEM1103R1SSF125	H81
1792231	KSEM1182R1SSF125	H81
1792232	KSEM1260R1SSF125	H81
1792253	KSEM1418R1SSF125	H81
1792254	KSEM0493R1SSF075	H81
1792255	KSEM0532R1SSF075	H81
1792256	KSEM0571R1SSF075	H81
1792258	KSEM125R1WN16M	H72
1792259	KSEM136R1WN16M	H72
1792260	KSEM146R1WN20M	H72
1792262	KSEM130R3WN16M	H73
1792293	KSEM135R3WN16M	H73
1792294	KSEM136R3WN16M	H73
1792295	KSEM140R3WN16M	H73
1792296	KSEM145R3WN20M	H73
1792297	KSEM146R3WN20M	H73
1792298	KSEM150R3WN20M	H73
1792299	KSEM155R3WN20M	H73
1792301	KSEM130R5WN16M	H73
1792302	KSEM136R5WN16M	H73
1792323	KSEM135R5WN16M	H73
1792325	KSEM145R5WN20M	H73
1792326	KSEM146R5WN20M	H73
1792328	KSEM155R5WN20M	H73
1792632	NR3047RK KC5010	C166
1792683	NR3047RK KC5025	C166
1792684	NR3062RK KC5010	C166
1792685	NR3062RK KC5025	C166
1793315	NG3110R KC5025	C170
1794406	NG3M225RK KC5025	C162
1794630	BGHX15L5PCFRGG K110M	S124
1794631	BGHX15L5PCFRGG KC510M	S124
1794653	BGHX15L5PCTRGG K110M	S124
1794655	BGHX15L5PCTRGG KC510M	S124
1795485	BGHX15L5PCERGGT KD1410	S124
1795486	BGHX15L5PCERGGT KD1415	S124
1795785	NT2RK KC5025	D22
1795786	NT2LK KC5025	D22
1795787	NT3RK KC5025	D22
1795788	NT3LK KC5025	D22

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1795789	NT4RK KC5025	D22
1795790	NT4LK KC5025	D22
1795791	NTF2R KC5025	D21
1795792	NTF2L KC5025	D21
1795793	NTF3R KC5025	D21
1795794	NTF3L KC5025	D21
1795795	NTK2R KC5025	D21
1795796	NTK2L KC5025	D21
1795797	NJP3014R12 KC5025	D16
1795799	NJP3010R16 KC5025	D16
1795800	NJP3010L16 KC5025	D16
1795801	NA3R4 KC5025	D11
1795802	NA3L4 KC5025	D11
1795809	364.016	H72–73, H75, H81–82, H85–86, H122
1795810	364.017	H72–73, H75, H81–82, H85–86
1795811	170.289	H72, H81, H86, H88
1795956	170.290	H88
1795960	170.291	H88
1796047	NT2L KC5010	D17
1796048	NT2L KC5025	D17
1796049	NT2R KC5010	D17
1796050	NT2R KC5025	D17
1796051	NT3R KC5010	D17
1796052	NT3R KC5025	D17
1796083	NT3L KC5010	D17
1796084	NT3L KC5025	D17
1796085	NT4L KC5010	D17
1796086	NT4L KC5025	D17
1796087	NT4R KC5010	D17
1796088	NT4R KC5025	D17
1796090	NTP2R KC5010	D22
1796091	NTP2R KC5025	D22
1796103	NTP2L KC5010	D22
1796104	NTP2L KC5025	D22
1796105	NTP3R KC5010	D22
1796106	NTP3R KC5025	D22
1796107	NTP3R KC5410	D22
1796109	NTP4R KC5010	D22
1796110	NTP4R KC5025	D22
1796112	NTP4L KC5010	D22
1796113	NTP4L KC5025	D22
1796115	NT2RK KC5010	D22
1796116	NT2LK KC5010	D22
1796117	NT3RK KC5010	D22
1796118	NT3LK KC5010	D22
1796119	NT4RK KC5010	D22
1796120	NT4LK KC5010	D22
1796121	NT3RCK KC5010	D19
1796122	NT3RCK KC5025	D19
1796133	NT3LCK KC5025	D19
1796134	NT4RCK KC5010	D19
1796135	NT4RCK KC5025	D19
1796137	NT4LCK KC5025	D19
1796138	NTF2R KC5010	D21
1796139	NTF2L KC5010	D21
1796140	NTF3R KC5010	D21
1796141	NTF3L KC5010	D21
1796153	NTF4R KC5025	D21
1796156	NTK2R KC5010	D21
1796157	NTK2L KC5010	D21
1796158	NTK3R KC5010	D21
1796159	NTK3R KC5025	D21
1796160	NTK3L KC5010	D21
1796161	NTK3L KC5025	D21
1796176	NJP3020R8 KC5010	D16
1796177	NJP3020R8 KC5025	D16
1796179	NJP3020L8 KC5025	D16
1796180	NJP3014R12 KC5010	D16
1796181	NJP3014L12 KC5010	D16
1796182	NJP3010R16 KC5010	D16
1796194	NJF3012R14 KC5010	D15
1796195	NJF3012R14 KC5025	D15
1796198	NJF3010R16 KC5010	D15
1796199	NJF3010R16 KC5025	D15
1796200	NJF3010L16 KC5010	D15
1796202	NJF3009R18 KC5010	D15
1796203	NJF3009R18 KC5025	D15
1796331	NJF3008R20 KC5010	D15
1796332	NJF3008R20 KC5025	D15
1796393	NJF3008L20 KC5010	D15
1796395	NJF3007R24 KC5010	D15
1796396	NJF3007R24 KC5025	D15
1796397	NJF3007L24 KC5010	D15
1796399	NJF3006R28 KC5010	D15
1796400	NJF3006R28 KC5025	D15
1796403	NJF3005R32 KC5010	D15
1796407	NJK3012R14 KC5010	D16
1796408	NJK3012R14 KC5025	D16
1796411	NJK3010R16 KC5010	D16
1796412	NJK3010R16 KC5025	D16
1796425	NJK3009R18 KC5010	D16
1796426	NJK3009R18 KC5025	D16
1796429	NJK3008R20 KC5010	D16
1796430	NJK3008R20 KC5025	D16
1796443	NJK3007R24 KC5010	D16
1796446	NJK3007R24 KC5025	D16
1796449	NJK3006R28 KC5010	D16
1796452	NJK3006L28 KC5025	D16
1796473	NJK3005R32 KC5010	D16
1796474	NJK3005R32 KC5025	D16
1796476	NJK3005L32 KC5025	D16
1796497	NA3R12 KC5025	D11
1796499	NA3L12 KC5010	D11
1796500	NA3L12 KC5025	D11
1796501	NA3R10 KC5010	D11
1796502	NA3R10 KC5025	D11
1796504	NA3L10 KC5025	D11
1796505	NA3R8 KC5010	D11
1796506	NA3R8 KC5025	D11
1796507	NA3L8 KC5010	D11
1796508	NA3L8 KC5025	D11
1796509	NA3R6 KC5010	D11
1796510	NA3R6 KC5025	D11
1796511	NA3L6 KC5010	D11
1796512	NA3L6 KC5025	D11
1796514	NA3R5 KC5010	D11
1796515	NA3R5 KC5025	D11
1796516	NA3L5 KC5010	D11
1796517	NA3L5 KC5025	D11
1796518	NA3R4 KC5010	D11
1796519	NA3L4 KC5010	D11
1796520	NAS3R16 KC5025	D12
1796524	NAS3R12 KC5025	D12
1796525	NAS3L12 KC5025	D12
1796526	NAS3R10 KC5010	D12
1796527	NAS3R10 KC5025	D12
1796529	NAS3L10 KC5025	D12
1796530	NAS3R8 KC5010	D12
1796531	NAS3R8 KC5025	D12
1796532	NAS3L8 KC5010	D12
1796543	NAS3L8 KC5025	D12
1796544	NAS3R6 KC5010	D12
1796545	NAS3R6 KC5025	D12
1796546	NAS3L6 KC5010	D12
1796547	NAS3L6 KC5025	D12
1796549	NAS3R5 KC5025	D12
1796551	NAS3L5 KC5025	D12
1796552	NJ3020R8 KC5010	D15
1796553	NJ3020R8 KC5025	D15
1796555	NJ3020L8 KC5025	D15
1796556	NJ3014R12 KC5010	D15
1796557	NJ3014R12 KC5025	D15
1796558	NJ3014L12 KC5010	D15
1796559	NJ3014L12 KC5025	D15
1796561	NJ3010R16 KC5025	D15
1796583	NJ3010L16 KC5025	D15
1796705	470.232	S32
1797157	KSEM125R7WN16M	H75
1797158	KSEM130R7WN16M	H75
1797159	KSEM135R7WN16M	H75
1797160	KSEM136R7WN16M	H75
1797161	KSEM140R7WN16M	H75
1797162	KSEM145R7WN20M	H75
1797203	KSEM146R7WN20M	H75
1797204	KSEM150R7WN20M	H75
1797205	KSEM155R7WN20M	H75
1797206	KSEM125R10WN16M	H75
1797207	KSEM130R10WN16M	H75
1797208	KSEM135R10WN16M	H75
1797209	KSEM136R10WN16M	H75
1797210	KSEM140R10WN16M	H75
1797211	KSEM145R10WN20M	H75
1797212	KSEM146R10WN20M	H75
1797233	KSEM150R10WN20M	H75
1797234	KSEM155R10WN20M	H75
1797235	SCFPR10CA09	B217
1798189	KSEM0500R7SS050	H79
1798190	KSEM0500R7SS075	H79
1798191	KSEM0509R7SS075	H79
1798192	KSEM0516R7SS075	H79
1798203	KSEM0531R7SS075	H79
1798204	KSEM0547R7SS075	H79
1798205	KSEM0563R7SS075	H79
1798206	KSEM0578R7SS075	H79
1798207	KSEM0594R7SS075	H79
1798208	KSEM0609R7SS075	H79
1798211	KSEM0500R10SS075	H79
1798212	KSEM0509R10SS075	H79
1798228	KSEM0516R10SS075	H79
1798231	KSEM0531R10SS075	H79
1798243	KSEM0547R10SS075	H79
1798244	KSEM0563R10SS075	H79
1798248	KSEM0578R10SS075	H79
1798249	KSEM0594R10SS075	H79
1798250	KSEM0609R10SS075	H79
1798962	DFR170R3WD32M	J11
1799053	DFR180R3WD32M	J11
1799055	DFR200R3WD32M	J11
1799056	DFR210R3WD25M	J11
1799059	DFR220R3WD25M	J11
1799238	NT1L KC5010	D23
1799239	NT1L KC5025	D23
1799241	NTC3R7E KC5025	D20
1799363	NTC3L8E KC5010	D20
1799366	NTC3L8I KC5025	D18
1799369	NTC3R10E KC5010	D20
1799370	NTC3R10E KC5025	D20
1799384	NTC3L10I KC5025	D18
1799386	NTC3R11E KC5025	D20
1799389	NTC3R12I KC5025	D18
1799390	NTC3L12I KC5025	D18
1799391	NTC3R13E KC5010	D20
1799392	NTC3R13E KC5025	D20
1799393	NTC3R14E KC5010	D20
1799394	NTC3R14E KC5025	D20
1799398	NTC3L14I KC5025	D18
1799399	NTC3R16E KC5010	D20
1799400	NTC3R16E KC5025	D20
1799404	NTC3L16I KC5025	D18
1799405	NTC3R18E KC5010	D20
1799406	NTC3R18E KC5025	D20
1799409	NTC3R20E KC5010	D20
1799410	NTC3R20E KC5025	D20
1799413	NTC3R24E KC5010	D20
1799414	NTC3R24E KC5025	D20
1799416	NTC3R28E KC5025	D20
1799418	NTC3R32E KC5025	D20
1799439	NA4R6 KC5025	D11
1799441	NA4L6 KC5025	D11
1799443	NA4R5 KC5025	D11
1799445	NA4L5 KC5025	D11
1799446	NA4R4 KC5010	D11
1799447	NA4R4 KC5025	D11
1799449	NA4L4 KC5025	D11
1799450	NA6R2 KC5010	D11
1799451	NA6R2 KC5025	D11
1799452	NA6L2 KC5010	D11
1799463	NA6L2 KC5025	D11
1799465	NA6R25 KC5025	D11
1799469	NA6R3 KC5025	D11
1799471	NA6L3 KC5025	D11
1799483	NDC38VR75 KC5010	D14
1799484	NDC38VL75 KC5010	D14
1799485	NDC3115VR75 KC5010	D14
1799486	NDC3115VL75 KC5010	D14
1799490	NDC88VR75M KC5010	D14
1799491	NDC88VL75M KC5010	D14
1799497	NTU4R KC5025	D22
1799500	NWC3R11E KC5010	D23
1799501	NWC3R11E KC5025	D23
1799502	NWC3L11I KC5025	D23
1799503	NWC3R14E KC5010	D23
1799507	ND3040R KC5025	D12
1799511	ND3038R KC5025	D12
1799513	ND3038L KC5025	D12
1799521	NDC3040R3 KC5025	D13
1799522	NDC3040L3 KC5010	D13
1799525	NDC4038R2 KC5025	D13
1799527	NDC4038L2 KC5025	D13
1799529	NDC4040R3 KC5025	D13
1799553	NDC4050R2 KC5025	D13
1799555	NDC4050L2 KC5025	D13
1799557	NDC4050R3 KC5025	D13
1799560	NDC38RDR75 KC5010	D13
1799561	NDC38RDR75 KC5025	D13
1799562	NDC38RDL75 KC5010	D13
1799563	NDC38RDL75 KC5025	D13
1799565	NDC310RDR75 KC5025	D13
1799567	NDC310RDL75 KC5025	D13
1799576	NTB3RA KC5025	D17
1799577	NTB3LA KC5010	D17
1799578	NTB3LA KC5025	D17
1799583	NTB2RB KC5010	D18
1799585	NTB2LB KC5010	D18
1799587	NTB3RB KC5010	D18
1799588	NTB3RB KC5025	D18
1799589	NTB3LB KC5010	D18
1799591	NTB3LB KC5025	D18
1799603	NTB4RB KC5010	D18
1799604	NTB4RB KC5025	D18
1799605	NTB4LB KC5010	D18
1799606	NTB4LB KC5025	D18
1799693	DFR190R2WD32M	J10
1799695	DFR220R3WD32M	J11
1801017	NG3M400LK KC5025	C164
1801125	3.41020R900STF CS5	I17
1801126	3.41220R900STF CS5	I17
1801129	3.41220R900SF KMF	I17
1801533	SSF200HTS130239	J89
1801534	SSF200HTS130664	J89
1801535	SSF200HTS131114	J89
1801536	SSF200HTS131764	J89
1801537	SSF200HTS160239	J89
1801538	SSF200HTS160714	J89
1801539	SSF200HTS161214	J89
1801540	SSF200HTS161964	J89
1801541	SSF200HTS220297	J89
1801542	SSF200HTS220922	J89
1801553	SSF200HTS221572	J89
1801554	SSF200HTS222572	J89
1801555	SSF200HTS270297	J89
1801556	SSF200HTS271122	J89
1801558	SSF200HTS271922	J89
1801559	SSF200HTS273122	J89
1801560	SSF200HTS320305	J89
1801561	SSF200HTS320805	J89
1801562	SSF200HTS321305	J89
1801573	SSF200HTS321805	J89
1801574	SSF250HTS400355	J89
1801575	SSF250HTS401055	J89
1801576	SSF250HTS401555	J89
1801577	SSF250HTS402555	J89
1801578	SSF300HTS500413	J89
1801579	SSF300HTS501313	J89
1801580	SSF300HTS502113	J89
1801581	SSF300HTS503113	J89
1801779	NR3031R KC5010	C172
1801793	NG3047R KC5010	C170
1802547	CCMT3251MW KT315	B192
1802549	CCMT3252MW KT315	B192
1802551	WNGG432LF KC5010	B156
1802564	CCMT3251MW KC5010	B192
1802566	CCMT3252MW KC5010	B192
1802567	CPMT3252MW KC5010	B208
1802568	CCMT431MW KC5010	B192
1802569	CCMT432MW KC5010	B192
1802813	CCMT21505FW KT315	B190
1802843	CPMT21505FW KT315	B206
1802844	CCMT2151FW KT315	B190
1802845	CPMT2151FW KT315	B206
1802846	CCMT2152FW KT315	B190
1802971	CPMT2152FW KT315	B206
1802983	CCMT3251FW KT315	B190
1802984	CPMT3251FW KT315	B206
1802986	CCMT3252FW KT315	B190
1802991	CPMT3252FW KT315	B206

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1802992	CCMT21505FW KC5010	B190
1803013	CPMT21505FW KC5010	B206
1803014	CCMT2151FW KC5010	B190
1803015	CPMT2151FW KC5010	B206
1803016	CCMT2152FW KC5010	B190
1803018	CPMT2152FW KC5010	B206
1803020	CCMT3251FW KC5010	B190
1803021	CPMT3251FW KC5010	B206
1803022	CCMT3252FW KC5010	B190
1803023	CPMT3252FW KC5010	B206
1803174	40A02RP90BG15CUPM	S122
1803175	50A03RP90BG15CUPM	S122
1803177	63A04RP90BG15C1WUPM	S122
1803178	80A05RP90BG15C1WUPM	S122
1803179	100B06RP90BG15C2WUPM	S122
1803284	NTC3MR150E KC5010	D19
1803285	NTC3MR150E KC5025	D19
1803292	NTC3MR200E KC5010	D19
1803924	NG2062L KC5025	C170
1804265	SPHX1205ZCELGP KC520M	S65
1804638	NG2062L KC5010	C170
1804784	DFT05T308HP KMF	J101
1804785	DFT06T308HP KMF	J101
1804790	DFT070408HP KMF	J101
1804791	DFT090508HP KMF	J101
1804829	DFT05T308HP KC7140	J101
1804830	DFT06T308HP KC7140	J101
1804832	DFT070408HP KC7140	J101
1805013	DFT090508HP KC7140	J101
1805715	80A06RP90BG15C2WUPM	S122
1805716	100B08RP90BG15C2WUPM	S122
1805720	63A04RP90BG15C4WUHPM	S123
1805745	80A05RP90BG15C5WUHPM	S123
1806435	DFR030204GD KC7140	J97
1806437	DFR040304GD KC7140	J97
1806465	125B08RP90BG15C2WUPM	S122
1806466	160B10RP90BG15C2WUPM	S122
1806847	125B08RP70SP15C2WUFP	S70
1806848	160B10RP70SP15C2WUFP	S70
1806927	360.650	I25, I29
1806928	360.651	I25, I29
1806929	360.652	I25, I29
1806930	360.653	I25, I29
1806943	360.654	I25, I29
1806945	360.655	I25, I29
1807220	CCGT3251LF KC5410	B189
1808097	H20MCFNR4	B75
1808100	H24MCFNR4	B75
1808102	H32MCFNR5	B75
1808109	A16TMCFNL4	B69
1808110	A16MCFNR4	B69
1808112	A20MCFNR4	B69
1808120	MCHNN164C	B61
1808121	MCHNN205D	B61
1808122	MCHNN246D	B61
1808134	MCKNL165D	B62
1808135	MCKNL205D	B62
1808138	MCKNR205D	B62
1808140	MCKNR246D	B62
1808143	MCLNL124A	B63
1808144	MCLNL166C	B63
1808145	MCLNL245D	B64
1808146	MCLNL248E	B64
1808147	MCLNL326F	B64
1808149	MCLNR124A	B63
1808150	MCLNR166C	B63
1808151	MCLNR245D	B63
1808152	MCLNR248E	B63
1808153	MCLNR326F	B63
1808156	MCMNN246D	B64
1808157	MCMNN246E	B64
1808160	MCRNL205D	B65
1808162	MCRNL246D	B65
1808163	MCRNR205D	B65
1808165	MCRNR246D	B65
1808167	MDJNL124A	B89
1808168	MDJNL245E	B89
1808169	MDJNR124A	B89
1808170	MDJNR245E	B89
1808175	MRGNL246D	B98
1808176	MRGNL248E	B98
1808177	MRGNR246D	B98
1808179	MRGNR248E	B98
1808182	MSDNN206	B111
1808183	MSDNN246	B111
1808185	MSKNL205D	B111
1808186	MSKNL206D	B111
1808187	MSKNL246D	B111
1808189	MSKNR205D	B111
1808190	MSKNR206D	B111
1808191	MSKNR248	B111
1808194	MSRNL165C	B112
1808195	MSRNL854D	B112
1808196	MSRNR165C	B112
1808197	MSRNR248	B112
1808198	MSRNR328	B112
1808203	A20MDPNL4	B92
1808204	A20MDPNR4	B92
1808205	A24MCFNL4	B69
1808206	A24MCFNR4	B69
1808207	A24MDPNL4	B92
1808208	A24MDPNR4	B92
1808212	A32MCKNR4	B70
1808225	A32MVUNL4	B154
1808226	A32MVUNR4	B154
1808227	A40VMCLNL5	B71
1808228	A40VMCLNR5	B71
1808229	A40MVUNL4	B154
1808230	A40MVUNR4	B154
1808338	MSSNL165D	B113
1808339	MSSNL205D	B113
1808341	MSSNL854D	B113
1808384	MSSNR165D	B113
1808445	MSSNR205D	B113
1808448	MSSNR854D	B113
1808452	MTANLS123	B133
1808487	NG2031RK KC5010	C162
1808488	NG4189RK KC5010	C163
1808491	NR3047LK KC5025	C166
1808493	MTANLS163	B133
1808494	MTANLS164	B133
1808495	MTANLS205	B133
1808498	MTANRS123	B133
1808499	MTANRS163	B133
1808500	MTANRS164	B133
1808501	MTANRS205	B133
1808504	MTENNS854	B134
1808506	MTFNLS164	B135
1808512	MTFNRS164	B135
1808515	MTGNR165C	B135
1808516	MTJNLS246	B137
1808518	MTJNRS246	B137
1808522	MTJNRS864	B137
1808531	H40MCFNR6	B75
1808532	SRACR164D	B243
1808533	SRACL164D	B243
1808534	SRACR204D	B243
1808535	SRACL204D	B243
1808536	SRACR163D	B243
1808538	SRACR162D	B243
1808539	SRACL162D	B243
1808540	SRACR203D	B243
1808541	SRACL203D	B243
1808542	SRACR202D	B243
1808543	SRACL202D	B243
1808550	MVJNL123A	B152
1808554	MVVNN244E	B153
1808555	MVUNR244D	B153
1808556	MVUNR204D	B153
1808557	MVUNL204D	B153
1808563	MVJNR243D	B152
1808583	NGD3125RK KC5025	C165
1809057	HSK100AHTS40085M	J92
1809059	HSK100AHTS50090M	J92
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	D68
1816983	LT11NR16UNJ KC5025	D68
1816990	LT11NR18UNJ KC5025	D68
1817050	LT16NR16UNJ KC5025	D68
1817054	LT16NR12UNJ KC5025	D68
1817487	LT22ER5API403 KC5010	D52
1817512	LT22ER4API502 KC5010	D52
1817533	LT22ER4API503 KC5010	D52
1817570	NF3125LK KC5025	C173
1817571	NF3125RK KC5025	C173
1817572	CNMG431FP KC5010	B49
1817588	NFD3125LK KC5025	C174
1817614	CNMG432FP KC5010	B49
1817616	DNMG331FP KC5010	B80
1817617	DNMG332FP KC5010	B80
1817618	NG3189RK KC5025	C163
1817619	NG3M100LK KC5025	C163
1817620	NG3M100RK KC5025	C162
1817623	NG3M120LK KC5025	C163
1817626	NG3M120RK KC5025	C162
1817627	NG3M150LK KC5025	C163
1817629	NG3M150RK KC5025	C162
1817630	NG3M175LK KC5025	C163
1817631	NG3M175RK KC5025	C162
1817632	NG3M200LK KC5025	C163
1817635	NG3M200RK KC5025	C162
1817636	NG3M220LK KC5025	C164
1817637	NG3M220RK KC5025	C162
1817640	NG3M225RK KC5010	C162
1817658	NFD3125RK KC5025	C174
1817659	NFD3125RKI KC5025	C174
1817662	NFD4189LK KC5025	C174
1817675	NG3M250LK KC5025	C164
1817676	NG3M250RK KC5025	C162
1817678	NG3M275LK KC5025	C164
1817679	NG3M275RK KC5010	C162
1817680	NG3M275RK KC5025	C162
1817681	NG3M300LK KC5010	C164
1817682	NG3M300LK KC5025	C164
1817699	NG1047L KC5025	C170
1817700	NG1062L KC5025	C170
1817702	NG1094L KC5025	C170
1817703	NG3M300RK KC5010	C162
1817704	NG3M300RK KC5025	C162
1817705	NG3M320LK KC5025	C164
1817706	NG3M320RK KC5025	C162
1817707	NG3M325LK KC5025	C164
1817708	NG3M325RK KC5025	C162
1817709	NG3M350LK KC5025	C164
1817710	NG3M350RK KC5025	C162
1817713	NG2031LK KC5010	C163
1817718	NG2031LK KC5025	C163
1817719	NG2031RK KC5025	C162
1817720	NG2041L KC5025	C170
1817721	NG2041R KC5025	C170
1817722	NG2047LK KC5010	C163
1817740	NG3M400RK KC5010	C162
1817741	NG3M400RK KC5025	C162
1817866	KSSISR197SE44345C3	S39
1817867	KSSISR197SE44345M3	S39
1817868	KSSISR248SE44345C4	S39
1817869	KSSISR248SE44345M4	S39
1817870	KSSISR315SE44345C4	S39
1817871	KSSISR315SE44345M4	S39
1817872	KSSISR394SE44345C5	S39
1817933	KSSISR394SE44345M5	S39
1817934	KSSISR492SE44345C6	S39
1817935	KSSISR492SE44345M6	S39
1817936	KSSISR630SE44345C6	S39
1817937	KSSISR630SE44345M6	S39
1817938	KSSISR787SE44345C10	S39
1817939	KSSISR787SE44345M10	S39
1817965	NG3M425RK KC5025	C163
1817970	NG4125RK KC5010	C163
1817972	NG4189LK KC5010	C164
1817975	NG2047LK KC5025	C163
1817977	NG2047RK KC5010	C162
1817979	NG2047RK KC5025	C162
1817993	NG4189LK KC5025	C164
1817994	NG4189RK KC5025	C163
1818000	NG4250RK KC5010	C163
1818001	NG4250RK KC5025	C163
1818003	NG2058R KC5025	C170
1818005	NG2062LK KC5010	C163
1818006	NG2062LK KC5025	C163
1818007	NG2062RK KC5010	C162
1818008	NG2062RK KC5025	C162
1818009	NG2094LK KC5010	C163
1818010	NG2094LK KC5025	C163
1818011	NG2094RK KC5010	C162
1818037	NG2094RK KC5025	C162
1818039	NG2125LK KC5010	C163
1818041	NG2125LK KC5025	C163
1818042	NG2125RK KC5010	C162
1818050	NG4M400RK KC5010	C163
1818051	NG4M400RK KC5025	C163
1818052	NG4M450LK KC5025	C164
1818054	NG4M500LK KC5010	C164
1818073	NG2125RK KC5025	C162
1818075	NG2M080LK KC5025	C163
1818077	NG2M080RK KC5025	C162
1818078	NG2M100LK KC5010	C163
1818079	NG2M100LK KC5025	C163
1818080	NG2M100RK KC5010	C162
1818081	NG2M100RK KC5025	C162
1818082	NG2M120LK KC5010	C163
1818093	NG2M120LK KC5025	C163
1818094	NG2M120RK KC5010	C162
1818095	NG2M120RK KC5025	C162
1818097	NG2M140LK KC5025	C163
1818098	NG2M140RK KC5010	C162
1818099	NG2M140RK KC5025	C162
1818110	NGD3062LK KC5010	C165
1818111	NGD3062LK KC5025	C165
1818112	NGD3062RK KC5010	C165
1818113	NGD3062RK KC5025	C165
1818114	NGD3094LK KC5010	C165
1818115	NGD3094LK KC5025	C165
1818116	NGD3094RK KC5010	C165
1818117	NGD3094RK KC5025	C165
1818118	NGD3125LK KC5010	C165
1818119	NGD3125LK KC5025	C165
1818120	NGD3125RK KC5010	C165
1818121	NGD3189LK KC5010	C165
1818122	NGD3189LK KC5025	C165
1818262	NGD3189RK KC5010	C165
1818352	NPD3012RK KC5010	C167
1818353	NGD3189RK KC5025	C165
1818354	NGD4125LK KC5010	C165
1818355	NGD4125LK KC5025	C165
1818356	NGD4125RK KC5010	C165
1818357	NGD4125RK KC5025	C165
1818359	NGD4189LK KC5010	C165
1818360	NGD4189LK KC5025	C165
1818361	NGD4189RK KC5010	C165
1818362	NGD4189RK KC5025	C165
1818366	NG2M300RK KC5010	C162
1818368	NG2M325RK KC5025	C162
1818369	NG3047LK KC5010	C163
1818370	NG3047LK KC5025	C163
1818371	NG3062LK KC5025	C163
1818372	NG3072LK KC5010	C163
1818374	NGD4250LK KC5025	C165
1818375	NGD4250RK KC5010	C165
1818376	NGD4250RK KC5025	C165
1818425	NR2031L KC5025	C172
1818426	NR2031R KC5025	C172
1818434	NP2002RK KC5010	C167
1818435	NP2002RK KC5025	C167
1818437	NP3002RK KC5010	C167
1818439	NP3012RK KC5025	C167
1818440	NPD2002RK KC5010	C167
1818444	NRD4125L KC5025	C173
1818455	NG2M170LK KC5010	C163

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1818456	NG2M170LK KC5025	C163
1818457	NG2M170RK KC5010	C162
1818458	NR3031LK KC5010	C166
1818459	NR3031LK KC5025	C166
1818460	NR3031RK KC5010	C166
1818461	NG2M170RK KC5025	C162
1818462	NR3031RK KC5025	C166
1818473	NR3047LK KC5010	C166
1818474	NG2M175LK KC5025	C163
1818476	NG2M195LK KC5010	C163
1818478	NR3062LK KC5010	C166
1818479	NG2M195RK KC5010	C162
1818480	NG2M195RK KC5025	C162
1818481	NR3062LK KC5025	C166
1818482	NG2M200LK KC5010	C163
1818483	NG2M200LK KC5025	C163
1818484	NG2M200RK KC5010	C162
1818485	NG2M200RK KC5025	C162
1818487	NG2M220RK KC5025	C162
1818489	NG2M225LK KC5025	C163
1818491	NG2M225RK KC5025	C162
1818492	NG2M250LK KC5025	C163
1818493	NG2M250RK KC5025	C162
1818494	NG2M275LK KC5010	C163
1818497	NG2M275RK KC5025	C162
1818498	NG2M300LK KC5010	C163
1818503	NG3072LK KC5025	C163
1818504	NG3072RK KC5010	C162
1818505	NG3072RK KC5025	C162
1818506	NG3078LK KC5010	C163
1818507	NG3078LK KC5025	C163
1818508	NG3078RK KC5010	C162
1818509	NG3078RK KC5025	C162
1818714	SPHX15T6ZCERGP KCK15	S71
1818721	SPHX15T6ZCTRGPK KY3500	S71
1818755	SPHX15T6ZCERGP4S KCK15	S71
1818766	NG3094LK KC5010	C164
1818768	NG3094LK KC5025	C164
1818769	NG3094RK KC5025	C162
1818824	NG3105R KC5025	C170
1818825	NG3110L KC5025	C171
1818827	NR3078LK KC5010	C166
1818828	NR3078LK KC5025	C166
1818829	NR3078RK KC5010	C166
1818831	NR3094L KC5010	C172
1818833	NR3094L KC5025	C172
1818834	NR3094R KC5010	C172
1818835	NR3094R KC5025	C172
1818836	NR4062LK KC5010	C166
1818838	NR4062RK KC5010	C166
1818840	NR4094LK KC5010	C166
1818841	NR4094LK KC5025	C166
1818842	NR4094RK KC5010	C166
1818854	NR4125LK KC5010	C166
1818856	NR4125RK KC5010	C166
1818857	NR4125RK KC5025	C166
1818858	NRD3031L KC5010	C173
1818859	NRD3031L KC5025	C173
1818860	NRD3031R KC5010	C173
1818861	NRD3031R KC5025	C173
1818862	NRD3062L KC5010	C173
1818863	NRD3062L KC5025	C173
1818864	NRD3062R KC5010	C173
1818865	NRD3062R KC5025	C173
1818866	NRD4062L KC5025	C173
1818874	NU3094L KC5025	C175
1818875	NU3094R KC5025	C175
1818876	NU3125L KC5025	C175
1818878	NU3156L KC5025	C175
1818891	NG3156LK KC5010	C164
1818892	NG3156LK KC5025	C164
1818913	NG3156RK KC5010	C162
1818914	NG3156RK KC5025	C162
1818916	NG3178R KC5025	C170
1818917	NG3185L KC5025	C171
1818919	NG3189LK KC5010	C164
1818920	NG3189LK KC5025	C164
1818921	NG3189RK KC5010	C163
1819108	SPHX15T6ZCTRGP4SK KY3500	S71
1819110	SPHX15T6ZCFRGN1W KCK15	S72
1819206	CNMG431FP KT315	B49
1819207	CNMG432FP KT315	B49
1819211	DNMG332FP KT315	B80
1819335	DNMG431FP KT315	B80
1819336	DNMG432FP KT315	B80
1819340	DNMG443FP KT315	B80
1819354	TNMG331FP KT315	B123
1819355	TNMG332FP KT315	B123
1819357	VNMG331FP KT315	B146
1819358	VNMG332FP KT315	B146
1819440	DNMG431FP KC5010	B80
1819441	DNMG432FP KC5010	B80
1819451	SPHX1205PCTRGPB KTPK20	S68
1819494	DNMG441FP KC5010	B80
1819495	DNMG442FP KC5010	B80
1819500	TNMG331FP KC5010	B123
1819501	TNMG332FP KC5010	B123
1819502	TNMG333FP KC5010	B123
1819513	VNMG331FP KC5010	B146
1819514	VNMG332FP KC5010	B146
1819515	WNMG331FP KC5010	B158
1819516	WNMG332FP KC5010	B158
1819517	WNMG431FP KC5010	B158
1819518	WNMG432FP KC5010	B158
1819519	WNMG433FP KC5010	B158
1819846	SPHX1205PCFRGN1WB KCK15	S69
1819848	SPHX1205PCFRGN1WB KC725M	S69
1819849	SPHX1205PCFRGN1WB KC520M	S69
1819850	SPHX1205PCFRGN1WB KTPK20	S69
1819852	SPHX1205PCFRGN1WBK KY3500	S69
1819853	SPHX1205ZCTRGP KTPK20	S65
1819858	SPHX1205ZCFRGN1W KCK15	S66
1819861	SPHX1205ZCFRGN1W KC520M	S66
1819864	SPHX1205ZCFRGN1WK KY3500	S66
1824861	TCMT3252LF KC5010	B257
1824882	TCMT3251LF KC5010	B257
1826709	S445	S5, S10, S14, S17, S20, S32, S45, S50, S56, S58, S64, S67, S121–123, T7, T33, T109, T113, V38, V47, V54
1829218	TNMG331FW KT315	B124
1829219	TNMG332FW KT315	B124
1829220	TNMG331FW KC5010	B124
1831439	841.142.200	K122–124
1831441	841.142.320	K122–123
1831442	841.142.420	K122–123
1831590	KM63XMZKR5060Y	K92
1831749	NG3062L KC5010	C170
1831750	NG4250R KC5010	C170
1832293	CNMG322MP KC5010	B51
1832294	CNMG431MP KC5010	B51
1832295	CNMG432MP KC5010	B51
1832296	CNMG433MP KC5010	B51
1832297	CNMG434MP KC5010	B51
1832298	CNMG542MP KC5010	B51
1832299	CNMG543MP KC5010	B51
1832301	CNMG544MP KC5010	B51
1832302	CNMG642MP KC5010	B51
1832313	CNMG643MP KC5010	B51
1832315	CNMG644MP KC5010	B51
1832316	DNMG332MP KC5010	B81
1832318	DNMG431MP KC5010	B81
1832319	DNMG432MP KC5010	B81
1832321	DNMG433MP KC5010	B81
1832322	DNMG441MP KC5010	B81
1832323	DNMG442MP KC5010	B81
1832324	DNMG443MP KC5010	B81
1832325	SNMG432MP KC5010	B102
1832327	SNMG433MP KC5010	B102
1832330	SNMG543MP KC5010	B102
1832353	SNMG644MP KC5010	B102
1832354	TNMG331MP KC5010	B124
1832355	TNMG332MP KC5010	B124
1832356	TNMG333MP KC5010	B124
1832357	TNMG432MP KC5010	B124
1832358	TNMG433MP KC5010	B124
1832359	TNMG434MP KC5010	B124
1832360	VNMG331MP KC5010	B147
1832361	VNMG332MP KC5010	B147
1832373	VNMG333MP KC5010	B147
1832374	WNMG331MP KC5010	B159
1832376	WNMG332MP KC5010	B159
1832378	WNMG432MP KC5010	B159
1832379	WNMG433MP KC5010	B159
1833500	SPHX1205PCERGNT1WB KB1340	S69
1833501	SPHX1205ZCERGNT1W KB1340	S66
1833766	B411A06100 KF1	G94
1834274	R67FBHS06	K140
1834295	SNMG433FW KT315	B102
1834819	170.294	H72, H81, H88
1836470	170.295	H88
1836471	170.296	H88
1840501	NPR51 KC5410	E35
1841355	VPGR334 KC5010	E38
1841782	MS2038	V62
1841815	S2043	S39
1841853	S2044	S39, U27
1843874	SCLCL124B	B194
1843875	SCLCR124B	B194
1843876	SCLCL164D	B194
1843877	SCLCR164D	B194
1843886	MCKNL246D	B62
1843889	MVUNL244D	B153
1843976	RCMT1204M0 KC5010	B240
1845216	TCMT2151LF KC5010	B257
1845218	CCMT432LF KC5010	B191
1845219	TPMT2151LF KC5010	B268
1845227	CCMT3251LF KC5010	B191
1845230	SCMT3251LF KC5010	B246
1845775	470.243	S20, S24, S32
1845807	420.201	S17, S20, S24, S32, S45, S50, S121–122, T17
1847935	CNGA433T0420FW KY3500	B313
1848593	SPGX060304RHP KC7140	J103
1848597	SPGX070304RHP KC7140	J103
1848601	SPPX09T308RHP KC7140	J103
1848605	SPPX120408RHP KC7140	J103
1848655	ICSN443 K9	B58–60
1849051	DPGR431 KC5010	E32
1849052	DPGR432 KC5010	E32
1849053	DPGR433 KC5010	E32
1849054	NPR505 KC5010	E35
1849055	NPL505 KC5010	E35
1849056	NPR508 KC5010	E35
1849058	NPR51 KC5010	E35
1849059	NPL51 KC5010	E35
1849060	NPR52 KC5010	E35
1849243	NPL52 KC5010	E35
1849249	NPR131F KC5010	E34
1849250	NPL131F KC5010	E34
1849251	NPR132F KC5010	E34
1849252	NPL132F KC5010	E34
1849274	NPGR51R KC5010	E33
1849275	NPGR51L KC5010	E33
1849279	VBMR221 KC5010	E36
1849281	VPGR3305 KC5010	E38
1849301	VPGR331 KC5010	E38
1849302	VPGR332 KC5010	E38
1849323	VPGR333 KC5010	E38
1849846	NPGR51L KT315	E33
1849866	NPGR52R KT315	E33
1849869	NPR508 KT315	E35
1849871	NPR51 KT315	E35
1849874	NPR52 KT315	E35
1849885	VBMR221 KT315	E36
1849903	NPGR52L KC5025	E33
1849906	VBMR221 KC5025	E36
1849908	VPGR3305 KC5025	E38
1849909	VPGR331 KC5025	E38
1849910	VPGR332 KC5025	E38
1849983	NPR505 KC5025	E35
1849998	NPR51 KC5025	E35
1850011	NPL51 KC5025	E35
1850012	NPR52 KC5025	E35
1850067	NPGR51R KC5025	E33
1850070	NPGR51L KC5025	E33
1851263	CNGA432T0420FW KY3500	B313
1851264	CNGA434T0420FW KY3500	B313
1851265	WNGA432T0420FW KY3500	B315
1851268	CNGX452T0420FW KY3500	B316
1851269	CNGX453T0420FW KY3500	B316
1851270	CNGX454T0420FW KY3500	B316
1851304	SCG332FW KY3500	B320
1852181	CS412	B168–169, B386–387
1852652	S432	B408
1852683	S435	B408
1854201	CPMT18151LF KC5010	B207
1854340	HTSR040R025M	J75
1854342	HTSR046R028M	J75
1854378	B514S08000 KC7030	J76
1854379	B514S10000 KC7030	J76
1855439	NG3M200RK KT315	C162
1855476	NG2031RK KT315	C162
1855479	NG2047RK KT315	C162
1855504	NG2062RK KT315	C162
1855506	NG2094RK KT315	C162
1855508	NG2125RK KT315	C162
1855556	NG2M200RK KT315	C162
1855576	NG3062RK KT315	C162
1855577	NG3094LK KT315	C164
1855578	NG3094RK KT315	C162
1855910	SPHX1205ZCSRGP KCK15	S65
1859604	VBMT331LF KT315	B281
1860701	190.458	J75
1860827	NG3088L KC5010	C170
1861004	FAS100302GD KC7015	H42
1862656	S321	B409
1863297	MTFNL854D	B134
1863299	MVJNR123A	B152
1863302	MVUNR204C	B153
1863407	552.210	B384
1864501	VCMR331 KC5010	E37
1864502	VCMR332 KC5010	E37
1864543	VCMR331 KC5025	E37
1864544	VCMR332 KC5025	E37
1864562	VCMR331 KT315	E37
1864583	VCMR332 KT315	E37
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	SPGF322 KC5010	B171
1865210	TPGF221 KC5010	B177
1865214	TPGF321 KC5010	B177
1865218	TPGF322 KC5010	B177
1865436	SPG321 KC5010	B171
1865452	SPG322 KC5010	B171
1865483	SPG421 KC5010	B171
1865484	SPG422 KC5010	B171
1865486	SPG424 KC5010	B171
1865531	TPG221 KC5010	B177
1865532	TPG222 KC5010	B177
1865533	TPG3205 KC5010	B177
1865534	TPG321 KC5010	B177
1865535	TPG322 KC5010	B177
1865536	TPG323 KC5010	B177
1865537	TPG324 KC5010	B177
1865538	TPG431 KC5010	B177
1865539	TPG432 KC5010	B177
1865540	TPG433 KC5010	B177
1865541	TPG434 KC5010	B177
1865870	RCMK152 KC5010	E69
1865871	RCMK23 KC5010	E69
1865953	RCMK35 KC5010	E69
1865954	RCMK46 KC5010	E69
1865955	RCGK152HP KC5010	E69
1865956	RCGK23HP KC5010	E69
1865959	RCGV23 KC5010	B166
1865960	RCGV35 KC5010	B166
1865961	RCGV45 KC5010	B166
1865962	RPGV35 KC5010	B167
1865999	RCMT0602M0 KC5010	B240
1866000	RCMT0803M0 KC5010	B240
1866001	RCMT10T3M0 KC5010	B240
1866014	RCMT1605M0 KC5010	B240
1866015	RCMT2006M0 KC5010	B240
1866017	RCMT215 KC5010	B240
1866019	RCMT325 KC5010	B240
1866310	CNMX453T0820 KY3500	B316
1866311	CNMX454T0820 KY3500	B316
1866356	SNMX453T0820 KY3500	B319
1866357	SNMX454T0820 KY3500	B319

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1866358	SNMX554T0820 KY3500	B319
1866564	CCGT215X0LF KC5025	B189
1866565	CCGT2150LF KC5025	B189
1866566	CCGT21505LF KC5025	B189
1866567	CCGT2151LF KC5025	B189
1866569	CCGT325X0LF KC5025	B189
1866570	CCGT3250LF KC5025	B189
1866571	CCGT32505LF KC5025	B189
1866572	CCGT3251LF KC5025	B189
1866593	CCGT3252LF KC5025	B189
1866616	CCGT3252LF K313	B189
1866617	CPGT2150LF KC5025	B206
1866618	CPGT21505LF KC5025	B206
1866619	CPGT2151LF KC5025	B206
1866620	CPGT2152LF KC5025	B206
1866621	CPGT32505LF KC5025	B206
1866622	CPGT3251LF KC5025	B206
1866623	CPGT3252LF KC5025	B206
1866625	CPGT2150LF KC5410	B206
1866638	TPGT18151LF KC5025	B267
1866640	TPGT21505LF KC5025	B267
1866641	TPGT2151LF KC5025	B267
1866643	DCGT215X0LF KC5025	B224
1866646	DCGT2150LF KC5025	B224
1866647	DCGT3250LF KC5025	B224
1866648	DCGT325X0LF KC5025	B224
1866650	DCGT2150LF KC5010	B224
1866651	DCGT3250LF KC5010	B224
1866652	DCGT432LF KC5010	B224
1866653	TPGT3251LF KC5025	B267
1866655	TPGT2152LF KC5010	B267
1866661	TPGT2151LF KC5410	B267
1866665	DPGT2151LF KC5025	B231
1866667	DPGT32505LF KC5025	B231
1866668	DPGT3251LF KC5025	B231
1866674	TPGT3252LF KC5410	B267
1866675	VBGT22X0LF KC5025	B280
1866676	VBGT220LF KC5025	B280
1866677	VBGT2205LF KC5025	B280
1866678	VBGT221LF KC5025	B280
1866679	VBGT33X0LF KC5025	B280
1866681	VBGT330LF KC5025	B280
1866682	VBGT3305LF KC5025	B280
1866683	VBGT331LF KC5025	B280
1866685	VBGT2205LF KC5010	B280
1866686	VBGT221LF KC5010	B280
1866754	VBGT330LF KC5010	B280
1866755	VBGT3305LF KC5010	B280
1866756	VBGT331LF KC5010	B280
1866757	VBGT220LF KC5410	B280
1866761	VBGT3305LF KC5410	B280
1866762	VBGT331LF KC5410	B280
1866781	DPGT2150LF KC5010	B231
1866782	SPGT3251LF KC5025	B252
1866793	SPGT3252LF KC5025	B252
1866795	SPGT3251LF KC5010	B252
1866796	SPGT3252LF KC5010	B252
1866801	TCGT2150LF KC5025	B256
1866802	TCGT2151LF KC5025	B256
1866955	CCGT21505HP KC5025	B189
1866956	CCGT2151HP KC5025	B189
1866959	CCGT32505HP KC5025	B189
1866960	CCGT3251HP KC5025	B189
1866961	CCGT3252HP KC5025	B189
1866994	CCGT431HP KC5025	B189
1866996	CPGT21505HP KC5025	B205
1866997	CPGT2151HP KC5025	B205
1867001	CPGT32505HP KC5025	B205
1867002	CPGT3251HP KC5025	B205
1867004	DCGT21505HP KC5025	B224
1867006	DCGT2151HP KC5025	B224
1867007	DCGT2152HP KC5025	B224
1867009	DCGT32505HP KC5025	B224
1867010	DCGT3251HP KC5025	B224
1867011	DCGT3252HP KC5025	B224
1867028	RCGT10T3M0HP KC5025	B238
1867029	RCGT1204M0HP KC5025	B238
1867031	TCGT2151HP KC5025	B256
1867034	TCGT3251HP KC5025	B256
1867035	TCGT3252HP KC5025	B256
1867036	TPGT21505HP KC5025	B267
1867037	TPGT2151HP KC5025	B267
1867042	TPGT3251HP KC5025	B267
1867046	VBGT331HP KC5025	B280
1867049	VBGT332HP KC5025	B280
1867050	VBGT221HP KC5025	B280
1867051	VBGT2205HP KC5025	B280
1867060	VBGT221HP KC5010	B280
1867061	VBGT2205HP KC5010	B280
1867212	SSP025016M	B58–60, B67–68, B87–88, B91–92, B98, B109–110, B113, B131, B138, B150–151, B154, B163
1867278	KMSP415IP	B58–60, B67–68, B87–88, B91–92, B98, B109–110, B131, B150–151, B163
1867314	KMSP515IP	B58–60, B67–68, B87
1867620	CNGP432 KC5010	B46
1868190	CPGM3250 KC5010	B205
1868253	CPGM3250 KC5025	B205
1868254	CPGM3250 KT315	B205
1868255	CPGM32505 KC5010	B205
1868257	CPGM32505 KC5025	B205
1868419	CNGP430 KC5010	B46
1868420	CNGP4305 KC5010	B46
1868421	CNGP431 KC5010	B46
1868443	CNGP433 KC5010	B46
1868444	CNGP434 KC5010	B46
1868451	DNGP430 KC5010	B77
1868452	DNGP4305 KC5010	B77
1868453	DNGP431 KC5010	B77
1868454	DNGP432 KC5010	B77
1868456	DNGP442 KC5010	B77
1868457	SNGP431 KC5010	B100
1868458	SNGP432 KC5010	B100
1868461	TNGP3305 KC5010	B121
1868462	TNGP331 KC5010	B121
1868463	TNGP332 KC5010	B121
1868464	VNGP330 KC5010	B144
1868465	VNGP3305 KC5010	B144
1868466	VNGP431 KC5010	B144
1868467	VNGP432 KC5010	B144
1869820	CCMT21505LF KC5010	B191
1869821	CCMT2151LF KC5010	B191
1869894	CPGM3251 KC5010	B205
1869896	CPGM3251 KC5025	B205
1869899	CPGM3251 KT315	B205
1869901	CPGM3252 KC5010	B205
1869903	CPGM3252 KC5025	B205
1869932	CCMT21505LF KT315	B191
1869964	CCMT2151LF KT315	B191
1869965	CCMT2152LF KT315	B191
1869966	CCMT32505LF KT315	B191
1869967	CCMT3251LF KT315	B191
1869968	CCMT3252LF KT315	B191
1869973	DCMT2151LF KT315	B225
1869974	DCMT32505LF KT315	B225
1869975	DCMT3251LF KT315	B225
1869976	DCMT3252LF KT315	B225
1869980	SCMT3251LF KT315	B246
1869996	TCMT2151LF KT315	B257
1869998	TCMT2152LF KT315	B257
1870000	TCMT3251LF KT315	B257
1870002	TCMT3252LF KT315	B257
1870021	CNGG430LF KC5010	B46
1870022	CNGG4305LF KC5010	B46
1870036	VBMT2205LF KT315	B281
1870037	VBMT221LF KT315	B281
1870039	VBMT3305LF KT315	B281
1870043	CNGG431LF KC5010	B46
1870044	CNGG432LF KC5010	B46
1870069	CNGG433LF KC5010	B46
1870072	DNGG4305LF KC5010	B77
1870113	DNGG431LF KC5010	B77
1870114	DNGG432LF KC5010	B77
1870323	VBMT332LF KT315	B281
1870324	CPMT18151LF KT315	B207
1870326	CPMT2151LF KT315	B207
1870328	CPMT32505LF KT315	B207
1870329	CPMT3251LF KT315	B207
1870333	CPMT3252LF KT315	B207
1870335	DPMT2151LF KT315	B232
1870337	DPMT3251LF KT315	B232
1870339	SPMT3251LF KT315	B252
1870342	TPMT18151LF KT315	B268
1870365	TPMT2152LF KT315	B268
1870366	TPMT3251LF KT315	B268
1870367	TPMT3252LF KT315	B268
1870619	TNGG3305LF KC5010	B121
1870983	CCMT2152LF KC5010	B191
1870984	CCMT32505LF KC5010	B191
1870986	CCMT3252LF KC5010	B191
1870987	CCMT431LF KC5010	B191
1870990	CPMT181505LF KC5010	B207
1870992	CPMT21505LF KC5010	B207
1870998	DPMT32505LF KC5010	B232
1870999	DPMT3251LF KC5010	B232
1871000	DPMT3252LF KC5010	B232
1871002	SCMT3252LF KC5010	B246
1871013	CPMT2151LF KC5010	B207
1871014	CPMT2152LF KC5010	B207
1871015	CPMT32505LF KC5010	B207
1871016	CPMT3251LF KC5010	B207
1871017	CPMT3252LF KC5010	B207
1871019	DCMT3253LF KC5010	B225
1871020	DCMT431LF KC5010	B225
1871021	DCMT432LF KC5010	B225
1871022	DPMT21505LF KC5010	B232
1871033	DPMT2151LF KC5010	B232
1871035	VBMT222LF KC5010	B281
1871036	VBMT3305LF KC5010	B281
1871038	WPMT2151LF KC5010	B288
1871039	WPMT3251LF KC5010	B288
1871040	WPMT3252LF KC5010	B288
1871041	WCMT2151LF KC5010	B286
1871042	WCMT3252LF KC5010	B286
1871083	SCMT431LF KC5010	B246
1871084	SCMT432LF KC5010	B246
1871085	SCMT433LF KC5010	B246
1871086	SPMT3251LF KC5010	B252
1871087	SPMT3252LF KC5010	B252
1871088	TCMT21505LF KC5010	B257
1871090	TCMT2152LF KC5010	B257
1871091	TCMT32505LF KC5010	B257
1871104	TCMT3253LF KC5010	B257
1871105	TCMT432LF KC5010	B257
1871106	TPMT181505LF KC5010	B268
1871107	TPMT18151LF KC5010	B268
1871108	TPMT21505LF KC5010	B268
1871110	TPMT2152LF KC5010	B268
1871111	TPMT3251LF KC5010	B268
1871112	TPMT3252LF KC5010	B268
1871134	TPMT432LF KC5010	B268
1871163	CCMT2151UF KC5010	B192
1871164	CCMT32505UF KC5010	B192
1871165	CCMT3251UF KC5010	B192
1871166	CCMT3252UF KC5010	B192
1871167	CPMT2151UF KC5010	B208
1871168	CPMT3251UF KC5010	B208
1871169	DCMT2151UF KC5010	B226
1871170	DCMT32505UF KC5010	B226
1871171	DCMT3251UF KC5010	B226
1871172	DCMT3252UF KC5010	B226
1871193	DPMT2151UF KC5010	B233
1871196	SCMT3252UF KC5010	B247
1871197	SPMT3251UF KC5010	B253
1871198	TCMT2151UF KC5010	B258
1871199	TCMT2152UF KC5010	B258
1871200	TCMT3252UF KC5010	B258
1871202	TPMT2151UF KC5010	B269
1871286	TNGG331LF KC5010	B121
1871287	TNGG332LF KC5010	B121
1871288	VNGG3305LF KC5010	B144
1871289	VNGG331LF KC5010	B144
1871313	VNGG332LF KC5010	B144
1871317	VNGG432LF KC5010	B144
1871318	WNGG430LF KC5010	B156
1871319	WNGG4305LF KC5010	B156
1871320	WNGG431LF KC5010	B156
1872409	ICSN543 K9	B58–60
1873125	CWLNR164DMX5	B384
1873128	CWLNL164DMX5	B384
1873184	CWLNR204DMX5	B384
1873185	CWLNL204DMX5	B384
1873486	KIPR125RP43540	V156
1874234	SPHX1205PCTLGPBK KY3500	S68
1874862	DCLNR164DKC3	B59
1875133	DCLNL164DKC3	B59
1875134	DCLNR164CKC3	B59
1875135	DCLNL164CKC3	B59
1875136	DDJNR164DKC3	B87
1875137	DCLNR124BKC3	B59
1875138	DWLNR164DKC3	B163
1875139	DDJNL164DKC3	B87
1875140	DDJNR164CKC3	B87
1875141	DCLNR204DKC3	B59
1875142	DCLNL124BKC3	B59
1875143	DWLNL164DKC3	B163
1875144	DWLNR164CKC3	B163
1875145	DCLNR165DKC4	B59
1875146	DCLNL204DKC3	B59
1875147	DCLNL165DKC4	B59
1875148	DDJNR204DKC3	B87
1875149	DDJNL164CKC3	B87
1875150	DCLNR205DKC4	B59
1875151	DDJNL204DKC3	B87
1875152	DTGNR164DKC3	B131
1875153	DCLNL205DKC4	B59
1875155	DWLNL164CKC3	B163
1875156	DCRNR164DKC3	B60
1875157	DCLNR244DKC3	B59
1875159	DCRNL164DKC3	B60
1875160	DCLNL244DKC3	B59
1875161	DCLNR165CKC4	B59
1875163	DSSNR164DKC3	B110
1875164	DCRNR124BKC3	B60
1875165	DCRNR204DKC3	B60
1875166	DWLNR204DKC3	B163
1875167	DDJNL165DKC4	B87
1875168	DSRNL164DKC3	B110
1875169	DCRNL204DKC3	B60
1875170	DDJNR165DKC4	B87
1875172	DWLNL204DKC3	B163
1875173	DCLNL165CKC4	B59
1875177	DDJNL205DKC4	B87
1875178	DDJNR245DKC4	B87
1875179	DSSNL164DKC3	B110
1875180	DCRNR245DKC4	B60
1875184	DSRNL204DKC3	B110
1875186	DDPNN164DKC3	B88
1876838	TNMG333FW KT315	B124
1876849	TNMG431FP KC5010	B123
1877480	DNG451T0820 KY1615	B333
1877482	DNG452T0820 KY1615	B333
1877594	DNG453T0820 KY1615	B333
1877595	DNG454T0820 KY1615	B333
1877596	ENG451T0820 KY1615	B335
1877597	ENG452T0820 KY1615	B335
1877598	ENG453T0820 KY1615	B335
1877599	ENG454T0820 KY1615	B335
1877601	RNG45T0820 KY1615	B336
1877602	RNG45T4015 KY1615	B336
1877603	RNG45T8015 KY1615	B336
1881130	CNGA431T0820 KY1615	B329
1881131	CNGA432T0220 KY1615	B329
1881132	CNGA432T0820 KY1615	B313, B329
1881199	NPR5M02 KC5010	E36
1881200	NPR5M05 KC5010	E36
1881201	NPL5M02 KC5010	E36
1881202	NPL5M05 KC5010	E36
1881203	NPR13M05F KC5010	E35
1881243	CNGA433T0820 KY1615	B313, B329
1881244	CNGA434T0820 KY1615	B313, B329
1881246	CNGA543T0820 KY1615	B313, B329
1881249	CNGA643T0820 KY1615	B313, B329
1881250	CNGA644T0820 KY1615	B313, B329
1881251	CNG431T0820 KY1615	B329
1881252	CNG432T0820 KY1615	B329
1881253	CNG433T0820 KY1615	B329
1881255	CNG452T0820 KY1615	B329
1881257	CNG453T0820 KY1615	B329
1881258	CNG454T0820 KY1615	B329
1881266	CNG554T0820 KY1615	B329
1881267	CNG554T2015 KY1615	B329
1881272	CNGX452T0820 KY1615	B331
1881273	CNGX453T0820 KY1615	B331

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1881278	DNGA431T0820 KY1615	B333
1881279	DNGA432T0820 KY1615	B333
1881280	DNGA433T0820 KY1615	B333
1881281	DNGA434T0820 KY1615	B333
1881282	DNGA441T0820 KY1615	B333
1881283	DNGA442T0820 KY1615	B333
1881285	DNGA443T0820 KY1615	B333
1881297	DNGX452T0820 KY1615	B317, B335
1881305	RCGW1204M0T01020 KY1615	B336
1881310	RCGV35T0420 KY1615	B335
1881311	RCGV35T0820 KY1615	B335
1881313	RCGV35T4015 KY1615	B335
1881314	RCGV35T8015 KY1615	B335
1881316	RCGV45T0820 KY1615	B335
1881318	RCGV45T4015 KY1615	B335
1881319	RCGV45T8015 KY1615	B335
1881320	RCGX151000T20015 KY1615	B335
1881321	RCGX191000T20015 KY1615	B335
1881322	RCGV88T8015 KY1615	B335
1881325	RNGA32T0820 KY1615	B336
1881326	RNGA43T0820 KY1615	B336
1881327	RNG32T0820 KY1615	B336
1881328	RNG33T0820 KY1615	B336
1881329	RNG42T0820 KY1615	B336
1881330	RNG43T0820 KY1615	B336
1881332	RNG65T0820 KY1615	B336
1881347	SNGA432T0820 KY1615	B337
1881348	SNGA433T0820 KY1615	B337
1881351	SNG322T0820 KY1615	B337
1881355	SNG432T0220 KY1615	B337
1881356	SNG432T0820 KY1615	B337
1881357	SNG433T0820 KY1615	B337
1881358	SNG434T0820 KY1615	B337
1881361	SNG451T0820 KY1615	B337
1881362	SNG452T0820 KY1615	B337
1881364	SNG453T0820 KY1615	B337
1881365	SNG454T0820 KY1615	B337
1881366	SNG455T0820 KY1615	B337
1881367	SNG455T4015 KY1615	B337
1881368	SNG455T8015 KY1615	B337
1881371	SNG554T0820 KY1615	B337
1881396	SNGX453T0820 KY1615	B338
1881402	SPG322T0420 KY1615	B338
1881405	SPG422T0420 KY1615	B338
1881413	TNGA332T0820 KY1615	B339
1881414	TNGA333T0820 KY1615	B339
1881416	TNGA432T0820 KY1615	B339
1881417	TNGA433T0820 KY1615	B339
1881422	TNG222T0820 KY1615	B339
1881423	TNG331T0820 KY1615	B339
1881424	TNG332T0820 KY1615	B319, B339
1881425	TNG333T0820 KY1615	B339
1881426	TNG334T0820 KY1615	B339
1881427	TNG352T0820 KY1615	B339
1881428	TNG353T0820 KY1615	B339
1881430	TNG432T0820 KY1615	B339
1881437	TPG221T0420 KY1615	B340
1881438	TPG222T0420 KY1615	B340
1881439	TPG223T0420 KY1615	B340
1881440	TPG321T0420 KY1615	B340
1881441	TPG322T0420 KY1615	B340
1881442	TPG323T0420 KY1615	B340
1881447	TPU221T0220 KY1615	B341
1881448	TPU222T0220 KY1615	B341
1881449	TPU321T0220 KY1615	B341
1881450	TPU322T0220 KY1615	B341
1881451	TPU323T0220 KY1615	B341
1881452	VNGA331T0820 KY1615	B342
1881453	VNGA332T0820 KY1615	B342
1881454	VNGA333T0820 KY1615	B342
1881455	VNGA432T0820 KY1615	B342
1882046	CNMX452T0820 KY3500	B316
1884626	420.101 SCREW	S121–123
1884627	420.121	S121–123
1884628	420.161	S121–122
1884629	420.241	S17, S20, S24, S32, S50, S121–122, T17
1884630	470.240	S17, S20, S24, S45, S50, S121–122
1884631	470.241	S17, S20, S24, S32, S50, S121–122
1884632	470.242	S20, S24, S32
1886490	SDJCLF083D	B228
1887616	NG3094L KC5010	C170
1893419	DTJNR164DKC3	B131
1893421	DDQNR164CKC3	B88
1893422	DDQNL164CKC3	B88
1895492	SPHX1205PCFLGN1WB KCK15	S69
1897657	TPGX0902ZPRGD KC7015	H85
1897658	TPGX1102ZPRGD KC7015	H85
1897659	TPGX1303ZPRGD KC7015	H85
1897660	TPGX1603ZPRGD KC7015	H85
1897830	BGHX15L508PCFRGG KC510M	S125
1903553	KGMSR2450N	C143
1905695	CNMG643RP KC5010	B53
1906272	MCFNL12CA4	B72
1907344	KGMER2450N	C145
1908809	DCLNR245DKC4	B59
1908811	DCLNL245DKC4	B59
1908834	DSDNN164KC3	B109
1908835	DSDNN204KC3	B109
1908976	SRCCR122B	B243
1908978	SRCCR162D	B243
1908980	SRCCL162D	B243
1908981	SRCCR123B	B243
1908994	SRCCR163D	B243
1908995	SRCCL163D	B243
1908996	SRCCR203D	B243
1909002	SRCCL203D	B243
1909004	KGMSL2450N	C143
1909005	SRACR244D	B243
1909006	SRACL244D	B243
1909159	D64TTB56	B409
1909790	CPGT2152LF KC5010	B206
1909791	TPGT21505LF KC5010	B267
1910043	VBGT2205HP KC5410	B280
1910044	VBGT221HP KC5410	B280
1910215	CNMG433RP KC5010	B53
1912477	STN1612UNI KC635M	W44
1913052	B966A03000 KC7315	G130
1913458	B966A03500 KC7315	G130
1913459	B966A03700 KC7315	G130
1913460	B966A03800 KC7315	G130
1913461	B966A04000 KC7315	G130
1913462	B966A04200 KC7315	G130
1913473	B966A04500 KC7315	G130
1913474	B966A04600 KC7315	G130
1913475	B966A04800 KC7315	G130
1913476	B966A05000 KC7315	G130
1913477	B966A05500 KC7315	G130
1913478	B966A05700 KC7315	G130
1913479	B966A05800 KC7315	G130
1913480	B966A06000 KC7315	G130
1913481	B966A06500 KC7315	G131
1913482	B966A06800 KC7315	G131
1913483	B966A07000 KC7315	G131
1913484	B966A07400 KC7315	G131
1913485	B966A07500 KC7315	G131
1913486	B966A07800 KC7315	G131
1913487	B966A08000 KC7315	G131
1913488	B966A08500 KC7315	G131
1913489	B966A08800 KC7315	G131
1913490	B966A09000 KC7315	G131
1913491	B966A09300 KC7315	G131
1913492	B966A09500 KC7315	G131
1913493	B966A09800 KC7315	G131
1913494	B966A10000 KC7315	G131
1913495	B966A10200 KC7315	G131
1913496	B966A10500 KC7315	G131
1913497	B966A10700 KC7315	G131
1913498	B966A11000 KC7315	G131
1913499	B966A11200 KC7315	G131
1913500	B966A11500 KC7315	G132
1913501	B966A11700 KC7315	G132
1913502	B966A12000 KC7315	G132
1913503	B966A12500 KC7315	G132
1913504	B966A12700 KC7315	G132
1913505	B966A13000 KC7315	G132
1913506	B966A13500 KC7315	G132
1913507	B966A13700 KC7315	G132
1913508	B966A14000 KC7315	G132
1913509	B966A14500 KC7315	G132
1913510	B966A14700 KC7315	G132
1913511	B966A15000 KC7315	G132
1913512	B966A15500 KC7315	G132
1913513	B966A15700 KC7315	G132
1913514	B966A16000 KC7315	G132
1913515	B976A04000 KC7315	G134
1913516	B976A04200 KC7315	G134
1913517	B976A04500 KC7315	G135
1913518	B976A04600 KC7315	G135
1913519	B976A04800 KC7315	G135
1913520	B976A05000 KC7315	G135
1913521	B976A05500 KC7315	G135
1913522	B976A05700 KC7315	G135
1913523	B976A05800 KC7315	G135
1913524	B976A06000 KC7315	G135
1913525	B976A06500 KC7315	G135
1913526	B976A06800 KC7315	G135
1913527	B976A07000 KC7315	G135
1913528	B976A07400 KC7315	G136
1913529	B976A07500 KC7315	G136
1913530	B976A07800 KC7315	G136
1913531	B976A08000 KC7315	G136
1913532	B976A08500 KC7315	G136
1913533	B976A08800 KC7315	G136
1913534	B976A09000 KC7315	G136
1913535	B976A09300 KC7315	G136
1913536	B976A09500 KC7315	G136
1913537	B976A09800 KC7315	G136
1913538	B976A10000 KC7315	G136
1913539	B976A10200 KC7315	G136
1913540	B976A10500 KC7315	G136
1913541	B976A10700 KC7315	G137
1913542	B976A11000 KC7315	G137
1913543	B976A11200 KC7315	G137
1913544	B976A11500 KC7315	G137
1913545	B976A11700 KC7315	G137
1913546	B976A12000 KC7315	G137
1913547	B976A12500 KC7315	G137
1913548	B976A12700 KC7315	G137
1913549	B976A13000 KC7315	G137
1913550	B976A13500 KC7315	G137
1913551	B976A13700 KC7315	G137
1913552	B976A14000 KC7315	G137
1913553	B976A14500 KC7315	G137
1913554	B976A14700 KC7315	G137
1913555	B976A15000 KC7315	G137
1913556	B976A15500 KC7315	G137
1913558	B976A16000 KC7315	G138
1913559	B976A16500 KC7315	G138
1913560	B976A17000 KC7315	G138
1913561	B976A17500 KC7315	G138
1913562	B976A18000 KC7315	G138
1913563	B976A18500 KC7315	G138
1913564	B976A19000 KC7315	G138
1913565	B976A19500 KC7315	G138
1913566	B976A20000 KC7315	G138
1913567	B977A04000 KC7315	G134
1913568	B977A04200 KC7315	G134
1913569	B977A04500 KC7315	G135
1913570	B977A04600 KC7315	G135
1913571	B977A04800 KC7315	G135
1913572	B977A05000 KC7315	G135
1913573	B977A05500 KC7315	G135
1913574	B977A05800 KC7315	G135
1913575	B977A06000 KC7315	G135
1913576	B977A06500 KC7315	G135
1913577	B977A06800 KC7315	G135
1913578	B977A07000 KC7315	G135
1913579	B977A07400 KC7315	G136
1913580	B977A07500 KC7315	G136
1913581	B977A07800 KC7315	G136
1913582	B977A08000 KC7315	G136
1913583	B977A08500 KC7315	G136
1913584	B977A08800 KC7315	G136
1913585	B977A09000 KC7315	G136
1913586	B977A09300 KC7315	G136
1913587	B977A09500 KC7315	G136
1913588	B977A09800 KC7315	G136
1913589	B977A10000 KC7315	G136
1913590	B977A10200 KC7315	G136
1913591	B977A10500 KC7315	G136
1913592	B977A10700 KC7315	G137
1913593	B977A11000 KC7315	G137
1913594	B977A11200 KC7315	G137
1913595	B977A11500 KC7315	G137
1913596	B977A11700 KC7315	G137
1913597	B977A12000 KC7315	G137
1913598	B977A12500 KC7315	G137
1913599	B977A12700 KC7315	G137
1913600	B977A13000 KC7315	G137
1913601	B977A13500 KC7315	G137
1913602	B977A13700 KC7315	G137
1913603	B977A14000 KC7315	G137
1913604	B977A14500 KC7315	G137
1913605	B977A14700 KC7315	G137
1913606	B977A15000 KC7315	G137
1913607	B977A15500 KC7315	G137
1913608	B977A15700 KC7315	G137
1913609	B977A16000 KC7315	G138
1913610	B977A16500 KC7315	G138
1913611	B977A17000 KC7315	G138
1913612	B977A17500 KC7315	G138
1913613	B977A18000 KC7315	G138
1913614	B977A18500 KC7315	G138
1913615	B977A19000 KC7315	G138
1913616	B977A19500 KC7315	G138
1913617	B977A20000 KC7315	G138
1913618	B978A05000 KC7315	G139
1913619	B978A05500 KC7315	G139
1913620	B978A06000 KC7315	G139
1913621	B978A06500 KC7315	G139
1913622	B978A06800 KC7315	G139
1913623	B978A07000 KC7315	G139
1913624	B978A07500 KC7315	G140
1913625	B978A07800 KC7315	G140
1913626	B978A08000 KC7315	G140
1913627	B978A08500 KC7315	G140
1913628	B978A09000 KC7315	G140
1913629	B978A09500 KC7315	G140
1913630	B978A10000 KC7315	G140
1913631	B978A10200 KC7315	G140
1913632	B978A10500 KC7315	G140
1913633	B978A11000 KC7315	G140
1913634	B978A11500 KC7315	G140
1913635	B978A12000 KC7315	G140
1913636	B978A12500 KC7315	G140
1913637	B978A13000 KC7315	G140
1913638	B978A13500 KC7315	G140
1913639	B978A14000 KC7315	G141
1913640	B978A14500 KC7315	G141
1913641	B978A15000 KC7315	G141
1913642	B978A15500 KC7315	G141
1913643	B978A16000 KC7315	G141
1913644	B978A16500 KC7315	G141
1913645	B978A17000 KC7315	G141
1913646	B978A17500 KC7315	G141
1913647	B978A18000 KC7315	G141
1913648	B978A18500 KC7315	G141
1913649	B978A19000 KC7315	G141
1913650	B978A19500 KC7315	G141
1913651	B978A20000 KC7315	G141
1914363	NG4250L KC5025	C171
1914364	NG4250R KC5025	C170
1915368	881.252.320	K137–139
1915629	MS2089	C132–133
1916212	LNEU1245R04SGP KC725M	U20
1916215	LNEU1245R08SGP KC725M	U20
1916218	LNEU1245R16SGP KC725M	U20
1916221	LNEU1250R04SGP KC725M	U20
1916224	LNEU1250R08SGP KC725M	U20
1918803	SM455 K9	S39
1920691	TPG321T0220 KY1615	B340
1920692	TPG322T0220 KY1615	B340
1920693	SPU422T0220 KY1615	B338
1920694	RCGX0907-001 KY1615	B336
1920751	NRD4125R KC5010	C173
1921611	193.395	V122–123
1921612	193.394	V121–123
1921713	193.393	V121–123, V132–133
1921714	193.392	V121, V123, V132
1921715	193.391	V121–123, V132–133
1921716	193.390	V121–123, V132
1921717	193.389	V121–122
1923011	NAS3R4 KC5025	D12
1923833	A4G0300M03P02GMP KC5025	C105

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1923834	A4R0500M05P00GMP KC5025	C106
1923835	A4G0500M05P04GMP KC5010	C105
1923836	A4G0505M05U04GMN KC5025	C106
1923837	A4G0505M05U08GMN KC5025	C106
1923838	A4G0505M05U04GMP KC5025	C105
1923839	A4G0505M05U08GMP KC5025	C105
1923840	A4G0500M05P08GMP KC5010	C105
1924131	HPFSS125S3025 KC635M	P108
1924283	HPFSS188S3031 KC635M	P108
1924285	HPFSS250S3038 KC635M	P108
1924288	HPFSS312S3081 KC635M	P108
1924289	HPFSS375S3050 KC635M	P108
1924290	HPFSS375S3088 KC635M	P108
1924291	HPFSS500S3063 KC635M	P108
1924292	HPFSS500S3125 KC635M	P108
1924576	HPFT250S6075 KC635M	P110
1924577	HPFT312S6081 KC635M	P110
1924578	HPFT375S6088 KC635M	P110
1924579	HPFT500S6100 KC635M	P110
1924580	HPFT500S6200 KC635M	P110
1924581	HPFT625S6125 KC635M	P110
1924743	HPFT750S6150 KC635M	P110
1924744	HPFT750S6225 KC635M	P110
1924745	HPFT1000S6150 KC635M	P110
1924746	HPFT1000S6225 KC635M	P110
1925120	HPRDM188S3019 KC633M	P149
1925121	HPRDM250S4025 KC633M	P149
1925122	HPRDM312S4031 KC633M	P149
1925133	HPRDM375S4038 KC633M	P149
1925134	HPRDM500S4050 KC633M	P149
1925138	HPBNDM125S4013 KC633M	P150
1925140	HPBNDM188S4019 KC633M	P150
1925141	HPBNDM250S4025 KC633M	P150
1925143	HPBNDM375S4038 KC633M	P150
1925144	HPBNDM500S4050 KC633M	P150
1925145	HPBNDM625S4063 KC633M	P150
1925146	HPBNDM750S4075 KC633M	P150
1925147	HPFDM250S4038 KC633M	P148
1925148	HPFDM250S4063 KC633M	P148
1925149	HPFDM250S4088 KC633M	P148
1925150	HPFDM312S4050 KC633M	P148
1925151	HPFDM312S4075 KC633M	P148
1925152	HPFDM312S4113 KC633M	P148
1925153	HPFDM375S4056 KC633M	P148
1925154	HPFDM375S5094 KC633M	P148
1925155	HPFDM375S5131 KC633M	P148
1925156	HPFDM500S4075 KC633M	P148
1925157	HPFDM500S6125 KC633M	P148
1925158	HPFDM500S6175 KC633M	P148
1925159	HPFDM625S4094 KC633M	P148
1925160	HPFDM625S6156 KC633M	P148
1925161	HPFDM625S6219 KC633M	P148
1925162	HPFDM750S4113 KC633M	P148
1925163	HPFDM750S6188 KC633M	P148
1925164	HPFDM750S6263 KC633M	P148
1925165	HPFDM1000S5150 KC633M	P148
1925166	HPFDM1000S6250 KC633M	P148
1925167	HPFDM1000S6350 KC633M	P148
1926594	CNMG4305FN KT315	B49
1926595	CNMG4305FN KC5010	B49
1927913	KSEM125R1WN16F45M	H85–86
1927914	KSEM160R1WN20F45M	H85–86
1927915	KSEM200R1WN25F45M	H85–86
1927916	KSEM241R1WN32F45M	H85–86
1928470	193.371	J87–89
1928504	193.372	J87–89
1928643	5.34032-025115	J88
1928644	5.34032-025200	J88
1928645	5.34050-025300	J88
1928646	5.34050-025450	J88
1928647	5.34125R025150	J87
1928667	SPHX090304R20 KC7215	J115
1928669	SPHX060204R20 KC7140	J115
1928670	SPHX070304R20 KC7140	J115
1928671	SPHX090304R20 KC7140	J115
1928672	SPHX120404R20 KC7140	J115
1931147	MS2091	C34–41, C122–125, C127–128, C130–131
1931554	TTP15	S44–45, T120, U35–37
1931573	MS2077	U35–37, V68–70
1931575	MS2078	S39, T113, U32–34
1937135	SSF150HTS130239	J89
1937136	SSF150HTS130664	J89
1937137	SSF150HTS131114	J89
1937138	SSF150HTS131764	J89
1937503	CDHB120601 KC5010	B199
1937504	CDHB120601 KC5025	B199
1937506	CDHB12061 KC5010	B199
1937507	CDHB12061 KC5025	B199
1937508	CDHB12061 KT315	B199
1937509	CDHB120605 KC5010	B199
1937510	CDHB120605 KC5025	B199
1937511	CDHB120605 KT315	B199
1937512	CDHH120605L KC5010	B199
1937513	CDHH120605R KC5010	B199
1937514	CDHH120605L KC5025	B199
1937515	CDHH120605R KC5025	B199
1937516	CDHH120605L KT315	B199
1937517	CDHH120605R KT315	B199
1937518	CDHH12061L KC5010	B199
1937519	CDHH12061R KC5010	B199
1937520	CDHH12061L KC5025	B199
1937530	GPCD505 KC5025	B238
1937532	TDHB12807501 KC5010	B263
1937534	TDHB12807501 KT315	B263
1937535	TDHB12807505 KC5010	B263
1937536	TDHB12807505 KC5025	B263
1937538	TDHB1280751 KC5010	B263
1937539	TDHB1280751 KC5025	B263
1937540	TDHB1280751 KT315	B263
1937542	TDHB1280752 KC5025	B263
1937544	TDHH12807505L KC5010	B263
1937550	TDHH1280751L KC5010	B263
1937562	WPGT1510UF KC5010	B288
1937563	WPGT15105UF KC5010	B288
1937571	TPCB2205 KC5010	B266
1937580	TPCG2205L KC5010	B266
1937586	TPCG221L KC5010	B266
1937592	TPCG222L KC5010	B266
1937598	TPCH2205 KC5010	B266
1937601	TPCH221 KC5010	B266
1937615	TD6P05 KC5010	B266
1937618	TD6P1 KC5010	B266
1937621	TD6P2 KC5010	B266
1937645	TPGH322 KC5010	B266
1937946	E04HSCFDL12	B200
1937955	E05MSCFDR12	B200
1937956	E05MSCLDL12	B202
1937957	E05MSCLDR12	B202
1937958	E03MSCLDL12A	B202
1937960	A2906XSCLDR1205	B203
1937962	A2906XSCLDR121	B203
1937966	A3206XSCLDR1205	B203
1937970	A3206XSCLDR121	B203
1937974	A0406XSCLDR12075	B203
1937976	A0406XSCFDR12125	B201
1937978	A0406XSCLDR12125	B203
1937982	A2908XSCLDR121	B203
1937990	A3208XSCLDR121	B203
1937992	A0408XSCFDR12075	B201
1938000	E2910XSCLDR12088	B203
1938010	E3210KSCLDR122	B203
1938013	E0410HSCLDR12125	B203
1938018	E2908XSCLDR12088	B203
1938022	E3208XSCLDR121	B203
1939528	B977A09700 KC7315	G136
1940731	HTSR10CI	J75
1940732	HTSR11CI	J75
1940738	B513S08000 A30	J76
1940739	B513S08000 AS3	J76
1940740	B513S10000 A30	J76
1940741	B513S10000 AS3	J76
1940783	HTSR12CI	J75
1940784	HTSR13CI	J75
1940785	HTSR14CI	J75
1940786	HTSR10CE	J75
1940787	HTSR11CE	J75
1940788	HTSR12CE	J75
1940789	HTSR13CE	J75
1940790	HTSR14CE	J75
1940958	CNMG432RP KC5010	B53
1940959	CNMG434RP KC5010	B53
1940961	CNMG543RP KC5010	B53
1940965	DNMG432RP KC5010	B84
1940967	DNMG434RP KC5010	B84
1940968	DNMG442RP KC5010	B84
1940971	SNMG432RP KC5010	B105
1940972	SNMG433RP KC5010	B105
1940975	SNMG643RP KC5010	B105
1940977	TNMG332RP KC5010	B127
1940979	TNMG432RP KC5010	B127
1940984	VNMG332RP KC5010	B148
1940986	WNMG432RP KC5010	B161
1940987	WNMG433RP KC5010	B161
1941189	B977A12800 KC7315	G137
1941190	B977A15800 KC7315	G138
1942326	HTSR043R025M	J75
1942327	HTSR049R028M	J75
1942328	HTSR052R028M	J75
1942450	B978A12800 KC7315	G140
1942715	193.397	J75
1949633	A4SMR1616K0314	C124
1949634	A4SML1616K0314	C125
1949635	A4SMR2020K0314	C124
1949636	A4SML2020K0314	C125
1949637	A4SMR2525M0317	C124
1949638	A4SML2525M0317	C125
1949639	A4SMR2020K0414	C124
1949640	A4SML2020K0414	C125
1949641	A4SMR2525M0417	C124
1949642	A4SML2525M0417	C125
1949643	A4SMR3225P0417	C124
1949644	A4SML3225P0417	C125
1949645	A4SMR2020K0519	C124
1949646	A4SML2020K0519	C125
1949647	A4SMR2525M0520	C124
1949648	A4SML2525M0520	C125
1949649	A4SMR3225P0522	C124
1949650	A4SML3225P0522	C125
1949651	A4ENN2020K0407	C131
1949652	A4ENN2525M0407	C131
1949654	A4ENN2525M0509	C131
1949655	A20RA4EMR0307M	C133
1949656	A20RA4EML0307M	C133
1949657	A25RA4EMR0310M	C133
1949658	A25RA4EML0310M	C133
1949659	A32SA4EMR0312M	C133
1949660	A32SA4EML0312M	C133
1949661	A20RA4EMR0407M	C133
1949662	A20RA4EML0407M	C133
1949663	A25RA4EMR0410M	C133
1949664	A25RA4EML0410M	C133
1949665	A32SA4EMR0412M	C133
1949666	A32SA4EML0412M	C133
1949667	A40TA4EMR0416M	C133
1949668	A40TA4EML0416M	C133
1949669	A32SA4EMR0516M	C133
1949670	A32SA4EML0516M	C133
1949671	A40TA4EMR0516M	C133
1949672	A40TA4EML0516M	C133
1950263	E0408HSCLDR1225	B203
1950374	A04HSWUPR15	B291
1950376	A05HSWUPR15	B291
1950378	E03MSWUPR15	B292
1950380	E04MSWUPR15	B292
1950382	E05MSWUPR15	B292
1950388	E06MSWUPR2	B292
1950390	E08RSWUPR2	B292
1950413	E06SSTLDR2	B265
1950709	SECW443AESN7GN KY3500	S41
1950712	SDCW43EDSR8GN KY3500	T117, T124
1952700	A4G0305M03U02GMN KC5010	C106
1952701	A4G0305M03U02GMN KC5025	C106
1952702	A4G0305M03U04GMN KC5010	C106
1952733	A4G0305M03U04GMN KC5025	C106
1952734	A4G0405M04U04GMN KC5010	C106
1952735	A4G0405M04U04GMN KC5025	C106
1952736	A4G0405M04U08GMN KC5010	C106
1952737	A4G0405M04U08GMN KC5025	C106
1952738	A4G0505M05U04GMN KC5010	C106
1952740	A4G0505M05U08GMN KC5010	C106
1952742	A4G0305M03U02GMP KT315	C105
1952743	A4G0305M03U02GMP KC5010	C105
1952744	A4G0305M03U02GMP KC5025	C105
1952745	A4G0305M03U04GMP KT315	C105
1952746	A4G0305M03U04GMP KC5010	C105
1952747	A4G0305M03U04GMP KC5025	C105
1952748	A4G0405M04U04GMP KT315	C105
1952749	A4G0405M04U04GMP KC5010	C105
1952750	A4G0405M04U04GMP KC5025	C105
1952751	A4G0405M04U08GMP KT315	C105
1952752	A4G0405M04U08GMP KC5010	C105
1952753	A4G0405M04U08GMP KC5025	C105
1952755	A4G0505M05U04GMP KC5010	C105
1952758	A4G0505M05U08GMP KC5010	C105
1952760	A4G0300M03P02GMP KC5010	C105
1952762	A4G0300M03P04GMP KC5010	C105
1952763	A4G0300M03P04GMP KC5025	C105
1952764	A4G0400M04P02GMP KC5010	C105
1952765	A4G0400M04P02GMP KC5025	C105
1952766	A4G0400M04P04GMP KC5010	C105
1952767	A4G0400M04P04GMP KC5025	C105
1952768	A4G0400M04P08GMP KC5010	C105
1952769	A4G0400M04P08GMP KC5025	C105
1952771	A4G0500M05P04GMP KC5025	C105
1952773	A4G0500M05P08GMP KC5025	C105
1952774	A4R0405M04U00GMN KC5010	C107
1952775	A4R0405M04U00GMN KC5025	C107
1952776	A4R0505M05U00GMN KC5010	C107
1952777	A4R0505M05U00GMN KC5025	C107
1952778	A4R0400M04P00GMP KC5010	C106
1952779	A4R0400M04P00GMP KC5025	C106
1952780	A4R0500M05P00GMP KC5010	C106
1952847	A4C0305N00CF02 KC5025	C112
1952848	A4C0305R06CF02 KC5025	C113
1952849	A4C0305L06CF02 KC5025	C113
1953085	A4G0300M03P02GMP K313	C105
1953086	A4G0300M03P04GMP K313	C105
1953087	A4G0400M04P02GMP K313	C105
1953088	A4G0400M04P04GMP K313	C105
1953090	A4G0500M05P04GMP K313	C105
1953091	A4G0500M05P08GMP K313	C105
1953092	A4R0400M04P00GMP K313	C106
1953153	A4R0500M05P00GMP K313	C106
1953177	A4SMR100314	C122
1953178	A4SML100314	C123
1953179	A4SMR120314	C122
1953180	A4SML120314	C123
1953181	A4SMR160317	C122
1953182	A4SML160317	C123
1953323	A4SMR120414	C122
1953324	A4SML120414	C123
1953325	A4SMR160417	C122
1953326	A4SML160417	C123
1953327	A4SMR120519	C122
1953328	A4SML120519	C123
1953329	A4SMR160520	C122
1953330	A4SML160520	C123
1953331	A4ENN120407	C130
1953332	A4ENN160407	C130
1953334	A4ENN160509	C130
1953335	A12RA4EMR0307N	C132
1953336	A12RA4EML0307N	C132
1953337	A16RA4EMR0310N	C132
1953338	A16RA4EML0310N	C132
1953339	A20SA4EMR0312N	C132
1953341	A12RA4EMR0407N	C132
1953342	A12RA4EML0407N	C132
1953343	A16RA4EMR0410N	C132
1953344	A16RA4EML0410N	C132
1953345	A20SA4EMR0412N	C132
1953347	A24TA4EMR0416N	C132
1953349	A20SA4EMR0516N	C132
1953351	A24TA4EMR0516N	C132
1953352	A24TA4EML0516N	C132
1956691	SEF180200RSS125M	I26
1956692	SEF750812RSS125	I25
1956753	SEF812875RSS150	I25
1956754	SEF875937RSS150	I25
1956755	SEF9371010RSS150	I25
1957224	A4SMR100414	C122
1957226	A4SMR200417	C122
1957227	A4SML200417	C123
1957228	A4SMR200522	C122
1957229	A4SML200522	C123
1957573	MS2090	C130–131
1957789	B966A05900 KC7315	G130

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
1959664	B977A05600 KC7315	G135
1959665	B977A03300 KC7315	G134
1959666	B977A06900 KC7315	G135
1960078	B977A14900 KC7315	G137
1960079	B977A15100 KC7315	G137
1961106	B976A09700 KC7315	G136
1961108	B966A03200 KC7315	G130
1962982	CT15	B291–292
1963407	DFR200R4WD32M	J12
1963863	QC21	B265
1967470	SN7T	W40
1971584	B978A09750 KC7315	G140
1971763	B977A08900 KC7315	G136
1972376	B966A13200 KC7315	G132
1974209	SPHX090310R20 KC7215	J115
1974252	S411	B285
1975006	B977A05200 KC7315	G135
1980539	BGHX15L504PCFRGG K110M	S125
1981264	BGHX15L508PCFRGG K110M	S125
1981758	BGHX15L515PCFRGG K110M	S125
1981759	BGHX15L515PCFRGG KC510M	S125
1982315	DFT030204HP KMF	J101
1982316	DFT030304HP KMF	J101
1982397	B966A06200 KC7315	G130
1983309	3.42805R081 KC7215	I30
1983310	3.42807R081 KC7215	I30
1983992	CCMT432LF KC5025	B191
1984003	CCMT3252MF KC5025	B191
1984183	B976A05200 KC7315	G135
1984545	B978A11200 KC7315	G140
1985037	B966A06700 KC7315	G131
1985038	B966A08200 KC7315	G131
1985784	KMSP315IP	B59, B87, B92, B113, B131, B150–151, B154, B163
1985792	TTP9	U28–29
1985985	B978A10800 KC7315	G140
1986652	B977A08200 KC7315	G136
1986773	B976A06200 KC7315	G135
1987659	SPHX1205PCSRGPB KCK15	S68
1988099	B966A06900 KC7315	G131
1988100	B966A07900 KC7315	G131
1988931	B977A05700 KC7315	G135
1988932	B976A05300 KC7315	G135
1988983	B976A08700 KC7315	G136
1989347	A4M50L0314M	C138
1989348	A4M50R0314M	C138
1989349	A4M50L0414M	C138
1989350	A4M50R0414M	C138
1989351	A4M50L0519M	C138
1989352	A4M50R0519M	C138
1990689	SECW443AEEN22GNW KC725M	S41
1991229	B966A12600 KC7315	G132
1992230	B977A07700 KC7315	G136
1992232	B966A10400 KC7315	G131
1992822	B105A04600 K10	G24
1993391	KSEM136R1WN16F45M	H85–86
1993392	KSEM146R1WN20F45M	H85–86
1993403	KSEM181R1WN25F45M	H85–86
1993404	KSEM221R1WN25F45M	H85–86
1993405	KSEM261R1WN32F45M	H85–86
1993406	KSEM281R1WN32F45M	H85–86
1993407	KSEM301R1WN32F45M	H85–86
1993408	KSEM321R1WD50F45M	H85–86
1993409	KSEM361R1WD50F45M	H85–86
1993552	THW2M	T63, T65, V77, V139–142
1994080	FAS100302GD KC7215	H42
1994291	TTP20	S32, S50, V155–156
1995000	B966A05100 KC7315	G130
1995002	B966A08600 KC7315	G131
1995073	B966A09400 KC7315	G131
1995074	B966A10100 KC7315	G131
1995075	B966A11400 KC7315	G132
1995076	B966A12100 KC7315	G132
1997389	B966A08100 KC7315	G131
1997391	B966A11800 KC7315	G132
1998276	CNGA431E KD1405	B362
1998277	CNGA432E KD1405	B362
1998279	CNMS432E KD1405	B363
1998280	DNGA431E KD1405	B364
1998287	VNMS331E KD1405	B368
1998288	VNMS332E KD1405	B368
1998291	CPGW2151E KD1405	B363
1998293	CPGW3251E KD1405	B363
1998296	DPGW3251E KD1405	B365
1998302	VBGW332E KD1405	B367
1998336	A4G0300M03P04E KD1405	B370, C110
1998337	A4G0400M04P04E KD1405	B370, C110
1998338	A4G0500M05P08E KD1405	B370, C110
1998340	A4R0500M05P00E KD1405	B370, C111
1998947	B966A09600 KC7315	G131
2006399	12748308500	S82
2008288	12748601000	S30–31
2018142	12748358200	S77, S82, S88
2018164	12748500200	S83
2018166	12748500400	S83
2018285	12148006000	T24
2018296	MS2260	V58
2018679	12148068700	K116–117
2029553	12148044900	S30–31, S77, S82, S88
2032259	12748600900	S77, S82, S88
2033468	12748503400	S83
2033852	360.660	H87
2033863	360.661	H87
2033865	360.663	H87
2033866	360.664	H87
2033867	360.665	H87
2033868	360.666	H87
2033869	360.667	H87
2033870	360.668	H87
2033871	360.669	H87
2033872	360.670	H87
2035319	DFR190R4WD32M	J12
2035688	OFPT64AFSN6HB KC725M	S52
2035689	OFPT64AFEN6GB KC725M	S52
2036154	B976A08100 KC7315	G136
2036529	KSEM1700HPM KC7315	H52
2036530	KSEM2200HPM KC7315	H52
2036531	KSEM1750HPM KC7315	H52
2036532	KSEM2000HPM KC7315	H52
2036592	DFR0656R3SSF075	J14
2036604	KSEM3200HPM KC7315	H53
2036605	KSEM1400HPM KC7315	H52
2036606	KSEM1500HPM KC7315	H52
2036607	KSEM2250HPM KC7315	H52
2036608	KSEM1600HPM KC7315	H52
2036609	KSEM2600HPM KC7315	H53
2036612	KSEM2650HPM KC7315	H53
2036643	DFR0688R3SSF075	J14
2036644	DFR0703R3SSF075	J14
2036645	DFR0734R3SSF075	J14
2036646	DFR0750R3SSF100	J14
2036647	DFR0813R3SSF100	J14
2036648	DFR0844R3SSF100	J14
2036649	DFR0875R3SSF100	J14
2036650	DFR0906R3SSF100	J14
2036651	DFR0938R3SSF100	J14
2036652	DFR0969R3SSF100	J14
2036653	DFR0984R3SSF100	J14
2036654	DFR1000R3SSF100	J14
2036655	DFR0500R2SSF075	J13
2036656	DFR0563R2SSF075	J13
2036657	DFR0625R2SSF075	J13
2036658	DFR0688R2SSF075	J13
2036659	DFR0750R2SSF100	J13
2036660	DFR0813R2SSF100	J13
2036661	DFR0875R2SSF100	J13
2036662	DFR0938R2SSF100	J13
2036663	DFR1000R2SSF100	J13
2036664	DFR0625R3SSF100	J14
2036665	DFR0656R3SSF100	J14
2036666	DFR0688R3SSF100	J14
2036667	DFR0703R3SSF100	J14
2036668	DFR0734R3SSF100	J14
2036670	DFR0750R3SSF075	J14
2036671	DFR0781R3SSF075	J14
2036672	DFR0813R3SSF075	J14
2036673	DFR0844R3SSF075	J14
2036674	DFR0875R3SSF075	J14
2036675	DFR1000R3SSF125	J14
2036695	DFR0781R3SSF100	J14
2036703	KSEM3300HPM KC7315	H53
2036704	KSEM2700HPM KC7315	H53
2036705	KSEM2100HPM KC7315	H52
2036706	KSEM2050HPM KC7315	H52
2036882	KSEM1800HPM KC7315	H52
2036903	KSEM2300HPM KC7315	H52
2036904	KSEM2400HPM KC7315	H52
2036905	KSEM3000HPM KC7315	H53
2036906	KSEM1250HPM KC7315	H52
2036907	KSEM1450HPM KC7315	H52
2036909	KSEM1300HPM KC7315	H52
2036910	KSEM2500HPM KC7315	H52
2036911	KSEM1650HPM KC7315	H52
2036912	KSEM3900HPM KC7315	H53
2036923	KSEM2900HPM KC7315	H53
2036924	KSEM1350HPM KC7315	H52
2036953	KSEM3050HPM KC7315	H53
2036954	KSEM1560HPM KC7315	H52
2036955	KSEM1900HPM KC7315	H52
2036956	KSEM2150HPM KC7315	H52
2036957	KSEM3500HPM KC7315	H53
2037058	B966A06400 KC7315	G131
2037059	B967A10000 KC7315	G131
2038613	B966A06050 KC7315	G130
2039536	SR3 KWH	B243–244
2039537	SR4	B243
2040139	DFR220R4WD32M	J12
2040680	B977A04300 KC7315	G135
2040682	B966A03900 KC7315	G130
2043136	B966A10600 KC7315	G131
2043137	B966A11600 KC7315	G132
2043415	B978A05700 KC7315	G139
2043417	B977A10600 KC7315	G137
2043418	B977A14600 KC7315	G137
2043552	KSEM3950HPM KC7315	H53
2043779	B977A06100 KC7315	G135
2044606	B978A11800 KC7315	G140
2044834	B976A19700 KC7315	G138
2045222	B966A05300 KC7315	G130
2045293	DFT030204HP KC7140	J101
2045294	DFT030304HP KC7140	J101
2045616	B978A11400 KC7315	G140
2045646	KSEM2950HPM KC7315	H53
2045820	B977A12300 KC7315	G137
2045822	B977A11600 KC7315	G137
2045867	B976A16800 KC7315	G138
2047379	KSEM0500HP KC7315	H52
2047380	KSEM1280HPM KC7315	H52
2047382	KSEM0516HP KC7315	H52
2047393	KSEM1320HPM KC7315	H52
2047395	KSEM1370HPM KC7315	H52
2047396	KSEM1380HPM KC7315	H52
2047397	KSEM0547HP KC7315	H52
2047398	KSEM1410HPM KC7315	H52
2047399	KSEM1420HPM KC7315	H52
2047400	KSEM0563HP KC7315	H52
2047401	KSEM1440HPM KC7315	H52
2047403	KSEM0578HP KC7315	H52
2047404	KSEM1480HPM KC7315	H52
2047405	KSEM0594HP KC7315	H52
2047406	KSEM1530HPM KC7315	H52
2047408	KSEM1550HPM KC7315	H52
2047409	KSEM1570HPM KC7315	H52
2047410	KSEM1580HPM KC7315	H52
2047411	KSEM0634HP KC7315	H52
2047412	KSEM1620HPM KC7315	H52
2047413	KSEM0641HP KC7315	H52
2047414	KSEM0656HP KC7315	H52
2047415	KSEM0672HP KC7315	H52
2047416	KSEM0688HP KC7315	H52
2047417	KSEM0703HP KC7315	H52
2047418	KSEM0719HP KC7315	H52
2047419	KSEM1850HPM KC7315	H52
2047420	KSEM0734HP KC7315	H52
2047421	KSEM0750HP KC7315	H52
2047422	KSEM0759HP KC7315	H52
2047423	KSEM1950HPM KC7315	H52
2047424	KSEM0781HP KC7315	H52
2047425	KSEM0797HP KC7315	H52
2047426	KSEM0813HP KC7315	H52
2047427	KSEM0844HP KC7315	H52
2047428	KSEM0859HP KC7315	H52
2047429	KSEM0875HP KC7315	H52
2047430	KSEM0884HP KC7315	H52
2047431	KSEM0922HP KC7315	H52
2047432	KSEM2350HPM KC7315	H52
2047433	KSEM0938HP KC7315	H52
2047434	KSEM2450HPM KC7315	H52
2047435	KSEM0969HP KC7315	H52
2047436	KSEM1000HP KC7315	H52
2047437	KSEM2550HPM KC7315	H52
2047438	KSEM1011HP KC7315	H52
2047439	KSEM1031HP KC7315	H53
2047440	KSEM1047HP KC7315	H53
2047441	KSEM2750HPM KC7315	H53
2047442	KSEM1094HP KC7315	H53
2047443	KSEM2800HPM KC7315	H53
2047444	KSEM1109HP KC7315	H53
2047445	KSEM2850HPM KC7315	H53
2047446	KSEM1125HP KC7315	H53
2047447	KSEM1156HP KC7315	H53
2047448	KSEM1172HP KC7315	H53
2047449	KSEM3100HPM KC7315	H53
2047450	KSEM3150HPM KC7315	H53
2047451	KSEM1250HP KC7315	H53
2047452	KSEM3250HPM KC7315	H53
2047453	KSEM1313HP KC7315	H53
2047456	KSEM3400HPM KC7315	H53
2047458	KSEM3550HPM KC7315	H53
2047460	KSEM3600HPM KC7315	H53
2047464	KSEM3750HPM KC7315	H53
2047465	KSEM3800HPM KC7315	H53
2047466	KSEM1500HP KC7315	H53
2047468	KSEM3850HPM KC7315	H53
2047469	KSEM4000HPM KC7315	H53
2047470	KSEM0625HP KC7315	H52
2047471	KSEM0766HP KC7315	H52
2047472	KSEM1188HP KC7315	H53
2047474	KSEM1219HP KC7315	H53
2047477	KSEM1344HP KC7315	H53
2047478	KSEM1375HP KC7315	H53
2047698	OFPT64AFSN6HB KC522M	S52
2047701	OFPT64AFEN6GB KC522M	S52
2049487	B977A05100 KC7315	G135
2049488	B977A11800 KC7315	G137
2049489	B977A12200 KC7315	G137
2050081	MS2111	C183, C185, C188–189, C192, D30
2050082	S2112	C182, C184–187, C189, C191, C194–195, D25–29, D35, D37–38
2050230	B978A09800 KC7315	G140
2057426	MTFNL12CA3	B140
2071739	MSSNL12CA4	B117
2071758	MSSNL10CA3	B117
2072222	MSKNR20CA5	B115
2074429	MTFNR16CA3	B140
2074430	MSKNR16CA4	B115
2074432	MSRNR16CA4	B116
2074433	MCFNR16CA4	B72
2074904	MSTNR12CA4	B118
2077947	MCLNL12CA4	B74
2078231	MSRNR12CA4	B116
2078236	MTFNR12CA3	B140
2079654	NG3189R KC5010	C170
2114011	MSKNR10CA3	B115
2114013	MSKNR12CA4	B115
2114015	MSYNR10CA3	B119
2114034	CTFPL10CA2	B186, B397
2114041	MTGNR12CA3	B141
2116588	CTFPR10CA2	B186, B397
2193621	MTFNL16CA3	B140
2202438	KRBB10FABDRS204C	K78, K100
2202439	KRBB10SCLDR4060C	K78, K100
2202440	KRBB10SCFPR06085C	K78, K100
2202450	KRBB10SCFPR06110C	K78, K101
2202451	KRBB10SCFPR06135C	K78, K101
2202510	B977A05300 KC7315	G135

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
2203486	B966A08400 KC7315	G131
2203489	B977A03900 KC7315	G134
2203577	B977A12600 KC7315	G137
2203579	B977A07100 KC7315	G135
2203787	B977A16200 KC7315	G138
2203834	B977A08700 KC7315	G136
2204116	B966A13300 KC7315	G132
2204393	CBTF150R2WD20N2M	J114
2204394	CBTF160R2WD20N2M	J114
2204395	CBTF170R2WD20N2M	J114
2204396	CBTF200R2WD20N2M	J114
2204397	CBTF210R2WD20N2M	J114
2204398	CBTF210R2WD20N3M	J114
2204399	CBTF220R2WD20N2M	J114
2204400	CBTF230R2WD20N3M	J114
2204401	CBTF250R2WD20N3M	J114
2204402	CBTF340R2WD32N3M	J114
2204403	CBTF350R2WD32N3M	J114
2204404	CBTF380R2WD32N3M	J114
2204405	CBTF180R2WD20N2M	J114
2204406	CBTF230R2WD20N2M	J114
2204407	CBTF250R2WD20N2M	J114
2204408	CBTF240R2WD20N3M	J114
2204409	CBTF270R2WD20N3M	J114
2210084	LNEQ1245R04 KCPK30	U20
2210086	LNEU1245R04 KCPK30	U19
2210095	SDET43PDSR8GB KCPK30	T116, T123, U39
2210766	OFPT64AFSN6HB KCPK30	S52
2210767	OFPT64AFEN6GB KCPK30	S52
2212773	OFKT64AFSN6HB KC522M	S52
2213696	B966A03300 KC7315	G130
2213700	B966A04300 KC7315	G130
2213701	B966A04400 KC7315	G130
2213842	193.409	S50, V155–156
2213947	WNMG332RP KC5010	B161
2213962	CCMT433MF KC5025	B191
2214237	B978A15200 KC7315	G141
2214926	B966A11300 KC7315	G131
2217005	B966A07700 KC7315	G131
2217646	NTB3L12B KC5010	D18
2217647	NTB3R12B KC5010	D18
2217898	B976A13300 KC7315	G137
2218437	SNHX1103T KCPK30	U14
2218492	B977A09200 KC7315	G136
2220306	LNEQ1245R04 KCK15	U20
2220307	LNEQ1250R04 KCK15	U20
2220308	LNEQ1255R04 KCK15	U20
2220309	LNEQ1260R04 KCK15	U20
2220334	SPG322 KCK15	B171
2220855	B966A06100 KC7315	G130
2220856	B966A06600 KC7315	G131
2220857	B966A14800 KC7315	G132
2221944	OFPT64AFEN6GB KCK15	S52
2221945	OFPT64AFSN6HB KCK15	S52
2222651	B976A08600 KC7315	G136
2223775	KSEM0493R1SSF075F45	H86
2223776	KSEM0532R1SSF075F45	H86
2223777	KSEM0571R1SSF075F45	H86
2223778	KSEM0625R1SSF075F45	H86
2223779	KSEM0709R1SSF075F45	H86
2223780	KSEM0788R1SSF100F45	H86
2223781	KSEM0867R1SSF100F45	H86
2223782	KSEM0945R1SSF100F45	H86
2223993	KSEM1024R1SSF125F45	H86
2223994	KSEM1103R1SSF125F45	H86
2223995	KSEM1182R1SSF125F45	H86
2223996	KSEM1260R1SSF125F45	H86
2223997	KSEM1418R1SSF125F45	H86
2224587	B976A05600 KC7315	G135
2224588	B976A09100 KC7315	G136
2226032	VNMG331MS K313	B147
2226630	B976A14100 KC7315	G137
2226662	B977A12900 KC7315	G137
2227124	ODG1063ISGB KCPK30	U9
2227125	ODG1063ISGD KCPK30	U9
2227126	ODG2087ISGB KCPK30	U9
2227127	ODG2087ISGD KCPK30	U9
2227128	ODG3125ISGB KCPK30	U9
2227129	ODG3125ISGD KCPK30	U9
2227130	ODG4158ISGB KCPK30	U9
2227131	ODG4158ISGD KCPK30	U9
2227133	ODG6236ISGB KCPK30	U10
2227145	SNHX1102PZTNGP KCPK30	U15
2227147	SNHX1203PZTNGP KCPK30	U15
2227149	SNHX12L4PZTNGP KCPK30	U15
2227150	SNHX12L5PZTNGP KCPK30	U15
2227155	SPHX1205PCERGPB KCPK30	S68
2227156	SPHX1205PCERGN1WB KCPK30	S69
2227157	SPHX1205PCSRGPB KCPK30	S68
2227159	SPHX1205ZCERGP KCPK30	S65
2227160	SPHX1205ZCSRGP KCPK30	S65
2227164	SPHX15T6ZCERGP KCPK30	S71
2227165	SPHX15T6ZCSRGP KCPK30	S71
2227338	B966A10300 KC7315	G131
2227374	OFKT64AFEN6GB KC520M	S52
2227380	OFKT64AFSN6HB KC520M	S52
2227984	B976A12800 KC7315	G137
2228362	B977A05900 KC7315	G135
2229054	B977A19200 KC7315	G138
2229055	B966A10800 KC7315	G131
2229138	B977A13300 KC7315	G137
2229285	THW3M	U28–29, U35–37
2229362	B256A16000 KC7315	G58
2229364	B256A13500 KC7315	G58
2229365	B256A11000 KC7315	G58
2229366	B256A14000 KC7315	G58
2229393	B256A08800 KC7315	G58
2229412	OFKT64AFSN6HB KCPK30	S52
2229543	OFKT64AFEN6GB KC522M	S52
2229547	CNGG431FS KC5010	B46
2229549	CNGG431FS KC5025	B46
2229550	CNGG432FS KC5010	B46
2229551	CNGG432FS KC5025	B46
2229552	DNGG4305FS KC5010	B77
2229644	DNGG431FS KC5010	B77
2229645	DNGG431FS KC5025	B77
2229646	DNGG432FS KC5010	B77
2229648	CNMG4305MS KC5010	B52
2229649	CNMG4305MS KC5025	B52
2229651	CNMG430MS KC5010	B52
2229652	CNMG430MS KC5025	B52
2229653	CNMG431MS K313	B52
2229654	CNMG431MS KC5010	B52
2229655	CNMG431MS KC5025	B52
2229656	CNMG432MS K313	B52
2229657	CNMG432MS KC5010	B52
2229659	CNMG432MS KC5025	B52
2229660	DNMG431MS K313	B82
2229661	DNMG431MS KC5010	B82
2229662	DNMG431MS KC5025	B82
2229693	DNMG432MS K313	B82
2229694	DNMG432MS KC5010	B82
2229695	DNMG432MS KC5025	B82
2229696	VNMG331MS KC5010	B147
2229697	VNMG331MS KC5025	B147
2230406	B977A14200 KC7315	G137
2230539	B977A06700 KC7315	G135
2231579	B966A07200 KC7315	G131
2231776	B976A06600 KC7315	G135
2231777	B976A08300 KC7315	G136
2231778	B976A09600 KC7315	G136
2231830	B966A12300 KC7315	G132
2233364	B977A16600 KC7315	G138
2234423	OFKT64AFEN6GB KCPK30	S52
2234816	A4C0405N00CF02 KC5025	C112
2234819	A4C0305R10CF02 KC5025	C113
2234821	A4C0405R10CF02 KC5025	C113
2234823	A4R0305M03U00GMN KC5025	C107
2234824	A4R0305M03U00GMN KC5010	C107
2234825	A4R0300M03P00GMP KC5025	C106
2234826	A4R0300M03P00GMP KC5010	C106
2235052	50A03RP90BG15CUM	S121
2235053	63A03RP90BG15CUM	S121
2235054	80A03RP90BG15CUM	S121
2235055	100B04RP90BG15CUM	S121
2235056	125B05RP90BG15CUM	S121
2235057	160B06RP90BG15CUM	S121
2235124	B978A19840 KC7315	G141
2235210	A4R0300M03P00GMP K313	C106
2236065	B977A08400 KC7315	G136
2238510	KSEM0500R3SS075	H77
2238511	KSEM0509R3SS075	H77
2238523	KSEM0531R3SS075	H77
2238524	KSEM0547R3SS075	H77
2238525	KSEM0563R3SS075	H77
2238526	KSEM0578R3SS075	H77
2238527	KSEM0594R3SS075	H77
2238528	KSEM0609R3SS075	H77
2238529	KSEM0625R3SS075	H77
2238530	KSEM0634R3SS075	H77
2238531	KSEM0641R3SS075	H77
2238532	KSEM0656R3SS075	H77
2238533	KSEM0672R3SS075	H77
2238534	KSEM0688R3SS075	H77
2238535	KSEM0703R3SS075	H77
2238536	KSEM0719R3SS075	H77
2238537	KSEM0734R3SS075	H77
2238538	KSEM0750R3SS075	H77
2238539	KSEM0750R3SS100	H77
2238540	KSEM0759R3SS075	H77
2238541	KSEM0766R3SS100	H77
2238542	KSEM0781R3SS100	H77
2238543	KSEM0797R3SS100	H77
2238544	KSEM0813R3SS100	H77
2238545	KSEM0844R3SS100	H77
2238546	KSEM0859R3SS100	H77
2238547	KSEM0875R3SS100	H77
2238548	KSEM0875R3SS125	H77
2238549	KSEM0884R3SS100	H77
2238550	KSEM0906R3SS100	H78
2238551	KSEM0922R3SS100	H78
2238552	KSEM0938R3SS100	H78
2238553	KSEM0969R3SS100	H78
2238554	KSEM0984R3SS100	H78
2238555	KSEM1000R3SS100	H78
2238557	KSEM1011R3SS125	H78
2238558	KSEM1031R3SS125	H78
2238560	KSEM1063R3SS125	H78
2238562	KSEM1109R3SS125	H78
2238563	KSEM1125R3SS125	H78
2238564	KSEM1156R3SS125	H78
2238565	KSEM1172R3SS125	H78
2238566	KSEM1188R3SS125	H78
2238568	KSEM1219R3SS125	H78
2238569	KSEM1250R3SS125	H78
2238570	KSEM1250R3SS150	H78
2238571	KSEM1281R3SS150	H78
2238572	KSEM1297R3SS150	H78
2238573	KSEM1313R3SS150	H78
2238574	KSEM1328R3SS150	H78
2238576	KSEM1375R3SS150	H78
2238577	KSEM1406R3SS150	H78
2238579	KSEM1438R3SS150	H78
2238581	KSEM1500R3SS150	H78
2238582	KSEM1514R3SS150	H78
2239620	DCMT3252FW KT315	B225
2239685	DCMT3251FW KC5010	B225
2240351	B977A10300 KC7315	G136
2240426	HNEN0905XNSN KY3500	S79
2240427	HNEN0905ANSN KY3500	S79
2242390	B966A05600 KC7315	G130
2242780	B978A06600 KC7315	G139
2244229	B977A08100 KC7315	G136
2244276	B977A18800 KC7315	G138
2244883	CNMG433MS KC5010	B52
2244884	CNMG434MS KC5010	B52
2244885	CNMG542MS KC5010	B52
2244886	CNMG543MS KC5010	B52
2244887	CNMG642MS KC5010	B52
2244888	CNMG643MS KC5010	B52
2244891	DNMG4305MS KC5010	B82
2244892	DNMG433MS KC5010	B82
2244893	DNMG441MS KC5010	B82
2244894	DNMG442MS KC5010	B82
2244896	SNMG432MS KC5010	B103
2244897	SNMG433MS KC5010	B103
2244901	TNMG3305MS KC5010	B125
2244902	TNMG331MS KC5010	B125
2244903	TNMG332MS KC5010	B125
2244904	TNMG431MS KC5010	B125
2244905	TNMG432MS KC5010	B125
2244910	VNMG330MS KC5010	B147
2244911	VNMG3305MS KC5010	B147
2244912	VNMG332MS KC5010	B147
2244913	VNMG431MS KC5010	B147
2244914	VNMG432MS KC5010	B147
2244916	WNMG4305MS KC5010	B160
2244917	WNMG431MS KC5010	B160
2244918	WNMG432MS KC5010	B160
2244919	CNMG433MS KC5025	B52
2244920	CNMG434MS KC5025	B52
2244921	CNMG542MS KC5025	B52
2244922	CNMG543MS KC5025	B52
2244923	CNMG642MS KC5025	B52
2244924	CNMG643MS KC5025	B52
2244929	DNMG441MS KC5025	B82
2244930	DNMG442MS KC5025	B82
2244931	DNMG443MS KC5025	B82
2244932	SNMG432MS KC5025	B103
2244936	SNMG643MS KC5025	B103
2244937	TNMG3305MS KC5025	B125
2244938	TNMG331MS KC5025	B125
2244939	TNMG332MS KC5025	B125
2244940	TNMG431MS KC5025	B125
2244941	TNMG432MS KC5025	B125
2244943	TNMG542MS KC5025	B125
2244947	VNMG3305MS KC5025	B147
2244948	VNMG332MS KC5025	B147
2244950	VNMG432MS KC5025	B147
2244953	WNMG431MS KC5025	B160
2244954	WNMG432MS KC5025	B160
2244955	CNMG433MS K313	B52
2244958	CNMG543MS K313	B52
2244965	DNMG441MS K313	B82
2244966	DNMG442MS K313	B82
2244977	TNMG432MS K313	B125
2244981	TNMG544MS K313	B125
2244983	VNMG3305MS K313	B147
2244984	VNMG332MS K313	B147
2244989	WNMG431MS K313	B160
2244990	WNMG432MS K313	B160
2245036	TNMG438RP KC5010	B127
2245037	TNMG543RP KC5010	B127
2245045	CNMG432RP KC5025	B53
2245046	CNMG433RP KC5025	B53
2245048	CNMG542RP KC5025	B53
2245049	CNMG543RP KC5025	B53
2245050	CNMG544RP KC5025	B53
2245051	CNMG643RP KC5025	B53
2245053	DNMG432RP KC5025	B84
2245056	DNMG442RP KC5025	B84
2245059	SNMG432RP KC5025	B105
2245060	SNMG433RP KC5025	B105
2245063	SNMG643RP KC5025	B105
2245064	SNMG644RP KC5025	B105
2245065	TNMG332RP KC5025	B127
2245066	TNMG333RP KC5025	B127
2245067	TNMG432RP KC5025	B127
2245074	VNMG332RP KC5025	B148
2245076	WNMG432RP KC5025	B161
2245079	DNMG332RP KC5010	B84
2245088	SNMG434RP KC5025	B105
2245191	B977A09900 KC7315	G136
2245263	B977A15900 KC7315	G138
2245484	A4SMR2525M0620	C124
2245485	A4SMR2525M0820	C124
2245486	A4SML2525M0620	C125
2245487	A4SML2525M0820	C125
2245738	SPHX060202R20 KC7215	J115
2245739	SPHX060206R20 KC7215	J115
2245740	SPHX060208R20 KC7215	J115
2245741	SPHX070302R20 KC7215	J115
2245742	SPHX070306R20 KC7215	J115
2245833	SPHX070308R20 KC7215	J115
2245834	SPHX070312R20 KC7215	J115
2245836	SPHX090312R20 KC7215	J115
2245837	SPHX090316R20 KC7215	J115
2245839	SPHX120410R20 KC7215	J115
2245840	SPHX120416R20 KC7215	J115
2245841	SPHX120420R20 KC7215	J115
2245843	SPHX150512R20 KC7215	J115
2245844	SPHX150516R20 KC7215	J115
2245845	SPHX150520R20 KC7215	J115
2245846	SPHX060202R21 KC7215	J116
2245847	SPHX060206R21 KC7215	J116
2245848	SPHX060208R21 KC7215	J116
2245849	SPHX070306R21 KC7215	J116

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
2245851	SPHX070310R21 KC7215	J116
2245853	SPHX090310R21 KC7215	J116
2245854	SPHX090312R21 KC7215	J116
2245855	SPHX090316R21 KC7215	J116
2245856	SPHX120408R21 KC7215	J116
2245857	SPHX120410R21 KC7215	J116
2245858	SPHX120416R21 KC7215	J116
2245859	SPHX120420R21 KC7215	J116
2245860	SPHX070310R20 KC7215	J115
2245861	SPHX120412R20 KC7215	J115
2245862	SPHX120412R21 KC7215	J116
2245972	HNEN090508S KY3500	S79
2246044	A4G0605M06U08GMP KC5025	C105
2246045	A4G0605M06U08GMP KC5010	C105
2246047	A4G0600M06P08GMP KC5025	C105
2246074	TPMT2151LF KC5025	B268
2246494	SECT443AEFN7LE KC410M	S40
2248306	B966A14300 KC7315	G132
2248993	50HC030M	G79
2248994	50HC050M	G79
2248995	75HC030M	G79
2248996	75HC040M	G79
2248997	75HC050M	G79
2249180	B978A09700 KC7315	G140
2250674	KTIP0335R5SS038	H39
2250675	KTIP0354R5SS038	H39
2250676	KTIP0374R5SS038	H39
2250677	KTIP0374R5SS044	H39
2250678	KTIP0394R5SS044	H39
2250679	KTIP0413R5SS044	H39
2250680	KTIP0433R5SS044	H39
2250681	KTIP0453R5SS050	H39
2250682	KTIP0472R5SS050	H39
2250683	KTIP0492R5SS050	H39
2250684	KTIP0492R5SS056	H39
2250685	KTIP0512R5SS056	H39
2250686	KTIP0532R5SS056	H39
2250687	KTIP0551R5SS056	H39
2250688	KTIP0571R5SS063	H39
2250689	KTIP0591R5SS063	H39
2250690	KTIP0630R5SS069	H39
2250704	KTIP0313R3SS038	H39
2250705	KTIP0335R3SS038	H39
2250706	KTIP0354R3SS038	H39
2250707	KTIP0374R3SS038	H39
2250708	KTIP0374R3SS044	H39
2250709	KTIP0394R3SS044	H39
2250710	KTIP0413R3SS044	H39
2250711	KTIP0433R3SS044	H39
2250712	KTIP0453R3SS050	H39
2250723	KTIP0472R3SS050	H39
2250724	KTIP0492R3SS050	H39
2250725	KTIP0492R3SS056	H39
2250726	KTIP0512R3SS056	H39
2250727	KTIP0532R3SS056	H39
2250728	KTIP0551R3SS056	H39
2250729	KTIP0571R3SS063	H39
2250730	KTIP0591R3SS063	H39
2250731	KTIP0630R3SS069	H39
2250771	CNGG430FS KC5010	B46
2250772	CNGG4305FS KC5010	B46
2250775	DNGG3305FS KC5010	B77
2250784	TNGG331FS KC5010	B121
2250789	VNGG3305FS KC5010	B144
2250790	VNGG331FS KC5010	B144
2250791	VNGG332FS KC5010	B144
2250809	TNGG3305FS KC5025	B121
2250810	TNGG331FS KC5025	B121
2250816	VNGG331FS KC5025	B144
2250817	VNGG332FS KC5025	B144
2250824	B966A05200 KC7315	G130
2251521	SSP025018M	B67–68
2251639	B977A13800 KC7315	G137
2252989	KSEM1250PCM KC7135	H70
2252992	KSEM1750PCM KC7135	H70
2253024	KSEM2600PCM KC7135	H70, H111
2255896	B978A08800 KC7315	G140
2256128	NGP2062R KC5010	C168
2256252	B966A09900 KC7315	G131
2256916	B966A04700 KC7315	G130
2256918	B977A10800 KC7315	G137
2257597	B256A10500 KC7315	G58
2257646	B256A09500 KC7315	G58
2258040	KTIP080R5SS10M	H38
2258041	KTIP100R5SS12M	H38
2258042	KTIP120R5SS14M	H38
2258053	KTIP160R5SS18M	H38
2259958	170.306	H38–41
2259959	170.307	H38–41
2259960	170.308	H38–41
2259961	170.309	H38–41
2259981	MS2126	T75–80
2261701	B978A06100 KC7315	G139
2262952	KSSC551-630R	U28–29
2262953	KSSC551-630L	U28–29
2262954	KSSC630-709R	U28
2262955	KSSC630-709L	U28
2262956	KSSC709-813R	U35, U37
2262957	KSSC709-813L	U35, U37
2262958	KSSC813-917R	U36
2262959	KSSC813-917L	U36
2262960	KSSW551-630	U28–29
2262961	KSSW630-709	U28
2262962	KSSW709-813	U35, U37
2262963	KSSW813-917	U36
2262964	KSSCP551-709	U28–29
2262965	KSSCP709-917	U35–37
2263089	A4SMR3225P0626	C124
2263090	A4SML3225P0626	C125
2263091	A4SMR3225P0826	C124
2263092	A4SML3225P0826	C125
2263173	A4SMR3225P1026	C124
2263174	A4SML3225P1026	C125
2263175	A4SMR120620	C122
2263176	A4SMR160620	C122
2263177	A4SMR160624	C122
2263178	A4SMR200626	C122
2263179	A4SMR240626	C122
2263180	A4SML120620	C123
2263181	A4SML160620	C123
2263182	A4SML160624	C123
2263183	A4SML200626	C123
2263184	A4SML240626	C123
2263185	A4SMR160820	C122
2263186	A4SMR160824	C122
2263187	A4SMR200826	C122
2263188	A4SMR240826	C122
2263190	A4SML160824	C123
2263193	A4SMR201026	C122
2263194	A4SML201026	C123
2263197	A40TA4EMR0616M	C133
2263198	A40TA4EML0616M	C133
2263199	A24TA4EMR0616N	C132
2263200	A32TA4EMR0616N	C132
2263201	A24TA4EML0616N	C132
2263203	A20SA4EMR0616N	C132
2263299	MS1490	C34–41, C47–48, C50–51, C122–125, C130, D32
2263361	A4G0605M06U04GMN KC5010	C106
2263362	A4G0605M06U04GMN KC5025	C106
2263373	A4G0605M06U08GMN KT315	C106
2263374	A4G0605M06U08GMN KC5010	C106
2263375	A4G0605M06U08GMN KC5025	C106
2263376	A4G0605M06U12GMN KC5010	C106
2263377	A4G0605M06U12GMN KC5025	C106
2263378	A4G0805M08U08GMN KC5010	C106
2263380	A4G0805M08U12GMN KC5010	C106
2263383	A4G1005M10U08GMN KC5025	C106
2263385	A4G1005M10U12GMN KC5025	C106
2263386	A4G0605M06U04GMP KC5010	C105
2263387	A4G0605M06U04GMP KC5025	C105
2263392	A4G0805M08U08GMP KC5025	C105
2263397	A4R0605M06U00GMN KC5010	C107
2263398	A4R0605M06U00GMN KC5025	C107
2263399	A4R0805M08U00GMN KC5010	C107
2263400	A4R0805M08U00GMN KC5025	C107
2263403	A4R0600M06P00GMP KC5010	C106
2263404	A4R0600M06P00GMP KC5025	C106
2263406	A4R0800M08P00GMP KC5010	C106
2263414	A4G0600M06P04GMP KC5010	C105
2263415	A4G0600M06P08GMP KC5010	C105
2263416	A4G0800M08P08GMP KC5010	C105
2263578	RCGH43 KC5010	B238
2263727	B978A15100 KC7315	G141
2264017	B977A16700 KC7315	G138
2264019	B977A07200 KC7315	G136
2264020	B977A11100 KC7315	G137
2264538	B976A05400 KC7315	G135
2264889	B978A05300 KC7315	G139
2264901	B978A15800 KC7315	G141
2264928	B978A06200 KC7315	G139
2264933	B978A05100 KC7315	G139
2264934	B978A05200 KC7315	G139
2264938	B978A10100 KC7315	G140
2264939	B978A10300 KC7315	G140
2264953	B978A08100 KC7315	G140
2264954	B978A08600 KC7315	G140
2264955	B978A08700 KC7315	G140
2264956	B978A09900 KC7315	G140
2264970	B978A06300 KC7315	G139
2264971	B978A06400 KC7315	G139
2264972	B978A06700 KC7315	G139
2266804	B966A03960 KC7315	G130
2267534	M1D100E1802C100L800	T77
2267535	M1D100E1802C100L1000	T77
2267536	M1D125E1802C125L800	T77
2267537	M1D125E1802C125L1000	T77
2267538	M1D150E1803C125L800	T77
2267539	M1D150E1803C125L1000	T77
2267542	M1D200E1803S075L157	T78
2267545	M1D097E1802W100L175	T75
2267546	M1D100E1802W100L175	T75
2267547	M1D100E1802W100L375	T75
2267548	M1D150E1804CV40L288	T79
2267549	M1D100E1802CV40L250	T79
2267550	M1D100E1802W100L175R	T75
2267551	M1D125E1803CV40L288	T79
2267552	M1D100E1802W100L375R	T75
2267616	M1D300E1805S100L175	T78
2267617	M1D400E1806S150L200	T78
2267618	M1D600E1808S200L200	T78
2267620	M1D800E1812S250L250	T78
2267621	M1D200E1805W125L225	T76
2267623	M1D125E1803W125L225	T75
2267624	M1D125E1803W125L225R	T75
2267625	M1D125E1803W125L425	T75
2267626	M1D125E1803W125L425R	T75
2267627	M1D150E1803W125L225	T76
2267628	M1D150E1804W125L225R	T76
2267629	M1D150E1804W125L225	T76
2267631	M1D150E1803W125L425R	T76
2267632	M1D250E1806S075L157	T78
2267643	M1D300E1807S100L175	T78
2267644	M1D400E1808S150L200	T78
2267645	M1D500E1809S150L200	T78
2267646	M1D600E1808S150L200	T78
2267650	M1D200E1805S075L157	T78
2267651	M1D150E1803W125L425	T76
2268052	KSSS400ASP10N551-630	U28
2268303	KTIP080R3SS10M	H38
2268304	KTIP085R3SS10M	H38
2268305	KTIP090R3SS10M	H38
2268306	KTIP095R3SS10M	H38
2268307	KTIP100R3SS12M	H38
2268308	KTIP105R3SS12M	H38
2268309	KTIP110R3SS12M	H38
2268310	KTIP115R3SS12M	H38
2268311	KTIP120R3SS14M	H38
2268312	KTIP125R3SS14M	H38
2268313	KTIP130R3SS14M	H38
2268314	KTIP135R3SS14M	H38
2268315	KTIP140R3SS16M	H38
2268316	KTIP145R3SS16M	H38
2268317	KTIP150R3SS16M	H38
2268318	KTIP160R3SS18M	H38
2268625	KSSS400BSP10N551-630	U29
2268634	KSSS500ASP10N630-709	U28
2268640	KSSS600ASP10N551-630	U28
2268652	KSSS800ASP10N551-630	U28
2268670	KSSS1200ASP10N630-709	U28
2268676	KSSS500ASD43N709-813	U35
2268679	KSSS500BSD43N709-813	U37
2268688	KSSS600ASD43N709-813	U35
2268694	KSSS600ASD43N813-917	U36
2268706	KSSS800ASD43N813-917	U36
2268712	KSSS1000ASD43N709-813	U35
2268724	KSSS1200ASD43N709-813	U35
2268727	KSSS1200BSD43N709-813	U37
2268730	KSSS1200ASD43N813-917	U36
2269611	KTIP0313R5SS038	H39
2269913	DT9IP	T4–7, T49–54, T63–64, T107–109, U25–27, V36–38
2269914	DT15IP	S39, T14–17, T75–80, T113, U32–34, V68–70, V75–77, V82–83, V139–141
2270351	114.305	E55, E61
2270901	RCGT86SHF KCPK30	V92
2270973	RCGT86SHF KC725M	V92
2271064	EP1816E KC725M	T83
2271067	EP1816E KC522M	T83
2271071	EP1816E KCPK30	T83
2271072	EP1832E KC725M	T83
2271087	EC1804E KC725M	T83
2271088	EC1804FJ KC410M	T81
2271089	EC1808FJ KC410M	T81
2271090	EC1816FJ KC410M	T81
2271091	EC1832FJ KC410M	T81
2271092	EC1864FJ KC410M	T81
2271093	EC1816E KC522M	T82
2271094	EC1832E KC522M	T82
2271095	EC1864E KC522M	T82
2271097	EP1824E KC725M	T83
2271115	EP1832E KC522M	T83
2271116	EP1832E KC520M	T83
2271118	EP1832E KCPK30	T83
2271119	EP1808E KC725M	T83
2271122	EP1808E KC520M	T83
2271135	EP1808E KCPK30	T83
2271155	EP1864E KC725M	T83
2271157	EP1864E KC522M	T83
2271158	EP1864E KCPK30	T83
2271159	EP1812E KC725M	T83
2272493	B977A11900 KC7315	G137
2272784	3.42805R021 KC7015	I30
2272786	3.42805R021 KC7315	I30
2272789	3.42807R021 KC7015	I30
2272790	3.42807R021 KC7315	I30
2273004	DCKNR164DKC3	B58
2273005	DCKNL164DKC3	B58
2273006	DCKNR204DKC3	B58
2273007	DCKNL204DKC3	B58
2273008	DCLNR166DKC4	B59
2273010	DCLNR206DKC4	B59
2273011	DCLNL206DKC4	B59
2273012	DCLNR246DKC4	B59
2273013	DCLNL246DKC4	B59
2273014	DDJNR123BKC3	B87
2273015	DDJNL123BKC3	B87
2273016	DDJNR163DKC3	B87
2273017	DDJNL163DKC3	B87
2273018	DDJNR203DKC3	B87
2273020	DDQNR164DKC3	B88
2273021	DDQNL164DKC3	B88
2273022	DDQNR204DKC3	B88
2273023	DDQNL204DKC3	B88
2273024	DSDNN206KC4	B109
2273027	DSRNL206DKC4	B110
2273035	DTGNR123BKC3	B131
2273038	DTGNL163DKC3	B131
2273045	DWLNR123BKC3	B163
2273046	DWLNL123BKC3	B163
2273047	DWLNR163CKC3	B163
2273048	DWLNL163CKC3	B163
2273049	DWLNR163DKC3	B163
2273059	DCKNR205DKC4	B58
2273061	DCKNR206DKC4	B58
2273063	DCKNR164CKC3	B58
2273065	DDJNR163CKC3	B87
2273066	DDJNL163CKC3	B87
2273070	DSKNR164CKC3	B109
2273071	DSKNL164CKC3	B109
2273072	DSDNN124KC3	B109
2273073	DCKNR124BKC3	B58
2273081	DCRNR206DKC4	B60
2273318	B966A03100 KC7315	G130
2273321	B966A09200 KC7315	G131

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
2273388	EP1848E KC725M	T83
2274469	NG2062R KC5010	C170
2274946	A4G125I03P05GMN KC5025	C107
2274947	A4G125I03P1GMN KC5025	C107
2274949	A4G187I04P2GMN KC5025	C107
2275076	A4R125I03P00GMN KC5025	C107
2275077	A4R187I04P00GMN KC5025	C107
2275078	A4R250I06P00GMN KC5025	C107
2275080	A4R375I10P00GMN KC5025	C107
2275081	A4G125I03P05GMN KC5010	C107
2275082	A4G125I03P1GMN KC5010	C107
2275083	A4G187I04P1GMN KC5010	C107
2275084	A4G187I04P2GMN KC5010	C107
2275085	A4G250I06P1GMN KC5010	C107
2275086	A4G250I06P2GMN KC5010	C107
2275087	A4G312I08P1GMN KC5010	C107
2275089	A4G375I10P1GMN KC5010	C107
2275090	A4G375I10P2GMN KC5010	C107
2275091	A4R125I03P00GMN KC5010	C107
2275092	A4R187I04P00GMN KC5010	C107
2275093	A4R250I06P00GMN KC5010	C107
2275452	B978A19800 KC7315	G141
2275583	MS2148	T63–64, T107–109, U25–29
2276088	B976A04300 KC7315	G135
2276090	B977A18400 KC7315	G138
2276698	B977A18600 KC7315	G138
2277900	VBMT221LF KC5025	B281
2383518	TPGX0902ZPRGD KC7315	H85
2383519	TPGX1102ZPRGD KC7315	H85
2383520	TPGX1303ZPRGD KC7315	H85
2383521	TPGX1603ZPRGD KC7315	H85
2383522	TPGX0902ZPRGD KC7140	H85
2383552	B977A06350 KC7315	G135
2383555	SDCT431PDER8LD2 KC725M	T115, T122, U38
2383556	SDCT431PDEL8LD2 KC725M	T115, T122, U38
2383557	SDCT43PDEL8LD2 KC725M	T115, T122, U38
2383558	SDCT433PDER8LD2 KC725M	T115, T122, U38
2383559	SDCT433PDEL8LD2 KC725M	T115, T122, U38
2383560	SDCT434ENLD2 KC725M	T115, T122, U38
2383561	SDCT435ENLD2 KC725M	T115, T122, U38
2383562	SDCT436ENLD2 KC725M	T115, T122, U38
2383583	SDCT438ENLD2 KC725M	T115, T122, U38
2383584	SPCT31251PPER8LD2 KC725M	T111, U30
2383585	SPCT31251PPEL8LD2 KC725M	T111, U30
2383586	SPCT3125PPEL8LD2 KC725M	T111, U30
2383587	SPCT31253PPER8LD2 KC725M	T111, U30
2383588	SPCT31253PPEL8LD2 KC725M	T111, U30
2383589	SPCT31254ENLD2 KC725M	T111, U30
2383590	SPCT31255ENLD2 KC725M	T111, U30
2383591	SDCT431PDFR8LE KC410M	T114, T121, U38, V143
2383592	SDCT431PDFL8LE KC410M	T114, T121, U38, V143
2383593	SDCT43PDFR8LE KC410M	T114, T121, U38, V143
2383594	SDCT43PDFL8LE KC410M	T114, T121, U38, V143
2383595	SDCT433PDFR8LE KC410M	T114, T121, U38, V143
2383596	SDCT433PDFL8LE KC410M	T114, T121, U38, V143
2383597	SDCT434FNLE KC410M	T114, T121, U38, V143
2383598	SDCT435FNLE KC410M	T114, T121, U38, V143
2383599	SDCT436FNLE KC410M	T114, T121, U38, V143
2383600	SDCT438FNLE KC410M	T114, T121, U38, V143
2383601	SPCT31251PPFR8LE KC410M	T110, U30
2383602	SPCT31251PPFL8LE KC410M	T110, U30
2383603	SPCT3125PPFR8LE KC410M	T110, U30
2383604	SPCT3125PPFL8LE KC410M	T110, U30
2383605	SPCT31253PPFR8LE KC410M	T110, U30
2383608	SPCT31255FNLE KC410M	T110, U30
2383778	B977A06400 KC7315	G135
2384123	TPGX1102ZPRGD KC7140	H85
2384124	TPGX1303ZPRGD KC7140	H85
2384125	TPGX1603ZPRGD KC7140	H85
2384430	B977A12100 KC7315	G137
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
2384521	STN1624UNI KC635M	W44
2384522	STN1627UNI KC635M	W44
2384524	STN1632UNI KC635M	W44
2384961	H40MCLNL4	B76
2384973	H40MCLNR4	B76
2384977	H40MVUNR3	B155
2384978	H40MVUNL3	B155
2384979	H32MVUNR3	B155
2384980	H32MVUNL3	B155
2385356	B976A05100 KC7315	G135
2386534	420.162	S32
2386665	B977A19700 KC7315	G138
2388424	DT8IP	W4–5, W10–13, W17–19, W24–25
2388784	B976A10800 KC7315	G137
2389802	PMT04525	C71, C149
2390123	B977A08300 KC7315	G136
2390253	SDCT43PDER8LD2 KC725M	T115, T122, U38
2390254	SPCT3125PPER8LD2 KC725M	T111, U30
2390256	SECT443AEEN7LD2 KC725M	S40
2390257	SEKT443AEEN7GP2 KC725M	S40
2390258	SEKT443AEEN7GP2 KC520M	S40
2390259	SEKT443AEEN7GP2 KCK15	S40
2390260	SEKT443AEEN7GP2 KCPK30	S40
2390261	SEKT443AESN7GP2 KC725M	S40
2390262	SEKT443AESN7GP2 KC520M	S40
2390263	SEKT443AESN7GP2 KCK15	S40
2390264	SEKT443AESN7GP2 KCPK30	S40
2390265	SPET3125PPEL8GB2 KC725M	T111, U31
2390266	SPET3125PPEL8GB2 KCK15	T111, U31
2390267	SPET3125PPEL8GB2 KCPK30	T111, U31
2390268	SPET3125PPEL8GB2 KC520M	T111, U31
2390269	SPET3125PPSL8GB2 KC725M	T111, U31
2390271	SPET3125PPSL8GB2 KCPK30	T111, U31
2390273	SPET3125PPER8GB2 KC725M	T111, U31
2390274	SPET3125PPER8GB2 KCK15	T111, U31
2390275	SPET3125PPER8GB2 KCPK30	T111, U31
2390276	SPET3125PPER8GB2 KC520M	T111, U31
2390277	SPET3125PPSR8GB2 KC725M	T111, U31
2390278	SPET3125PPSR8GB2 KCK15	T111, U31
2390279	SPET3125PPSR8GB2 KCPK30	T111, U31
2390280	SPET3125PPSR8GB2 KC520M	T111, U31
2390281	SDET43PDEL8GB2 KC520M	T115, T122, U39
2390282	SDET43PDEL8GB2 KCK15	T115, T122, U39
2390283	SDET43PDEL8GB2 KCPK30	T115, T122, U39
2390284	SDET43PDEL8GB2 KC725M	T115, T122, U39
2390285	SDET43PDER8GB2 KC520M	T115, T122, U39
2390286	SDET43PDER8GB2 KCK15	T115, T122, U39
2390287	SDET43PDER8GB2 KCPK30	T115, T122, U39
2390288	SDET43PDER8GB2 KC725M	T115, T122, U39
2390289	SDET43PDSR8GB2 KC520M	T115, T122, U39
2390290	SDET43PDSR8GB2 KCK15	T115, T122, U39
2390291	SDET43PDSR8GB2 KCPK30	T115, T122, U39
2390292	SDET43PDSR8GB2 KC725M	T115, T122, U39
2390293	SDET433PDEL8GB2 KC520M	T115, T122, U39
2390294	SDET433PDEL8GB2 KCK15	T115, T122, U39
2390296	SDET433PDEL8GB2 KC725M	T115, T122, U39
2390297	SDET433PDER8GB2 KC520M	T115, T122, U39
2390298	SDET433PDER8GB2 KCK15	T115, T122, U39
2390299	SDET433PDER8GB2 KCPK30	T115, T122, U39
2390300	SDET433PDER8GB2 KC725M	T115, T122, U39
2390961	B976A08200 KC7315	G136
2391872	B977A17700 KC7315	G138
2391902	B966A06350 KC7315	G131
2391925	B966A05040 KC7315	G130
2392360	B976A03800 KC7315	G134
2392361	B976A03900 KC7315	G134
2393422	STN1118UNE KC635M	W44
2393667	STN1624UNE KC635M	W44
2393668	STN1620UNE KC635M	W44
2393670	STN1616UNE KC635M	W44
2393671	STN1614UNE KC635M	W44
2396971	B977A04900 KC7315	G135
2397289	B976A17100 KC7315	G138
2397687	B976A04900 KC7315	G135
2397689	B976A07900 KC7315	G136
2397697	DRGNR164DKC3	B98
2397698	DRGNL164DKC3	B98
2397700	DRGNL204DKC3	B98
2397707	DRGNR206DKC4	B98
2397767	KMSP625IP	B58–60, B68, B98, B109–110
2398751	A4M50R0314B036048	C141
2398752	A4M50R0314B042058	C141
2398763	A4M50R0314B052074	C141
2398764	A4M50R0314B068100	C141
2398765	A4M50R0314B090160	C141
2398766	A4M50R0314B130300	C141
2398767	A4M50R0314B290999	C141
2398768	A4M50L0314B036048	C142
2398769	A4M50L0314B042058	C142
2398770	A4M50L0314B052074	C142
2398771	A4M50L0314B068100	C142
2398772	A4M50L0314B090160	C142
2398773	A4M50L0314B130300	C142
2398774	A4M50L0314B290999	C142
2398775	A4M50R0414B048072	C141
2398776	A4M50R0414B064100	C141
2398777	A4M50R0414B092150	C141
2398778	A4M50R0414B132300	C141
2398779	A4M50R0414B290999	C141
2398780	A4M50L0414B048072	C142
2398781	A4M50L0414B064100	C142
2398782	A4M50L0414B092150	C142
2398783	A4M50L0414B132300	C142
2398784	A4M50L0414B290999	C142
2398785	A4M50R0519B058094	C141
2398786	A4M50R0519B080136	C141
2398787	A4M50R0519B120300	C141
2398788	A4M50R0519B250999	C141
2398789	A4M50L0519B058094	C142
2398790	A4M50L0519B080136	C142
2398791	A4M50L0519B120300	C142
2398792	A4M50L0519B250999	C142
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	D77
2399505	KM25LSSL1630	D77
2399506	KM25LSER1630	D77
2399507	KM25LSEL1630	D77
2400680	KSSP200R3SD43L168	T120
2400681	KSSP250R3SD43L200	T120
2400682	KSSP300R4SD43L240	T120
2401853	B977A13100 KC7315	G137
2402283	KTIP085R5SS10M	H38
2402284	KTIP090R5SS10M	H38
2402285	KTIP095R5SS10M	H38
2402286	KTIP105R5SS12M	H38
2402287	KTIP110R5SS12M	H38
2402288	KTIP115R5SS12M	H38
2402289	KTIP125R5SS14M	H38
2402290	KTIP130R5SS14M	H38
2402291	KTIP135R5SS14M	H38
2402292	KTIP140R5SS16M	H38
2402293	KTIP145R5SS16M	H38
2402294	KTIP150R5SS16M	H38
2402838	K400B14RF45HN09C	S77
2402839	K500B18RF45HN09C	S77
2402999	AADF0125J2B K600	P126
2403000	AADF0188J2B K600	P126
2403001	AADF0250J2B K600	P126
2403013	AADF0375J2B K600	P126
2403014	AADF0500J2B K600	P127
2403016	AADF0750J2B K600	P127
2403807	B966A08300 KC7315	G131
2404108	B976A14200 KC7315	G137
2404433	B978A11700 KC7315	G140
2404438	B966A06300 KC7315	G131
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
2404707	A4G0305M03U02B KC5025	C108
2404708	A4G0405M04U04B KC5025	C108
2405161	KTIP080R3SCF12M	H40
2405162	KTIP085R3SCF12M	H40
2405203	KTIP090R3SCF12M	H40
2405204	KTIP095R3SCF12M	H40
2405205	KTIP100R3SCF16M	H40
2405206	KTIP105R3SCF16M	H40
2405207	KTIP110R3SCF16M	H40

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
2405208	KTIP115R3SCF16M	H40
2405209	KTIP120R3SCF16M	H40
2405210	KTIP125R3SCF16M	H40
2405211	KTIP130R3SCF16M	H40
2405212	KTIP135R3SCF16M	H40
2405213	KTIP140R3SCF16M	H40
2405214	KTIP145R3SCF16M	H40
2405215	KTIP150R3SCF20M	H40
2405216	KTIP160R3SCF20M	H40
2405248	KTIP080R5SCF12M	H40
2405249	KTIP085R5SCF12M	H40
2405250	KTIP090R5SCF12M	H40
2405251	KTIP095R5SCF12M	H40
2405252	KTIP100R5SCF16M	H40
2405273	KTIP105R5SCF16M	H40
2405274	KTIP110R5SCF16M	H40
2405275	KTIP115R5SCF16M	H40
2405276	KTIP120R5SCF16M	H40
2405277	KTIP125R5SCF16M	H40
2405278	KTIP130R5SCF16M	H40
2405279	KTIP135R5SCF16M	H40
2405280	KTIP140R5SCF16M	H40
2405281	KTIP145R5SCF16M	H40
2405282	KTIP150R5SCF20M	H40
2405283	KTIP160R5SCF20M	H40
2405361	SEPT443AEEN7GB2 KC725M	S41
2405362	SEPT443AEEN7GB2 KCK15	S41
2405373	SEPT443AEEN7GB2 KCPK30	S41
2405375	SEPT443AESN7GB2 KC725M	S41
2405376	SEPT443AESN7GB2 KCK15	S41
2405377	SEPT443AESN7GB2 KCPK30	S41
2405379	SPPT3125PPER8GB2 KCK15	T112, U31
2405380	SPPT3125PPER8GB2 KCPK30	T112, U31
2405381	SPPT3125PPSR8GB2 KCK15	T112, U31
2405382	SPPT3125PPSR8GB2 KCPK30	T112, U31
2405383	SPPT3125PPSR8GB2 KTPK20	T112, U31
2405384	SDPT43PDER8GB2 KC725M	T116, T123, U39
2405385	SDPT43PDER8GB2 KCK15	T116, T123, U39
2405386	SDPT43PDER8GB2 KCPK30	T116, T123, U39
2405387	SDPT43PDSR8GB2 KC725M	T116, T123, U39
2405388	SDPT43PDSR8GB2 KCK15	T116, T123, U39
2405389	SDPT43PDSR8GB2 KCPK30	T116, T123, U39
2405616	KSEM3200PCM KC7135	H70, H111
2405618	KSEM4000PCM KC7135	H70, H111
2407294	B977A10100 KC7315	G136
2407297	B978A07700 KC7315	G140
2408209	B977A09400 KC7315	G136
2408266	B966A03400 KC7315	G130
2408308	B976A09200 KC7315	G136
2408389	A16TDDUNR3KC3	B92
2408390	A20UDDUNR3KC3	B92
2408391	A20UDDUNR4KC3	B92
2408392	A24UDDUNR4KC3	B92
2408464	A32VDDUNR4KC3	B92
2408469	A16TDTFNR3KC3	B138
2408487	A32VDCKNL4KC3	B67
2408488	A32VDCKNL5KC4	B67
2408494	A20UDSKNL3KC2	B113
2408503	A16TDCFNR4KC3	B67
2408505	A24UDCFNR4KC3	B67
2408507	A16TDCLNL4KC3	B68
2408508	A20UDCLNL4KC3	B68
2408509	A24UDCLNL4KC3	B68
2408511	A28UDCLNL4KC3	B68
2408512	A32VDCLNL4KC3	B68
2408514	A32VDCLNL6KC4	B68
2408515	A40VDCLNL4KC3	B68
2408516	A40VDCLNL6KC4	B68
2408517	A16TDCLNR3KC2	B68
2408518	A16TDCLNR4KC3	B68
2408519	A20UDCLNR4KC3	B68
2408520	A24UDCLNR4KC3	B68
2408521	A24UDCLNR5KC4	B68
2408522	A28UDCLNR4KC3	B68
2408523	A32VDCLNR4KC3	B68
2408524	A32VDCLNR5KC4	B68
2408526	A40VDCLNR4KC3	B68
2408527	A40VDCLNR6KC4	B68
2408528	A16TDDUNL3KC3	B92
2408544	A24UDDPNL4KC3	B91
2408545	A20UDDPNR4KC3	B91
2408546	A24UDDPNR4KC3	B91
2408547	A20UDDQNL4KC3	B91
2408548	A24UDDQNL4KC3	B91
2408549	A20UDDQNR4KC3	B91
2408550	A24UDDQNR4KC3	B91
2412903	RCGT86ELF KCPK30	V92
2414136	A4ENN2020K0305	C131
2414137	A4ENN2525M0305	C131
2414138	A4ENN120305	C130
2414139	A4ENN160305	C130
2416198	B977A16400 KC7315	G138
2416279	B977A04100 KC7315	G134
2417292	DCLNR123BKC3	B59
2417293	DCLNL123BKC3	B59
2417294	DCLNR163DKC3	B59
2417295	DCLNL163DKC3	B59
2417433	IRSN64 K9	B98
2419790	B976A12300 KC7315	G137
2421384	SSY5T K9	D76, D78–79
2421386	SSA5T	D76, D78–79
2424997	B967A12500 KC7315	G132
2425000	B967A09000 KC7315	G131
2425052	B967A10800 KC7315	G131
2425073	B967A08500 KC7315	G131
2425113	B966A04100 KC7315	G130
2425114	B966A04900 KC7315	G130
2425115	B966A05400 KC7315	G130
2425117	B966A03600 KC7315	G130
2425118	B966A07100 KC7315	G131
2425119	B966A07300 KC7315	G131
2425120	B966A07600 KC7315	G131
2425143	B966A08700 KC7315	G131
2425145	B966A08900 KC7315	G131
2425146	B966A09100 KC7315	G131
2425149	B966A09700 KC7315	G131
2425151	B966A10900 KC7315	G131
2425173	B966A11100 KC7315	G131
2425176	B966A11900 KC7315	G132
2425178	B966A12200 KC7315	G132
2425203	B966A12400 KC7315	G132
2425205	B966A12800 KC7315	G132
2425206	B966A12900 KC7315	G132
2425233	B966A14200 KC7315	G132
2425285	B977A03000 KC7315	G134
2425288	B977A03100 KC7315	G134
2425290	B977A03200 KC7315	G134
2425292	B977A03400 KC7315	G134
2425303	B977A03500 KC7315	G134
2425304	B977A03600 KC7315	G134
2425305	B977A03700 KC7315	G134
2425306	B977A03800 KC7315	G134
2425309	B977A04400 KC7315	G135
2425310	B977A04700 KC7315	G135
2425311	B977A05400 KC7315	G135
2425323	B977A06200 KC7315	G135
2425324	B977A06300 KC7315	G135
2425325	B977A06600 KC7315	G135
2425326	B977A07300 KC7315	G136
2425328	B977A07900 KC7315	G136
2425330	B977A07600 KC7315	G136
2425331	B977A08600 KC7315	G136
2425332	B977A09100 KC7315	G136
2425344	B977A09600 KC7315	G136
2425380	B977A12400 KC7315	G137
2425381	B977A11400 KC7315	G137
2425455	B977A10400 KC7315	G136
2425456	B977A11300 KC7315	G137
2425457	B977A10900 KC7315	G137
2425659	CCMT21505LF KC5025	B191
2425660	CCMT2151LF KC5025	B191
2425661	CCMT2152LF KC5025	B191
2425662	CCMT32505LF KC5025	B191
2425773	CCMT3251LF KC5025	B191
2425775	CCMT431LF KC5025	B191
2425779	CPMT18151LF KC5025	B207
2425780	CPMT21505LF KC5025	B207
2425781	CPMT2151LF KC5025	B207
2425782	CPMT2152LF KC5025	B207
2425784	CPMT3251LF KC5025	B207
2425785	CPMT3252LF KC5025	B207
2425786	DCMT21505LF KC5025	B225
2425788	DCMT431LF KC5025	B225
2425789	DCMT432LF KC5025	B225
2425790	DPMT21505LF KC5025	B232
2425791	DPMT2151LF KC5025	B232
2425793	DPMT3251LF KC5025	B232
2425794	DPMT3252LF KC5025	B232
2425795	SCMT3251LF KC5025	B246
2425796	SCMT3252LF KC5025	B246
2425798	SCMT432LF KC5025	B246
2425800	SPMT3251LF KC5025	B252
2425801	SPMT3252LF KC5025	B252
2425802	TCMT21505LF KC5025	B257
2425803	TCMT2151LF KC5025	B257
2425804	TCMT2152LF KC5025	B257
2425805	TCMT32505LF KC5025	B257
2425806	TCMT3251LF KC5025	B257
2425807	TCMT3252LF KC5025	B257
2425809	TCMT432LF KC5025	B257
2425811	TPMT18151LF KC5025	B268
2425813	TPMT2152LF KC5025	B268
2425814	TPMT3251LF KC5025	B268
2425815	TPMT3252LF KC5025	B268
2425817	TPMT432LF KC5025	B268
2425818	VBMT222LF KC5025	B281
2425819	VBMT3305LF KC5025	B281
2425820	WPMT15121LF KC5025	B288
2425821	WPMT2151LF KC5025	B288
2425825	WCMT3252LF KC5025	B286
2425826	CNMG431RP KC5010	B53
2425828	CNMG431RP KC5025	B53
2425841	DNGG433FS KC5010	B77
2425843	DCMT2151LF KC5025	B225
2425844	DCMT32505LF KC5025	B225
2425845	DCMT3251LF KC5025	B225
2425846	DCMT3252LF KC5025	B225
2425847	VBMT331LF KC5025	B281
2425848	VBMT332LF KC5025	B281
2425863	DNMG332MS KC5010	B82
2425864	DNMG332MS KC5025	B82
2425869	WNMG332MS KC5010	B160
2425870	WNMG332MS KC5025	B160
2425871	WNMG332MS K313	B160
2426878	SDET43PDSL8GB2 KCPK30	T115, T122, U39
2426879	SDET43PDSL8GB2 KC725M	T115, T122, U39
2428744	B978A15300 KC7315	G141
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
2429851	CNMG432CT KC5010	B48
2429979	CNMG431CT KC5010	B79
2429985	DNMG432CT KC5010	B79
2430006	DNMG443CT KC5010	B79
2430830	K315A62RF60HN09C	S82
2430931	K600B164RF60HN09C	S82
2434886	RCGT64ELF KC725M	V89
2435131	B967A08000 KC7315	G131
2435183	WLLNR32CA19S	E61
2435184	WLLNL32CA19S	E61
2435185	WLLNR32CA30S	E61
2435186	WLLNL32CA30S	E61
2435187	WLFNR32CA19S	E61
2435188	WLFNL32CA19S	E61
2435196	KSEM3800PCM KC7135	H70, H111
2435297	CNMG431P KC5010	B52
2435298	CNMG432P KC5010	B52
2435299	CNMG433P KC5010	B52
2435301	DNMG431P KC5010	B83
2435302	DNMG432P KC5010	B83
2435315	TNMG331P KC5010	B126
2435320	VNMG331P KC5010	B147
2435321	VNMG332P KC5010	B147
2435322	WNMG431P KC5010	B160
2435323	WNMG432P KC5010	B160
2435325	DNMG442P KC5010	B83
2436719	B978A11300 KC7315	G140
2436798	B978A16200 KC7315	G141
2438407	NG3125R KC5010	C170
2438408	NG3125R KC5025	C170
2438663	BGHX15L5PCERGGTM KD1410	S124
2438664	BGHX15L5PCTRHET KD1410	S125
2438665	BGHX15L504ERGET KD1415	S125
2440526	KTIP085R8SS10M	H38
2440527	KTIP160R8SS18M	H38
2442348	RCGT64SHF KCPK30	V89
2442642	B978A09100 KC7315	G140
2443608	KTIP0472R8SS050	H39
2444419	RCGK23FS KC5010	E69
2444420	RCGK35FS KC5010	E69
2444424	RCGK35FS KC5025	E69
2445393	KMSP4S15IP	B68
2445394	KMSP5S15IP	B68
2446615	RPGV45 KC5010	B167
2446618	RPGV23 KC5010	B167
2447377	EC1808E2 KC522M	T82
2447380	EC1848E KC522M	T82
2449473	KSEM2600HPGM KC7315	H55
2449475	KSEM3000HPGM KC7315	H55
2449476	KSEM4000HPGM KC7315	H55
2449518	KSEM2300HPGM KC7315	H55
2449924	KSEM1250HPGM KC7315	H54
2450291	B707A04000FBG KC7315	G110
2450292	B707A05000FBG KC7315	G110
2450343	B707A06000FBG KC7315	G110
2450344	B707A08000FBG KC7315	G111
2450345	B707A13000FBG KC7315	G111
2450346	B707A20000FBG KC7315	G112
2450909	KSEM2000HPGM KC7315	H54
2451576	EC1808E KC725M	T83
2451578	EC1812FJ KC410M	T81
2451579	EC1812E KC725M	T83
2451580	EC1824FJ KC410M	T81
2451581	EC1840FJ KC410M	T81
2451582	EC1840E KC522M	T82
2451684	EC1848FJ KC410M	T81
2452135	OFKT64AFEN6GB KC725M	S52
2452136	OFKT64AFSN6HB KC725M	S52
2452372	M1D100E1802W075L175	T76
2452414	M1D125E1802W100L225	T76
2453684	OFPT53AFEN4GB KC725M	S48
2453686	OFPT53AFSN4HB KC725M	S48
2453687	OFKT53AFEN4GB KC725M	S47
2453688	OFKT53AFSN4HB KC725M	S47
2455054	B976A06100 KC7315	G135
2455056	B976A07300 KC7315	G136
2455057	B976A07700 KC7315	G136
2455430	A4R0500M05P00T01025 KY3500	B321, C110
2455801	OFPT53AFEN4GB KCK15	S48
2455802	OFPT53AFSN4HB KCK15	S48
2455814	OFKT53AFEN4GB KCK15	S47
2455816	OFPT53AFEN4GB KCPK30	S48
2455818	OFPT53AFSN4HB KCPK30	S48
2455819	OFKT53AFEN4GB KCPK30	S47
2455820	OFKT53AFSN4HB KCPK30	S47
2455821	OFPT53AFEN4GB KC520M	S48
2455822	OFPT53AFSN4HB KC520M	S48
2455854	OFKT53AFEN4GB KC520M	S47
2456097	RCGT0803M0MS KC5010	B239
2456099	RCGT1204M0MS KC5010	B239
2456906	DFR125R4WD20M	J12
2456907	DFR127R4WD20M	J12
2456908	DFR130R4WD20M	J12
2456909	DFR135R4WD20M	J12

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
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	OFKT53AFEN4GB KC522M	S47
2458791	OFKT53AFSN4HB KC522M	S47
2458833	OFKT53AFFN4LNJ KC410M	S46
2458914	SDET434SNGB2 KCPK30	T115, T122, U39
2458915	SDET434SNGB2 KC725M	T115, T122, U39
2458916	SDET434SNGB2 KCK15	T115, T122, U39
2458917	SDET434SNGB2 KC520M	T115, T122, U39
2458918	SDET435SNGB2 KCPK30	T115, T122, U39
2458919	SDET435SNGB2 KC725M	T115, T122, U39
2458920	SDET435SNGB2 KCK15	T115, T122, U39
2458921	SDET435SNGB2 KC520M	T115, T122, U39
2458922	SDET436SNGB2 KCPK30	T115, T122, U39
2458933	SDET436SNGB2 KC725M	T115, T122, U39
2458934	SDET436SNGB2 KCK15	T115, T122, U39
2458936	SDET438SNGB2 KCPK30	T115, T122, U39
2458937	SDET438SNGB2 KC725M	T115, T122, U39
2458938	SDET438SNGB2 KCK15	T115, T122, U39
2458939	SDET438SNGB2 KC520M	T115, T122, U39
2460124	EP1812S KC725M	T85
2460125	EP1812S KCPK30	T85
2460185	EP1812S KCK15	T85
2460273	881.252.200	K137–139
2465988	KSEM2050HPGM KC7315	H54
2466477	KSEM3500HPGM KC7315	H55
2466478	KSEM3800HPGM KC7315	H55
2466598	KSEM3700HPGM KC7315	H55
2476832	KSSR250SN434M3	S88
2476963	KSSR300SN434M4	S88
2476964	KSSR400SN434M5	S88
2479506	M1D125E1404W125L225	T49
2479507	M1D100E1403W075L175	T50
2479508	M1D100E1403W100L175	T49
2479509	M1D125E1404S050L157	T53
2479510	M1D200E1406S075L157	T53
2479512	M1D125E1404W100L225	T50
2487433	KSEM1750HPGM KC7315	H54
2488036	EC1820FJ KC410M	T81
2488096	193.433	S44–45
2488759	S2044CG	T53, T78
2490989	B976A11300 KC7315	G137
2494500	KSEM2650HPGM KC7315	H55
2494501	KSEM3300HPGM KC7315	H55
2496015	KSEM2133HPGM KC7315	H55
2496869	M1D300K2503S100L225	T90
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	G111
2499607	KSEM0500HPG KC7315	H54
2499608	KSEM0509HPG KC7315	H54
2499609	KSEM0516HPG KC7315	H54
2499610	KSEM0547HPG KC7315	H54
2499611	KSEM0563HPG KC7315	H54
2499612	KSEM0578HPG KC7315	H54
2499723	KSEM1260HPGM KC7315	H54
2499725	KSEM1280HPGM KC7315	H54
2499727	KSEM1300HPGM KC7315	H54
2499729	KSEM1320HPGM KC7315	H54
2499730	KSEM1350HPGM KC7315	H54
2499731	KSEM1360HPGM KC7315	H54
2499732	KSEM1370HPGM KC7315	H54
2499733	KSEM1380HPGM KC7315	H54
2499735	KSEM1400HPGM KC7315	H54
2499736	KSEM1410HPGM KC7315	H54
2499737	KSEM1420HPGM KC7315	H54
2499739	KSEM1440HPGM KC7315	H54
2499740	KSEM1450HPGM KC7315	H54
2499741	KSEM1460HPGM KC7315	H54
2499743	KSEM1480HPGM KC7315	H54
2499744	KSEM1500HPGM KC7315	H54
2499746	KSEM1530HPGM KC7315	H54
2499748	KSEM1550HPGM KC7315	H54
2499749	KSEM1560HPGM KC7315	H54
2499750	KSEM1570HPGM KC7315	H54
2499751	KSEM1580HPGM KC7315	H54
2499753	KSEM1600HPGM KC7315	H54
2499755	KSEM1620HPGM KC7315	H54
2499757	KSEM1650HPGM KC7315	H54
2499759	KSEM1700HPGM KC7315	H54
2499763	KSEM1800HPGM KC7315	H54
2499765	KSEM1850HPGM KC7315	H54
2499767	KSEM1900HPGM KC7315	H54
2499771	KSEM1950HPGM KC7315	H54
2499775	KSEM2100HPGM KC7315	H54
2499777	KSEM2150HPGM KC7315	H55
2499779	KSEM2200HPGM KC7315	H55
2499782	KSEM2250HPGM KC7315	H55
2499784	KSEM2350HPGM KC7315	H55
2499786	KSEM2400HPGM KC7315	H55
2499787	KSEM2450HPGM KC7315	H55
2499789	KSEM2500HPGM KC7315	H55
2499791	KSEM2550HPGM KC7315	H55
2499795	KSEM2700HPGM KC7315	H55
2499796	KSEM2750HPGM KC7315	H55
2499798	KSEM2800HPGM KC7315	H55
2499800	KSEM2850HPGM KC7315	H55
2499802	KSEM2900HPGM KC7315	H55
2499803	KSEM2950HPGM KC7315	H55
2499807	KSEM3050HPGM KC7315	H55
2499810	KSEM3100HPGM KC7315	H55
2499811	KSEM3150HPGM KC7315	H55
2499813	KSEM3200HPGM KC7315	H55
2499814	KSEM3250HPGM KC7315	H55
2499818	KSEM3350HPGM KC7315	H55
2499820	KSEM3400HPGM KC7315	H55
2499822	KSEM3450HPGM KC7315	H55
2499824	KSEM3550HPGM KC7315	H55
2499826	KSEM3600HPGM KC7315	H55
2499828	KSEM3650HPGM KC7315	H55
2499831	KSEM3750HPGM KC7315	H55
2499834	KSEM3850HPGM KC7315	H55
2499835	KSEM3900HPGM KC7315	H55
2499836	KSEM3950HPGM KC7315	H55
2499837	OFKT64AFFN6LNJ KC410M	S51
2499843	KSEM0594HPG KC7315	H54
2499844	KSEM0609HPG KC7315	H54
2499845	KSEM0625HPG KC7315	H54
2499846	KSEM0634HPG KC7315	H54
2499847	KSEM0641HPG KC7315	H54
2499848	KSEM0656HPG KC7315	H54
2499849	KSEM0672HPG KC7315	H54
2499850	KSEM0688HPG KC7315	H54
2499851	KSEM0703HPG KC7315	H54
2499852	KSEM0719HPG KC7315	H54
2499853	KSEM0734HPG KC7315	H54
2499854	KSEM0750HPG KC7315	H54
2499855	KSEM0759HPG KC7315	H54
2499856	KSEM0766HPG KC7315	H54
2499857	KSEM0781HPG KC7315	H54
2499858	KSEM0797HPG KC7315	H54
2499859	KSEM0813HPG KC7315	H54
2499860	KSEM0844HPG KC7315	H55
2499861	KSEM0859HPG KC7315	H55
2499862	KSEM0875HPG KC7315	H55
2499863	KSEM0884HPG KC7315	H55
2499864	KSEM0922HPG KC7315	H55
2499865	KSEM0938HPG KC7315	H55
2499866	KSEM0969HPG KC7315	H55
2499867	KSEM1000HPG KC7315	H55
2499868	KSEM1011HPG KC7315	H55
2499869	KSEM1031HPG KC7315	H55
2499870	KSEM1047HPG KC7315	H55
2499871	KSEM1094HPG KC7315	H55
2499872	KSEM1109HPG KC7315	H55
2499873	KSEM1125HPG KC7315	H55
2499874	KSEM1156HPG KC7315	H55
2499875	KSEM1172HPG KC7315	H55
2499876	KSEM1188HPG KC7315	H55
2499877	KSEM1203HPG KC7315	H55
2499878	KSEM1219HPG KC7315	H55
2499879	KSEM1250HPG KC7315	H55
2499880	KSEM1281HPG KC7315	H55
2499881	KSEM1297HPG KC7315	H55
2499882	KSEM1313HPG KC7315	H55
2499883	KSEM1328HPG KC7315	H55
2499884	KSEM1344HPG KC7315	H55
2499885	KSEM1375HPG KC7315	H55
2499886	KSEM1406HPG KC7315	H55
2499887	KSEM1422HPG KC7315	H55
2499888	KSEM1438HPG KC7315	H55
2499889	KSEM1469HPG KC7315	H55
2499890	KSEM1500HPG KC7315	H55
2499891	KSEM1514HPG KC7315	H55
2500876	LT16ERAG60K KU25T	D52
2500931	LT16NRAG60K KU25T	D61
2503543	A4ENN2020K0611	C131
2503544	A4ENN2525M0611	C131
2503545	A4ENN3232P0611	C131
2503550	A4SML2020K0317	C125
2503551	A4SMR2020K0317	C124
2503552	A4SML2020K0417	C125
2503553	A4SMR2020K0417	C124
2503554	A4SML2020K0620	C125
2503555	A4SMR2020K0620	C124
2503556	A4SML2016K0317	C125
2503557	A4SMR2016K0317	C124
2503559	A4SMR2016K0417	C124
2503996	DVJNR123CKC3	B150
2503997	DVJNL123CKC3	B150
2503998	DVJNR163DKC3	B150
2503999	DVJNL163DKC3	B150
2504000	DVJNR853DKC3	B150
2504001	DVJNL853DKC3	B150
2504002	DVJNR164DKC3	B150
2504003	DVJNL164DKC3	B150
2504004	DVJNR854DKC3	B150
2504005	DVJNL854DKC3	B150
2504006	DVONR123CKC3	B151
2504007	DVONL123CKC3	B151
2504008	DVONR163DKC3	B151
2504009	DVONL163DKC3	B151
2504010	DVONR853DKC3	B151
2504011	DVONL853DKC3	B151
2504012	DVVNN123CKC3	B151
2504013	DVVNN163DKC3	B151
2504014	DVVNN853DKC3	B151
2504015	DVVNN164DKC3	B151
2504223	KSEM1970HPGM KC7315	H54
2505276	193.407	C130
2506705	B977A15200 KC7315	G137
2507899	KSEM1008HP KC7315	H52
2509326	EP1808S KC725M	T85
2509327	EP1808S KCPK30	T85
2509328	EP1808S KCK15	T85
2509387	EP1816S KC725M	T85
2509388	EP1816S KCPK30	T85
2509408	EP1832S KC725M	T85
2509410	EP1832S KCPK30	T85
2511469	A4ENN160611	C130
2511470	A4ENN200611	C130
2511471	A4ENN160811	C130
2526351	KG2531ELDJ KC410M	T93
2526385	KG2508ELDJ KC410M	T93
2526387	KG2564ELDJ KC410M	T93
2526757	KG2516ELDJ KC410M	T93
2528269	KSSP200R3SD43W125L169	T119
2530317	M1D150K2502W125L200	T89
2530318	M1D150K2502C125L200	T89
2530320	M1D150K2502C125L400	T89
2530322	M1D200K2503C125L200	T89
2530357	M1D150K2502HSK63L477	T91
2530374	M1D200K2503CV50L700	T92
2539334	CM184LP	C185, D25
2539335	CM185LP	C185, D25
2541018	KSEM1800PCM KC7135	H70, H111
2541019	KSEM1850PCM KC7135	H70
2541020	KSEM2300PCM KC7135	H70, H111
2541133	B707A07000FBG KC7315	G110
2541200	KRDEA046AM	K79
2541201	KRDEA051AM	K79
2541202	KRDEA012AM	K79
2541213	KRDE025010M	K80
2541214	KRDE033010M	K80
2541215	KRDE043010M	K80
2541216	KRDE065012M	K80
2541217	KRCW032A	K80
2541511	KSEM1300PCM KC7135	H70, H111
2541512	KSEM1350PCM KC7135	H70
2541535	B976A05530 KC7315	G135
2541967	M1D100E1802CV40L450	T79
2541969	M1D100E1802BT40L450	T80
2541970	M1D125E1803CV40L488	T79
2541972	M1D150E1804CV40L488	T79
2541984	M1D150E1804BT40L488	T80
2542068	KTIP0313R8SS038	H39
2542069	KTIP0335R8SS038	H39
2542071	KTIP0354R8SS038	H39
2542072	KTIP0374R8SS038	H39
2542083	KTIP0374R8SS044	H39
2542084	KTIP0394R8SS044	H39
2542085	KTIP0413R8SS044	H39
2542086	KTIP0433R8SS044	H39
2542087	KTIP0453R8SS050	H39
2542088	KTIP0492R8SS050	H39
2542089	KTIP0492R8SS056	H39
2542090	KTIP0512R8SS056	H39
2542091	KTIP0532R8SS056	H39
2542092	KTIP0551R8SS056	H39
2542093	KTIP0571R8SS063	H39
2542094	KTIP0591R8SS063	H39
2542095	KTIP0630R8SS069	H39
2542517	A4M50R0314A036048	C139
2542518	A4M50R0314A042058	C139
2542519	A4M50R0314A052074	C139
2542520	A4M50R0314A068100	C139
2542521	A4M50R0314A090160	C139
2542522	A4M50R0314A130300	C139
2542523	A4M50R0314A290999	C139
2542524	A4M50L0314A036048	C140
2542527	A4M50L0314A068100	C140
2542528	A4M50L0314A090160	C140
2542529	A4M50L0314A130300	C140
2542530	A4M50L0314A290999	C140
2542531	A4M50R0414A048072	C139
2542532	A4M50R0414A064100	C139
2542533	A4M50R0414A092150	C139
2542534	A4M50R0414A132300	C139
2542535	A4M50R0414A290999	C139
2542537	A4M50L0414A064100	C140
2542538	A4M50L0414A092150	C140
2542539	A4M50L0414A132300	C140
2542540	A4M50L0414A290999	C140
2542541	A4M50R0519A058094	C139
2542542	A4M50R0519A080136	C139
2542543	A4M50R0519A120300	C139
2542544	A4M50R0519A250999	C139
2542545	A4M50L0519A058094	C140
2542546	A4M50L0519A080136	C140
2542547	A4M50L0519A120300	C140
2542548	A4M50L0519A250999	C140
2542822	KSEM2500PCM KC7135	H70, H111
2542849	KSEM3000PCM KC7135	H70, H111

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
2544200	SPCT3125PPER8LD2 KC520M	T111, U30
2544413	SDCT43PDER8LD2 KC520M	T115, T122, U38
2545095	OFKT64AFEN6LB KCPK30	S51
2545097	OFKT64AFSN6LB KCPK30	S51
2546816	BGHX15L5PCSRLET KD1410	S125
2548776	KTIP080R8SS10M	H38
2548777	KTIP090R8SS10M	H38
2548778	KTIP095R8SS10M	H38
2548779	KTIP100R8SS12M	H38
2548780	KTIP105R8SS12M	H38
2548781	KTIP110R8SS12M	H38
2548782	KTIP115R8SS12M	H38
2548913	KTIP120R8SS14M	H38
2548914	KTIP125R8SS14M	H38
2548915	KTIP130R8SS14M	H38
2548916	KTIP135R8SS14M	H38
2548917	KTIP140R8SS16M	H38
2548918	KTIP145R8SS16M	H38
2548919	KTIP150R8SS16M	H38
2548920	KTIP080R8SCF12M	H40
2548921	KTIP085R8SCF12M	H40
2548922	KTIP090R8SCF12M	H40
2548923	KTIP095R8SCF12M	H40
2548924	KTIP100R8SCF16M	H40
2548925	KTIP105R8SCF16M	H40
2548926	KTIP110R8SCF16M	H40
2548927	KTIP115R8SCF16M	H40
2548928	KTIP120R8SCF16M	H40
2548929	KTIP125R8SCF16M	H40
2548930	KTIP130R8SCF16M	H40
2548931	KTIP135R8SCF16M	H40
2548932	KTIP140R8SCF16M	H40
2548933	KTIP145R8SCF16M	H40
2548934	KTIP150R8SCF20M	H40
2548935	KTIP160R8SCF20M	H40
2549023	NG3047L KC5010	C170
2549978	OFPT64AFEN6GB KC520M	S52
2576202	S459	V70, V77, V83, V149
2579622	B976A06900 KC7315	G135
2581445	M1D200K2502S075L200	T90
2581447	M1D250K2503S100L225	T90
2581449	M1D400K2504S125L225	T90
2582207	CTFPR20CA4	B186, B397
2582790	B707A17000FBG KC7315	G112
2594849	B707A21000FBG KC7315	G112
2598551	E06MSCLCL2	B197
2598552	E06MSCLCR2	B197
2598694	E08RSCLCR2	B197
2598696	E10SSCLCR2	B197
2598697	E10SSCLCL3	B197
2598698	E10SSCLCR3	B197
2598699	E12SSCLCL3	B197
2598700	E12SSCLCR3	B197
2598702	E16TSCLCR3	B197
2598759	NG3072R KC5010	C170
2598760	NG3072L KC5010	C170
2598761	NG3078R KC5010	C170
2598803	NG3088R KC5010	C170
2598804	NG3097R KC5010	C170
2598806	NG3105R KC5010	C170
2598807	NG3105L KC5010	C171
2598808	NG3125L KC5010	C171
2598809	NG3142R KC5010	C170
2598811	NG3156R KC5010	C170
2598813	NG3189L KC5010	C171
2598816	NGP3125R KC5010	C168
2598817	NGP3125L KC5010	C168
2598823	NGD3189L KC5010	C171
2598824	NG3062R KC5010	C170
2599495	NG4189R KC5010	C170
2599496	NR3031L KC5010	C172
2599497	NG4189L KC5010	C171
2599498	NG4250L KC5010	C171
2599501	NGP4250R KC5010	C168
2599504	NGD4250L KC5010	C171
2599505	NR4125R KC5010	C172
2599506	NR3047R KC5010	C172
2599507	NR3047L KC5010	C172
2599508	NR3062R KC5010	C172
2599509	NR3062L KC5010	C172
2599510	NRP3031R KC5010	C169
2599511	NRP3031L KC5010	C169
2599512	NRP3047R KC5010	C169
2599513	NRP3047L KC5010	C169
2599514	NRP3062R KC5010	C169
2599515	NRP3062L KC5010	C169
2599516	NRP3094R KC5010	C169
2599518	NRP3094L KC5010	C169
2599519	NG3047R KC5025	C170
2599521	NG3062R KC5025	C170
2599522	NG3062L KC5025	C170
2599523	NG3094R KC5025	C170
2599524	NG3094L KC5025	C170
2599525	NG3125L KC5025	C171
2599526	NG3156R KC5025	C170
2599527	NG3156L KC5025	C171
2599528	NG3189R KC5025	C170
2599529	NG3189L KC5025	C171
2599530	NR3031R KC5025	C172
2599531	NR3031L KC5025	C172
2599534	NR3062R KC5025	C172
2599535	NR3062L KC5025	C172
2599536	NRD4062R KC5010	C173
2599537	NRD4062L KC5010	C173
2599538	NRD4094R KC5010	C173
2599539	NRD4094L KC5010	C173
2599540	NRD4125L KC5010	C173
2599550	NR4125L KC5010	C172
2599571	NG2031R KC5010	C170
2599572	NG2031L KC5010	C170
2599743	NG2041R KC5010	C170
2599744	NG2041L KC5010	C170
2599745	NG2047R KC5010	C170
2599746	NG2047L KC5010	C170
2599748	NG2094R KC5010	C170
2599749	NG2094L KC5010	C170
2599750	NG2125R KC5010	C170
2599751	NG2125L KC5010	C170
2599752	NGP2031R KC5010	C168
2599757	NR2031R KC5010	C172
2599758	NR2031L KC5010	C172
2599759	NR2062R KC5010	C172
2599760	NR2062L KC5010	C172
2599761	NG2031R KC5025	C170
2599765	NG2062R KC5025	C170
2599887	B976A04100 KC7315	G134
2601012	KSSP200R3SD43L125	T120
2603030	KSEM2430HPGM KC7315	H55
2604354	RNMG43RN KC5010	B97
2605982	RCGT64ELF KCPK30	V89
2606186	RCGT64SHF KC725M	V89
2607377	B707A10000FBG KC7315	G111
2610667	BMD200R6403W150L200	V87
2610668	BMD250R6404S075L200	V88
2610670	BMD300R6405S100L200	V88
2610672	BMD400R6405S125L200	V88
2610683	BMD400R6406S125L200	V88
2610684	BMD500R6406S150L250	V88
2610685	BMD500R6408S150L250	V88
2610686	BMD600R6407S150L250	V88
2610687	BMD600R6408S150L250	V88
2610688	BMD800R6409S250L250	V88
2610689	BMD300R8603S075L200	V91
2610691	BMD400R8605S125L250	V91
2610694	BMD600R8607S150L250	V91
2610696	BMD800R8608S250L250	V91
2610697	BMD500R8606S150L250	V91
2613790	3.41020R904 KC7315	I17
2613791	3.41020R901 KC7315	I16
2613792	3.41020R902 KC7315	I16
2613858	B967A14000 KC7315	G132
2614153	MS2055	B197
2614817	B976A07100 KC7315	G135
2615043	3.41020R903 KC7315	I16
2615044	3.41220R904 KC7315	I17
2615045	3.41220R901 KC7315	I16
2615046	3.41220R902 KC7315	I16
2615047	3.41220R903 KC7315	I16
2616697	KSEM2215HPGM KC7315	H55
2618743	170.314	H38–41
2618967	KSSS600ASD43N750	U33
2618969	KSSS600ASD43R750	U32
2619033	B707A05560FBG KC7315	G110
2620169	B978A04600 KC7315	G139
2623070	B707A16000FBG KC7315	G112
2623553	B256A05100 KC7315	G58
2623856	M1D075E1402W075L175	T49
2623857	M1D100E1402W100L175	T49
2623858	M1D125E1403W100L225	T50
2623859	M1D150E1405W125L225	T50
2623860	KSEM2000PCM KC7135	H70, H111
2624187	M1D075E1402C075L650	T52
2624188	M1D075E1402W075L175DE	T51
2624189	M1D097E1403W100L175	T49
2624190	M1D100E1403C100L750	T52
2624191	M1D100E1403W100L175DE	T51
2624192	M1D125E1404C125L800	T52
2624194	M1D150E1404W125L225	T50
2624197	M1D075E1402C075L800	T52
2624198	M1D100E1402C100L1000	T52
2624199	M1D100E1403W100L175R	T50
2624200	M1D125E1403C125L1000	T52
2624201	M1D125E1404W125L225R	T50
2624202	M1D150E1404C125L1000	T52
2624243	M1D062E1401W075L150	T49
2624245	M1D088E1402W100L175	T49
2624246	M1D100E1403CV40L300	T54
2624248	M1D125E1404CV40L300	T54
2624250	M1D150E1405C125L800	T52
2624253	M1D150E1405CV40L300	T54
2624254	M1D250E1407S075L157	T53
2624255	M1D150E1405S075L157	T53
2624270	M1D200E1405S075L157	T53
2624271	M1D150E1405W125L225R	T50
2624274	M1D250E1405S075L157	T53
2624275	M1D300E1408S100L175	T53
2624277	M1D300E1406S100L175	T53
2624278	M1D400E1410S150L200	T53
2624279	M1D400E1408S150L200	T53
2625682	B256A07000 KC7315	G58
2625743	B256A08000 KC7315	G58
2627240	B967A12000 KC7315	G132
2628928	B707A11570FBG KC7315	G111
2629032	B707A04900FBG KC7315	G110
2629368	B707A12000FBG KC7315	G111
2629768	KSSS400ASP10N625	U26
2629769	KSSS400ASP10L625	U25
2629770	KSSS400ASP10R625	U25
2629772	KSSS500ASP10L625	U25
2629774	KSSS600ASP10N625	U26
2629780	KSSS400BSP10N625	U27
2629781	KSSS500BSP10N625	U27
2629783	KSSS800BSP10N625	U27
2629784	KSSS600ASD43L750	U32
2629785	KSSS800ASD43N750	U33
2629786	KSSS800ASD43L750	U32
2629787	KSSS800ASD43R750	U32
2629788	KSSS1000ASD43N750	U33
2629790	KSSS1000ASD43R750	U32
2629791	KSSS600BSD43N750	U34
2629792	KSSS800BSD43N750	U34
2629794	KSSS500ASP10N625	U26
2633016	B707A18000FBG KC7315	G112
2633730	KTIP080R3BF08M	I11
2633731	KTIP090R5BF10M	I13
2633732	KTIP160R3BF17M	I11
2634374	3.77000R224V	J85
2634375	3.77000R227V	J85
2634376	3.77000R229V	J85
2634377	3.77000R231V	J85
2634378	3.77000R239V	J85
2634379	3.77000R249V	J85
2634380	3.77000R251V	J85
2634381	3.77000R253V	J85
2634382	3.77000R274V	J85
2634413	3.77000R276V	J85
2634414	3.77000R278V	J85
2634415	3.77000R280V	J85
2634416	3.77000R282V	J85
2634417	3.77000R284V	J85
2634418	3.77000R286V	J85
2634419	3.77000R288V	J85
2634568	B707A07500FBG KC7315	G111
2635436	B977A15300 KC7315	G137
2635710	M1D125E1803W100L225	T76
2636514	B707A12800FBG KC7315	G111
2636741	S2160	V87, V91
2636813	S446CG	V70, V77
2636819	S2162C	S17, S20, S24, S45, S50, V70, V77, V88, V141
2636820	S2163C	S10, S14, S58, V77, V88, V91, V141
2636821	S2164C	T90, V91
2636822	S445CG	S17, S20, T53, T78, T90, V54, V88, V91, V141
2636823	S458CG	S17, S20, S24, T90, V54, V88, V141
2637756	MS2060	S32
2637762	MS2066	B197
2637805	F7IP	T29, T40
2639052	B707A11800FBG KC7315	G111
2639144	B707A15250FBG KC7315	G112
2639491	KSEM3900PCM KC7135	H70, H111
2641904	B966A16500 KC7315	G132
2646000	B707A15000FBG KC7315	G111
2646064	KSEM1280PCM KC7135	H70
2646067	KSEM1380PCM KC7135	H70
2646068	KSEM1400PCM KC7135	H70, H111
2646069	KSEM1410PCM KC7135	H70
2646072	KSEM1450PCM KC7135	H70
2646073	KSEM1460PCM KC7135	H70
2646074	KSEM1480PCM KC7135	H70
2646075	KSEM1500PCM KC7135	H70, H111
2646077	KSEM1550PCM KC7135	H70
2646078	KSEM1560PCM KC7135	H70
2646080	KSEM1580PCM KC7135	H70
2646081	KSEM1600PCM KC7135	H70, H111
2646082	KSEM1620PCM KC7135	H70
2646083	KSEM1650PCM KC7135	H70
2646084	KSEM1700PCM KC7135	H70, H111
2646085	KSEM1900PCM KC7135	H70, H111
2646086	KSEM1950PCM KC7135	H70
2646087	KSEM2050PCM KC7135	H70
2646088	KSEM2100PCM KC7135	H70, H111
2646089	KSEM2150PCM KC7135	H70
2646090	KSEM2200PCM KC7135	H70, H111
2646091	KSEM2250PCM KC7135	H70
2646092	KSEM2350PCM KC7135	H70
2646093	KSEM2400PCM KC7135	H70, H111
2646094	KSEM2450PCM KC7135	H70
2646095	KSEM2550PCM KC7135	H70
2646096	KSEM2650PCM KC7135	H70
2646097	KSEM2700PCM KC7135	H70, H111
2646099	KSEM2800PCM KC7135	H70, H111
2646100	KSEM2850PCM KC7135	H70
2646101	KSEM2900PCM KC7135	H70, H111
2646102	KSEM2950PCM KC7135	H70
2646103	KSEM3050PCM KC7135	H70
2646104	KSEM3100PCM KC7135	H70, H111
2646106	B343S04803HPG KC7315	I10
2646108	B343S04921HPG KC7315	I10
2646109	B343S05000HPG KC7315	I10
2646110	B343S05039HPG KC7315	I10
2646111	B343S05118HPG KC7315	I10
2646112	B343S02402HPG KC7315	I8
2646253	B343S02441HPG KC7315	I8
2646254	B343S02480HPG KC7315	I8
2646255	B343S02500HPG KC7315	I8
2646256	B343S02520HPG KC7315	I8
2646257	B343S02559HPG KC7315	I8
2646258	B343S02570HPG KC7315	I8
2646259	B343S02598HPG KC7315	I8
2646260	B343S02638HPG KC7315	I8
2646261	B343S02656HPG KC7315	I9
2646262	B343S02677HPG KC7315	I9
2646263	B343S02717HPG KC7315	I9
2646265	B343S02756HPG KC7315	I9
2646266	B343S02813HPG KC7315	I9
2646267	B343S02874HPG KC7315	I9
2646268	B343S02913HPG KC7315	I9
2646269	B343S02953HPG KC7315	I9
2646270	B343S02969HPG KC7315	I9
2646272	B343S03071HPG KC7315	I9
2646273	B343S03110HPG KC7315	I9
2646274	B343S03125HPG KC7315	I9

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
2646275	B343S03150HPG KC7315	I9
2646276	B343S01250HPG KC7315	I8
2646277	B343S01339HPG KC7315	I8
2646278	B343S01378HPG KC7315	I8
2646279	B343S01495HPG KC7315	I8
2646280	B343S01496HPG KC7315	I8
2646281	B343S01563HPG KC7315	I8
2646282	B343S01575HPG KC7315	I8
2646333	B343S01614HPG KC7315	I8
2646334	B343S01654HPG KC7315	I8
2646335	B343S01693HPG KC7315	I8
2646336	B343S01772HPG KC7315	I8
2646337	B343S01811HPG KC7315	I8
2646338	B343S01820HPG KC7315	I8
2646339	B343S01875HPG KC7315	I8
2646340	B343S01929HPG KC7315	I8
2646341	B343S01969HPG KC7315	I8
2646342	B343S02008HPG KC7315	I8
2646343	B343S02047HPG KC7315	I8
2646344	B343S02087HPG KC7315	I8
2646345	B343S02126HPG KC7315	I8
2646346	B343S02130HPG KC7315	I8
2646347	B343S02165HPG KC7315	I8
2646348	B343S02185HPG KC7315	I8
2646349	B343S02188HPG KC7315	I8
2646350	B343S02205HPG KC7315	I8
2646351	B343S02283HPG KC7315	I8
2646352	B343S02362HPG KC7315	I8
2646385	B343S05197HPG KC7315	I10
2646386	B343S05315HPG KC7315	I10
2646387	B343S05512HPG KC7315	I10
2646389	B343S05591HPG KC7315	I10
2646390	B343S05625HPG KC7315	I10
2646391	B343S05906HPG KC7315	I10
2646392	B343S06102HPG KC7315	I10
2646393	B343S06250HPG KC7315	I10
2646394	B343S06299HPG KC7315	I10
2646395	B343S06496HPG KC7315	I10
2646396	B343S06562HPG KC7315	I10
2646397	B343S06693HPG KC7315	I10
2646399	B343S06890HPG KC7315	I10
2646400	B343S06969HPG KC7315	I10
2646401	B343S07087HPG KC7315	I10
2646402	B343S03976HPG KC7315	I9
2646423	B343S04016HPG KC7315	I9
2646424	B343S04055HPG KC7315	I9
2646425	B343S04063HPG KC7315	I9
2646426	B343S04094HPG KC7315	I9
2646427	B343S04134HPG KC7315	I9
2646428	B343S04173HPG KC7315	I9
2646429	B343S04213HPG KC7315	I9
2646430	B343S04219HPG KC7315	I9
2646431	B343S04252HPG KC7315	I9
2646432	B343S04331HPG KC7315	I9
2646433	B343S04370HPG KC7315	I9
2646434	B343S04375HPG KC7315	I9
2646435	B343S04409HPG KC7315	I9
2646436	B343S04449HPG KC7315	I9
2646437	B343S04528HPG KC7315	I9
2646438	B343S04531HPG KC7315	I9
2646439	B343S04606HPG KC7315	I9
2646440	B343S04646HPG KC7315	I10
2646441	B343S04688HPG KC7315	I10
2646442	B343S04724HPG KC7315	I10
2649363	B976A03970 KC7315	G134
2649364	B976A04763 KC7315	G135
2649365	B976A05575 KC7315	G135
2649366	B976A06350 KC7315	G135
2649367	B976A06746 KC7315	G135
2649368	B976A07145 KC7315	G135
2649369	B976A07541 KC7315	G136
2649370	B976A07938 KC7315	G136
2649371	B976A08334 KC7315	G136
2649372	B976A08733 KC7315	G136
2649373	B976A09129 KC7315	G136
2649374	B976A09525 KC7315	G136
2649375	B976A09921 KC7315	G136
2649376	B976A10320 KC7315	G136
2649377	B976A10716 KC7315	G137
2649378	B976A11113 KC7315	G137
2649379	B976A11509 KC7315	G137
2649380	B976A11908 KC7315	G137
2649381	B976A12304 KC7315	G137
2649382	B976A14288 KC7315	G137
2649383	B976A15875 KC7315	G138
2649384	B976A17463 KC7315	G138
2649385	B976A19050 KC7315	G138
2649386	B977A03970 KC7315	G134
2649387	B977A04580 KC7315	G135
2649388	B977A04623 KC7315	G135
2649389	B977A04763 KC7315	G135
2649390	B977A05410 KC7315	G135
2649391	B977A05558 KC7315	G135
2649486	B967A10500 KC7315	G131
2649548	R30FBHS06	K140
2649549	R38FBHS06	K140
2649550	R48FBHS06	K140
2649551	R65FBHS06	K140
2649552	R85FBHS06	K140
2649553	R85FBHS09	K140
2649554	R125FBHS09	K140
2649555	R24FBHS06LF	K140
2649556	R31FBHS06LF	K140
2649557	R40FBHS06LF	K140
2649558	R51FBHS06LF	K140
2649559	R67FBHS09LF	K140
2649913	DH35M	S39, T113
2650038	B707A08500FBG KC7315	G111
2651013	B343S03189HPG KC7315	I9
2651014	B343S03228HPG KC7315	I9
2651015	B343S03268HPG KC7315	I9
2651016	B343S03281HPG KC7315	I9
2651017	B343S03307HPG KC7315	I9
2651018	B343S03320HPG KC7315	I9
2651019	B343S03346HPG KC7315	I9
2651020	B343S03386HPG KC7315	I9
2651021	B343S03425HPG KC7315	I9
2651022	B343S03438HPG KC7315	I9
2651023	B343S03465HPG KC7315	I9
2651025	B343S03543HPG KC7315	I9
2651026	B343S03583HPG KC7315	I9
2651028	B343S03680HPG KC7315	I9
2651029	B343S03701HPG KC7315	I9
2651030	B343S03740HPG KC7315	I9
2651031	B343S03750HPG KC7315	I9
2651033	B343S03819HPG KC7315	I9
2651034	B343S03858HPG KC7315	I9
2651035	B343S03906HPG KC7315	I9
2651036	B343S03937HPG KC7315	I9
2651037	HSK63FBH01695	K128
2651038	AFB38115SCFPR09	K134
2651039	AFB42115SCFPR09	K134
2651040	AFB47115SCFPR09	K134
2651042	RS1605	K129
2651163	CFB10082	K135
2651164	CFB12096	K135
2651165	CFB14110	K135
2651166	CFB16120	K135
2651167	CFB18140	K135
2651168	HFB1023SCFPR06	K130
2651169	HFB1223SCFPR06	K130
2651170	HFB1627SCFPR06	K130
2651171	HFB2127SCFPR06	K130
2651172	HFB2427SCFPR06	K130
2651173	HFB2727SCFPR06	K130
2651174	HFB3127SCFPR06	K130
2651175	HFB3427SCFPR06	K130
2651176	HFB14FBHS1440	K130
2651177	HFB16FBHS1640	K130
2651178	HFB19FBHS1840	K130
2652755	B707A09000FBG KC7315	G111
2652965	SYB24RBHT06F	K125
2652967	SYB30RBHT06F	K125
2652968	SYB40RBHT09F	K125
2652969	SYB50RBHT09F	K125
2652970	SYB66RBHT12F	K125
2652971	SYB66RBHT12LF	K125
2652972	SYB87RBHT12F	K125
2652983	SYB87RBHT16LF	K125
2652984	SYB115RBHT16LF	K125
2653917	KSEM0758HPG KC7315	H54
2655215	B977A13200 KC7315	G137
2655963	B707A04800FBG KC7315	G110
2657603	B707A11700FBG KC7315	G111
2658030	B707A08800FBG KC7315	G111
2658054	B256A08400 KC7315	G58
2658075	B967A10700 KC7315	G131
2658213	B977A06528 KC7315	G135
2658214	B977A09746 KC7315	G136
2658215	B977A06909 KC7315	G135
2658216	B977A07145 KC7315	G135
2658217	B977A07541 KC7315	G136
2658218	B977A07938 KC7315	G136
2658219	B977A08334 KC7315	G136
2658220	B977A08433 KC7315	G136
2658221	B977A08733 KC7315	G136
2658222	B977A09129 KC7315	G136
2658223	B977A09347 KC7315	G136
2658224	B977A09525 KC7315	G136
2658226	B977A09921 KC7315	G136
2658227	B977A10320 KC7315	G136
2658228	B977A10716 KC7315	G137
2658229	B977A11113 KC7315	G137
2658230	B977A11509 KC7315	G137
2658231	B977A11908 KC7315	G137
2658232	B977A12304 KC7315	G137
2658234	B977A13096 KC7315	G137
2658235	B977A14288 KC7315	G137
2658236	B977A15875 KC7315	G138
2658237	B977A16078 KC7315	G138
2658239	B977A17463 KC7315	G138
2658240	B977A19050 KC7315	G138
2658241	B977A19253 KC7315	G138
2658242	B977A19446 KC7315	G138
2658352	SFRHEC250S3075 K600	P131
2658393	B978A03970 KC7315	G139
2658394	B978A04763 KC7315	G139
2658395	B978A05558 KC7315	G139
2658396	B978A06350 KC7315	G139
2658397	B978A06746 KC7315	G139
2658398	B978A07145 KC7315	G139
2658399	B978A07541 KC7315	G140
2658400	B978A07938 KC7315	G140
2658401	B978A08334 KC7315	G140
2658402	B978A08733 KC7315	G140
2658403	B978A09129 KC7315	G140
2658404	B978A09525 KC7315	G140
2658405	B978A09921 KC7315	G140
2658406	B978A10320 KC7315	G140
2658407	B978A10716 KC7315	G140
2658408	B978A11113 KC7315	G140
2658409	B978A11509 KC7315	G140
2658410	B978A11908 KC7315	G140
2658411	B978A12304 KC7315	G140
2658412	B978A12700 KC7315	G140
2658413	B978A14288 KC7315	G141
2658414	B978A15875 KC7315	G141
2658415	B978A16078 KC7315	G141
2658416	B978A17463 KC7315	G141
2658417	B978A19050 KC7315	G141
2658418	B978A19253 KC7315	G141
2658419	A4G0300M03P04T01025 KY3500	B321, C110
2658420	A4G0400M04P04T01025 KY3500	B321, C110
2658421	A4G0500M05P08T01025 KY3500	B321, C110
2658422	A4G0600M06P08T01025 KY3500	B321, C110
2658444	SFRHEC375S3088 K600	P131
2658445	SFRHEC500S3100 K600	P131
2658446	SFRHEC500S3200 K600	P131
2658448	SFRHEC625S3225 K600	P131
2658449	SFRHEC750S3150 K600	P131
2658450	SFRHEC750S3225 K600	P131
2658452	SFRHEC100S3225 K600	P131
2658685	B967A16000 KC7315	G132
2659233	A4G0800M08P08T01025 KY3500	B321, C110
2659234	A4G125I03P1T0425 KY3500	B321, C110
2659236	A4G250I06P2T0425 KY3500	B321, C110
2659238	A4R0300M03P00T01025 KY3500	B321, C110
2659240	A4R0600M06P00T01025 KY3500	B321, C110
2659241	A4R0800M08P00T01025 KY3500	B321, C110
2659244	A4R250I06P00T0425 KY3500	B321, C110
2659293	A20UDVUNR3KC3	B154
2659294	A24UDVUNL3KC3	B154
2659295	A24UDVUNR3KC3	B154
2659833	KG2520ELDJ KC410M	T93
2660255	KG2540ELDJ KC410M	T93
2660384	B707A05900FBG KC7315	G110
2818063	B977A21000 KC7315	G138
2825941	QTM20 WG	B292
2832635	CT11 WG	B291–292
2868502	3.77000R250V	J85
2869513	3.77000R252V	J85
2869514	3.77000R228V	J85
2869515	3.77000R230V	J85
2869516	3.77000R248V	J85
2872839	KSEM0757HP KC7315	H52
2875458	KG2550ELDJ KC410M	T93
2875584	B978A05800 KC7315	G139
2876977	RPGV45MP KC5010	B167
2877454	EP1808EHD KC725M	T84
2877455	EP1808EHD KCPK30	T84
2877456	EP1812EHD KC725M	T84
2877457	EP1812EHD KCPK30	T84
2877458	EP1816EHD KC725M	T84
2877459	EP1816EHD KCPK30	T84
2877460	EP1832EHD KC725M	T84
2877461	EP1832EHD KCPK30	T84
2877462	KDMB0500M0ERGN KC515M	V126
2877812	KDMB0375R354A038SN	V121
2878423	KDMB0750M0ERGN KC515M	V126
2878424	KDMB1000M0ERGN KC515M	V126
2878433	KDMB0500R591A050SN	V121
2878434	KDMB0500R512A050SN	V121
2878435	KDMB0625R551A063SN	V121
2878436	KDMB0625R630A063SN	V121
2878437	KDMB0750R630A075SN	V121
2878438	KDMB0750R689A075SN	V121
2878439	KDMB0750R827A075SN	V121
2878440	KDMB1000R630A100SN	V121
2878441	KDMB1000R748A100SN	V121
2878442	KDMB1250R689A125SN	V121
2878443	KDMB1250R827A125SN	V121
2878444	KDMB0312R551A031ST	V122
2878445	KDMB0375R591A038ST	V122
2878446	KDMB0500R630A050ST	V122
2878448	KDMB0750R748A075ST	V122
2878449	KDMB1000R827A100ST	V122
2878450	KDMB1250R945A125ST	V122
2878591	B976A03300 KC7315	G134
2878592	B976A03000 KC7315	G134
2878733	KDMT0500R630A050HNC	V133
2878737	KDMT0750R748A075HNC	V133
2879403	KDMB0375R472A038HNC	V123
2879404	KDMB0375R591A038HNC	V123
2879405	KDMB0500R472A050HNC	V123
2879406	KDMB0500R630A050HNC	V123
2879408	KDMB0625R689A063HNC	V123
2879409	KDMB0750R551A075HNC	V123
2879410	KDMB0750R827A075HNC	V123
2879411	KDMB1000R630A100HNC	V123
2879412	KDMB1000R906A100HNC	V123
2879415	KDMT05002ERGN KC515M	V134
2879416	KDMT05004ERGN KC515M	V134
2879418	KDMT06254ERGN KC515M	V134
2879419	KDMT07502ERGN KC515M	V134
2879420	KDMT07504ERGN KC515M	V134
2879514	KDMT05004ERGC KC515M	V134
2879515	KDMT05002ERGC KC515M	V134
2879519	KDMT07502ERGC KC515M	V134
2879520	KDMT10004ERGC KC515M	V134
2879521	KDMT10002ERGC KC515M	V134
2881212	193.450	J85
2881283	193.451	J85
2882164	B976A16200 KC7315	G138
2883559	KG2512ELDJ KC410M	T93
2884170	B976A10400 KC7315	G136
2884902	KSCMCA75UN KD1420	S111

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
2884915	KSCMCA90UN KD1420	S110
2884917	KSCMCA75HR KD1420	S111
2884918	KSCMCA75QF KD1420	S111
2884919	KSCMCA75PT KD1420	S111
2885009	B707A12500FBG KC7315	G111
2886972	SDET438XENGB2 KC725M	T115, T122, U39
2887393	KSEM2120HPGM KC7315	H54
2887394	KSEM2670HPGM KC7315	H55
2887395	KSEM1770HPGM KC7315	H54
2887724	B707A03000FBG KC7315	G110
2888086	KTIP080R4BF09M	I12
2888087	KTIP085R4BF09M	I12
2888088	KTIP090R4BF10M	I12
2888089	KTIP095R4BF10M	I12
2888090	KTIP100R4BF11M	I12
2888091	KTIP105R4BF11M	I12
2888092	KTIP110R4BF12M	I12
2888306	B978A04000 KC7315	G139
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	SDCT438ENLD2 KC522M	T115, T122, U38
2890223	B976A03700 KC7315	G134
2896948	B707A19000FBG KC7315	G112
2907289	FBSCUCR09CA06F	K117
2907291	FBSTFCR09CA11F	K117
2940518	B978A08200 KC7315	G140
2951623	BGHX15L5PCSRLET KD1415	S125
2951631	3.37092R320	I14
2951632	3.37092R820	I14
2956333	VNGX353T0820 KY3500	B319
2956334	VNGX354T0820 KY3500	B319
2957497	B707A14500FBG KC7315	G111
2957711	SNXF433ENLD KC514M	S89
2957728	SNXF43ZNENLD KC524M	S89
2957730	SNXF433SNGP KC524M	S89
2957732	SNXF43ZNSNGP KC524M	S89
2957734	SNXF433ENLD KC524M	S89
2957735	SNXF433SNHE KC524M	S89
2957736	SNXF43ZNENLD KC514M	S89
2957738	SNXF433SNGP KC514M	S89
2957739	SNXF43ZNSNGP KC514M	S89
2957741	SNXF43ZNSNHE KC514M	S89
2957828	KDMT0500R512A050SN	V132
2957829	KDMT0500R591A050SN	V132
2957831	KDMT0625R630A063SN	V132
2957832	KDMT0750R630A075SN	V132
2958143	KDMT0750R827A075SN	V132
2958144	KDMT1000R630A100SN	V132
2958146	KDMT1000R906A100SN	V132
2962052	SFRHEC312S3075 KC625M	P131
2962053	SFRHEC375S3088 KC625M	P131
2962054	SFRHEC500S3100 KC625M	P131
2962055	SFRHEC500S3200 KC625M	P131
2962057	SFRHEC625S3225 KC625M	P131
2962058	SFRHEC750S3150 KC625M	P131
2962059	SFRHEC750S3225 KC625M	P131
2962060	SFRHEC100S3150 KC625M	P131
2962061	SFRHEC100S3225 KC625M	P131
2963631	B511S08000 KC7315	J86
2963632	B511S10000 KC7315	J86
2963663	B511S15000 KC7315	J86
2963664	B511S20000 KC7315	J86
2963665	B511S25000 KC7315	J86
2963666	B511S30000 KC7315	J86
2964507	RNMG64RN KC5010	B97
2965409	B977A04650 KC7315	G135
2971371	RCGT64SGF KC522M	V89
2972258	A4C0155N00CF01 KC5025	C112
2972259	A4C0155L06CF01 KC5025	C113
2972262	A4C0155R06CF01 KC5025	C113
2973094	A4C0155R16CF01 KC5025	C113
2974425	A4SMR2020K0217	C124
2975401	MS2166	T49–54
2975402	MS2167	T49, T51–52
2976491	A4SML100214	C123
2976493	A4SML120217	C123
2976494	A4SML160217	C123
2976495	A4SMR100214	C122
2976496	A4SMR120214	C122
2976497	A4SMR120217	C122
2976498	A4SMR160217	C122
2977923	KSSP300R5SD43L400HC	T120
2978378	A4SCR1212K0113	C128
2979048	B978A05900 KC7315	G139
2979110	A4C0205L10CF02 KC5025	C113
2979111	A4C0205N00CF02 KC5025	C112
2979112	A4C0205R06CF02 KC5025	C113
2979192	A20RA4EML0207M	C133
2979216	A4C0255N00CF02 KC5025	C112
2979217	A4C0255R06CF02 KC5025	C113
2979223	A20RA4EMR0207M	C133
2979224	A25RA4EML0210M	C133
2979225	A25RA4EMR0210M	C133
2979227	A12RA4EMR0207N	C132
2979229	A16RA4EMR0210N	C132
2980526	EP1412SGD KCPK30	T58, T70
2980527	EP1412SGD KC520M	T58, T70
2980530	EP1408SGD KC520M	T58, T70
2980531	EP1408SGD KCPK30	T58, T70
2980568	EP1412SGD KC725M	T58, T70
2981100	A4SCL120113	C127
2981101	A4SCL100113	C127
2981102	A4SCL080113	C127
2981194	A4SCR120113	C127
2981195	A4SCR100113	C127
2981196	A4SCR080113	C127
2981197	A4SCR060113	C127
2981644	EP1408SGD KC725M	T58, T70
2982018	OFKT64AFSN6LB KC725M	S51
2982019	OFKT64AFEN6LB KC725M	S51
2982020	OFKT53AFSN6LB KC725M	S47
2982021	OFKT53AFEN6LB KC725M	S47
2982056	KSCM125R16CAB40U	S109
2982065	OFKT64AFEN6LB KC522M	S51
2982069	OFKT53AFSN6LB KC522M	S47
2982070	OFKT53AFSN6LB KC520M	S47
2982072	OFKT53AFSN6LB KCPK30	S47
2982077	EP1416SGD KC725M	T58, T70
2982084	OFKT53AFEN6LB KC522M	S47
2982086	OFKT53AFEN6LB KCK15	S47
2982087	OFKT53AFEN6LB KCPK30	S47
2982090	EP1416SGD KC520M	T58, T70
2982091	EP1416SGD KCPK30	T58, T70
2982168	A4SCL2020K0113	C128
2982169	A4SCL1616K0113	C128
2982170	A4SCL1212K0113	C128
2982172	A4SCR2020K0113	C128
2982223	A4SCR1616K0113	C128
2982224	A4SCR1010K0113	C128
2983278	EC1408ELD KC522M	T56, T67
2983279	EC1408FLDJ KC410M	T55, T66
2983331	EC1408EGD KC725M	T57, T68
2983890	EC1404EGD KC725M	T57, T68
2983891	EC1431EGD KC725M	T57, T68
2983980	A4G0205M02U02GMN KC5010	C106
2983981	A4G0205M02U02GMN KC5025	C106
2983982	A4G0205M02U02GMP KC5010	C105
2984013	A4G0205M02U02GMP KC5025	C105
2984015	A4G0200M02P02GMP KC5010	C105
2984016	A4G0200M02P02GMP KC5025	C105
2984018	A4G0255M2BU02GMN KC5025	C106
2984020	A4G0255M2BU02GMP KC5025	C105
2984022	A4G0250M2BP02GMP KC5010	C105
2984024	A4R0205M02U00GMN KC5010	C107
2984025	A4R0205M02U00GMN KC5025	C107
2984026	A4R0200M02P00GMP KC5010	C106
2984027	A4R0200M02P00GMP KC5025	C106
2984028	A4G094I2BP05GMN KC5010	C107
2984053	EC1404ELD KC522M	T56, T67
2984054	EC1404FLDJ KC410M	T55, T66
2984056	EC1431ELD KC522M	T56, T67
2984057	EC1431FLDJ KC410M	T55, T66
2984137	EC1412ELD KC522M	T56, T67
2984138	EC1412FLDJ KC410M	T55, T66
2984210	EC1412EGD KC725M	T57, T68
2984359	EC1416ELD KC522M	T56, T67
2984360	EC1416FLDJ KC410M	T55, T66
2984773	EC1416EGD KC725M	T57, T68
2985272	B707A03500FBG KC7315	G110
2985333	B707A04500FBG KC7315	G110
2985334	B707A06500FBG KC7315	G110
2985335	B707A09500FBG KC7315	G111
2985336	B707A14000FBG KC7315	G111
2985682	193.465	S109
2985876	193.462	S109
2987166	MSKNR25CA6	B115
2993398	B707A07800FBG KC7315	G111
3005898	B967A11000 KC7315	G131
3005899	B967A13500 KC7315	G132
3005956	B976A03100 KC7315	G134
3013657	KSEM1880HPGM KC7315	H54
3015439	DFR030204MD KC7140	J97
3015440	DFR040304MD KC7140	J97
3016028	KSEM2305HPGM KC7315	H55
3017334	A4SML2525M0217	C125
3017335	A4SML2525M0214	C125
3017336	A4SML2020K0214	C125
3017337	A4SML2020K0217	C125
3017338	A4SML1616K0214	C125
3017339	A4SMR2525M0217	C124
3017340	A4SMR2525M0214	C124
3017341	A4SMR2020K0214	C124
3017342	A4SMR1616K0214	C124
3017663	KTIP170R3SS18M	H38
3017664	KTIP180R3SS20M	H38
3017665	KTIP190R3SS20M	H38
3017666	KTIP200R3SS25M	H38
3017667	KTIP170R3SCF20M	H40
3017668	KTIP180R3SCF25M	H40
3017669	KTIP190R3SCF25M	H40
3017670	KTIP200R3SCF25M	H40
3017671	KTIP170R5SS18M	H38
3017672	KTIP180R5SS20M	H38
3017673	KTIP190R5SS20M	H38
3017674	KTIP200R5SS25M	H38
3017675	KTIP170R5SCF20M	H40
3017676	KTIP180R5SCF25M	H40
3017677	KTIP190R5SCF25M	H40
3017678	KTIP200R5SCF25M	H40
3018928	KTIP0669R3SS069	H39
3018929	KTIP0709R3SS075	H39
3018930	KTIP0748R3SS075	H39
3018931	KTIP0787R3SS081	H39
3018932	KTIP0669R5SS069	H39
3018933	KTIP0709R5SS075	H39
3018934	KTIP0748R5SS075	H39
3018935	KTIP0787R5SS081	H39
3020201	B707A10600FBG KC7315	G111
3022047	DFR0500R4SSF075	J15
3022048	DFR0531R4SSF075	J15
3022049	DFR0563R4SSF075	J15
3022050	DFR0594R4SSF075	J15
3022051	DFR0625R4SSF075	J15
3022052	DFR0625R4SSF100	J15
3022343	DFR0656R4SSF100	J15
3022344	DFR0688R4SSF100	J15
3022345	DFR0703R4SSF100	J15
3022346	DFR0734R4SSF100	J15
3022347	DFR0750R4SSF100	J15
3022348	DFR0781R4SSF100	J15
3022349	DFR0813R4SSF100	J15
3022350	DFR0844R4SSF100	J15
3022351	DFR0875R4SSF100	J15
3022352	DFR0906R4SSF100	J15
3022353	DFR0938R4SSF100	J15
3022354	DFR0969R4SSF100	J15
3022355	DFR0984R4SSF100	J15
3022356	DFR1000R4SSF100	J15
3022357	DFR1000R4SSF125	J15
3022625	A4M50L0214M	C138
3023165	EP1848EHD KC725M	T84
3023166	EP1848EHD KCPK30	T84
3023574	KSEM2210HPGM KC7315	H55
3024727	B707A10200FBG KC7315	G111
3024745	B966A13100 KC7315	G132
3026450	12MHC030M	G79
3026451	12MHC040M	G79
3026452	12MHC050M	G79
3026643	12MHC060M	G79
3026644	12MHC070M	G79
3026645	12MHC080M	G79
3026646	12MHC090M	G79
3026647	12MHC100M	G79
3026648	20MHC030M	G79
3026649	20MHC040M	G79
3026650	20MHC050M	G79
3026651	20MHC060M	G79
3026652	20MHC070M	G79
3026653	20MHC080M	G79
3026654	20MHC090M	G79
3026655	20MHC100M	G79
3026656	20MHC110M	G79
3026657	20MHC120M	G79
3026658	20MHC130M	G79
3026659	20MHC140M	G79
3026660	20MHC150M	G79
3026661	20MHC160M	G79
3026662	25MHC030M	G79
3026663	25MHC040M	G79
3026664	25MHC050M	G79
3026665	25MHC060M	G79
3026666	25MHC070M	G79
3026667	25MHC080M	G79
3026668	25MHC090M	G79
3026669	25MHC100M	G79
3026670	25MHC120M	G79
3026671	25MHC140M	G79
3026672	25MHC160M	G79
3026675	32MHC060M	G79
3026676	32MHC070M	G79
3026677	32MHC080M	G79
3026678	32MHC090M	G79
3026679	32MHC100M	G79
3026680	32MHC110M	G79
3026681	32MHC120M	G79
3026682	32MHC130M	G79
3026683	32MHC140M	G79
3026684	32MHC150M	G79
3026685	32MHC160M	G79
3027980	KSEM1760HPGM KC7315	H54
3029371	PKG1402	K130

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3029372	PKG1602	K130
3029373	PKG1802	K130
3029375	PKG0011	K130
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
3031708	TMT25D067L110Z2	W11
3031712	TMT25D087L170Z3	W11
3031715	TMT25D110L170Z4	W11
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	EP1412EHD KC520M	T57, T68
3033024	KTIP0669R8SS069	H39
3033025	KTIP0709R8SS075	H39
3033026	KTIP0748R8SS075	H39
3033027	KTIP0787R8SS081	H39
3033723	EP1412EHD KC522M	T57, T68
3033724	EP1412EHD KC725M	T57, T68
3033725	EP1412EHD KCK15	T57, T68
3033726	EP1412EHD KCPK30	T57, T68
3033727	EP1408EHD KC520M	T57, T68
3033728	EP1408EHD KC522M	T57, T68
3033729	EP1408EHD KC725M	T57, T68
3033730	EP1408EHD KCK15	T57, T68
3033731	EP1408EHD KCPK30	T57, T68
3033751	EP1416EHD KC522M	T57, T68
3033752	EP1416EHD KC725M	T57, T68
3033953	EP1416EHD KCK15	T57, T68
3033954	EP1416EHD KCPK30	T57, T68
3033966	B707A06800FBG KC7315	G110
3039409	KSEM3400PCM KC7135	H70, H111
3039410	KSEM3600PCM KC7135	H70, H111
3041312	B707A06100FBG KC7315	G110
3043944	KSEM3500PCM KC7135	H70, H111
3045090	KSSP200R3SD43L200HC	T120
3045800	S422CG	T53, V54, V70
3045801	S467	T7, U27, U37, V54, V58
3047641	T320MF140X150R6HX KC7542	M4
3048604	KLS20C	T78
3048803	KSEM3300PCM KC7135	H70, H111
3050716	DFR020204MD KC7140	J97
3050792	HPFSS250S3050 KC635M	P108
3050793	HPFSS125S5025 KC635M	P109
3050794	HPFSS188S5031 KC635M	P109
3050799	HPFT375S6113 KC635M	P110
3051244	EP1420EHD KC522M	T57, T68
3051245	EP1420EHD KC725M	T57, T68
3051246	EP1420EHD KCPK30	T57, T68
3051247	EP1431EHD KC522M	T57, T68
3051248	EP1431EHD KC725M	T57, T68
3051249	EP1431EHD KCPK30	T57, T68
3051250	EP1440EHD KC522M	T57, T68
3051251	EP1440EHD KC725M	T57, T68
3051252	EP1440EHD KCPK30	T57, T68
3051549	EP1424EHD KC522M	T57, T68
3051550	EP1424EHD KC725M	T57, T68
3051551	EP1424EHD KCPK30	T57, T68
3051552	EP1404EHD KC522M	T57, T68
3051623	A4M50L2B14M	C138
3051624	A4M50R0214M	C138
3051629	A4M50L0212A060084	C140
3051631	A4M50L0212A120254	C140
3051632	A4M50L0212A250999	C140
3051663	A4M50L0212B036046	C142
3051664	A4M50L0212B042054	C142
3051665	A4M50L0212B050064	C142
3051666	A4M50L0212B060084	C142
3051667	A4M50L0212B080124	C142
3051668	A4M50L0212B120254	C142
3051670	A4M50R0212A036046	C139
3051671	A4M50R0212A042054	C139
3051672	A4M50R0212A050064	C139
3051673	A4M50R0212A060084	C139
3051674	A4M50R0212A080124	C139
3051675	A4M50R0212A120254	C139
3051676	A4M50R0212A250999	C139
3051677	A4M50R0212B036046	C141
3051678	A4M50R0212B042054	C141
3051679	A4M50R0212B050064	C141
3051680	A4M50R0212B060084	C141
3051681	A4M50R0212B080124	C141
3051682	A4M50R0212B120254	C141
3051683	A4M50R0212B250999	C141
3051863	EP1404EHD KC725M	T57, T68
3051864	EP1404EHD KCK15	T57, T68
3051865	EP1404EHD KCPK30	T57, T68
3051866	EP1404EHD KC520M	T57, T68
3053564	SDET433PDENGDZ KCPK30	V143
3053565	SDET433PDSNGDZ KCPK30	V143
3054849	KSSZR200SD430C3A04	V141
3055223	B707A13500FBG KC7315	G111
3057117	B978A03700 KC7315	G139
3057121	B978A07400 KC7315	G140
3057122	B978A09300 KC7315	G140
3058199	KSEM1008HPG KC7315	H55
3058984	B707A04400FBG KC7315	G110
3064493	KSSZR300SD430C4A05	V141
3064549	KSEM2470HPGM KC7315	H55
3064601	KISZR125SD430C4A02	V140
3064602	KSSZR300SD430M4A06	V141
3064755	KSSZR200SD430M3A05	V141
3064902	KSSZR300SD430F4A07	V141
3066053	A4G0605M06U04B KCK20	C108
3066133	SDET433PDENGDZ KC725M	V143
3066281	SDET433PDSNGDZ KC725M	V143
3066375	SDET433PDSNGDZ KC522M	V143
3066674	KSSZR400SD430F5A09	V141
3077140	SF150FBH01660	K129
3077141	SF100FBH01660	K129
3093561	HNGJ535ANENLD KC522M	S18, S21
3093600	KSOM125OF5345F5	S44
3093623	KSOM150OF5345F3	S44
3093625	KSOM125OF5345M3	S44
3093627	KSOM150OF5345M3	S44
3093632	KSOM500OF5345F6	S45
3093634	KSOM200OF5345M3	S45
3093635	KSOM250OF5345M3	S45
3093636	KSOM300OF5345M4	S45
3093637	KSOM400OF5345M5	S45
3093638	KSOM500OF5345M6	S45
3093640	KSOM250OF6445F3	S50
3093641	KSOM300OF6445F4	S50
3093642	KSOM400OF6445F5	S50
3093643	KSOM500OF6445F6	S50
3093644	KSOM600OF6445F8	S50
3093645	KSOM250OF6445M3	S50
3093646	KSOM300OF6445M4	S50
3093647	KSOM400OF6445M5	S50
3093648	KSOM500OF6445M6	S50
3093649	KSOM600OF6445M8	S50
3093719	HNGJ535ANSNGD KCPK30	S18, S22
3094010	843.006.000	K124–126, K140
3094035	880.252.200	K137–139
3097294	KSEM1660HPGM KC7315	H54
3097295	KSEM1860HPGM KC7315	H54
3098071	B707A04200FBG KC7315	G110
3102669	B977A08020 KC7315	G136
3106096	SDPT433PDENHPZ KCPK30	V143
3106097	SDPT433PDSNHPZ KCPK30	V143
3106098	SDPT433PDENHPZ KC725M	V143
3106099	SDPT433PDSNHPZ KC725M	V143
3107215	KISZR150SD430C5A03	V140
3107216	KISZR200SD430C6A04	V140
3110522	B976A03200 KC7315	G134
3110544	B976A03600 KC7315	G134
3110545	B976A07200 KC7315	G136
3114313	KTIP170R8SS18M	H38
3114314	KTIP180R8SS20M	H38
3114315	KTIP190R8SS20M	H38
3114316	KTIP200R8SS25M	H38
3114317	KTIP170R8SCF20M	H40
3114318	KTIP180R8SCF25M	H40
3114319	KTIP190R8SCF25M	H40
3114320	KTIP200R8SCF25M	H40
3114636	RIQ09E1312 KC6305	K58
3117503	B967A09500 KC7315	G131
3119977	B976A10300 KC7315	G136
3120318	KSEM2170HPGM KC7315	H55
3121225	193.492	S4–5, S8–10, S14, S17, S20, S56, S58, V51–54, V62
3121287	B976A06700 KC7315	G135
3124549	193.491	J25, J27, J29, J31, J33, J35, J37, J39
3124699	EP1864S KC725M	T85
3127186	NAS3L4 KC5025	D12
3133459	MS1294CG	V62
3135660	B256A12500 KC7315	G58
3136510	EP1840EHD KC725M	T84
3138954	SNXF433AMSN KY3500	S90
3138955	SNXF43ZNAMSN KY3500	S90
3138957	S2172CG	V54, V58
3139149	843.009.000	K124–126, K140
3176219	KM25LSSR2230	D77
3176220	KM25LSSL2230	D77
3176596	TRM50R0640M	E71
3176598	TRM50L0640M	E71
3176599	TRM50L0432M	E71
3176600	TRM50R0432M	E71
3176601	TRM50R0920M	E71
3176602	TRM50L0920M	E71
3176604	TRM50R0940M	E71
3176605	TRM50R0620M	E71
3176606	TRM50L0620M	E71
3176688	MS2173	B217, B220, B222–223
3176689	MS2175	B217–223, B245, B276–278
3180571	B977A14100 KC7315	G137
3273589	EC1402FLDJ KC410M	T55, T66
3273590	EC1440FLDJ KC410M	T55, T66
3287987	CSWM 035 040	B217, B220, B222–223
3287988	CSWM 040 050	B217–223, B245, B276–278
3287989	CSWM 060 050	B72–74, B94, B115–119, B140–142, B174–176, B186–187, B198, B217, B220, B236–237, B245, B249–251, B254–255, B276–279, B394–398, C196, D41
3287990	CSWM 080 050	B72–74, B94–95, B115–117, B119, B140–142, B186, B198, B249, B397
3287991	CSWM 100 080	B74, B115, B119, C196, D41
3292774	EC1808EJ KC422M	T82
3292775	EC1824EJ KC422M	T82
3300212	B707A05800FBG KC7315	G110
3322050	B707A10500FBG KC7315	G111
3322370	CFM0402R45RHP KCU40	H43
3324493	KTIP170R3BF17M	I11
3324494	KTIP170R3BF18M	I11
3324495	KTIP180R3BF18M	I11
3324496	KTIP170R4BF18M	I12
3324497	KTIP180R4BF18M	I12
3324498	KTIP170R5BF18M	I13
3324499	KTIP180R5BF18M	I13
3324721	A4G0305M03U02B KCK20	C108
3324722	A4G0405M04U04B KCK20	C108
3324723	A4G0505M05U04B KCK20	C108
3324724	A4G0805M08U08B KCK20	C108
3324725	A4G1005M10U08B KCK20	C108
3324726	EC1424ELDJ KC422M	T56, T67
3324993	EC1404ELDJ KC422M	T56, T67
3324994	EC1408ELDJ KC422M	T56, T67
3326217	RCGT86SGF KC522M	V92
3326850	KSHR200HN5345C3	S20
3326851	KSHR200HN5345M3	S20
3326852	KSHR250HN5345C3	S20
3326923	KSHR250HN5345M3	S20
3326924	KSHR300HN5345C4	S20
3326925	KSHR300HN5345M4	S20
3326926	KSHR400HN5345C5	S20
3326927	KSHR400HN5345M5	S20
3326928	KSHR500HN5345C6	S20
3326929	KSHR500HN5345M6	S20
3326930	KSHR600HN5345C8	S20
3326931	KSHR600HN5345M8	S20
3330191	CTGPR12CA3	B187, B398
3330195	MCFNR20CA4	B72
3330196	MCLNL20CA4	B74
3330197	MCLNR20CA4	B74
3330199	MDJNR20CA4	B94
3330200	MDQNL20CA4	B95
3330201	MDQNR20CA4	B95
3330202	MSKNL20CA5	B115
3330203	MSRNL20CA5	B116
3330206	MSSNR20CA5	B117
3330207	MTFNL20CA4	B140
3330208	MTFNR20CA4	B140
3330209	MTGNL20CA4	B141
3330222	MCKNR16CA4	B73
3330273	MCLNL16CA4	B74
3330274	MDJNL16CA4	B94
3330275	MDJNR16CA4	B94
3330276	MDQNL16CA4	B95
3330277	MDQNR16CA4	B95
3330279	MSRNL16CA4	B116
3330281	MSSNR16CA4	B117
3330283	MSYNR16CA4	B119
3330285	MTGNR16CA3	B141
3330528	100G10RP90SP10	U25
3330531	125H11RP90SP10	U25
3330952	HNGJ535ANENLD KCK15	S18, S21
3330995	L08RSCFPL2	B213
3330999	L06MSCFPR2	B213
3331000	L08RSCFPR2	B213
3331001	L10RSCFPR2	B213
3331002	L12RSCFPR3	B213

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3331033	L16SSCFPR3	B213
3331034	L08RSCLPL2	B215
3331035	L06MSCLPL2	B215
3331036	L05MSCLPL2	B215
3331038	L12RSCLPL3	B215
3331039	L10RSCLPL3	B215
3331040	L16SSCLPL3	B215
3331041	L08RSCLPR2	B215
3331042	L05MSCLPR2	B215
3331043	L06MSCLPR2	B215
3331044	L10RSCLPR2	B215
3331045	L10RSCLPR3	B215
3331046	L12RSCLPR3	B215
3331047	L16SSCLPR3	B215
3331048	L06MSDUPL2	B235
3331049	L08RSDUPL2	B235
3331052	L06MSDUPR2	B235
3331073	L08RSDUPR2	B235
3331074	L10RSDUPR2	B235
3331075	L12RSDUPR3	B235
3331079	L08RSTFPR2	B273
3331080	L10RSTFPR2	B273
3331081	L06MSTFPR2	B273
3331082	L12RSTFPR3	B273
3331084	L08RNEL2	D37
3331088	L06MNER1S	D37
3331089	L08RNER1S	D37
3331090	L05MNER1S	D37
3331091	L08RNER2	D37
3331092	L12RNER2	D37
3331103	L10RNER2	D37
3331105	L16SNER3	D37
3331132	CSRPR10CA3	B175, B395
3331143	CSSPL10CA3	B176, B396
3331145	MCFNL10CA3	B72
3331146	MCFNR10CA3	B72
3331149	MSTNR10CA3	B118
3331150	MSYNL10CA3	B119
3331173	HNGJ535ANSNGD KCK15	S18, S22
3331174	HNGJ535ANENLD KC520M	S18, S21
3331175	HNGJ535ANENLD KC725M	S18, S21
3331176	HNGJ535ANSNGD KC725M	S18, S22
3331178	HNGJ535ANENLD KCPK30	S18, S21
3331465	HPHVT500S4063 KC643M	P24
3331466	HPHVT500S4063CH KC643M	P24
3331467	HPHVT500S4125 KC643M	P24
3331468	HPHVT500S4125CH KC643M	P24
3331469	HPHVT625S4075 KC643M	P24
3331470	HPHVT625S4075CH KC643M	P24
3331471	HPHVT625S4125 KC643M	P24
3331472	HPHVT625S4125CH KC643M	P24
3331473	HPHVT750S4088 KC643M	P24
3331474	HPHVT750S4088CH KC643M	P24
3331475	HPHVT750S4150 KC643M	P24
3331476	HPHVT750S4150CH KC643M	P24
3331477	HPHVT1000S4150 KC643M	P24
3331478	HPHVT1000S4150CH KC643M	P24
3331481	HPRST250S4038 KC643M	P92
3331482	HPRST250S4075 KC643M	P92
3331483	HPRST375S4050 KC643M	P92
3331484	HPRST375S4088 KC643M	P92
3331485	HPRST500S4063 KC643M	P92
3331486	HPRST500S4125 KC643M	P92
3331487	HPRST625S4075 KC643M	P92
3331488	HPRST625S4125 KC643M	P92
3331489	HPRST625S6125 KC643M	P92
3331490	HPRST750S4088 KC643M	P92
3331491	HPRST750S4150 KC643M	P92
3331492	HPRST750S6150 KC643M	P92
3331493	HPRST1000S4150 KC643M	P92
3331494	HPRST1000S6150 KC643M	P92
3332362	MCLNL25CA6	B74
3332803	MCLNR25CA4	B74
3332804	MCLNR25CA5	B74
3332805	MCLNR25CA6	B74
3343592	KSEM2310HPGM KC7315	H55
3346236	MCFNR12CA4	B72
3346237	MCKNL12CA4	B73
3346238	MCKNR12CA4	B73
3346240	MDJNL12CA3	B94
3346241	MDJNR12CA3	B94
3346242	MSKNL12CA4	B115
3346273	MSYNL12CA4	B119
3346274	MSYNR12CA4	B119
3346275	MTGNL12CA3	B141
3349309	HNEN0905ANSN KD200	S79
3352074	881.252.720	K137–138
3352573	KMDA0250J6ANA KC639M	P142
3352574	KMDA0312J6ANA KC639M	P142
3352575	KMDA0375J6ANA KC639M	P142
3352576	KMDA0500J6ANA KC639M	P142
3352577	KMDA0625J6ANA KC639M	P142
3352578	KMDA0750J6ANA KC639M	P142
3352730	KHDA0250J6ANA KC639M	P143
3352731	KHDA0312J6ANA KC639M	P143
3352732	KHDA0375J6ANA KC639M	P143
3352773	KHDA0500J6ANA KC639M	P143
3352774	KHDA0625J6ANA KC639M	P143
3352775	KHDA0750J6ANA KC639M	P143
3353405	KSEM2973HPGM KC7315	H55
3362163	881.252.550	K137–138
3367371	B531A03200SPF KDF400	G100
3367372	B531A05100SPF KDF400	G100
3367373	B531A06500SPF KDF400	G100
3367382	B532A03200SPF KDF400	G100
3367383	B532A05100SPF KDF400	G100
3367384	B532A06500SPF KDF400	G100
3367385	B531A06000SPF KDF400	G100
3367386	B532A06000SPF KDF400	G100
3379064	EP1864EHD KC725M	T84
3379065	EP1864EHD KCPK30	T84
3380488	KSEM1250HPLM KC7320	H62
3380490	KSEM0500HPL KC7320	H62
3380491	KSEM1280HPLM KC7320	H62
3380492	KSEM0509HPL KC7320	H62
3381103	KSEM1300HPLM KC7320	H62
3381104	KSEM1350HPLM KC7320	H62
3381105	KSEM1360HPLM KC7320	H62
3381106	KSEM1380HPLM KC7320	H62
3381107	KSEM0547HPL KC7320	H62
3381108	KSEM1400HPLM KC7320	H62
3381109	KSEM1410HPLM KC7320	H62
3381110	KSEM1415HPLM KC7320	H62
3381111	KSEM1420HPLM KC7320	H62
3381112	KSEM0563HPL KC7320	H62
3381113	KSEM1450HPLM KC7320	H62
3381114	KSEM1460HPLM KC7320	H62
3381115	KSEM0578HPL KC7320	H62
3381116	KSEM1480HPLM KC7320	H62
3381117	KSEM1500HPLM KC7320	H62
3381118	KSEM0594HPL KC7320	H62
3381119	KSEM0609HPL KC7320	H62
3381120	KSEM1550HPLM KC7320	H62
3381121	KSEM1560HPLM KC7320	H62
3381122	KSEM0625HPL KC7320	H62
3381123	KSEM1600HPLM KC7320	H62
3381124	KSEM0634HPL KC7320	H62
3381125	KSEM1610HPLM KC7320	H62
3381126	KSEM1615HPLM KC7320	H62
3381127	KSEM1620HPLM KC7320	H62
3381128	KSEM0641HPL KC7320	H62
3381129	KSEM1650HPLM KC7320	H62
3381130	KSEM0656HPL KC7320	H62
3381131	KSEM1700HPLM KC7320	H62
3381132	KSEM0672HPL KC7320	H62
3381133	KSEM0688HPL KC7320	H62
3381134	KSEM1750HPLM KC7320	H62
3381135	KSEM1775HPLM KC7320	H62
3381136	KSEM1780HPLM KC7320	H62
3381137	KSEM0703HPL KC7320	H62
3381138	KSEM1790HPLM KC7320	H62
3381139	KSEM1800HPLM KC7320	H62
3381140	KSEM0719HPL KC7320	H62
3381142	KSEM1850HPLM KC7320	H62
3381143	KSEM1860HPLM KC7320	H62
3381144	KSEM0734HPL KC7320	H62
3381145	KSEM1890HPLM KC7320	H62
3381146	KSEM1900HPLM KC7320	H62
3381147	KSEM0750HPL KC7320	H62
3381148	KSEM1920HPLM KC7320	H62
3381149	KSEM0757HPL KC7320	H62
3381150	KSEM0758HPL KC7320	H62
3381151	KSEM0759HPL KC7320	H62
3381152	KSEM1935HPLM KC7320	H62
3381153	KSEM1936HPLM KC7320	H62
3381154	KSEM0766HPL KC7320	H62
3381155	KSEM1950HPLM KC7320	H62
3381156	KSEM0781HPL KC7320	H62
3381157	KSEM2000HPLM KC7320	H62
3381158	KSEM2010HPLM KC7320	H62
3381159	KSEM0797HPL KC7320	H62
3381160	KSEM2035HPLM KC7320	H62
3381161	KSEM2050HPLM KC7320	H62
3381162	KSEM0813HPL KC7320	H62
3381163	KSEM2100HPLM KC7320	H62
3381164	KSEM2115HPLM KC7320	H62
3381165	KSEM2133HPLM KC7320	H62
3381166	KSEM2810HPLM KC7320	H63
3381167	KSEM0844HPL KC7320	H62
3381168	KSEM2850HPLM KC7320	H63
3381169	KSEM2150HPLM KC7320	H62
3381170	KSEM1125HPL KC7320	H63
3381171	KSEM0859HPL KC7320	H62
3381172	KSEM2900HPLM KC7320	H63
3381173	KSEM2200HPLM KC7320	H62
3381174	KSEM1156HPL KC7320	H63
3381175	KSEM0875HPL KC7320	H62
3381176	KSEM2950HPLM KC7320	H63
3381177	KSEM0884HPL KC7320	H62
3381178	KSEM1172HPL KC7320	H63
3381179	KSEM2250HPLM KC7320	H62
3381180	KSEM3000HPLM KC7320	H63
3381181	KSEM2277HPLM KC7320	H62
3381182	KSEM1188HPL KC7320	H63
3381183	KSEM2300HPLM KC7320	H62
3381184	KSEM3050HPLM KC7320	H63
3381185	KSEM0922HPL KC7320	H62
3381186	KSEM3100HPLM KC7320	H63
3381187	KSEM2350HPLM KC7320	H62
3381188	KSEM3150HPLM KC7320	H63
3381189	KSEM0938HPL KC7320	H62
3381190	KSEM1250HPL KC7320	H63
3381191	KSEM2400HPLM KC7320	H62
3381192	KSEM3200HPLM KC7320	H63
3381193	KSEM2450HPLM KC7320	H62
3381194	KSEM3300HPLM KC7320	H63
3381195	KSEM0969HPL KC7320	H62
3381196	KSEM1375HPL KC7320	H63
3381197	KSEM1406HPL KC7320	H63
3381198	KSEM1500HPL KC7320	H63
3381199	KSEM1514HPL KC7320	H63
3381615	KSEM3400HPLM KC7320	H63
3381616	KSEM2500HPLM KC7320	H62
3381617	KSEM3500HPLM KC7320	H63
3381618	KSEM2507HPLM KC7320	H62
3381619	KSEM3600HPLM KC7320	H63
3381620	KSEM1000HPL KC7320	H62
3381621	KSEM3700HPLM KC7320	H63
3381622	KSEM2550HPLM KC7320	H62
3381623	KSEM3750HPLM KC7320	H63
3381624	KSEM1008HPL KC7320	H62
3381625	KSEM3800HPLM KC7320	H63
3381626	KSEM2565HPLM KC7320	H63
3381627	KSEM3900HPLM KC7320	H63
3381628	KSEM1011HPL KC7320	H63
3381630	KSEM2600HPLM KC7320	H63
3381631	KSEM4000HPLM KC7320	H63
3381632	KSEM1016HPL KC7320	H63
3381633	KSEM1031HPL KC7320	H63
3381634	KSEM0516HPL KC7320	H62
3381635	KSEM2650HPLM KC7320	H63
3381636	KSEM1047HPL KC7320	H63
3381637	KSEM1094HPL KC7320	H63
3381638	KSEM2670HPLM KC7320	H63
3381639	KSEM1109HPL KC7320	H63
3381640	KSEM2700HPLM KC7320	H63
3381641	KSEM1281HPL KC7320	H63
3381642	KSEM2750HPLM KC7320	H63
3381643	KSEM1313HPL KC7320	H63
3381644	KSEM2800HPLM KC7320	H63
3382970	B707A12100FBG KC7315	G111
3383028	CNGA432S0420MT KB1345	B310
3383030	CNGA432S0820MT KB1345	B310
3383031	DNGA432S0420MT KB1345	B310
3383294	CCGW3252EC KB1345	B311
3383296	TPGW2151EC KB1345	B312
3383298	DCGW3251S0415MT KB1345	B312
3383314	DCGW3252S0415MT KB1345	B312
3383760	B707A09800FBG KC7315	G111
3387723	RCGT64SGF KC725M	V89
3387724	RCGT86SGF KC725M	V92
3387910	NR2M050L KC5010	C172
3387928	NR3M150L KC5010	C172
3387935	NR2M050R KC5010	C172
3387936	NR2M075R KC5010	C172
3387937	NR2M100R KC5010	C172
3388407	NR2M100L KC5025	C172
3388409	NR2M150L KC5025	C172
3388411	NR3M100L KC5025	C172
3388453	NR3M150L KC5025	C172
3388455	NR3M200L KC5025	C172
3388460	NR2M050R KC5025	C172
3388462	NR2M100R KC5025	C172
3388463	NR2M125R KC5025	C172
3388464	NR2M150R KC5025	C172
3388465	NR2M175R KC5025	C172
3388466	NR3M100R KC5025	C172
3388468	NR3M150R KC5025	C172
3388470	NR3M200R KC5025	C172
3396984	MS2085	T120, V81–83
3397222	NGD2M200LK KC5010	C165
3397223	NGD2M250LK KC5010	C165
3397226	NGD3M300LK KC5010	C165
3397243	NGD2M150RK KC5010	C165
3397244	NGD2M200RK KC5010	C165
3397246	NGD3M200RK KC5010	C165
3397247	NGD3M250RK KC5010	C165
3397248	NGD3M300RK KC5010	C165
3397250	NGD3M400RK KC5010	C165
3397259	NGD2M150LK KC5025	C165
3397273	NGD2M200LK KC5025	C165
3397274	NGD2M250LK KC5025	C165
3397275	NGD3M200LK KC5025	C165
3397276	NGD3M250LK KC5025	C165
3397277	NGD3M300LK KC5025	C165
3397279	NGD3M350LK KC5025	C165
3397280	NGD3M400LK KC5025	C165
3397286	NGD2M150RK KC5025	C165
3397287	NGD2M200RK KC5025	C165
3397288	NGD2M250RK KC5025	C165
3397289	NGD3M200RK KC5025	C165
3397290	NGD3M250RK KC5025	C165
3397291	NGD3M300RK KC5025	C165
3397293	NGD3M400RK KC5025	C165
3397369	NG2M050LK KC5010	C163
3397370	NG2M050RK KC5010	C162
3397613	NF3M200LK KC5025	C173
3397614	NF3M300LK KC5025	C173
3397615	NFD3M300LK KC5025	C174
3397616	NF3M200RK KC5025	C173
3397617	NF3M300RK KC5025	C173
3397618	NFD3M300RK KC5025	C174
3399619	KSEM3700PCM KC7135	H70, H111
3400552	MS2197	V139–141
3400611	MS2191C00	T63, T65, V139–140, V142
3400612	MS2191C06	T63, T65, V139–140, V142
3400613	MS2191C08	T63, T65, V139–142
3400616	MS2191C12	T63, T65, V139–142
3400617	MS2191C14	T63, T65, V139–140, V142
3400618	MS2191C16	T63–65, V139–140, V142
3400619	MS2191C18	T63, T65, V139–140, V142
3400620	MS2191C20	T63–65, V139–140, V142
3400879	12748500500	S83
3403362	CNMG431UP KC5010	B54
3403423	CNMG432UP KC5010	B54
3403424	CNMG433UP KC5010	B54
3403430	DNMG432UP KC5010	B84
3403433	DNMG442UP KC5010	B84
3403435	SNMG432UP KC5010	B106
3403444	VNMG331UP KC5010	B148
3403445	VNMG332UP KC5010	B148
3403448	WNMG432UP KC5010	B162

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3403449	WNMG433UP KC5010	B162
3448592	KSSZR250SD430C3A05	V141
3448913	KSSZR250SD430M3A06	V141
3448914	KSSZR400SD430C5A07	V141
3448915	KSSZR400SD430M5A08	V141
3448916	KSSZR400SD430C6A07	V141
3448917	KSSZR400SD430M6A08	V141
3448918	KSSZR400SD430F6A09	V141
3448920	KSSZR500SD430M6A09	V141
3449167	KTSZR125SD430CM16A02	V139
3449168	KTSZR150SD430CM16A03	V139
3449169	KTSZR200SD430CM16A04	V139
3450355	MS1234CG	V62
3480435	B977A03250 KC7315	G134
3482532	CCMT3252FP KCU10	B190
3482959	T331NC2500-20R3BX KC7542	M44
3482960	T331NF2500-28R3BX KC7542	M44
3482961	T331NC3125-18R3BX KC7542	M44
3482962	T331NC3750-16R3BX KC7542	M44
3483053	T331NC4375-14R3BX KC7542	M44
3483054	T331NC5000-13R3BX KC7542	M44
3483057	T331M060X100R6HX KC7542	M45
3483058	T331M080X125R6HX KC7542	M45
3483059	T331M100X150R6HX KC7542	M45
3483061	T331M120X175R6HX KC7542	M45
3483062	T331MF120X150R6HX KC7542	M45
3483073	T331M140X200R6HX KC7542	M45
3483074	T331MF140X150R6HX KC7542	M45
3483075	T331M160X200R6HX KC7542	M45
3491692	B978A13100 KC7315	G140
3492010	MCC080001	V88, V91
3492053	S2192C	T17
3494648	KSHR800HN5345C10	S20
3494649	KSHR1000HN5345C10	S20
3494650	KSHR1200HN5345C10	S20
3503895	EC1864EJ KC422M	T82
3505052	B707A03175FBG KC7315	G110
3505133	B707A03970FBG KC7315	G110
3505134	B707A04763FBG KC7315	G110
3505135	B707A06350FBG KC7315	G110
3505136	B707A07145FBG KC7315	G111
3505137	B707A07938FBG KC7315	G111
3505138	B707A08334FBG KC7315	G111
3505139	B707A09129FBG KC7315	G111
3505140	B707A09525FBG KC7315	G111
3505141	B707A10320FBG KC7315	G111
3505142	B707A11111FBG KC7315	G111
3505143	B707A11509FBG KC7315	G111
3505144	B707A11908FBG KC7315	G111
3505145	B707A14288FBG KC7315	G111
3505146	B707A15875FBG KC7315	G112
3505147	B707A17463FBG KC7315	G112
3505148	B707A19050FBG KC7315	G112
3505149	B707A15500FBG KC7315	G112
3505150	B707A16500FBG KC7315	G112
3505151	B707A17500FBG KC7315	G112
3505152	B707A18500FBG KC7315	G112
3505952	B966A20000 KC7315	G132
3519355	B707A10800FBG KC7315	G111
3521303	KSEM2330HPGM KC7315	H55
3526417	KSEM1935HPGM KC7315	H54
3528124	B976A03180 KC7315	G134
3528125	B976A03500 KC7315	G134
3528126	B976A04620 KC7315	G135
3528127	B976A05250 KC7315	G135
3528128	B976A06530 KC7315	G135
3528129	B976A06750 KC7315	G135
3528131	B976A08430 KC7315	G136
3528132	B976A09750 KC7315	G136
3547022	XNGJ535ANSNGD3W KCK15	S21
3547033	XNGJ535ANSNGD3W KC725M	S21
3547035	XNGJ535ANSNGD3W KCPK30	S21
3553429	KGMSR2525M65	C144
3553430	KGMSL2525M65	C144
3553431	KGMSR3232P65	C144
3553432	KGMSL3232P65	C144
3553453	KGMER2525M65	C145
3553454	KGMEL2525M65	C145
3553455	KGMER3232P65	C145
3553456	KGMEL3232P65	C145
3553503	B976A07600 KC7315	G136
3554366	CV40BKR32157	K91
3554367	CV40BKR50236	K91
3554368	CV50BKR32157	K91
3554369	CV50BKR50157	K91
3554370	CV50BKR63236	K91
3554371	CV50BKR80275	K91
3554372	BT40BKR32030M	K91
3554373	BT40BKR50050M	K91
3554374	BT50BKR32040M	K91
3554375	BT50BKR50040M	K91
3554376	BT50BKR63060M	K91
3554377	BT50BKR80060M	K91
3556330	HNGJ535ANSNHD KCK15	S19, S22
3556331	HNGJ535ANSNHD KC725M	S19, S22
3556332	HNGJ535ANSNHD KCPK30	S19, S22
3556346	MB24RBHT06F	K124
3556347	MB30RBHT06F	K124
3556348	MB40RBHT09F	K124
3556349	MB50RBHT09F	K124
3556350	MB66RBHT12F	K124
3556352	MB66RBHT12LF	K124
3556374	HNGJ53511ANSNHD KC725M	S19, S22
3556375	HNGJ53511ANSNHD KCPK30	S19, S22
3556393	MB87RBHT12F	K124
3556394	MB87RBHT16LF	K124
3556395	MB115RBHT12F	K124
3556396	MB115RBHT16LF	K124
3556397	MB24RBHT06K	K125
3556398	MB30RBHT06K	K125
3556399	MB40RBHT09K	K125
3556400	MB50RBHT09K	K125
3556401	MB66RBHT12K	K125
3556402	MB66RBHT12LK	K125
3556403	MB87RBHT12K	K125
3556404	MB87RBHT16LK	K125
3556405	MB115RBHT16LK	K125
3556992	KGMSR1665N	C143
3557103	KGMSL1665N	C143
3557104	KGMSR2065N	C143
3557105	KGMSL2065N	C143
3557106	KGMSR2465N	C143
3557107	KGMSL2465N	C143
3557108	KGMER1665N	C145
3557109	KGMEL1665N	C145
3557110	KGMER2065N	C145
3557111	KGMEL2065N	C145
3557113	KGMEL2465N	C145
3557114	A4M65R0620M	C138
3557115	A4M65L0620M	C138
3557116	A4M65R0626M	C138
3557117	A4M65L0626M	C138
3557119	A4M65L0820M	C138
3557120	A4M65R0826M	C138
3557121	A4M65L0826M	C138
3557123	A4M65L1020M	C138
3557124	A4M65R1026M	C138
3557125	A4M65L1026M	C138
3557131	A4M65R0624A070-112	C139
3557132	A4M65L0624A070-112	C140
3557163	A4M65R0624A100-212	C139
3557164	A4M65L0624A100-212	C140
3557165	A4M65R0624A200-999	C139
3557166	A4M65L0624A200-999	C140
3557167	A4M65R0824A090-200	C139
3557169	A4M65R0824A184-999	C139
3557173	A4M65R1024A200-999	C139
3557174	A4M65L1024A200-999	C140
3557175	A4M65R0624B070-112	C141
3557176	A4M65L0624B070-112	C142
3557177	A4M65R0624B100-212	C141
3557178	A4M65L0624B100-212	C142
3557179	A4M65R0624B200-999	C141
3557180	A4M65L0624B200-999	C142
3557181	A4M65R0824B090-200	C141
3557182	A4M65L0824B090-200	C142
3557193	A4M65R0824B184-999	C141
3557194	A4M65L0824B184-999	C142
3557195	A4M65R1024B100-220	C141
3557197	A4M65R1024B200-999	C141
3557198	A4M65L1024B200-999	C142
3557310	12147629800	K116–117
3559794	B967A14500 KC7315	G132
3560480	SDCT4316ENLD2 KC725M	T115, T122, U38
3560482	SDET4316SNGB2 KCPK30	T115, T122, U39
3563231	B707A12700FBG KC7315	G111
3575847	193.531	S24
3577119	KTMS21S25SD06H	U3
3577121	KTMS25S25SD06H	U3
3577133	KTMS32S32SD08H	U3
3577135	KTMS40S32SD12H	U3
3577137	KTMS50S32SD12H	U3
3579858	KSEM2070HPGM KC7315	H54
3580522	UCDE250J5ARA KC643M	P32
3580763	UCDE375J5ARA KC643M	P32
3580764	UCDE500K5ARB KC643M	P32
3580765	UCDE625K5ARB KC643M	P32
3580766	UCDE750K5ARB KC643M	P32
3580767	UCDE1000K5ARB KC643M	P32
3580769	UCDE500K5BS KC643M	P30
3580770	UCDE500K5BRA KC643M	P30
3580771	UCDE500K5BRB KC643M	P30
3580772	UCDE500K5BRF KC643M	P30
3580783	UCDE625K5BS KC643M	P30
3580784	UCDE625K5BRB KC643M	P30
3580785	UCDE750K5BS KC643M	P31
3580786	UCDE750K5BRB KC643M	P30
3580787	UCDE750K5BRF KC643M	P31
3580788	UCDE1000K5BS KC643M	P31
3580789	UCDE1000K5BRB KC643M	P31
3580790	UCDE1000K5BRF KC643M	P31
3580791	UDDE500J5BS KC643M	P33
3580792	UDDE500J5BRA KC643M	P33
3580803	UDDE500J5BRB KC643M	P33
3580804	UDDE500J5BRF KC643M	P33
3580805	UDDE625J5BS KC643M	P33
3580806	UDDE625J5BRB KC643M	P33
3580807	UDDE750J5BS KC643M	P33
3580808	UDDE750J5BRB KC643M	P33
3580809	UDDE750J5BRF KC643M	P33
3580810	UDDE1000J5BS KC643M	P33
3580811	UDDE1000J5BRB KC643M	P33
3580812	UDDE1000J5BRF KC643M	P33
3580813	UDDE500K5BS KC643M	P33
3580814	UDDE500K5BRA KC643M	P33
3580815	UDDE500K5BRB KC643M	P33
3580816	UDDE500K5BRF KC643M	P33
3580817	UDDE625K5BS KC643M	P33
3580818	UDDE625K5BRB KC643M	P33
3580819	UDDE750K5BS KC643M	P33
3580820	UDDE750K5BRB KC643M	P33
3580821	UDDE750K5BRF KC643M	P33
3580822	UDDE1000K5BS KC643M	P33
3580833	UDDE1000K5BRB KC643M	P33
3580834	UDDE1000K5BRF KC643M	P33
3580836	UCDE188J5BS KC643M	P30
3580837	UCDE188J5BRA KC643M	P30
3580838	UCDE188J5BRB KC643M	P30
3580839	UCDE250J5BS KC643M	P30
3580840	UCDE250J5BRA KC643M	P30
3580841	UCDE250J5BRB KC643M	P30
3580842	UCDE312J5BS KC643M	P30
3580863	UCDE312J5BRA KC643M	P30
3580864	UCDE312J5BRB KC643M	P30
3580865	UCDE375J5BS KC643M	P30
3580866	UCDE375J5BRA KC643M	P30
3580867	UCDE375J5BRB KC643M	P30
3580868	UCDE500J5BS KC643M	P30
3580869	UCDE500J5BRA KC643M	P30
3580870	UCDE500J5BRB KC643M	P30
3580871	UCDE500J5BRF KC643M	P30
3580872	UCDE625J5BS KC643M	P30
3580873	UCDE625J5BRB KC643M	P30
3580874	UCDE750J5BS KC643M	P31
3580875	UCDE750J5BRB KC643M	P30
3580876	UCDE750J5BRD KC643M	P31
3580877	UCDE750J5BRE KC643M	P31
3580878	UCDE750J5BRF KC643M	P31
3580879	UCDE1000J5BS KC643M	P31
3580880	UCDE1000J5BRB KC643M	P31
3580881	UCDE1000J5BRD KC643M	P31
3580882	UCDE1000J5BRE KC643M	P31
3580883	UCDE1000J5BRF KC643M	P31
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	G100
3585207	B531A03600SPF KDF400	G100
3585208	B531A04000SPF KDF400	G100
3585209	B531A04366SPF KDF400	G100
3585210	B531A04851SPF KDF400	G100
3585211	B531A04864SPF KDF400	G100
3585212	B531A05200SPF KDF400	G100
3585213	B531A06375SPF KDF400	G100
3585214	B531A06400SPF KDF400	G100
3585215	B531A07938SPF KDF400	G100
3585217	B531A09550SPF KDF400	G100
3585218	B531A09563SPF KDF400	G100
3585219	B531A11125SPF KDF400	G100
3585220	B531A12725SPF KDF400	G100
3585221	B532A03300SPF KDF400	G100
3585222	B532A03600SPF KDF400	G100
3585224	B532A04366SPF KDF400	G100
3585225	B532A04851SPF KDF400	G100
3585227	B532A05200SPF KDF400	G100
3585228	B532A06375SPF KDF400	G100
3585229	B532A06400SPF KDF400	G100
3585230	B532A07938SPF KDF400	G100
3585233	B532A09563SPF KDF400	G100
3585235	B532A12725SPF KDF400	G100
3586088	KSEM125SEFM	H87
3586089	KSEM130SEFM	H87
3586090	KSEM135SEFM	H87
3586091	KSEM140SEFM	H87
3586092	KSEM145SEFM	H87
3586183	KSEM150SEFM	H87
3586184	KSEM155SEFM	H87
3586185	KSEM160SEFM	H87
3586186	KSEM165SEFM	H87
3586187	KSEM170SEFM	H87
3586188	KSEM175SEFM	H87
3586189	KSEM180SEFM	H87
3586190	KSEM185SEFM	H87
3586191	KSEM190SEFM	H87
3586192	KSEM195SEFM	H87
3586193	KSEM200SEFM	H87
3586194	KSEM205SEFM	H87
3586195	KSEM210SEFM	H87
3586196	KSEM215SEFM	H87
3586197	KSEM220SEFM	H87
3586198	KSEM225SEFM	H87
3586199	KSEM230SEFM	H87
3586200	KSEM235SEFM	H87
3586201	KSEM240SEFM	H87
3586202	KSEM245SEFM	H87
3586203	KSEM250SEFM	H87
3586204	KSEM255SEFM	H87
3586205	KSEM260SEFM	H87
3586206	KSEM265SEFM	H87
3586207	KSEM270SEFM	H87
3586208	KSEM275SEFM	H87
3586209	KSEM280SEFM	H87
3586210	KSEM285SEFM	H87
3586211	KSEM290SEFM	H87
3586212	KSEM295SEFM	H87
3586213	KSEM300SEFM	H87
3586214	KSEM305SEFM	H87
3586215	KSEM310SEFM	H87
3586216	KSEM315SEFM	H87
3586217	KSEM320SEFM	H87
3586519	KM32RBHT24	K122
3586520	KM32RBHT30	K122
3586521	KM40RBHT40	K122
3586522	KM50RBHT50	K122
3586543	KM50RBHT66	K122
3586544	KM50RBHT87	K122
3586545	KM63UTRBHT87	K122
3586546	KM63UTRBHT115	K122
3586547	HSK63RBHT24	K122
3586548	HSK63RBHT30	K122

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3586549	HSK63RBHT40	K122
3586550	HSK63RBHT50	K122
3586551	HSK63RBHT66	K122
3586563	HSK63RBHT87	K122
3586564	SF075RBHT24	K123
3586565	SF100RBHT30	K123
3586566	SF125RBHT40	K123
3586567	SF100RBHT50	K123
3586569	SF125RBHT66	K123
3586570	SF150RBHT87	K123
3586571	SF200RBHT115	K123
3586572	KM32FBHS24	K137
3586573	KM32FBHS31	K137
3586574	KM40FBHS40	K137
3586575	KM50FBHS51	K137
3586576	KM50FBHS67	K137
3586577	KM50FBHS87	K137
3586578	KM63UTFBHS87	K137
3586579	KM63UTFBHS116	K137
3586580	HSK63FBHS24	K137
3586581	HSK63FBHS31	K137
3586582	HSK63FBHS40	K137
3586583	HSK63FBHS51	K137
3586584	HSK63FBHS67	K137
3586585	HSK63FBHS87	K137
3586586	SF075FBHS24	K138
3586587	SF100FBHS31	K138
3586588	SF125FBHS40	K138
3586589	SF100FBHS51	K138
3586590	SF125FBHS67	K138
3586591	SF150FBHS87	K138
3586592	SF200FBHS116	K138
3586593	SSE075FBHS24	K139
3586594	SSE100FBHS31	K139
3586595	SSE125FBHS40	K139
3587211	881.252.250	K137–139
3587212	880.252.250	K137–139
3587695	880.252.320	K137–139
3587698	881.252.420	K137–138
3587699	880.252.420	K137–138
3587703	881.252.940	K137–138
3587704	841.342.200	K122–124
3587705	848.200.005	K125
3587706	848.200.407	K124–126
3587707	848.250.005	K125
3587708	848.250.409	K124–126
3587709	848.320.005	K125
3587710	848.320.413	K124–126
3587711	841.342.420	K122–123
3587712	848.420.005	K125
3587713	848.420.614	K124–126
3587714	841.142.550	K122–123
3587715	848.550.620	K124–126
3587716	848.550.005	K125
3587717	843.012.000	K124–126
3587718	844.012.000	K124–126
3587719	845.012.000	K124–126
3587720	846.012.000	K124–126
3587721	847.012.000	K124–126
3587722	841.142.720	K122–123
3587723	848.720.000	K124–126
3587724	848.720.005	K125
3587725	844.016.000	K124–126
3587726	845.016.000	K124–126
3587727	846.016.000	K124–126
3587728	847.016.000	K124–126
3587729	841.142.940	K122–123
3587730	848.940.640	K124, K126
3588387	KSEM1604HPGM KC7315	H54
3588680	KM63XMZKGMSLF65Y	C148
3592190	B978A05600 KC7315	G139
3593089	B978A04500 KC7315	G139
3593675	MS2206	U3
3593676	MS2207	U3
3593681	MS2208	U3
3593911	MS2205	T29–33, T40–43
3597589	MS2219	V36–38
3598160	B256A10200 KC7315	G58
3598188	B967A06500 KC7315	G131
3609446	KSEM2325HPGM KC7315	H55
3613696	MS2038CG	V62
3615883	B976A09400 KC7315	G136
3616778	KSEM3220HPGM KC7315	H55
3617131	RIQ06E1306 KC6305	K58
3636039	RPG2150E KYSP30	V157
3637915	D28TTB26KM40	B410
3637916	D32TTB29KM40	B410
3637917	D40TTB36KM40	B410
3638033	D48TTB45KM63	B410
3638034	D64TTB58KM63	B410
3638615	B256A05000 KC7315	G58
3638616	B256A05500 KC7315	G58
3638617	B256A05800 KC7315	G58
3638618	B256A06000 KC7315	G58
3638619	B256A06500 KC7315	G58
3638620	B256A06800 KC7315	G58
3638621	B256A07800 KC7315	G58
3638622	B256A08500 KC7315	G58
3638623	B256A09000 KC7315	G58
3638624	B256A10000 KC7315	G58
3638625	B256A11800 KC7315	G58
3638626	B256A12000 KC7315	G58
3638627	B256A13000 KC7315	G58
3638628	B256A15000 KC7315	G58
3639212	NG3062LEST KD1425	C177
3639213	NG3062REST KD1425	C177
3639214	NG3094LEST KD1425	C177
3639215	NG3094REST KD1425	C177
3639217	NG3125REST KD1425	C177
3639219	NG3189REST KD1425	C177
3639221	NGP3088R KD1425	C168
3639223	NGP3125R KD1425	C168
3639344	NG3062LEST KB1630	C177
3639345	NG3062REST KB1630	C177
3639346	NG3094LEST KB1630	C177
3639347	NG3094REST KB1630	C177
3639348	NG3125LEST KB1630	C177
3639349	NG3125REST KB1630	C177
3639350	NG4189LEST KB1630	C171, C177
3639351	NG4189REST KB1630	C177
3639762	SCMT3252MP KCP25	B247
3639874	SCMT3252MP KCU10	B247
3639875	DCMT3252MP KCK20	B226
3639877	DCMT3252MP KCP25	B226
3639878	DCMT3252MP KCU10	B226
3639881	TCMT3252MP KCP25	B258
3639883	TCMT3252MP KCU10	B258
3640677	B291A03000YPL KC7315	G88
3640678	B291A04000YPL KC7315	G88
3640679	B291A04500YPL KC7315	G88
3640680	B291A05000YPL KC7315	G88
3640681	B291A05100YPL KC7315	G88
3640682	B291A05500YPL KC7315	G88
3640703	B291A06000YPL KC7315	G88
3640704	B291A06350YPL KC7315	G89
3640705	B291A06500YPL KC7315	G89
3640706	B291A06800YPL KC7315	G89
3640707	B291A07000YPL KC7315	G89
3640708	B291A07500YPL KC7315	G89
3640709	B291A08000YPL KC7315	G89
3640710	B291A08334YPL KC7315	G89
3640711	B291A08500YPL KC7315	G89
3640712	B291A09000YPL KC7315	G89
3640713	B291A09500YPL KC7315	G89
3640714	B291A09525YPL KC7315	G89
3640715	B291A10000YPL KC7315	G89
3640716	B291A10320YPL KC7315	G89
3640717	B291A10500YPL KC7315	G89
3640718	B291A11000YPL KC7315	G89
3640719	B291A11500YPL KC7315	G89
3640720	B291A12000YPL KC7315	G90
3640721	B291A12500YPL KC7315	G90
3640722	B291A12700YPL KC7315	G90
3640723	B291A13000YPL KC7315	G90
3640724	B291A14000YPL KC7315	G90
3640725	B291A14500YPL KC7315	G90
3640726	B291A15000YPL KC7315	G90
3640727	B291A16000YPL KC7315	G90
3640728	B291A17000YPL KC7315	G90
3640729	B291A18000YPL KC7315	G90
3640730	B292A03000YPL KC7315	G88
3640731	B292A03175YPL KC7315	G88
3640732	B292A03500YPL KC7315	G88
3640743	B292A04000YPL KC7315	G88
3640744	B292A04200YPL KC7315	G88
3640745	B292A04300YPL KC7315	G88
3640746	B292A04500YPL KC7315	G88
3640747	B292A04800YPL KC7315	G88
3640748	B292A05000YPL KC7315	G88
3640749	B292A05100YPL KC7315	G88
3640750	B292A05200YPL KC7315	G88
3640751	B292A05410YPL KC7315	G88
3640752	B292A05500YPL KC7315	G88
3640753	B292A05558YPL KC7315	G88
3640754	B292A05600YPL KC7315	G88
3640755	B292A05800YPL KC7315	G88
3640756	B292A06000YPL KC7315	G88
3640757	B292A06350YPL KC7315	G89
3640758	B292A06500YPL KC7315	G89
3640759	B292A06528YPL KC7315	G89
3640760	B292A06746YPL KC7315	G89
3640761	B292A06800YPL KC7315	G89
3640762	B292A06900YPL KC7315	G89
3640763	B292A07000YPL KC7315	G89
3640764	B292A07100YPL KC7315	G89
3640765	B292A07145YPL KC7315	G89
3640766	B292A07500YPL KC7315	G89
3640767	B292A07938YPL KC7315	G89
3640768	B292A08000YPL KC7315	G89
3640769	B292A08334YPL KC7315	G89
3640770	B292A08433YPL KC7315	G89
3640771	B292A08500YPL KC7315	G89
3640772	B292A08733YPL KC7315	G89
3640773	B292A08800YPL KC7315	G89
3640774	B292A09000YPL KC7315	G89
3640775	B292A09200YPL KC7315	G89
3640776	B292A09347YPL KC7315	G89
3640777	B292A09500YPL KC7315	G89
3640778	B292A09525YPL KC7315	G89
3640779	B292A10000YPL KC7315	G89
3640780	B292A10200YPL KC7315	G89
3640781	B292A10320YPL KC7315	G89
3640782	B292A10500YPL KC7315	G89
3640783	B292A10716YPL KC7315	G89
3640784	B292A11000YPL KC7315	G89
3640785	B292A11112YPL KC7315	G89
3640786	B292A11500YPL KC7315	G89
3640787	B292A12000YPL KC7315	G90
3640788	B292A12304YPL KC7315	G90
3640789	B292A12500YPL KC7315	G90
3640790	B292A13000YPL KC7315	G90
3640791	B292A13500YPL KC7315	G90
3640792	B292A14000YPL KC7315	G90
3640793	B292A14500YPL KC7315	G90
3640794	B292A15000YPL KC7315	G90
3640795	B292A15500YPL KC7315	G90
3640796	B292A16000YPL KC7315	G90
3640797	B292A16500YPL KC7315	G90
3640798	B292A17000YPL KC7315	G90
3640799	B292A17500YPL KC7315	G90
3640800	B292A18000YPL KC7315	G90
3640801	B292A18500YPL KC7315	G90
3640802	B292A19000YPL KC7315	G90
3640803	B292A19050YPL KC7315	G90
3640806	B292A20000YPL KC7315	G90
3640807	B292A20500YPL KC7315	G90
3640808	B292A21000YPL KC7315	G90
3641465	DTQ3054	S94, S98, S100
3641473	BTQT25	S94, S98, S100
3641572	CRDPN162DV	B168, B386
3641593	CRDPN163DV	B168, B386
3641594	CRDPN203DV	B168, B386
3641595	CRDPN164DV	B168, B386
3641597	CRDPN204DV	B168, B386
3641603	CRGPR162DV	B169, B387
3641604	CRGPL162DV	B169, B387
3641608	CRGPL203DV	B169, B387
3641611	CRGPR204DV	B169, B387
3641712	EP1008EHD KC522M	T36, T46
3641734	EP1008EHD KC725M	T36, T46
3641735	EP1008EHD KCK15	T36, T46
3641736	EP1008EHD KCPK30	T36, T46
3641740	EP1004EHD KC522M	T36, T46
3641741	EP1004EHD KC725M	T36, T46
3641742	EP1004EHD KCK15	T36, T46
3641783	EP1004EHD KCPK30	T36, T46
3642028	EP1012EHD KC522M	T36, T46
3642029	EP1012EHD KC725M	T36, T46
3642031	EP1012EHD KCPK30	T36, T46
3642093	EP1016EHD KC522M	T36, T46
3642094	EP1016EHD KC725M	T36, T46
3642096	EP1016EHD KCPK30	T36, T46
3642097	EP1020EHD KC725M	T36, T46
3642098	EP1020EHD KCPK30	T36, T46
3642102	EP1024EHD KC725M	T36, T46
3642133	EP1024EHD KCPK30	T36, T46
3642136	EP1031EHD KC522M	T36, T46
3642137	EP1031EHD KC725M	T36, T46
3642138	EP1031EHD KCPK30	T36, T46
3642141	EP1004SGD KC725M	T37, T47
3642142	EP1004SGD KCK15	T37, T47
3642163	EP1004SGD KCPK30	T37, T47
3642170	EP1008SGD KC725M	T37, T47
3642171	EP1008SGD KCK15	T37, T47
3642172	EP1008SGD KCPK30	T37, T47
3642193	EP1012SGD KC725M	T37, T47
3642194	EP1012SGD KCK15	T37, T47
3642195	EP1012SGD KCPK30	T37, T47
3642196	EP1016SGD KC725M	T37, T47
3642198	EP1016SGD KCPK30	T37, T47
3643846	NPGR51R KD1425	E33
3643847	NPGR52L KD1425	E33
3643849	NPL505 KD1425	E35
3643850	NPR505 KD1425	E35
3643851	NPL508 KD1425	E35
3643852	NPR508 KD1425	E35
3643853	NPL51 KD1425	E35
3643854	NPR51 KD1425	E35
3643855	VPGN331 KD1425	B369, E38
3643856	VPGN332 KD1425	B369, E38
3643858	VPGR331 KD1425	B369, E38
3643859	VPGR332 KD1425	B369, E38
3643860	VPGR333 KD1425	B369, E38
3643862	DPGR432 KD1425	E32
3644073	DT7IP	T30–33, T41–43
3646911	SNMG866RM KC5010	B104
3648330	CPG421F KD1425	B363
3648331	CPG422F KD1425	B363
3648332	TPG221F KD1425	B367
3648428	DFT06T308D36MD KC7140	H113
3648430	DFT05T308D32MD KC7140	H113
3648474	DFT070408D45MD KC7140	H113
3648478	DFT090508D56MD KC7140	H113
3648584	TPG321F KD1425	B367
3648585	TPG322F KD1425	B367
3648588	TPG432F KD1425	B367
3649187	EC1008FLDJ KC410M	T35, T44
3649188	EC1008ELDJ KC422M	T35, T45
3649189	EC1008ELD KC520M	T36, T45
3649190	EC1008ELD KC522M	T36, T45
3649191	EC1008ELD KC725M	T36, T45
3649192	EC1008ELD KCPK30	T36, T45
3649213	EC1008ELD KCK15	T36, T45
3650831	SCMT432MP KCK20	B247
3650903	SCMT432MP KCP25	B247
3654372	SPET31251PPER8GB2 KC725M	T111, U31
3654503	SPET31251PPER8GB2 KCPK30	T111, U31
3654504	SPET31251PPER8GB2 KCK15	T111, U31
3654505	SPET31251PPEL8GB2 KC725M	T111, U31
3654506	SPET31251PPEL8GB2 KCPK30	T111, U31
3654507	SPET31251PPEL8GB2 KCK15	T111, U31
3655880	CNGA431FST KD1400	B362
3655881	CNGA432FST KD1400	B362
3655882	CNMS431FST KD1400	B363
3656063	CNMS432FST KD1400	B363
3656064	DNGA431FST KD1400	B365
3656065	DNGA432FST KD1400	B365
3656066	DNMS431FST KD1400	B365
3656067	DNMS432FST KD1400	B365
3656068	TNMS331FST KD1400	B366
3656069	TNMS332FST KD1400	B366

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3656070	VNGA331FST KD1400	B368
3656071	VNGA332FST KD1400	B368
3656072	VNMS331FST KD1400	B368
3656073	VNMS332FST KD1400	B368
3656449	CNGA431FST KD1425	B362
3656450	CNGA432FST KD1425	B362
3656452	CNMS432FST KD1425	B363
3656463	DNGA431FST KD1425	B365
3656464	DNGA432FST KD1425	B365
3656466	DNMS432FST KD1425	B365
3656467	TNMS331FST KD1425	B366
3656468	TNMS332FST KD1425	B366
3656470	VNGA332FST KD1425	B368
3656471	VNMS331FST KD1425	B368
3656472	VNMS332FST KD1425	B368
3656474	WNGA432FST KD1425	B369
3658815	AADE0250J3A K600	P128
3658816	AADE0250J3ARB K600	P128
3658817	AADE0250J3BRA K600	P128
3658818	AADE0250J3BRB K600	P128
3658819	AADE0250J3C K600	P128
3658820	AADE0250J3CRA K600	P128
3658821	AADE0250J3CRB K600	P128
3658824	AADE0375J3A K600	P128
3658825	AADE0375J3BRB K600	P128
3658826	AADE0375J3BRC K600	P128
3658827	AADE0375J3C K600	P129
3658828	AADE0375J3CRB K600	P129
3658829	AADE0375J3CRC K600	P129
3658830	AADE0500J3A K600	P129
3658831	AADE0500J3ARB K600	P129
3658832	AADE0500J3ARC K600	P129
3658833	AADE0500J3BRB K600	P129
3658834	AADE0500J3BRC K600	P129
3658835	AADE0500J3BRE K600	P129
3658836	AADE0500J3C K600	P129
3658837	AADE0500J3CRB K600	P129
3658838	AADE0500J3CRC K600	P129
3658839	AADE0500J3D K600	P129
3658840	AADE0500J3DRB K600	P129
3658841	AADE0500J3DRC K600	P129
3658843	AADE0625J3B K600	P130
3658845	AADE0750J3A K600	P130
3658846	AADE0750J3BRB K600	P130
3658847	AADE0750J3BRC K600	P130
3658848	AADE0750J3BRE K600	P130
3658849	AADE0750J3C K600	P130
3658850	AADE0750J3CRB K600	P130
3658851	AADE0750J3CRC K600	P130
3658852	AADE0750J3D K600	P130
3658863	AADE0750J3DRB K600	P130
3658864	AADE0750J3DRC K600	P130
3658865	AADE1000J3A K600	P130
3658866	AADE1000J3ARB K600	P130
3658869	AADE1000J3B K600	P130
3658871	AADE1000J3BRC K600	P130
3658872	AADE1000J3C K600	P130
3658873	AADE1000J3CRB K600	P130
3658874	AADE1000J3CRC K600	P130
3658875	AADF0125J2A K600	P126
3658877	AADF0188J2A K600	P126
3658879	AADF0250J2A K600	P126
3658881	AADF0250J2BRA K600	P126
3658882	AADF0250J2BRB K600	P126
3658893	AADF0250J2C K600	P126
3658901	AADF0375J2C K600	P126
3658902	AADF0375J2CRB K600	P126
3658903	AADF0375J2CRC K600	P126
3658904	AADF0500J2A K600	P126
3658907	AADF0500J2BRB K600	P127
3658910	AADF0500J2C K600	P127
3658911	AADF0500J2CRB K600	P127
3658912	AADF0500J2CRC K600	P127
3658913	AADF0500J2D K600	P127
3658920	AADF0750J2BRB K600	P127
3658923	AADF0750J2C K600	P127
3658924	AADF0750J2CRB K600	P127
3658929	AADF1000J2A K600	P127
3658934	AADF1000J2BRB K600	P127
3658936	AADF1000J2C K600	P127
3659963	CDHB120605FST KD1400	B362
3659964	CDHB1206X0FST KD1400	B362
3659965	CCGW2151FST KD1400	B362
3659966	CCGW3251FST KD1400	B362
3659967	CCGW3252FST KD1400	B362
3659968	CPGW21505FST KD1400	B364
3659969	CPGW2151FST KD1400	B364
3659970	CPGW2152FST KD1400	B364
3659971	CPGW3251FST KD1400	B364
3659972	CPGW3252FST KD1400	B364
3659975	CPGW2151FWST KD1400	B364
3659976	CPGW3252FWST KD1400	B364
3659977	CPGW432FWST KD1400	B364
3659978	DCGW2151FST KD1400	B364
3659979	DCGW3251FST KD1400	B364
3659980	DPGW21505FST KD1400	B366
3659981	DPGW2151FST KD1400	B366
3659982	DPGW3251FST KD1400	B366
3659985	TCGW2151FST KD1400	B366
3659986	TCGW3251FST KD1400	B366
3659987	TPGW2151FST KD1400	B367
3659988	TPGW2152FST KD1400	B367
3659990	TPGW3252FST KD1400	B367
3659991	VBGW221FST KD1400	B368
3659992	VBGW331FST KD1400	B368
3659994	CDHB120605FST KD1425	B362
3659996	CCGW2151FST KD1425	B362
3659997	CCGW3251FST KD1425	B362
3659998	CCGW3252FST KD1425	B362
3659999	CPGW21505FST KD1425	B364
3660000	CPGW2151FST KD1425	B364
3660001	CPGW2152FST KD1425	B364
3660002	CPGW3251FST KD1425	B364
3660003	CPGW3252FST KD1425	B364
3660006	CPGW2151FWST KD1425	B364
3660007	CPGW3252FWST KD1425	B364
3660008	CPGW432FWST KD1425	B364
3660009	DCGW2151FST KD1425	B364
3660010	DCGW3251FST KD1425	B364
3660011	DPGW21505FST KD1425	B366
3660012	DPGW2151FST KD1425	B366
3660013	DPGW3251FST KD1425	B366
3660015	DPGW3251FWST KD1425	B366
3660016	TCGW2151FST KD1425	B366
3660018	TPGW2151FST KD1425	B367
3660020	TPGW3251FST KD1425	B367
3660021	TPGW3252FST KD1425	B367
3660022	VBGW221FST KD1425	B368
3660023	VBGW331FST KD1425	B368
3660154	KSEMP1300HPGM KC7315	H111
3660156	KSEMP2000HPGM KC7315	H111
3660157	KSEMP3400HPGM KC7315	H111
3660396	ABDF0250J2AS K600	P116
3660397	ABDF0250J2ARB K600	P116
3660398	ABDF0312J2ARB K600	P116
3660399	ABDF0375J2AS K600	P116
3660400	ABDF0375J2ARB K600	P116
3660401	ABDE0250J3AS K600	P117
3660402	ABDE0250J3ARB K600	P117
3660423	ABDE0312J3ARB K600	P117
3660424	ABDE0375J3AS K600	P117
3660425	ABDE0375J3ARB K600	P117
3660426	ABDF0500J2AS K600	P116
3660427	ABDF0500J2ARB K600	P116
3660428	ABDF0500J2ARC K600	P116
3660429	ABDE0500J3AS K600	P117
3660430	ABDE0500J3ARB K600	P117
3660431	ABDE0500J3ARC K600	P117
3660432	ABDF0625J2AS K600	P116
3660433	ABDF0750J2AS K600	P116
3660434	ABDF0750J2ARB K600	P116
3660435	ABDF0750J2ARC K600	P116
3660436	ABDF0750J2ARE K600	P116
3660437	ABDF1000J2AS K600	P116
3660438	ABDF1000J2ARB K600	P116
3660439	ABDF1000J2ARC K600	P116
3660440	ABDF1000J2ARE K600	P116
3660441	ABDE0625J3AS K600	P117
3660442	ABDE0750J3AS K600	P117
3660443	ABDE0750J3ARB K600	P117
3660444	ABDE0750J3ARC K600	P117
3660445	ABDE0750J3ARE K600	P117
3660446	ABDE1000J3AS K600	P117
3660447	ABDE1000J3ARB K600	P117
3660448	ABDE1000J3ARC K600	P117
3660449	ABDE1000J3ARE K600	P117
3660590	CM214	B168–169, B386–387
3660591	CM219	B168–169, B386–387
3660592	CM216	B168–169, B386–387
3663324	KSSC709813RX	U35
3663325	KSSC709813LX	U35
3663326	KSSC813917RX	U36
3663327	KSSC813917LX	U36
3667056	SIF70HC12090M	K51
3667057	SIF70HC20100M	K51
3667058	SIF80HC12090M	K51
3667059	SIF80HC20100M	K51
3667060	SIF80HC25100M	K51
3667061	SIF100HC12090M	K51
3667062	SIF100HC20100M	K51
3667918	B707A11350FBG KC7315	G111
3668023	SIF100HC25100M	K51
3668057	B291A07200YPL KC7315	G89
3668058	B292A07200YPL KC7315	G89
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	H113
3669001	DFT06T308D39MD KC7140	H113
3669002	DFT06T308D44MD KC7140	H113
3669071	NST1	B168–169, B386–387
3669072	NST2	B168–169, B386–387
3669083	DFT070408D50MD KC7140	H113
3669084	DFT090508D63MD KC7140	H113
3669183	NST3	B168–169, B386–387
3682450	EC1004FLDJ KC410M	T35, T44
3682451	EC1004ELDJ KC422M	T35, T45
3682452	EC1004ELD KC520M	T36, T45
3682513	EC1004ELD KC522M	T36, T45
3682514	EC1004ELD KC725M	T36, T45
3682515	EC1004ELD KCPK30	T36, T45
3682520	EC1012FLDJ KC410M	T35, T44
3682653	EC1012ELD KC522M	T36, T45
3682655	EC1012ELD KC725M	T36, T45
3682777	EC1016FLDJ KC410M	T35, T44
3682778	EC1016ELDJ KC422M	T35, T45
3682780	EC1016ELD KC522M	T36, T45
3682781	EC1016ELD KC725M	T36, T45
3682782	EC1016ELD KCPK30	T36, T45
3683704	B707A03700FBG KC7315	G110
3683843	KSEM3975HPGM KC7315	H55
3684779	EC1002FLDJ KC410M	T35, T44
3684824	EC1031FLDJ KC410M	T35, T44
3684828	EC1031ELD KC725M	T36
3684829	EC1031ELD KCPK30	T36, T45
3690478	KSEMP1400HPGM KC7315	H111
3690479	KSEMP1500HPGM KC7315	H111
3690480	KSEMP1600HPGM KC7315	H111
3690481	KSEMP1700HPGM KC7315	H111
3690482	KSEMP1800HPGM KC7315	H111
3690713	KSEMP1900HPGM KC7315	H111
3690714	KSEMP2100HPGM KC7315	H111
3690715	KSEMP2200HPGM KC7315	H111
3690716	KSEMP2300HPGM KC7315	H111
3690717	KSEMP2400HPGM KC7315	H111
3690718	KSEMP2500HPGM KC7315	H111
3690719	KSEMP2600HPGM KC7315	H111
3690720	KSEMP2700HPGM KC7315	H111
3690721	KSEMP2800HPGM KC7315	H111
3690722	KSEMP2900HPGM KC7315	H111
3690723	KSEMP3000HPGM KC7315	H111
3690724	KSEMP3100HPGM KC7315	H111
3690725	KSEMP3200HPGM KC7315	H111
3690726	KSEMP3300HPGM KC7315	H111
3727352	ASPM07001802	T63–64
3732218	B707A05200FBG KC7315	G110
3732889	M1HR125E14W125Z2L200C4	T63, T72
3732890	M1HR150E14W125Z3L200C6	T63, T72
3732891	M1HR150E14W125Z3L250C9	T63, T72
3732892	M1HR150E14W125Z3L300C12	T63, T72
3732933	M1HR200E14S075Z3L200C6	T64, T72
3732934	M1HR200E14S075Z3L250C9	T64, T72
3732935	M1HR200E14W150Z3L300C12	T63, T72
3732937	M1HR250E14S100Z3L250C9	T64, T72
3732938	M1HR250E14S100Z4L250C12	T64, T72
3732939	M1HR250E14S100Z3L300C12	T64, T72
3733337	CNGA433S0420MT KB5630	B310, B330
3733417	DNGA431S0425MT KB5630	B310, B334
3737769	KSEM2110HPGM KC7315	H54
3738473	A4G0605M06U04GMN KCP25	C106
3738488	DV40BSIF80061M	K49
3738490	DV50BSIF70060M	K49
3738491	DV50BSIF100060M	K49
3738492	BT40BSIF80063M	K48
3738503	BT50BSIF70063M	K49
3738504	BT50BSIF100068M	K49
3738505	CV40BSIF80248	K48
3738506	CV50BSIF70236	K48
3738507	CV50BSIF100236	K48
3738508	HSK63ASIF70066M	K50
3738510	HSK80ASIF70066M	K50
3738511	HSK100ASIF70050M	K50
3738512	HSK100ASIF100070M	K50
3739296	B292A15600YPL KC7315	G90

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3742210	KSEMP3300FDS32A1M	H104, H115, H122
3742211	KSEMP5000FDS50A1M	H105, H116, H122
3742212	KSEMP7000FDS63A1M	H105, H116, H123
3742293	WD32FDS32321M	H127
3742294	WD50FDS50503M	H127
3742296	WD50FDS63779M	H127
3742470	M1D062E1002CM08	T29
3742471	M1D075E1002CM10	T29
3742472	M1D075E1003CM10	T29
3742513	M1D100E1003CM12	T29
3742514	M1D100E1004CM12	T29
3742516	M1D125E1005CM16	T29
3742517	M1D150E1006CM16	T29
3742518	M1D050E1001C062L350	T31
3742519	M1D062E1002C075L400	T31
3742520	M1D075E1002C075L450	T31
3742521	M1D075E1003C075L450	T31
3742522	M1D100E1003C100L480	T31
3742533	M1D100E1004C100L480	T31
3742534	M1D125E1004C125L520	T31
3742535	M1D125E1005C125L520	T31
3742536	M1D062E1002C062L670	T31
3742537	M1D062E1002C062L670R	T32
3742538	M1D075E1002C075L670	T31
3742540	M1D075E1003C075L670	T31
3742541	M1D075E1003C075L670R	T32
3742542	M1D088E1003C075L670	T31
3742543	M1D100E1003C100L800	T31
3742544	M1D100E1003C100L800R	T32
3742545	M1D100E1004C100L800	T31
3742546	M1D100E1004C100L800R	T32
3742547	M1D110E1004C100L800	T31
3742548	M1D125E1004C125L800	T31
3742550	M1D125E1005C125L800	T31
3742551	M1D125E1005C125L800R	T32
3742552	M1D062E1002W075L100	T30
3742553	M1D075E1002W075L110	T30
3742554	M1D075E1003W075L110	T30
3742555	M1D100E1003W100L125	T30
3742556	M1D100E1004W100L125	T30
3742557	M1D125E1004W125L160	T30
3742558	M1D125E1005W125L160	T30
3744865	CCMT2151MP KCM15	B191
3744872	DCMT3252MP KCM15	B226
3744873	SCMT3251MP KCM15	B247
3744874	SCMT3252MP KCM15	B247
3744878	SPMT3252MP KCM15	B253
3744880	TCMT3252MP KCM15	B258
3744884	CCMT2151MP KCP25	B191
3744886	CCMT3251MP KCP25	B191
3744887	CCMT3252MP KCP25	B191
3744888	CCMT3253MP KCP25	B191
3744890	CCMT432MP KCP25	B191
3744891	CCMT433MP KCP25	B191
3744893	CPMT3252MP KCP25	B207
3744895	DCMT3251MP KCP25	B226
3744896	DCMT3253MP KCP25	B226
3744897	DPMT3252MP KCP25	B233
3744898	SCMT3251MP KCP25	B247
3744900	SCMT433MP KCP25	B247
3744903	SPMT432MP KCP25	B253
3744904	TCMT2152MP KCP25	B258
3744906	TCMT3251MP KCP25	B258
3744907	TCMT3253MP KCP25	B258
3744908	TPMT2152MP KCP25	B269
3744909	TPMT3252MP KCP25	B269
3744910	TPMT3253MP KCP25	B269
3744911	VBMT331MP KCP25	B281
3744912	VBMT332MP KCP25	B281
3744917	CCMT2151MP KCM25	B191
3744918	CCMT3251MP KCM25	B191
3744919	CCMT3252MP KCM25	B191
3744920	CCMT3253MP KCM25	B191
3744923	CCMT433MP KCM25	B191
3744924	CPMT3252MP KCM25	B207
3744925	DCMT3252MP KCM25	B226
3744926	SCMT3251MP KCM25	B247
3744927	SCMT3252MP KCM25	B247
3744928	SCMT431MP KCM25	B247
3744929	SCMT432MP KCM25	B247
3744930	SCMT433MP KCM25	B247
3744931	TCMT3251MP KCM25	B258
3744932	TCMT3252MP KCM25	B258
3744935	VBMT331MP KCM25	B281
3744936	VBMT332MP KCM25	B281
3744940	CCMT2151MP KCP10	B191
3744941	CCMT3251MP KCP10	B191
3744942	CCMT3252MP KCP10	B191
3744943	CCMT432MP KCP10	B191
3744945	CPMT3252MP KCP10	B207
3744946	DCMT3251MP KCP10	B226
3744947	DCMT3252MP KCP10	B226
3744949	SCMT3252MP KCP10	B247
3744950	SCMT432MP KCP10	B247
3744951	TCMT3252MP KCP10	B258
3744955	CCMT3252MP KCK20	B191
3744956	CCMT432MP KCK20	B191
3744957	CCMT433MP KCK20	B191
3744958	CPMT3252MP KCK20	B207
3744962	SCMT3251MP KCK20	B247
3744965	SPMT3252MP KCK20	B253
3744974	VBMT332MP KCK20	B281
3744975	CCMT2151MP KCU10	B191
3744976	CCMT3251MP KCU10	B191
3744977	CCMT3252MP KCU10	B191
3744978	CCMT432MP KCU10	B191
3744979	CPMT2152MP KCU10	B207
3744980	CPMT3252MP KCU10	B207
3744981	DCMT3251MP KCU10	B226
3744982	DCMT3253MP KCU10	B226
3744983	DPMT3252MP KCU10	B233
3744984	SCMT3251MP KCU10	B247
3744985	SCMT431MP KCU10	B247
3744986	SCMT432MP KCU10	B247
3744987	SPMT3252MP KCU10	B253
3744988	SPMT432MP KCU10	B253
3744989	TCMT2152MP KCU10	B258
3744990	TCMT3251MP KCU10	B258
3745033	S449	T64
3745036	S464	T64
3745039	M1D150E1004S075L157	T33
3745040	M1D150E1006S075L157	T33
3745041	M1D200E1005S075L157	T33
3745042	M1D200E1008S075L157	T33
3745043	M1D250E1006S075L157	T33
3745045	M1D250E1009S075L157	T33
3745047	M1D300E1008S100L175	T33
3745048	M1D300E1010S100L175	T33
3745049	M1D400E1008S150L200	T33
3746074	DNMG331MN KCP05	B81
3746075	DNMG332MN KCP05	B81
3746077	DNMG433MN KCP05	B81
3746083	VNMG332MN KCP05	B146
3746085	CNMG433MW KCP05	B52
3746086	DNMG442MW KCP05	B82
3746087	TNMG332MW KCP05	B126
3746089	WNMG432MW KCP05	B160
3746090	DNMG432MW KCP05	B82
3746091	DNMG433MW KCP05	B82
3746092	DNMG443MW KCP05	B82
3746093	M1HR075ED10W075Z2L140C6	T41
3746097	M1HR100ED10W100Z2L180C8	T41
3746098	M1HR125ED10W125Z2L210C10	T41
3746099	M1HR125ED10W125Z3L210C15	T41
3746100	M1HR075ED10C075Z2L110C4	T42
3746101	M1HR100ED10C100Z2L110C4	T42
3746106	M1HR125ED10M16Z2L160C4	T40
3746107	M1HR125ED10M16Z3L160C6	T40
3746108	M1HR150ED10S075Z3L200C12	T43
3746109	M1HR150ED10S075Z5L200C20	T43
3746110	M1HR200ED10S075Z3L240C15	T43
3746111	M1HR200ED10S075Z5L240C25	T43
3746114	CNMG433RP KCP05	B53
3746116	DNMG442RP KCP05	B84
3746118	SNMG432RP KCP05	B105
3746119	SNMG433RP KCP05	B105
3746120	TNMG332RP KCP05	B127
3746121	TNMG333RP KCP05	B127
3746122	WNMG432RP KCP05	B161
3746123	WNMG433RP KCP05	B161
3746125	CCMT2151UF KCP05	B192
3746126	CCMT32505UF KCP05	B192
3746132	DCMT32505UF KCP05	B226
3746133	DCMT3251UF KCP05	B226
3746134	DCMT3252UF KCP05	B226
3746135	SCMT3252UF KCP05	B247
3746137	TPMT21505UF KCP05	B269
3746138	TPMT2151UF KCP05	B269
3747113	EP1010EHD KC522M	T36, T46
3747114	EP1010EHD KC725M	T36, T46
3747115	EP1010EHD KCK15	T36, T46
3747116	EP1010EHD KCPK30	T36, T46
3747124	KSHR250HN5345XC3	S20
3747125	KSHR300HN5345XC4	S20
3747126	KSHR400HN5345XC5	S20
3747127	KSHR500HN5345XC6	S20
3747128	KSHR600HN5345XC8	S20
3747140	CNGA431S0425MT KB5630	B310, B330
3747141	CNGA432S0425MT KB5630	B310, B330
3747142	CNGA433S0425MT KB5630	B310, B330
3747223	CNGA431S0425FWMT KB5630	B310, B330
3747224	CNGA432S0425FWMT KB5630	B310, B330
3747225	DNGA432S0425MT KB5630	B310, B334
3747226	VNGA331S0425MT KB5630	B313, B342
3747227	VNGA332S0425MT KB5630	B313, B342
3747228	RNG32S0815C KB5630	B337
3747231	CCGW21505S0415C KB5630	B311, B328
3747232	CCGW2151S0415C KB5630	B311, B328
3747233	CCGW3251S0415MT KB5630	B311, B328
3747234	CCGW3252S0415MT KB5630	B311, B328
3747237	CPGW3251S0415MT KB5630	B331
3747238	CPGW3252S0415MT KB5630	B331
3747239	DCGW21505S0415C KB5630	B311, B332
3747240	DCGW2151S0415C KB5630	B311, B332
3747241	DCGW3251S0415MT KB5630	B312, B332
3747242	DCGW3252S0415MT KB5630	B312, B332
3747244	TPGW2152S0415C KB5630	B312, B340
3747245	VBGW331S0415MT KB5630	B312, B341
3747246	VBGW332S0415MT KB5630	B312, B341
3748345	CNMG432CT KCP05	B48
3748348	DNMG332CT KCP05	B79
3748363	DNMG443CT KCP05	B79
3748366	CNMG431FF KCP05	B48
3748367	CNMG432FF KCP05	B48
3748368	DNMG332FF KCP05	B79
3748374	TNMG332FF KCP05	B123
3748375	VNMG331FF KCP05	B146
3748376	VNMG332FF KCP05	B146
3748377	CNMG431FW KCP05	B49
3748378	CNMG432FW KCP05	B49
3748379	CNMG433FW KCP05	B49
3748381	DNMG332FW KCP05	B80
3748383	DNMG432FW KCP05	B80
3748384	DNMG441FW KCP05	B80
3748385	DNMG442FW KCP05	B80
3748386	SNMG432FW KCP05	B102
3748388	TNMG331FW KCP05	B124
3748389	TNMG332FW KCP05	B124
3748390	TNMG333FW KCP05	B124
3748391	WNMG331FW KCP05	B158
3748392	WNMG332FW KCP05	B158
3748394	WNMG431FW KCP05	B158
3748395	WNMG432FW KCP05	B158
3748396	WNMG433FW KCP05	B158
3748397	CCMT2152LF KCP05	B191
3748401	CPMT3251LF KCP05	B207
3748422	VBMT221LF KCP05	B281
3748423	VBMT222LF KCP05	B281
3748425	VBMT332LF KCP05	B281
3749127	HNGJ535ANSNHD KC520M	S19, S22
3749128	HNGJ53511ANSNHD KC520M	S19, S22
3749198	CNMG433MW KCP10	B52
3749200	DNMG442MW KCP10	B82
3749253	SNMG433MW KCP10	B104
3749254	TNMG332MW KCP10	B126
3749255	TNMG333MW KCP10	B126
3749256	WNMG332MW KCP10	B160
3749258	WNMG432MW KCP10	B160
3749259	CNMG431RP KCP10	B53
3749260	CNMG433RP KCP10	B53
3749261	CNMG434RP KCP10	B53
3749262	CNMG542RP KCP10	B53
3749263	CNMG543RP KCP10	B53
3749264	CNMG544RP KCP10	B53
3749266	CNMG644RP KCP10	B53
3749267	DNMG332RP KCP10	B84
3749269	DNMG432RP KCP10	B84
3749271	DNMG442RP KCP10	B84
3749272	DNMG443RP KCP10	B84
3749273	DNMG444RP KCP10	B84
3749274	RCMT1204M0RP KCP10	B242
3749277	SNMG432RP KCP10	B105
3749278	SNMG433RP KCP10	B105
3749279	SNMG434RP KCP10	B105
3749282	SNMG643RP KCP10	B105
3749283	SNMG644RP KCP10	B105
3749284	TNMG332RP KCP10	B127
3749285	TNMG333RP KCP10	B127
3749286	TNMG334RP KCP10	B127
3749288	TNMG433RP KCP10	B127
3749289	TNMG434RP KCP10	B127
3749290	TNMG543RP KCP10	B127
3749291	VNMG332RP KCP10	B148
3749292	VNMG333RP KCP10	B148
3749293	WNMG332RP KCP10	B161
3749294	WNMG333RP KCP10	B161
3749295	WNMG432RP KCP10	B161
3749296	WNMG433RP KCP10	B161
3749297	WNMG434RP KCP10	B161
3749298	CCMT2151UF KCP10	B192
3749299	CCMT32505UF KCP10	B192
3749300	CCMT3251UF KCP10	B192
3749307	DCMT3252UF KCP10	B226
3749309	DPMT3251UF KCP10	B233
3749310	DPMT3252UF KCP10	B233
3749311	SCMT3252UF KCP10	B247
3749318	TPMT3252UF KCP10	B269
3749336	CNMG434CT KCP10	B48
3749337	DNMG332CT KCP10	B79
3749338	DNMG431CT KCP10	B79
3749339	DNMG432CT KCP10	B79
3749341	DNMG441CT KCP10	B79
3749342	DNMG442CT KCP10	B79
3749344	DNMG443CT KCP10	B79
3749347	CNMG431FF KCP10	B48
3749348	CNMG432FF KCP10	B48
3749349	DNMG332FF KCP10	B79
3749350	DNMG431FF KCP10	B79
3749352	DNMG442FF KCP10	B79
3749353	SNMG322FF KCP10	B101
3749355	TNMG331FF KCP10	B123
3749357	VNMG331FF KCP10	B146
3749358	VNMG332FF KCP10	B146
3749359	CNMG431FW KCP10	B49
3749360	CNMG432FW KCP10	B49
3749361	CNMG433FW KCP10	B49
3749362	DNMG331FW KCP10	B80
3749363	DNMG332FW KCP10	B80
3749364	DNMG431FW KCP10	B80
3749367	DNMG442FW KCP10	B80
3749368	SNMG432FW KCP10	B102
3749369	SNMG433FW KCP10	B102
3749370	TNMG331FW KCP10	B124
3749374	WNMG332FW KCP10	B158
3749375	WNMG333FW KCP10	B158
3749376	WNMG431FW KCP10	B158

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3749377	WNMG432FW KCP10	B158
3749378	WNMG433FW KCP10	B158
3749379	CCMT2152LF KCP10	B191
3749380	CCMT432LF KCP10	B191
3749381	CPMT2151LF KCP10	B207
3749382	CPMT2152LF KCP10	B207
3749383	CPMT3251LF KCP10	B207
3749384	CPMT3252LF KCP10	B207
3749386	DCMT2151LF KCP10	B225
3749387	DCMT3252LF KCP10	B225
3749388	DCMT3253LF KCP10	B225
3749389	DCMT431LF KCP10	B225
3749390	DCMT432LF KCP10	B225
3749391	DPMT2151LF KCP10	B232
3749392	DPMT3251LF KCP10	B232
3749393	DPMT3252LF KCP10	B232
3749394	SCMT3251LF KCP10	B246
3749395	SCMT3252LF KCP10	B246
3749396	SCMT431LF KCP10	B246
3749399	SPMT3251LF KCP10	B252
3749401	TCMT2151LF KCP10	B257
3749402	TCMT2152LF KCP10	B257
3749403	TCMT3251LF KCP10	B257
3749404	TCMT3252LF KCP10	B257
3749408	TPMT2151LF KCP10	B268
3749410	TPMT3251LF KCP10	B268
3749412	VBMT221LF KCP10	B281
3749413	VBMT222LF KCP10	B281
3749414	VBMT331LF KCP10	B281
3749415	VBMT332LF KCP10	B281
3749416	WPMT2151LF KCP10	B288
3749422	CCMT2151MF KCP10	B191
3749444	CCMT3253MF KCP10	B191
3749447	CPMT3252MF KCP10	B207
3749449	DCMT3251MF KCP10	B226
3749450	DCMT3252MF KCP10	B226
3749451	DCMT3253MF KCP10	B226
3749453	SCMT3252MF KCP10	B247
3749454	SCMT432MF KCP10	B247
3749455	SCMT433MF KCP10	B247
3749456	SPMT3252MF KCP10	B253
3749459	TCMT3252MF KCP10	B258
3749460	TCMT3253MF KCP10	B258
3749462	TPMT3252MF KCP10	B268
3749463	CNMG321MN KCP10	B50
3749464	CNMG322MN KCP10	B50
3749465	CNMG431MN KCP10	B50
3749466	CNMG434MN KCP10	B50
3749467	CNMG542MN KCP10	B50
3749468	CNMG543MN KCP10	B50
3749469	CNMG544MN KCP10	B50
3749470	CNMG642MN KCP10	B50
3749471	CNMG643MN KCP10	B50
3749474	DNMG332MN KCP10	B81
3749475	DNMG333MN KCP10	B81
3749476	DNMG431MN KCP10	B81
3749479	DNMG441MN KCP10	B81
3749480	DNMG443MN KCP10	B81
3749481	DNMG444MN KCP10	B81
3749483	SNMG322MN KCP10	B102
3749484	SNMG323MN KCP10	B102
3749486	SNMG432MN KCP10	B102
3749487	SNMG433MN KCP10	B102
3749490	SNMG643MN KCP10	B102
3749491	TNMG331MN KCP10	B124
3749493	TNMG431MN KCP10	B124
3749494	TNMG432MN KCP10	B124
3749496	VNMG331MN KCP10	B146
3749497	VNMG332MN KCP10	B146
3749498	VNMG333MN KCP10	B146
3749499	WNMG331MN KCP10	B159
3749500	WNMG332MN KCP10	B159
3749501	WNMG333MN KCP10	B159
3749502	WNMG433MN KCP10	B159
3749503	CNMP432K KCP10	B57
3749507	TNMP332K KCP10	B129
3749508	VNMP332K KCP10	B149
3750568	B292A09600YPL KC7315	G89
3751151	DNMG331FF KCP05	B79
3751152	DNMG432FF KCP05	B79
3751405	RCMT1204M0RP KCK20	B242
3751406	RCMT2006M0RP KCK20	B242
3751474	CNMG431FN KCP05	B49
3751475	CNMG432FN KCP05	B49
3751477	DNMG331FN KCP05	B79
3751478	DNMG332FN KCP05	B79
3751479	DNMG333FN KCP05	B79
3751480	DNMG431FN KCP05	B79
3751481	DNMG432FN KCP05	B79
3751482	DNMG433FN KCP05	B79
3751483	DNMG441FN KCP05	B79
3751484	DNMG442FN KCP05	B79
3751485	DNMG443FN KCP05	B79
3751486	SNMG431FN KCP05	B101
3751488	TNMG331FN KCP05	B123
3751490	TNMG333FN KCP05	B123
3751492	VNMG331FN KCP05	B146
3751493	VNMG332FN KCP05	B146
3751494	WNMG431FN KCP05	B157
3751495	WNMG432FN KCP05	B157
3751498	CCMT3252LF KCP05	B191
3751499	DCMT3251LF KCP05	B225
3751500	CNMG432MN KCP05	B50
3751501	CNMG433MN KCP05	B50
3751505	TNMG332MN KCP05	B124
3751506	WNMG432MN KCP05	B159
3751507	CNMG432MW KCP05	B52
3751508	WNMG433MW KCP05	B160
3751509	CNMG432RN KCP05	B53
3751511	CNMG432RP KCP05	B53
3751512	CNMM432RP KCP05	B56
3751519	CNMG643 KCP25	B47
3751520	CNMG644 KCP25	B47
3751521	CNMG866 KCP25	B47
3751522	RNMG64 KCP25	B97
3751546	SNMG866 KCP25	B100
3751547	TNMG666 KCP25	B122
3751548	RCMT0602M0 KCP25	B240
3751549	RCMT0803M0 KCP25	B240
3751550	RCMT10T3M0 KCP25	B240
3751551	RCMT1605M0 KCP25	B240
3751552	RCMT2006M0 KCP25	B240
3751553	RCMT215 KCP25	B240
3751554	RCMT325 KCP25	B240
3751555	CNMG432CT KCP25	B48
3751556	CNMG433CT KCP25	B48
3751557	DNMG431CT KCP25	B79
3751558	DNMG432CT KCP25	B79
3751559	DNMG442CT KCP25	B79
3751560	DNMG443CT KCP25	B79
3751561	CCMT2151FW KCP25	B190
3751562	CCMT2152FW KCP25	B190
3751563	CCMT3251FW KCP25	B190
3751564	CCMT3252FW KCP25	B190
3751566	CPMT2152FW KCP25	B206
3751567	CPMT3251FW KCP25	B206
3751568	CPMT3252FW KCP25	B206
3751569	DCMT3251FW KCP25	B225
3751570	DCMT3252FW KCP25	B225
3751571	DPMT2151FW KCP25	B232
3751575	CCMT2152LF KCP25	B191
3751576	CCMT432LF KCP25	B191
3751577	CPMT2151LF KCP25	B207
3751578	CPMT2152LF KCP25	B207
3751579	CPMT3251LF KCP25	B207
3751580	CPMT3252LF KCP25	B207
3751581	DCMT2151LF KCP25	B225
3751582	DCMT3252LF KCP25	B225
3751583	DCMT3253LF KCP25	B225
3751585	DCMT432LF KCP25	B225
3751586	DPMT2151LF KCP25	B232
3751587	DPMT3251LF KCP25	B232
3751588	DPMT3252LF KCP25	B232
3751589	SCMT3251LF KCP25	B246
3751590	SCMT3252LF KCP25	B246
3751591	SCMT431LF KCP25	B246
3751592	SCMT432LF KCP25	B246
3751594	SPMT3251LF KCP25	B252
3751595	SPMT3252LF KCP25	B252
3751596	TCMT2151LF KCP25	B257
3751597	TCMT2152LF KCP25	B257
3751598	TCMT3251LF KCP25	B257
3751599	TCMT3252LF KCP25	B257
3751600	TCMT3253LF KCP25	B257
3751601	TCMT432LF KCP25	B257
3751602	TPMT18151LF KCP25	B268
3751603	TPMT2151LF KCP25	B268
3751604	TPMT2152LF KCP25	B268
3751605	TPMT3251LF KCP25	B268
3751606	TPMT3252LF KCP25	B268
3751607	VBMT221LF KCP25	B281
3751608	VBMT222LF KCP25	B281
3751609	VBMT331LF KCP25	B281
3751610	VBMT332LF KCP25	B281
3751611	WPMT3251LF KCP25	B288
3751615	CCMT3252MW KCP25	B192
3751616	CCMT431MW KCP25	B192
3751617	CCMT432MW KCP25	B192
3751618	CNMG433MW KCP25	B52
3751620	CPMT3252MW KCP25	B208
3751622	DCMT3252MW KCP25	B226
3751633	DNMG432MW KCP25	B82
3751635	DNMG442MW KCP25	B82
3751636	DNMG443MW KCP25	B82
3751637	SNMG432MW KCP25	B104
3751639	TNMG332MW KCP25	B126
3751640	TNMG333MW KCP25	B126
3751641	WNMG332MW KCP25	B160
3751643	WNMG432MW KCP25	B160
3751644	CNMG431RP KCP25	B53
3751645	CNMG433RP KCP25	B53
3751646	CNMG434RP KCP25	B53
3751647	CNMG542RP KCP25	B53
3751648	CNMG543RP KCP25	B53
3751649	CNMG544RP KCP25	B53
3751650	CNMG643RP KCP25	B53
3751652	CNMM866RP KCP25	B56
3751655	DNMG432RP KCP25	B84
3751656	DNMG433RP KCP25	B84
3751657	DNMG442RP KCP25	B84
3751658	DNMG443RP KCP25	B84
3751659	DNMG444RP KCP25	B84
3751661	RCGT1204M0RP KCP25	B239
3751673	RCMT1204M0RP KCP25	B242
3751674	RCMT1606M0RP KCP25	B242
3751675	RCMT2006M0RP KCP25	B242
3751677	RCMX2507M0RP KCP25	B242
3751679	SNMG432RP KCP25	B105
3751680	SNMG433RP KCP25	B105
3751681	SNMG543RP KCP25	B105
3751682	SNMG544RP KCP25	B105
3751685	SNMM856RP KCP25	B107
3751686	SNMM866RP KCP25	B107
3751687	TNMG332RP KCP25	B127
3751688	TNMG333RP KCP25	B127
3751689	TNMG432RP KCP25	B127
3751692	TNMG543RP KCP25	B127
3751694	TNMG666RP KCP25	B127
3751695	VNMG332RP KCP25	B148
3751696	VNMG333RP KCP25	B148
3751697	WNMG332RP KCP25	B161
3751698	WNMG333RP KCP25	B161
3751699	WNMG432RP KCP25	B161
3751700	WNMG433RP KCP25	B161
3751701	WNMG434RP KCP25	B161
3751702	CCMT2151UF KCP25	B192
3751703	CCMT3251UF KCP25	B192
3751705	CPMT2151UF KCP25	B208
3751706	CPMT3251UF KCP25	B208
3751707	DCMT2151UF KCP25	B226
3751710	DCMT3252UF KCP25	B226
3751711	DPMT2151UF KCP25	B233
3751712	TCMT2151UF KCP25	B258
3751714	TCMT3252UF KCP25	B258
3751715	CNMM432RM KCP25	B55
3751716	CNMM433RM KCP25	B55
3751718	CNMM543RM KCP25	B55
3751719	CNMM544RM KCP25	B55
3751721	CNMM643RM KCP25	B55
3751722	CNMM644RM KCP25	B55
3751733	CNMM646RM KCP25	B55
3751734	DNMM432RM KCP25	B85
3751737	DNMM443RM KCP25	B85
3751738	DNMM444RM KCP25	B85
3751739	SNMM432RM KCP25	B107
3751741	SNMM433RM KCP25	B107
3751743	SNMM543RM KCP25	B107
3751744	SNMM544RM KCP25	B107
3751745	SNMM643RM KCP25	B107
3751746	SNMM644RM KCP25	B107
3751747	SNMM646RM KCP25	B107
3751748	TNMM332RM KCP25	B128
3751749	TNMM333RM KCP25	B128
3751751	TNMM433RM KCP25	B128
3751753	TNMM543RM KCP25	B128
3751754	TNMM544RM KCP25	B128
3751755	CNMG432RN KCP25	B53
3751756	CNMG434RN KCP25	B53
3751757	CNMG432RP KCP25	B53
3751759	CNMM433RP KCP25	B56
3751760	CNMM434RP KCP25	B56
3751762	CNMM543RP KCP25	B56
3751763	CNMM544RP KCP25	B56
3751764	CNMM643RP KCP25	B56
3751765	CNMM644RP KCP25	B56
3751766	CNMM646RP KCP25	B56
3751767	DNMM442RP KCP25	B85
3751768	DNMM443RP KCP25	B85
3751769	DNMM444RP KCP25	B85
3751770	SNMM432RP KCP25	B107
3751771	SNMM433RP KCP25	B107
3751772	SNMM543RP KCP25	B107
3751773	SNMM643RP KCP25	B107
3751775	SNMM646RP KCP25	B107
3751777	TNMM433RP KCP25	B129
3751805	RNMG64 KCP40	B97
3751808	SNMG644 KCP40	B100
3751809	SNMG866 KCP40	B100
3751810	TNMG666 KCP40	B122
3751811	CNMG432MN KCP40	B50
3751812	CNMG433MN KCP40	B50
3751814	DNMG432MN KCP40	B81
3751816	DNMG442MN KCP40	B81
3751818	SNMG432MN KCP40	B102
3751819	SNMG433MN KCP40	B102
3751823	TNMG333MN KCP40	B124
3751824	TNMG432MN KCP40	B124
3751826	WNMG432MN KCP40	B159
3751828	CNMG432RP KCP40	B53
3751829	CNMG433RP KCP40	B53
3751830	CNMG543RP KCP40	B53
3751833	CNMM432RP KCP40	B56
3751837	CNMM543RP KCP40	B56
3751847	SNMG433RP KCP40	B105
3751848	SNMG543RP KCP40	B105
3751850	SNMG644RP KCP40	B105
3751854	SNMM643RP KCP40	B107
3751855	SNMM644RP KCP40	B107
3751856	SNMM856RP KCP40	B107
3751858	TNMG433RP KCP40	B127
3751859	TNMG666RP KCP40	B127
3751862	CNMG432RP KCK05	B53
3751873	CNMG431UN KCK05	B54
3751874	CNMG432UN KCK05	B54
3751875	CNMG433UN KCK05	B54
3751882	CNMG644UN KCK05	B54
3751896	CNMA432 KCK05	B47
3751898	CNMA433 KCK05	B47
3751899	CNMA434 KCK05	B47
3751906	CNMA643 KCK05	B47
3751908	TNMG332UN KCK05	B127
3751909	DNMA332 KCK05	B78
3751910	DNMA432 KCK05	B78
3751911	TNMG333UN KCK05	B127
3751912	DNMA433 KCK05	B78
3751915	DNMA442 KCK05	B78
3751931	TNMA432 KCK05	B122
3751934	VNMA332 KCK05	B145
3751938	WNMA432 KCK05	B157
3751944	CNMG322FN KCK05	B49
3751945	CNMG431FN KCK05	B49
3751946	CNMG432FN KCK05	B49
3751950	DNMG331FN KCK05	B79
3751951	WNMG433UN KCK05	B162
3751952	DNMG332FN KCK05	B79
3751955	DNMG431FN KCK05	B79
3751956	DNMG432FN KCK05	B79
3751957	DNMG432UN KCK05	B84

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3751958	DNMG433FN KCK05	B79
3751959	DNMG441FN KCK05	B79
3751960	DNMG442FN KCK05	B79
3751961	DNMG443FN KCK05	B79
3751963	SNMG322FN KCK05	B101
3751964	SNMG431FN KCK05	B101
3751970	TNMG331FN KCK05	B123
3751971	TNMG332FN KCK05	B123
3751972	TNMG333FN KCK05	B123
3751974	VNMG331FN KCK05	B146
3751975	VNMG332FN KCK05	B146
3751976	WNMG331FN KCK05	B157
3751978	WNMG431FN KCK05	B157
3751979	WNMG432FN KCK05	B157
3751980	CCMT2151LF KCK05	B191
3751981	CCMT3251LF KCK05	B191
3751982	CCMT3252LF KCK05	B191
3751985	DCMT3251LF KCK05	B225
3751986	CCMT2152LF KCK15	B191
3751987	CCMT432LF KCK15	B191
3751988	CPMT2151LF KCK15	B207
3751989	CPMT2152LF KCK15	B207
3751991	CPMT3252LF KCK15	B207
3751992	DCMT3252LF KCK15	B225
3752013	SCMT3252LF KCK15	B246
3752014	SCMT432LF KCK15	B246
3752015	SPMT3252LF KCK15	B252
3752016	TCMT2151LF KCK15	B257
3752017	TCMT2152LF KCK15	B257
3752018	TCMT3251LF KCK15	B257
3752019	TCMT3252LF KCK15	B257
3752020	TCMT3253LF KCK15	B257
3752021	TPMT18151LF KCK15	B268
3752024	TPMT3251LF KCK15	B268
3752025	TPMT3252LF KCK15	B268
3752026	VBMT331LF KCK15	B281
3752027	VBMT332LF KCK15	B281
3752028	CCMT2151MF KCK15	B191
3752029	CCMT3251MF KCK15	B191
3752030	CCMT3253MF KCK15	B191
3752031	CCMT433MF KCK15	B191
3752032	CPMT2152MF KCK15	B207
3752033	CPMT3252MF KCK15	B207
3752035	DCMT3251MF KCK15	B226
3752036	DCMT3252MF KCK15	B226
3752037	DCMT3253MF KCK15	B226
3752039	SCMT3252MF KCK15	B247
3752040	SCMT432MF KCK15	B247
3752041	SCMT433MF KCK15	B247
3752042	SPMT3252MF KCK15	B253
3752043	SPMT432MF KCK15	B253
3752044	TCMT2152MF KCK15	B258
3752045	TCMT3252MF KCK15	B258
3752047	TPMT2152MF KCK15	B268
3752048	TPMT3252MF KCK15	B268
3752049	TPMT3253MF KCK15	B268
3752050	CNMG433RP KCK15	B53
3752052	CNMG543RP KCK15	B53
3752053	CNMG643RP KCK15	B53
3752057	DNMG443RP KCK15	B84
3752058	RCMT1204M0RP KCK15	B242
3752059	RCMT1606M0RP KCK15	B242
3752061	SNMG433RP KCK15	B105
3752066	TNMG434RP KCK15	B127
3752067	VNMG332RP KCK15	B148
3752068	VNMG333RP KCK15	B148
3752069	WNMG432RP KCK15	B161
3752070	WNMG433RP KCK15	B161
3752072	CCMT2152LF KCK05	B191
3752074	CPMT2151LF KCK05	B207
3752075	CPMT2152LF KCK05	B207
3752076	CPMT3251LF KCK05	B207
3752077	CPMT3252LF KCK05	B207
3752079	DCMT3252LF KCK05	B225
3752083	DPMT2151LF KCK05	B232
3752084	DPMT3251LF KCK05	B232
3752086	SCMT3251LF KCK05	B246
3752087	SCMT3252LF KCK05	B246
3752089	SCMT432LF KCK05	B246
3752093	TCMT2151LF KCK05	B257
3752094	TCMT2152LF KCK05	B257
3752095	TCMT3251LF KCK05	B257
3752099	TPMT18151LF KCK05	B268
3752102	TPMT3251LF KCK05	B268
3752103	TPMT3252LF KCK05	B268
3752106	VBMT221LF KCK05	B281
3752107	VBMT222LF KCK05	B281
3752109	VBMT332LF KCK05	B281
3752110	VBMT333LF KCK05	B281
3752113	WPMT3252LF KCK05	B288
3752114	CNMG433RP KCK05	B53
3752115	CNMG543RP KCK05	B53
3752117	DNMG432RP KCK05	B84
3752119	DNMG443RP KCK05	B84
3752121	SNMG433RP KCK05	B105
3752122	TNMG332RP KCK05	B127
3752124	WNMG432RP KCK05	B161
3752125	WNMG433RP KCK05	B161
3752127	CNMA431 KCK15	B47
3752128	CNMA432 KCK15	B47
3752129	CNMA433 KCK15	B47
3752130	CNMA434 KCK15	B47
3752131	CNMA542 KCK15	B47
3752132	CNMA543 KCK15	B47
3752143	CNMA544 KCK15	B47
3752144	CNMA643 KCK15	B47
3752145	DNMA432 KCK15	B78
3752146	DNMA433 KCK15	B78
3752147	DNMA442 KCK15	B78
3752152	SNMA433 KCK15	B100
3752157	TNMA332 KCK15	B122
3752158	TNMA333 KCK15	B122
3752159	TNMA334 KCK15	B122
3752163	TNMA544 KCK15	B122
3752164	VNMA332 KCK15	B145
3752165	WNMA332 KCK15	B157
3752167	WNMA432 KCK15	B157
3752168	WNMA433 KCK15	B157
3752170	CCMT2151LF KCK15	B191
3752171	CCMT3251LF KCK15	B191
3752172	CCMT3252LF KCK15	B191
3752173	DCMT3251LF KCK15	B225
3752174	CCMT3252MF KCK15	B191
3752175	CCMT432MF KCK15	B191
3752176	CNMG432RP KCK15	B53
3752177	CNMG431UN KCK15	B54
3752178	CNMG432UN KCK15	B54
3752179	CNMG433UN KCK15	B54
3752181	CNMG542UN KCK15	B54
3752182	CNMG543UN KCK15	B54
3752183	CNMG544UN KCK15	B54
3752184	CNMG642UN KCK15	B54
3752185	CNMG643UN KCK15	B54
3752186	CNMG644UN KCK15	B54
3752187	DNMG332UN KCK15	B84
3752188	DNMG333UN KCK15	B84
3752189	DNMG432UN KCK15	B84
3752192	DNMG442UN KCK15	B84
3752193	DNMG443UN KCK15	B84
3752196	SNMG432UN KCK15	B106
3752200	SNMG544UN KCK15	B106
3752201	SNMG643UN KCK15	B106
3752203	TNMG332UN KCK15	B127
3752207	TNMG433UN KCK15	B127
3752209	VNMG331UN KCK15	B148
3752210	VNMG332UN KCK15	B148
3752211	WNMG332UN KCK15	B162
3752213	WNMG431UN KCK15	B162
3752214	WNMG432UN KCK15	B162
3752215	WNMG433UN KCK15	B162
3753009	B291A05600YPL KC7315	G88
3753162	DNMG331FF KCP10	B79
3753203	DNMG432FF KCP10	B79
3753206	WNMG331FF KCP10	B157
3753207	WNMG332FF KCP10	B157
3753208	WNMG432FF KCP10	B157
3753209	CNMG321FN KCP10	B49
3753210	CNMG322FN KCP10	B49
3753211	CNMG431FN KCP10	B49
3753212	CNMG432FN KCP10	B49
3753214	CNMG434FN KCP10	B49
3753215	DNMG331FN KCP10	B79
3753216	DNMG332FN KCP10	B79
3753218	DNMG431FN KCP10	B79
3753219	DNMG432FN KCP10	B79
3753221	DNMG441FN KCP10	B79
3753222	DNMG442FN KCP10	B79
3753223	DNMG443FN KCP10	B79
3753225	SNMG322FN KCP10	B101
3753227	SNMG432FN KCP10	B101
3753228	SNMG433FN KCP10	B101
3753229	SNMG434FN KCP10	B101
3753231	TNMG222FN KCP10	B123
3753232	TNMG331FN KCP10	B123
3753233	TNMG332FN KCP10	B123
3753238	VNMG331FN KCP10	B146
3753239	VNMG332FN KCP10	B146
3753240	WNMG331FN KCP10	B157
3753241	WNMG332FN KCP10	B157
3753242	WNMG431FN KCP10	B157
3753243	WNMG432FN KCP10	B157
3753244	CCMT2151LF KCP10	B191
3753245	CCMT3251LF KCP10	B191
3753246	CCMT3252LF KCP10	B191
3753247	CCMT431LF KCP10	B191
3753248	CCMT433LF KCP10	B191
3753249	DCMT3251LF KCP10	B225
3753251	CCMT432MF KCP10	B191
3753252	CNMG432MN KCP10	B50
3753253	CNMG433MN KCP10	B50
3753254	DNMG432MN KCP10	B81
3753255	DNMG442MN KCP10	B81
3753256	TNMG332MN KCP10	B124
3753257	WNMG432MN KCP10	B159
3753288	CNMG433RN KCP10	B53
3753292	CNMG543RN KCP10	B53
3753293	CNMG544RN KCP10	B53
3753295	CNMG643RN KCP10	B53
3753298	DNMG432RN KCP10	B83
3753301	DNMG442RN KCP10	B83
3753302	DNMG443RN KCP10	B83
3753303	DNMG444RN KCP10	B83
3753307	CNMG432MW KCP10	B52
3753308	RNMG43RN KCP10	B97
3753311	RNMG86RN KCP10	B97
3753312	SNMG333RN KCP10	B105
3753313	SNMG432RN KCP10	B105
3753314	WNMG433MW KCP10	B160
3753315	SNMG433RN KCP10	B105
3753319	CNMM646RH KCP10	B55
3753321	SNMG542RN KCP10	B105
3753322	SNMM644RH KCP10	B106
3753323	SNMM646RH KCP10	B106
3753325	CNMM432RM KCP10	B55
3753326	CNMM433RM KCP10	B55
3753328	CNMM543RM KCP10	B55
3753329	CNMM544RM KCP10	B55
3753331	CNMM546RM KCP10	B55
3753332	CNMM643RM KCP10	B55
3753333	CNMM644RM KCP10	B55
3753334	SNMG644RN KCP10	B105
3753335	DNMM442RM KCP10	B85
3753336	DNMM443RM KCP10	B85
3753337	TNMG332RN KCP10	B126
3753339	SNMM543RM KCP10	B107
3753341	SNMM544RM KCP10	B107
3753342	SNMM643RM KCP10	B107
3753343	SNMM644RM KCP10	B107
3753347	TNMG433RN KCP10	B126
3753348	CNMG432RN KCP10	B53
3753349	CNMG434RN KCP10	B53
3753351	CNMG432RP KCP10	B53
3753352	CNMM432RP KCP10	B56
3753354	TNMG542RN KCP10	B126
3753356	CNMM543RP KCP10	B56
3753357	TNMG543RN KCP10	B126
3753358	CNMM544RP KCP10	B56
3753360	CNMM644RP KCP10	B56
3753361	TNMG544RN KCP10	B126
3753364	DNMM442RP KCP10	B85
3753367	VNMG332RN KCP10	B148
3753368	SNMM544RP KCP10	B107
3753371	VNMG333RN KCP10	B148
3753372	TNMM432RP KCP10	B129
3753374	VNMG432RN KCP10	B148
3753375	TNMM434RP KCP10	B129
3753376	VNMG433RN KCP10	B148
3753379	WNMG432RN KCP10	B161
3753380	WNMG433RN KCP10	B161
3753381	WNMG434RN KCP10	B161
3753386	EP1008SGD KC520M	T37, T47
3753387	EP1012SGD KC520M	T37, T47
3753389	CCMT2151MF KCP25	B191
3753390	CCMT3251MF KCP25	B191
3753391	CCMT3253MF KCP25	B191
3753413	CCMT433MF KCP25	B191
3753415	CPMT3252MF KCP25	B207
3753416	CPMT3253MF KCP25	B207
3753417	EC1008ELD KC510M	T36, T45
3753418	DCMT3251MF KCP25	B226
3753419	DCMT3252MF KCP25	B226
3753421	DPMT3252MF KCP25	B232
3753422	SCMT3252MF KCP25	B247
3753423	SCMT432MF KCP25	B247
3753424	SCMT433MF KCP25	B247
3753425	SPMT3252MF KCP25	B253
3753426	SPMT432MF KCP25	B253
3753427	TCMT2152MF KCP25	B258
3753428	TCMT3252MF KCP25	B258
3753430	TPMT2152MF KCP25	B268
3753431	TPMT3252MF KCP25	B268
3753432	TPMT3253MF KCP25	B268
3753434	CNMG322MN KCP25	B50
3753435	CNMG323MN KCP25	B50
3753436	CNMG431MN KCP25	B50
3753437	CNMG434MN KCP25	B50
3753438	CNMG542MN KCP25	B50
3753439	CNMG543MN KCP25	B50
3753440	CNMG544MN KCP25	B50
3753441	CNMG642MN KCP25	B50
3753442	CNMG643MN KCP25	B50
3753443	CNMG644MN KCP25	B50
3753444	DNMG331MN KCP25	B81
3753445	DNMG332MN KCP25	B81
3753446	DNMG333MN KCP25	B81
3753447	DNMG431MN KCP25	B81
3753448	DNMG433MN KCP25	B81
3753450	DNMG441MN KCP25	B81
3753451	DNMG443MN KCP25	B81
3753453	SNMG322MN KCP25	B102
3753454	SNMG323MN KCP25	B102
3753456	SNMG432MN KCP25	B102
3753457	SNMG433MN KCP25	B102
3753458	SNMG434MN KCP25	B102
3753459	SNMG543MN KCP25	B102
3753462	SNMG644MN KCP25	B102
3753463	TNMG331MN KCP25	B124
3753464	TNMG333MN KCP25	B124
3753465	TNMG431MN KCP25	B124
3753466	TNMG432MN KCP25	B124
3753467	TNMG433MN KCP25	B124
3753469	VNMG331MN KCP25	B146
3753470	VNMG332MN KCP25	B146
3753471	VNMG333MN KCP25	B146
3753472	WNMG331MN KCP25	B159
3753473	WNMG332MN KCP25	B159
3753474	WNMG333MN KCP25	B159
3753475	WNMG433MN KCP25	B159
3753476	WNMG434MN KCP25	B159
3753477	CNMP431K KCP25	B57
3753478	CNMP432K KCP25	B57
3753481	DNMP431K KCP25	B86
3753482	DNMP432K KCP25	B86
3753483	DNMP433K KCP25	B86
3753484	SNMP432K KCP25	B108
3753487	TNMP332K KCP25	B129
3753489	TNMP432K KCP25	B129
3753491	VNMP331K KCP25	B149
3753494	VNMP332K KCP25	B149
3753502	SNMG866RM KCP25	B104
3753504	CNMG433RN KCP25	B53
3753505	CNMG542RN KCP25	B53
3753506	CNMG543RN KCP25	B53
3753507	CNMG544RN KCP25	B53
3753508	CNMG642RN KCP25	B53
3753509	CNMG643RN KCP25	B53
3753510	CNMG644RN KCP25	B53
3753511	CNMG646RN KCP25	B53

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3753512	DNMG432RN KCP25	B83
3753513	DNMG433RN KCP25	B83
3753514	DNMG434RN KCP25	B83
3753515	DNMG442RN KCP25	B83
3753516	DNMG443RN KCP25	B83
3753517	DNMG444RN KCP25	B83
3753518	DNMG542RN KCP25	B83
3753519	DNMG543RN KCP25	B83
3753520	RNMG32RN KCP25	B97
3753523	RNMG64RN KCP25	B97
3753525	RNMG86RN KCP25	B97
3753526	SNMG432RN KCP25	B105
3753527	SNMG433RN KCP25	B105
3753528	SNMG434RN KCP25	B105
3753529	SNMG542RN KCP25	B105
3753530	SNMG543RN KCP25	B105
3753531	SNMG544RN KCP25	B105
3753543	SNMG643RN KCP25	B105
3753544	SNMG644RN KCP25	B105
3753545	SNMG646RN KCP25	B105
3753546	TNMG332RN KCP25	B126
3753547	TNMG333RN KCP25	B126
3753548	TNMG432RN KCP25	B126
3753549	TNMG433RN KCP25	B126
3753550	TNMG434RN KCP25	B126
3753551	TNMG542RN KCP25	B126
3753552	TNMG543RN KCP25	B126
3753553	TNMG544RN KCP25	B126
3753554	TNMG666RN KCP25	B126
3753555	VNMG332RN KCP25	B148
3753556	VNMG333RN KCP25	B148
3753557	VNMG432RN KCP25	B148
3753558	VNMG433RN KCP25	B148
3753559	WNMG332RN KCP25	B161
3753560	WNMG333RN KCP25	B161
3753561	WNMG432RN KCP25	B161
3753562	WNMG433RN KCP25	B161
3753563	WNMG434RN KCP25	B161
3753592	EP1004EHD KC520M	T36, T46
3753593	EP1008EHD KC520M	T36, T46
3753594	EP1012EHD KC520M	T36, T46
3753608	CNMG433RN KCP30	B53
3753609	CNMG542RN KCP30	B53
3753610	CNMG543RN KCP30	B53
3753611	CNMG643RN KCP30	B53
3753612	CNMG644RN KCP30	B53
3753633	CNMG646RN KCP30	B53
3753636	DNMG442RN KCP30	B83
3753637	DNMG443RN KCP30	B83
3753639	DNMG542RN KCP30	B83
3753640	DNMG543RN KCP30	B83
3753641	RNMG43RN KCP30	B97
3753642	RNMG54RN KCP30	B97
3753650	SNMG642RN KCP30	B105
3753653	SNMG646RN KCP30	B105
3753654	TNMG332RN KCP30	B126
3753655	TNMG333RN KCP30	B126
3753656	TNMG432RN KCP30	B126
3753658	TNMG542RN KCP30	B126
3753662	VNMG432RN KCP30	B148
3753663	VNMG433RN KCP30	B148
3753664	WNMG432RN KCP30	B161
3753665	WNMG433RN KCP30	B161
3753699	CNMG431FN KCP25	B49
3753700	CNMG432FN KCP25	B49
3753701	CNMG433FN KCP25	B49
3753702	CNMG434FN KCP25	B49
3753705	DNMG431FN KCP25	B79
3753706	DNMG432FN KCP25	B79
3753707	DNMG441FN KCP25	B79
3753708	DNMG442FN KCP25	B79
3753709	DNMG443FN KCP25	B79
3753713	SNMG433FN KCP25	B101
3753714	TNMG221FN KCP25	B123
3753715	TNMG222FN KCP25	B123
3753716	TNMG331FN KCP25	B123
3753717	TNMG332FN KCP25	B123
3753718	TNMG333FN KCP25	B123
3753719	TNMG431FN KCP25	B123
3753720	TNMG432FN KCP25	B123
3753721	TNMG433FN KCP25	B123
3753722	VNMG331FN KCP25	B146
3753723	VNMG332FN KCP25	B146
3753724	WNMG332FN KCP25	B157
3753726	WNMG432FN KCP25	B157
3753727	CCMT2151LF KCP25	B191
3753728	CCMT3251LF KCP25	B191
3753729	CCMT3252LF KCP25	B191
3753730	CCMT431LF KCP25	B191
3753732	DCMT3251LF KCP25	B225
3753733	CCMT3252MF KCP25	B191
3753734	CCMT432MF KCP25	B191
3753735	RCMT0602M0 KCP30	B240
3753737	RCMT10T3M0 KCP30	B240
3753739	CCMT2152LF KCP30	B191
3753742	CPMT2152LF KCP30	B207
3753743	CPMT3251LF KCP30	B207
3753744	CPMT3252LF KCP30	B207
3753745	DCMT2151LF KCP30	B225
3753750	SCMT3251LF KCP30	B246
3753751	SCMT3252LF KCP30	B246
3753752	SCMT431LF KCP30	B246
3753753	SCMT432LF KCP30	B246
3753754	TCMT2151LF KCP30	B257
3753755	TCMT2152LF KCP30	B257
3753757	TCMT3252LF KCP30	B257
3753760	VBMT331LF KCP30	B281
3753761	VBMT332LF KCP30	B281
3753762	CCMT2151MF KCP30	B191
3753763	CCMT3251MF KCP30	B191
3753765	DCMT3251MF KCP30	B226
3753766	DCMT3252MF KCP30	B226
3753767	SCMT432MF KCP30	B247
3753768	SPMT432MF KCP30	B253
3753769	TCMT3252MF KCP30	B258
3753770	TPMT3252MF KCP30	B268
3753771	CNMG321MN KCP30	B50
3753772	CNMG322MN KCP30	B50
3753773	CNMG431MN KCP30	B50
3753774	CNMG542MN KCP30	B50
3753775	CNMG543MN KCP30	B50
3753776	CNMG642MN KCP30	B50
3753777	CNMG643MN KCP30	B50
3753778	CNMG644MN KCP30	B50
3753779	DNMG331MN KCP30	B81
3753780	DNMG332MN KCP30	B81
3753781	DNMG431MN KCP30	B81
3753782	DNMG441MN KCP30	B81
3753783	DNMG543MN KCP30	B81
3753784	SNMG322MN KCP30	B102
3753786	SNMG432MN KCP30	B102
3753787	SNMG433MN KCP30	B102
3753789	TNMG331MN KCP30	B124
3753791	TNMG431MN KCP30	B124
3753793	TNMG433MN KCP30	B124
3753794	VNMG331MN KCP30	B146
3753795	VNMG332MN KCP30	B146
3753796	VNMG333MN KCP30	B146
3753797	WNMG332MN KCP30	B159
3753798	CNMG433RP KCP30	B53
3753799	CNMG543RP KCP30	B53
3753801	CNMG643RP KCP30	B53
3753802	CNMG644RP KCP30	B53
3753804	DNMG433RP KCP30	B84
3753805	DNMG442RP KCP30	B84
3753810	RCMX2507M0RP KCP30	B242
3753812	SNMG433RP KCP30	B105
3753816	TNMG332RP KCP30	B127
3753819	TNMG438RP KCP30	B127
3753821	CNMG432MN KCP25	B50
3753822	WNMG433RP KCP30	B161
3753823	CNMG433MN KCP25	B50
3753825	DNMG432MN KCP25	B81
3753827	DNMG442MN KCP25	B81
3753828	TNMG332MN KCP25	B124
3753829	WNMG432MN KCP25	B159
3753830	CNMG432MW KCP25	B52
3753831	WNMG433MW KCP25	B160
3753832	CNMM643RH KCP25	B55
3753834	CNMM646RH KCP25	B55
3753836	SNMM644RH KCP25	B106
3753837	SNMM646RH KCP25	B106
3753867	CCMT3252MW KCK20	B192
3753871	CPMT3252MW KCK20	B208
3753875	CNMG433RP KCK20	B53
3753877	CNMG542RP KCK20	B53
3753878	CNMG543RP KCK20	B53
3753879	CNMG544RP KCK20	B53
3753884	DNMG432RP KCK20	B84
3753887	DNMG442RP KCK20	B84
3753888	DNMG443RP KCK20	B84
3753891	SNMG432RP KCK20	B105
3753892	SNMG433RP KCK20	B105
3753897	SNMG644RP KCK20	B105
3753898	TNMG332RP KCK20	B127
3753899	TNMG333RP KCK20	B127
3753904	TNMG438RP KCK20	B127
3753909	VNMG333RP KCK20	B148
3753912	WNMG432RP KCK20	B161
3753923	WNMG433RP KCK20	B161
3753926	CCMT2152FW KCK20	B190
3753929	CCMT3252FW KCK20	B190
3753931	CPMT2151FW KCK20	B206
3753932	CPMT2152FW KCK20	B206
3753934	CPMT3252FW KCK20	B206
3753935	DCMT3251FW KCK20	B225
3753981	CNMG432RN KCP40	B53
3753982	CNMG433RN KCP40	B53
3753993	CNMG434RN KCP40	B53
3753994	CNMG543RN KCP40	B53
3753996	CNMG642RN KCP40	B53
3753997	CNMG643RN KCP40	B53
3753998	CNMG644RN KCP40	B53
3753999	DNMG432RN KCP40	B83
3754004	SNMG433RN KCP40	B105
3754005	SNMG434RN KCP40	B105
3754006	SNMG543RN KCP40	B105
3754008	SNMG643RN KCP40	B105
3754010	TNMG432RN KCP40	B126
3754012	TNMG543RN KCP40	B126
3754014	WNMG432RN KCP40	B148
3754015	WNMG432RN KCP40	B161
3754059	RCMT1204M0 KCP30	B240
3754060	CCMT2151LF KCP30	B191
3754061	CCMT3251LF KCP30	B191
3754062	CCMT3252LF KCP30	B191
3754343	CCMT431LF KCP30	B191
3754344	DCMT3251LF KCP30	B225
3754345	CCMT3252MF KCP30	B191
3754346	CCMT432MF KCP30	B191
3754347	CNMG432MN KCP30	B50
3754349	DNMG432MN KCP30	B81
3754351	TNMG332MN KCP30	B124
3754352	WNMG432MN KCP30	B159
3754363	CNMG432RN KCP30	B53
3754365	CNMG432RP KCP30	B53
3754367	CNMM433RP KCP30	B56
3754374	CNMM644RH KCP30	B55
3754375	CNMM646RH KCP30	B55
3754376	SNMM643RH KCP30	B106
3754377	SNMM644RH KCP30	B106
3754378	SNMM646RH KCP30	B106
3754379	CNMM432RM KCP30	B55
3754383	CNMM544RM KCP30	B55
3754385	CNMM644RM KCP30	B55
3754386	CNMM646RM KCP30	B55
3754388	DNMM442RM KCP30	B85
3754396	TNMM332RM KCP30	B128
3754398	TNMM433RM KCP30	B128
3754399	TNMM543RM KCP30	B128
3754815	CNMM643RH KCP40	B55
3754818	CNMM866RH KCP40	B55
3754819	SNMM644RH KCP40	B106
3754821	SNMM856RH KCP40	B106
3754822	SNMM866RH KCP40	B106
3754856	CNMM643RM KCP40	B55
3754858	CNMM866RM KCP40	B55
3754861	DNMM443RM KCP40	B85
3754863	SNMM643RM KCP40	B107
3754864	SNMM866RM KCP40	B107
3755331	WNMG431FF KCP10	B157
3755332	CNMM866RH KCP10	B55
3755363	LNUX191940RRH KCP10	E57
3755366	RCMT2006M0RH KCP10	B241
3755367	RCMX2507M0RH KCP10	B241
3755369	SNMM856RH KCP10	B106
3755370	SNMM866RH KCP10	B106
3755371	CNMM866RM KCP10	B55
3755372	SNMM856RM KCP10	B107
3755475	RCMT1605M0 KCK20	B240
3755479	RCMT43 KCK20	B240
3755481	CCMT432LF KCK20	B191
3755482	CPMT2151LF KCK20	B207
3755484	CPMT3251LF KCK20	B207
3755485	CPMT3252LF KCK20	B207
3755486	DCMT2151LF KCK20	B225
3755487	DCMT3252LF KCK20	B225
3755490	DCMT432LF KCK20	B225
3755491	DPMT2151LF KCK20	B232
3755492	DPMT3251LF KCK20	B232
3755503	DPMT3252LF KCK20	B232
3755504	SCMT3251LF KCK20	B246
3755505	SCMT3252LF KCK20	B246
3755507	SCMT432LF KCK20	B246
3755508	SCMT433LF KCK20	B246
3755509	SPMT3251LF KCK20	B252
3755510	SPMT3252LF KCK20	B252
3755511	TCMT2151LF KCK20	B257
3755512	TCMT2152LF KCK20	B257
3755513	TCMT3251LF KCK20	B257
3755514	TCMT3252LF KCK20	B257
3755515	TCMT3253LF KCK20	B257
3755517	TPMT2151LF KCK20	B268
3755520	TPMT3252LF KCK20	B268
3755522	TPMT432LF KCK20	B268
3755526	VBMT332LF KCK20	B281
3755527	VBMT333LF KCK20	B281
3755528	WPMT2151LF KCK20	B288
3755531	CCMT2151MF KCK20	B191
3755532	CCMT3251MF KCK20	B191
3755533	CCMT3253MF KCK20	B191
3755534	CCMT433MF KCK20	B191
3755535	CPMT2152MF KCK20	B207
3755536	CPMT3252MF KCK20	B207
3755538	DCMT3251MF KCK20	B226
3755539	DCMT3252MF KCK20	B226
3755540	DCMT3253MF KCK20	B226
3755542	SCMT3252MF KCK20	B247
3755543	SCMT432MF KCK20	B247
3755544	SCMT433MF KCK20	B247
3755545	SPMT3252MF KCK20	B253
3755546	SPMT432MF KCK20	B253
3755547	TCMT2152MF KCK20	B258
3755548	TCMT3252MF KCK20	B258
3755549	TCMT3253MF KCK20	B258
3755550	TPMT2152MF KCK20	B268
3755551	TPMT3252MF KCK20	B268
3755552	TPMT3253MF KCK20	B268
3755565	CCMT2151LF KCM15	B191
3755570	DCMT3251LF KCM15	B225
3755593	CNMG432RP KCM15	B53
3755632	CNMM866RH KCP25	B55
3755635	CPMT2151LF KCM15	B207
3755637	CPMT3251LF KCM15	B207
3755638	CPMT3252LF KCM15	B207
3755639	DCMT2151LF KCM15	B225
3755640	DCMT3252LF KCM15	B225
3755648	SCMT432LF KCM15	B246
3755649	TCMT2151LF KCM15	B257
3755650	TCMT2152LF KCM15	B257
3755651	TCMT3251LF KCM15	B257
3755655	TPMT2151LF KCM15	B268
3755657	TPMT3251LF KCM15	B268
3755659	VBMT221LF KCM15	B281
3755661	VBMT331LF KCM15	B281
3755662	VBMT332LF KCM15	B281
3755664	WPMT3252LF KCM15	B288
3755670	CPMT3252MF KCM15	B207
3755672	DCMT3251MF KCM15	B226
3755673	DCMT3252MF KCM15	B226
3755677	SCMT432MF KCM15	B247
3755682	TPMT3252MF KCM15	B268
3755684	CNMG431MP KCM15	B51
3755685	CNMG432MP KCM15	B51
3755686	CNMG433MP KCM15	B51
3755689	CNMG543MP KCM15	B51
3755691	CNMG643MP KCM15	B51
3755693	DNMG332MP KCM15	B81

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3755694	DNMG333MP KCM15	B81
3755699	DNMG442MP KCM15	B81
3755700	DNMG443MP KCM15	B81
3755701	SNMG432MP KCM15	B102
3755702	SNMG433MP KCM15	B102
3755704	SNMG543MP KCM15	B102
3755705	SNMG643MP KCM15	B102
3755706	TNMG331MP KCM15	B124
3755707	TNMG332MP KCM15	B124
3755711	VNMG331MP KCM15	B147
3755712	VNMG332MP KCM15	B147
3755714	WNMG331MP KCM15	B159
3755715	WNMG332MP KCM15	B159
3755716	WNMG432MP KCM15	B159
3755717	WNMG433MP KCM15	B159
3755753	LNUX191940RRH KCP25	E57
3755754	LNUX301940RRH KCP25	E57
3755755	RCMT2006M0RH KCP25	B241
3755756	RCMX2507M0RH KCP25	B241
3755757	RCMX3209M0RH KCP25	B241
3755758	SNMM856RH KCP25	B106
3755760	SNMM866RH KCP25	B106
3755761	CNMM866RM KCP25	B55
3755762	RCMT2006M0RM KCP25	B241
3755763	SNMM856RM KCP25	B107
3755764	SNMM866RM KCP25	B107
3755769	ABDF0625J2AQ K600	P118
3755771	ABDF0625J2BQ K600	P118
3755772	ABDF0625J2BQB K600	P118
3755802	ABDE0250J3AQ K600	P120
3755835	B292A08200YPL KC7315	G89
3755843	ABDF0625J2BQE K600	P118
3755844	ABDF0750J2AQ K600	P118
3755845	ABDF0750J2AQB K600	P118
3755846	ABDF0750J2AQE K600	P118
3755847	ABDF0750J2BQ K600	P119
3755848	ABDF0750J2BQB K600	P118
3755849	ABDF0750J2BQC K600	P118
3755850	ABDF0750J2BQD K600	P119
3755851	ABDF0750J2BQE K600	P119
3755852	ABDF0750J2CQ K600	P119
3755853	ABDF0750J2CQB K600	P119
3755854	ABDF1000J2AQ K600	P119
3755855	ABDF1000J2AQB K600	P119
3755856	ABDF1000J2AQE K600	P119
3755857	ABDF1000J2BQ K600	P119
3755858	ABDF1000J2BQB K600	P119
3755859	ABDF1000J2BQE K600	P119
3755860	ABDF1000J2CQ K600	P119
3755861	ABDF1000J2CQB K600	P119
3755863	ABDF0250J2AQB K600	P118
3755864	ABDF0250J2BQ K600	P118
3755865	ABDF0250J2BQB K600	P118
3755866	ABDF0250J2CQ K600	P118
3755867	ABDF0250J2CQB K600	P118
3755868	ABDF0312J2AQB K600	P118
3755869	ABDF0375J2AQ K600	P118
3755870	ABDF0375J2AQB K600	P118
3755871	ABDF0375J2BQ K600	P118
3755872	ABDF0375J2BQB K600	P118
3755873	ABDF0500J2AQ K600	P118
3755874	ABDF0500J2AQB K600	P118
3755875	ABDF0500J2AQE K600	P118
3755876	ABDF0500J2BQ K600	P118
3755877	ABDF0500J2BQB K600	P118
3755878	ABDF0500J2BQC K600	P118
3755879	ABDF0500J2BQD K600	P118
3755880	ABDF0500J2BQE K600	P118
3755881	ABDF0500J2CQ K600	P118
3755882	ABDF0500J2CQB K600	P118
3755883	ABDF0500J2CQC K600	P118
3755884	ABDF0500J2CQD K600	P118
3755885	ABDF0500J2CQE K600	P118
3755893	ABDE0250J3AQB K600	P120
3755894	ABDE0250J3BQ K600	P120
3755895	ABDE0250J3BQB K600	P120
3755896	ABDE0250J3CQ K600	P120
3755897	ABDE0250J3CQB K600	P120
3755898	ABDE0312J3AQB K600	P120
3755899	ABDE0375J3AQ K600	P120
3755900	ABDE0375J3AQB K600	P120
3755901	ABDE0375J3BQ K600	P120
3755902	ABDE0375J3BQB K600	P120
3755903	ABDE0500J3AQ K600	P120
3755904	ABDE0500J3AQB K600	P120
3755905	ABDE0500J3AQE K600	P120
3755906	ABDE0500J3BQ K600	P120
3755907	ABDE0500J3BQB K600	P120
3755908	ABDE0500J3BQC K600	P120
3755909	ABDE0500J3BQD K600	P120
3755910	ABDE0500J3BQE K600	P120
3755911	ABDE0500J3CQ K600	P120
3755912	ABDE0500J3CQB K600	P120
3755913	ABDE0500J3CQC K600	P120
3755914	ABDE0500J3CQD K600	P120
3755915	ABDE0500J3CQE K600	P120
3755916	ABDE0625J3AQ K600	P120
3755917	ABDE0625J3AQB K600	P120
3755918	ABDE0625J3BQ K600	P120
3755919	ABDE0625J3BQB K600	P120
3755920	ABDE0625J3BQE K600	P120
3755921	ABDE0750J3AQ K600	P120
3755922	ABDE0750J3AQB K600	P120
3755923	ABDE0750J3AQE K600	P120
3755924	ABDE0750J3BQ K600	P121
3755925	ABDE0750J3BQB K600	P121
3755926	ABDE0750J3BQC K600	P121
3755927	ABDE0750J3BQD K600	P121
3755928	ABDE0750J3BQE K600	P121
3755929	ABDE0750J3CQ K600	P121
3755930	ABDE0750J3CQB K600	P121
3755931	ABDE1000J3AQ K600	P121
3755932	ABDE1000J3AQB K600	P121
3755933	ABDE1000J3AQE K600	P121
3755934	ABDE1000J3BQ K600	P121
3755935	ABDE1000J3BQB K600	P121
3755936	ABDE1000J3BQE K600	P121
3755937	ABDE1000J3CQ K600	P121
3755938	ABDE1000J3CQB K600	P121
3757585	WNMA333 KCK20	B157
3757586	CNMG431UN KCK20	B54
3757587	CNMG432UN KCK20	B54
3757588	CNMG433UN KCK20	B54
3757589	CNMG434UN KCK20	B54
3757590	CNMG542UN KCK20	B54
3757591	CNMG543UN KCK20	B54
3757592	CNMG544UN KCK20	B54
3757593	CNMG642UN KCK20	B54
3757594	CNMG643UN KCK20	B54
3757595	CNMG644UN KCK20	B54
3757596	DNMG332UN KCK20	B84
3757597	DNMG333UN KCK20	B84
3757598	DNMG432UN KCK20	B84
3757600	DNMG434UN KCK20	B84
3757601	DNMG442UN KCK20	B84
3757602	DNMG443UN KCK20	B84
3757603	DNMG444UN KCK20	B84
3757604	RNMG43UN KCK20	B97
3757605	SNMG432UN KCK20	B106
3757606	SNMG433UN KCK20	B106
3757607	SNMG434UN KCK20	B106
3757608	SNMG543UN KCK20	B106
3757609	SNMG544UN KCK20	B106
3757610	SNMG643UN KCK20	B106
3757611	SNMG644UN KCK20	B106
3757612	TNMG332UN KCK20	B127
3757613	TNMG333UN KCK20	B127
3757614	TNMG334UN KCK20	B127
3757615	TNMG432UN KCK20	B127
3757616	TNMG433UN KCK20	B127
3757617	TNMG434UN KCK20	B127
3757618	VNMG331UN KCK20	B148
3757619	VNMG332UN KCK20	B148
3757622	WNMG431UN KCK20	B162
3757623	WNMG432UN KCK20	B162
3757624	WNMG433UN KCK20	B162
3757625	WNMG434UN KCK20	B162
3757726	B966A13400 KC7315	G132
3757916	CCMW3252 KCK20	B192
3757917	CCMW432 KCK20	B192
3757918	CCMW433 KCK20	B192
3757919	SCMW3251 KCK20	B248
3757920	SCMW3252 KCK20	B248
3757921	SCMW432 KCK20	B248
3757922	SCMW433 KCK20	B248
3757960	DNMG442RN KCP05	B83
3757961	DNMG443RN KCP05	B83
3758013	WNMG433RN KCP05	B161
3758033	DNMG332RP KCM15	B84
3758035	DNMG432RP KCM15	B84
3758036	DNMG442RP KCM15	B84
3758043	TNMG332RP KCM15	B127
3758046	TNMG543RP KCM15	B127
3758048	VNMG332RP KCM15	B148
3758050	WNMG332RP KCM15	B161
3758051	WNMG432RP KCM15	B161
3758053	WNMG433RP KCM15	B161
3758055	CNMG432UP KCM15	B54
3758056	CNMG433UP KCM15	B54
3758064	DNMG431UP KCM15	B84
3758065	DNMG432UP KCM15	B84
3758068	DNMG442UP KCM15	B84
3758073	SNMG543UP KCM15	B106
3758076	TNMG332UP KCM15	B128
3758080	VNMG331UP KCM15	B148
3758081	VNMG332UP KCM15	B148
3758082	VNMG333UP KCM15	B148
3758084	WNMG432UP KCM15	B162
3758086	RCMT1204M0 KCM25	B240
3758087	CCMT2151LF KCM25	B191
3758088	CCMT3251LF KCM25	B191
3758089	CCMT3252LF KCM25	B191
3758091	CCMT433LF KCM25	B191
3758092	DCMT3251LF KCM25	B225
3758093	CCMT3252MF KCM25	B191
3758094	CCMT432MF KCM25	B191
3758095	CNMG432RP KCM25	B53
3758096	CNMM432RP KCM25	B56
3758099	CNMM544RP KCM25	B56
3758106	SNMM433RP KCM25	B107
3758108	SNMM544RP KCM25	B107
3758110	SNMM644RP KCM25	B107
3758111	SNMM646RP KCM25	B107
3758133	CNMA431 KCK20	B47
3758134	CNMA432 KCK20	B47
3758135	CNMA433 KCK20	B47
3758136	CNMA434 KCK20	B47
3758137	CNMA542 KCK20	B47
3758138	CNMA543 KCK20	B47
3758141	CNMA643 KCK20	B47
3758142	CNMA644 KCK20	B47
3758143	DNMA432 KCK20	B78
3758144	DNMA433 KCK20	B78
3758145	DNMA442 KCK20	B78
3758146	DNMA443 KCK20	B78
3758149	SNMA432 KCK20	B100
3758150	SNMA433 KCK20	B100
3758152	SNMA543 KCK20	B100
3758154	SNMA643 KCK20	B100
3758155	SNMA644 KCK20	B100
3758156	TNMA332 KCK20	B122
3758157	TNMA333 KCK20	B122
3758158	TNMA334 KCK20	B122
3758162	VNMA332 KCK20	B145
3758163	WNMA432 KCK20	B157
3758164	WNMA433 KCK20	B157
3758165	WNMA434 KCK20	B157
3758166	RCMT1204M0 KCK20	B240
3758167	CCMT2151LF KCK20	B191
3758168	CCMT3251LF KCK20	B191
3758169	CCMT3252LF KCK20	B191
3758170	CCMT431LF KCK20	B191
3758172	DCMT3251LF KCK20	B225
3758173	CCMT3252MF KCK20	B191
3758174	CCMT432MF KCK20	B191
3758175	CNMG432RP KCK20	B53
3758783	CNMG431FP KCM15	B49
3758784	CNMG432FP KCM15	B49
3758785	CNMG433FP KCM15	B49
3758786	DNMG331FP KCM15	B80
3758787	DNMG332FP KCM15	B80
3758788	DNMG431FP KCM15	B80
3758789	DNMG432FP KCM15	B80
3758791	DNMG441FP KCM15	B80
3758792	DNMG442FP KCM15	B80
3758794	SNMG431FP KCM15	B101
3758795	SNMG432FP KCM15	B101
3758797	TNMG331FP KCM15	B123
3758798	TNMG332FP KCM15	B123
3758799	TNMG333FP KCM15	B123
3758800	TNMG431FP KCM15	B123
3758801	TNMG432FP KCM15	B123
3758802	VNMG331FP KCM15	B146
3758803	VNMG332FP KCM15	B146
3758804	WNMG331FP KCM15	B158
3758805	WNMG332FP KCM15	B158
3758806	WNMG431FP KCM15	B158
3758807	WNMG432FP KCM15	B158
3758808	WNMG433FP KCM15	B158
3758827	CNMM866RH KCP30	B55
3758828	SNMM856RH KCP30	B106
3758830	SNMM866RH KCP30	B106
3758873	SNMM866RM KCP30	B107
3759083	EC1004FR-PCD KD1410	T34
3759084	EC1008FR-PCD KD1410	T34
3759533	KIPR062RP21229	V156
3759534	KIPR075RP21332	V156
3759535	KIPR100RP32438	V156
3759595	B291A03100YPL KC7315	G88
3759627	B292A03100YPL KC7315	G88
3759628	B291A03175YPL KC7315	G88
3759629	B291A03200YPL KC7315	G88
3759630	B292A03200YPL KC7315	G88
3759654	B291A03300YPL KC7315	G88
3759655	B292A03300YPL KC7315	G88
3759656	B291A03400YPL KC7315	G88
3759657	B292A03400YPL KC7315	G88
3759661	B291A03500YPL KC7315	G88
3759662	B291A03600YPL KC7315	G88
3759713	B292A03600YPL KC7315	G88
3759714	B291A03700YPL KC7315	G88
3759715	B292A03700YPL KC7315	G88
3759716	B291A03800YPL KC7315	G88
3759717	B292A03800YPL KC7315	G88
3759718	B291A03900YPL KC7315	G88
3759722	B292A03900YPL KC7315	G88
3759763	B291A04100YPL KC7315	G88
3759764	B292A04100YPL KC7315	G88
3760221	CCMT2151LF KCM35	B191
3760254	CCMT3251LF KCM35	B191
3760257	CCMT3252LF KCM35	B191
3760261	CCMT3252MF KCM35	B191
3760262	CCMT432MF KCM35	B191
3760273	CNMG432RP KCM35	B53
3760277	SNMM432RP KCM35	B107
3760279	RCMT0602M0 KCM25	B240
3760280	RCMT0803M0 KCM25	B240
3760281	RCMT10T3M0 KCM25	B240
3760282	RCMT1605M0 KCM25	B240
3760286	RCMT43 KCM25	B240
3760287	CCMT2152LF KCM25	B191
3760290	CPMT2151LF KCM25	B207
3760291	CPMT2152LF KCM25	B207
3760292	CPMT3251LF KCM25	B207
3760293	CPMT3252LF KCM25	B207
3760294	DCMT2151LF KCM25	B225
3760295	DCMT3252LF KCM25	B225
3760296	DPMT2151LF KCM25	B232
3760298	DPMT3252LF KCM25	B232
3760299	SCMT3251LF KCM25	B246
3760300	SCMT3252LF KCM25	B246
3760302	SCMT432LF KCM25	B246
3760305	TCMT3251LF KCM25	B257
3760306	TCMT3252LF KCM25	B257
3760307	TCMT3253LF KCM25	B257
3760310	TPMT2152LF KCM25	B268
3760312	TPMT3252LF KCM25	B268
3760314	VBMT222LF KCM25	B281
3760315	VBMT331LF KCM25	B281
3760316	VBMT332LF KCM25	B281
3760319	CCMT2151MF KCM25	B191
3760320	CCMT3251MF KCM25	B191
3760324	CPMT3252MF KCM25	B207
3760326	DCMT3251MF KCM25	B226
3760327	DCMT3252MF KCM25	B226
3760329	DPMT3252MF KCM25	B232
3760330	SCMT3252MF KCM25	B247
3760331	SCMT432MF KCM25	B247

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3760334	SPMT432MF KCM25	B253
3760336	TCMT3252MF KCM25	B258
3760338	TPMT2152MF KCM25	B268
3760341	CNMG322MP KCM25	B51
3760342	CNMG431MP KCM25	B51
3760343	CNMG432MP KCM25	B51
3760344	CNMG433MP KCM25	B51
3760346	CNMG542MP KCM25	B51
3760347	CNMG543MP KCM25	B51
3760349	CNMG642MP KCM25	B51
3760350	CNMG643MP KCM25	B51
3760351	CNMG644MP KCM25	B51
3760352	DNMG332MP KCM25	B81
3760354	DNMG431MP KCM25	B81
3760355	DNMG432MP KCM25	B81
3760356	DNMG433MP KCM25	B81
3760357	DNMG441MP KCM25	B81
3760358	DNMG442MP KCM25	B81
3760360	SNMG432MP KCM25	B102
3760361	SNMG433MP KCM25	B102
3760364	SNMG543MP KCM25	B102
3760365	SNMG544MP KCM25	B102
3760366	SNMG643MP KCM25	B102
3760368	RCMT2006M0 KCM25	B240
3760369	KIPR100RP32M1203	V155
3760370	KIPR125RP43M1603	V155
3760394	CCMT432LF KCM35	B191
3760395	DCMT2151LF KCM35	B225
3760398	TCMT2151LF KCM35	B257
3760399	TCMT3251LF KCM35	B257
3760400	TCMT3252LF KCM35	B257
3760402	VBMT331LF KCM35	B281
3760403	VBMT332LF KCM35	B281
3760404	CCMT2151MF KCM35	B191
3760406	CPMT3252MF KCM35	B207
3760407	DCMT3252MF KCM35	B226
3760410	SCMT432MF KCM35	B247
3760411	TCMT3252MF KCM35	B258
3760413	CNMG431MP KCM35	B51
3760414	CNMG432MP KCM35	B51
3760415	CNMG433MP KCM35	B51
3760416	CNMG542MP KCM35	B51
3760420	DNMG431MP KCM35	B81
3760421	DNMG432MP KCM35	B81
3760422	DNMG441MP KCM35	B81
3760423	DNMG442MP KCM35	B81
3760425	SNMG433MP KCM35	B102
3760426	SNMG434MP KCM35	B102
3760427	SNMG643MP KCM35	B102
3760430	TNMG332MP KCM35	B124
3760431	VNMG331MP KCM35	B147
3760432	VNMG332MP KCM35	B147
3760434	WNMG432MP KCM35	B159
3760435	WNMG433MP KCM35	B159
3760436	CNMG433RP KCM35	B53
3760437	CNMG434RP KCM35	B53
3760438	CNMG543RP KCM35	B53
3760439	CNMG643RP KCM35	B53
3760440	CNMG644RP KCM35	B53
3760441	DNMG432RP KCM35	B84
3760442	DNMG433RP KCM35	B84
3760445	SNMG432RP KCM35	B105
3760447	SNMG543RP KCM35	B105
3760448	SNMG643RP KCM35	B105
3760450	TNMG333RP KCM35	B127
3760451	TNMG543RP KCM35	B127
3760453	WNMG432RP KCM35	B161
3760454	WNMG433RP KCM35	B161
3760455	CNMG432UP KCM35	B54
3760457	CNMG542UP KCM35	B54
3760458	CNMG543UP KCM35	B54
3760459	CNMG643UP KCM35	B54
3760461	DNMG432UP KCM35	B84
3760465	SNMG432UP KCM35	B106
3760466	SNMG433UP KCM35	B106
3760470	TNMG432UP KCM35	B128
3760473	WNMG433UP KCM35	B162
3760968	TNMG331MP KCM25	B124
3760969	TNMG332MP KCM25	B124
3760970	TNMG333MP KCM25	B124
3760971	TNMG432MP KCM25	B124
3760972	TNMG433MP KCM25	B124
3760994	VNMG331MP KCM25	B147
3760995	VNMG332MP KCM25	B147
3760998	WNMG332MP KCM25	B159
3760999	WNMG333MP KCM25	B159
3761000	WNMG432MP KCM25	B159
3761001	WNMG433MP KCM25	B159
3761002	CNMG431RP KCM25	B53
3761003	CNMG433RP KCM25	B53
3761004	CNMG434RP KCM25	B53
3761005	CNMG543RP KCM25	B53
3761006	CNMG544RP KCM25	B53
3761007	CNMG643RP KCM25	B53
3761008	CNMG644RP KCM25	B53
3761009	DNMG432RP KCM25	B84
3761011	DNMG442RP KCM25	B84
3761012	DNMG443RP KCM25	B84
3761014	SNMG432RP KCM25	B105
3761015	SNMG433RP KCM25	B105
3761019	SNMG644RP KCM25	B105
3761020	SNMM856RP KCM25	B107
3761021	SNMM866RP KCM25	B107
3761022	TNMG332RP KCM25	B127
3761023	TNMG333RP KCM25	B127
3761025	TNMG432RP KCM25	B127
3761026	TNMG433RP KCM25	B127
3761027	TNMG434RP KCM25	B127
3761029	TNMG544RP KCM25	B127
3761030	TNMG666RP KCM25	B127
3761031	VNMG333RP KCM25	B148
3761032	WNMG332RP KCM25	B161
3761033	WNMG432RP KCM25	B161
3761034	WNMG433RP KCM25	B161
3761035	CNMG431UP KCM25	B54
3761036	CNMG432UP KCM25	B54
3761037	CNMG433UP KCM25	B54
3761038	CNMG542UP KCM25	B54
3761039	CNMG543UP KCM25	B54
3761041	CNMG643UP KCM25	B54
3761042	CNMG644UP KCM25	B54
3761043	DNMG332UP KCM25	B84
3761045	DNMG431UP KCM25	B84
3761046	DNMG432UP KCM25	B84
3761048	DNMG441UP KCM25	B84
3761052	SNMG433UP KCM25	B106
3761054	SNMG543UP KCM25	B106
3761056	TNMG331UP KCM25	B128
3761057	TNMG332UP KCM25	B128
3761059	TNMG432UP KCM25	B128
3761061	VNMG331UP KCM25	B148
3761062	VNMG332UP KCM25	B148
3761065	WNMG432UP KCM25	B162
3761066	WNMG433UP KCM25	B162
3763185	HNPJ535ANSNHD KCK15	S19, S23
3763632	HNPJ535ANSNHD KC520M	S19, S23
3763723	HNPJ535ANSNHD KC725M	S19, S23
3763724	HNPJ535ANSNHD KCPK30	S19, S23
3763725	HNPJ535ANSNGD KCK15	S19, S22
3763726	HNPJ535ANSNGD KC520M	S19, S22
3763727	HNPJ535ANSNGD KC725M	S19, S22
3763728	HNPJ535ANSNGD KCPK30	S19, S22
3763729	HNPJ53511ANSNHD KCK15	S19, S23
3763730	HNPJ53511ANSNHD KC725M	S19, S23
3763731	HNPJ53511ANSNHD KCPK30	S19, S23
3764792	CNMA432S0820 KB1340	B309
3764823	B292A06600YPL KC7315	G89
3764824	B292A10100YPL KC7315	G89
3764833	CNMA433S0820 KB1340	B309
3764836	CNM432S0820 KB1340	B304
3764837	CNM433S0820 KB1340	B304
3764838	DNMA332S0820 KB1340	B309
3764839	DNMA333S0820 KB1340	B309
3764840	RNM32S0820 KB1340	B305
3764841	RNM42S0820 KB1340	B305
3764842	RNM43S0820 KB1340	B305
3764844	SNMA433S0820 KB1340	B310
3764845	SNM322S0820 KB1340	B306
3764847	SNM324S0820 KB1340	B306
3764850	SNM424S0820 KB1340	B306
3764851	SNM434S0820 KB1340	B306
3765830	EC1020FLDJ KC410M	T35, T44
3765831	EC1020ELDJ KC422M	T35, T45
3766023	EC1020ELD KC725M	T36, T45
3766024	EC1020ELD KCPK30	T36, T45
3766027	EC1024ELDJ KC422M	T35, T45
3766028	EC1024ELD KC522M	T36, T45
3766029	EC1024ELD KC725M	T36, T45
3766820	RIQ09E1306 KC6305	K58
3767813	OFKT53AFFN4LBJ KC410M	S46
3767814	OFKT53AFEN4LBJ KC422M	S46
3768928	CCMT2151FP KCP05	B190
3768930	CCMT3251FP KCP05	B190
3768936	CCMT21505FP KCP10	B190
3768937	CCMT2151FP KCP10	B190
3768940	CCMT3252FP KCP10	B190
3768970	DCMT2152FP KCP05	B225
3768971	DCMT3251FP KCP05	B225
3768972	DCMT3252FP KCP05	B225
3768973	DCMT432FP KCP05	B225
3768984	TCMT222FP KCP05	B257
3768985	TCMT223FP KCP05	B257
3768989	TCMT432FP KCP05	B257
3768996	VBMT331FP KCP05	B281
3768997	VBMT332FP KCP05	B281
3769003	CCMT433FP KCP10	B190
3769005	CPMT21505FP KCP10	B206
3769006	CPMT2151FP KCP10	B206
3769008	CPMT3251FP KCP10	B206
3769009	CPMT3252FP KCP10	B206
3769010	DCMT2151FP KCP10	B225
3769012	DCMT3251FP KCP10	B225
3769013	DCMT3252FP KCP10	B225
3769014	DCMT3253FP KCP10	B225
3769015	DCMT431FP KCP10	B225
3769017	DPMT2151FP KCP10	B231
3769018	DPMT3251FP KCP10	B231
3769020	SCMT3251FP KCP10	B246
3769021	SCMT3252FP KCP10	B246
3769026	TCMT2151FP KCP10	B257
3769028	TCMT3251FP KCP10	B257
3769029	TCMT3252FP KCP10	B257
3769030	TCMT3253FP KCP10	B257
3769033	TPMT2151FP KCP10	B267
3769035	TPMT3251FP KCP10	B267
3769036	TPMT3252FP KCP10	B267
3769037	VBMT221FP KCP10	B281
3769038	VBMT331FP KCP10	B281
3769039	VBMT332FP KCP10	B281
3769050	CCMT2151FP KTP10	B190
3769051	CCMT2152FP KTP10	B190
3769052	CCMT32505FP KTP10	B190
3769053	CCMT3251FP KTP10	B190
3769054	CCMT3252FP KTP10	B190
3769055	CPMT21505FP KTP10	B206
3769056	CPMT2151FP KTP10	B206
3769057	CPMT2152FP KTP10	B206
3769060	CPMT3252FP KTP10	B206
3769061	DCMT21505FP KTP10	B225
3769063	DCMT32505FP KTP10	B225
3769064	DCMT3251FP KTP10	B225
3769065	DCMT3252FP KTP10	B225
3769066	DPMT2151FP KTP10	B231
3769068	DPMT3252FP KTP10	B231
3769069	SCMT3252FP KTP10	B246
3769071	TCMT21505FP KTP10	B257
3769072	TCMT2151FP KTP10	B257
3769076	TCMT3252FP KTP10	B257
3769082	VBMT221FP KTP10	B281
3769083	VBMT3305FP KTP10	B281
3769084	VBMT331FP KTP10	B281
3769085	VBMT332FP KTP10	B281
3769093	CCMT21505FP KCP25	B190
3769094	CCMT2151FP KCP25	B190
3769095	CCMT2151FP KCM15	B190
3769096	CCMT2152FP KCP25	B190
3769097	CCMT32505FP KCP25	B190
3769099	CCMT3251FP KCM15	B190
3769103	CCMT3251FP KCP25	B190
3769106	CCMT3252FP KCP25	B190
3769107	CPMT3251FP KCM15	B206
3769109	DCMT2151FP KCM15	B225
3769111	DCMT3251FP KCM15	B225
3769112	DCMT3252FP KCM15	B225
3769114	DPMT2151FP KCM15	B231
3769118	SCMT3252FP KCM15	B246
3769121	CPMT18151FP KCP25	B206
3769122	TCMT2152FP KCM15	B257
3769124	CPMT21505FP KCP25	B206
3769128	CPMT2151FP KCP25	B206
3769130	VBMT221FP KCM15	B281
3769131	VBMT222FP KCM15	B281
3769132	CPMT2152FP KCP25	B206
3769133	VBMT331FP KCM15	B281
3769134	VBMT332FP KCM15	B281
3769139	DCMT2151FP KCP25	B225
3769140	DCMT2152FP KCP25	B225
3769141	DCMT32505FP KCP25	B225
3769142	DCMT3251FP KCP25	B225
3769143	DCMT3252FP KCP25	B225
3769146	DCMT432FP KCP25	B225
3769147	DPMT2151FP KCP25	B231
3769148	DPMT3251FP KCP25	B231
3769150	SCMT3251FP KCP25	B246
3769151	SCMT3252FP KCP25	B246
3769152	SCMT431FP KCP25	B246
3769154	SCMT433FP KCP25	B246
3769155	SPMT3251FP KCP25	B252
3769157	TCMT2151FP KCP25	B257
3769158	TCMT2152FP KCP25	B257
3769159	TCMT3251FP KCP25	B257
3769160	TCMT3252FP KCP25	B257
3769161	TCMT432FP KCP25	B257
3769162	TPMT18152FP KCP25	B267
3769163	TPMT2151FP KCP25	B267
3769165	TPMT3251FP KCP25	B267
3769166	TPMT3252FP KCP25	B267
3769168	VBMT2205FP KCP25	B281
3769169	VBMT221FP KCP25	B281
3769170	VBMT222FP KCP25	B281
3769171	VBMT3305FP KCP25	B281
3769172	VBMT331FP KCP25	B281
3769173	VBMT332FP KCP25	B281
3769174	VBMT333FP KCP25	B281
3769175	WCMT3252FP KCP25	B286
3769176	WPMT2151FP KCP25	B288
3769178	WPMT15121FP KCP25	B288
3769203	CCMT21505FP KCM25	B190
3769204	CCMT2151FP KCM25	B190
3769205	CCMT2152FP KCM25	B190
3769206	CCMT32505FP KCM25	B190
3769207	CCMT3251FP KCM25	B190
3769208	CCMT3252FP KCM25	B190
3769210	CCMT432FP KCM25	B190
3769223	CPMT21505FP KCM25	B206
3769224	CPMT2151FP KCM25	B206
3769226	CPMT32505FP KCM25	B206
3769227	CPMT3251FP KCM25	B206
3769228	CPMT3252FP KCM25	B206
3769229	DCMT21505FP KCM25	B225
3769230	DCMT2151FP KCM25	B225
3769231	DCMT2152FP KCM25	B225
3769232	DCMT32505FP KCM25	B225
3769233	DCMT3251FP KCM25	B225
3769234	DCMT3252FP KCM25	B225
3769235	DCMT431FP KCM25	B225
3769236	DCMT432FP KCM25	B225
3769240	SCMT3251FP KCM25	B246
3769243	SCMT432FP KCM25	B246
3769248	TCMT2151FP KCM25	B257
3769251	TCMT3252FP KCM25	B257
3769253	TCMT432FP KCM25	B257
3769257	TPMT3251FP KCM25	B267
3769260	VBMT221FP KCM25	B281
3769262	VBMT3305FP KCM25	B281
3769283	VBMT331FP KCM25	B281
3769284	VBMT332FP KCM25	B281
3769285	WPMT2151FP KCM25	B288
3769290	CCMT21505FP KCU10	B190
3769291	CCMT2151FP KCU10	B190
3769292	CCMT2152FP KCU10	B190
3769310	CPMT2151FP KCK20	B206
3769320	SCMT3252FP KCK20	B246
3769334	TPMT3251FP KCK20	B267
3769337	VBMT332FP KCK20	B281
3769343	CCMT32505FP KCU10	B190
3769344	CCMT3251FP KCU10	B190
3769345	CCMT431FP KCU10	B190

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3769346	CCMT432FP KCU10	B190
3769347	CPMT181505FP KCU10	B206
3769348	CPMT18151FP KCU10	B206
3769349	CPMT21505FP KCU10	B206
3769350	CPMT2151FP KCU10	B206
3769352	CPMT32505FP KCU10	B206
3769353	CPMT3251FP KCU10	B206
3769354	CPMT3252FP KCU10	B206
3769355	DCMT21505FP KCU10	B225
3769356	DCMT2151FP KCU10	B225
3769357	DCMT2152FP KCU10	B225
3769358	DCMT32505FP KCU10	B225
3769359	DCMT3251FP KCU10	B225
3769360	DCMT3252FP KCU10	B225
3769363	DCMT432FP KCU10	B225
3769364	DPMT21505FP KCU10	B231
3769365	DPMT2151FP KCU10	B231
3769366	DPMT2152FP KCU10	B231
3769368	DPMT3251FP KCU10	B231
3769369	DPMT3252FP KCU10	B231
3769370	SCMT3251FP KCU10	B246
3769371	SCMT3252FP KCU10	B246
3769372	SCMT431FP KCU10	B246
3769373	SCMT432FP KCU10	B246
3769374	SCMT433FP KCU10	B246
3769375	SPMT3251FP KCU10	B252
3769376	SPMT3252FP KCU10	B252
3769377	TCMT18151FP KCU10	B257
3769378	TCMT18152FP KCU10	B257
3769380	TCMT2151FP KCU10	B257
3769381	TCMT2152FP KCU10	B257
3769382	TCMT221FP KCU10	B257
3769383	TCMT222FP KCU10	B257
3769384	TCMT223FP KCU10	B257
3769386	TCMT3251FP KCU10	B257
3769387	TCMT3252FP KCU10	B257
3769388	TCMT3253FP KCU10	B257
3769389	TCMT432FP KCU10	B257
3769390	TPMT18151FP KCU10	B267
3769391	TPMT18152FP KCU10	B267
3769392	TPMT21505FP KCU10	B267
3769393	TPMT2151FP KCU10	B267
3769394	TPMT2152FP KCU10	B267
3769395	TPMT221FP KCU10	B267
3769396	TPMT222FP KCU10	B267
3769397	TPMT3251FP KCU10	B267
3769401	VBMT2205FP KCU10	B281
3769402	VBMT221FP KCU10	B281
3769403	VBMT222FP KCU10	B281
3769404	VBMT3305FP KCU10	B281
3769405	VBMT331FP KCU10	B281
3769406	VBMT332FP KCU10	B281
3769407	WCMT2151FP KCU10	B286
3769408	WCMT3252FP KCU10	B286
3769409	WPMT2151FP KCU10	B288
3769410	WPMT3251FP KCU10	B288
3769411	WPMT3252FP KCU10	B288
3769412	WPMT15121FP KCU10	B288
3769413	CCMT21505FP KCU25	B190
3769414	CCMT2151FP KCU25	B190
3769415	CCMT2152FP KCU25	B190
3769416	CCMT32505FP KCU25	B190
3769417	CCMT3251FP KCU25	B190
3769418	CCMT3252FP KCU25	B190
3769419	CCMT431FP KCU25	B190
3769421	CPMT181505FP KCU25	B206
3769422	CPMT18151FP KCU25	B206
3769423	CPMT21505FP KCU25	B206
3769424	CPMT2151FP KCU25	B206
3769427	CPMT3251FP KCU25	B206
3769428	CPMT3252FP KCU25	B206
3769430	DCMT2151FP KCU25	B225
3769431	DCMT32505FP KCU25	B225
3769432	DCMT3251FP KCU25	B225
3769433	DCMT3252FP KCU25	B225
3769435	DPMT2151FP KCU25	B231
3769436	DPMT2152FP KCU25	B231
3769438	DPMT3251FP KCU25	B231
3769440	SCMT3251FP KCU25	B246
3769441	SCMT3252FP KCU25	B246
3769444	SPMT3251FP KCU25	B252
3769446	TCMT18151FP KCU25	B257
3769447	TCMT18152FP KCU25	B257
3769448	TCMT21505FP KCU25	B257
3769449	TCMT2151FP KCU25	B257
3769450	TCMT2152FP KCU25	B257
3769451	TCMT221FP KCU25	B257
3769452	TCMT222FP KCU25	B257
3769454	TCMT3251FP KCU25	B257
3769455	TCMT3252FP KCU25	B257
3769456	TCMT3253FP KCU25	B257
3769457	TCMT432FP KCU25	B257
3769458	TPMT18152FP KCU25	B267
3769460	TPMT2151FP KCU25	B267
3769461	TPMT221FP KCU25	B267
3769462	TPMT3251FP KCU25	B267
3769463	TPMT3252FP KCU25	B267
3769464	VBMT221FP KCU25	B281
3769465	VBMT222FP KCU25	B281
3769466	VBMT3305FP KCU25	B281
3769467	VBMT331FP KCU25	B281
3769468	VBMT332FP KCU25	B281
3769469	WCMT2151FP KCU25	B286
3773323	B967A05000 KC7315	G130
3774249	HNPJ535ANSNHD KC522M	S19, S23
3774250	HNPJ535ANSNGD KC522M	S19, S22
3774251	HNPJ53511ANSNHD KC522M	S19, S23
3774691	A4G0405M04U04GUP KCU25	C102
3774692	A4G0405M04U08GUP KCU25	C102
3774723	A4G0505M05U08GUP KCU25	C102
3774724	A4G0805M08U12GUP KCU25	C102
3774906	SPPX15T508RHP KC7140	J103
3774919	EP1016SGE KC522M	T37, T46
3774920	EP1016SGE KC725M	T37, T46
3774921	EP1016SGE KCPK30	T37, T46
3775003	EP1012SGE KC522M	T37, T46
3775004	EP1012SGE KC725M	T37, T46
3775005	EP1012SGE KCPK30	T37, T46
3775016	EP1008SGE KC522M	T37, T46
3775017	EP1008SGE KC725M	T37, T46
3775018	EP1008SGE KCPK30	T37, T46
3775022	EP1031SGE KC522M	T37, T46
3775063	EP1031SGE KC725M	T37, T46
3775064	EP1031SGE KCPK30	T37, T46
3776430	B291A12900YPL KC7315	G90
3779249	EP1004SGE KC522M	T37, T46
3779250	EP1004SGE KC725M	T37, T46
3779251	EP1004SGE KCPK30	T37, T46
3780360	MS-2071	T14–17, V75–77
3781192	A4G0200M02P02GUP KCU10	C103
3781252	A4G0200M02P02GUP KCU25	C103
3781253	A4G0300M03P02GUP KCU25	C103
3781254	A4G0300M03P04GUP KCU25	C103
3781255	A4G0400M04P02GUP KCU25	C103
3781256	A4G0400M04P04GUP KCU25	C103
3781257	A4G0400M04P08GUP KCU25	C103
3781258	A4G0500M05P04GUP KCU25	C103
3781259	A4G0500M05P08GUP KCU25	C103
3781260	A4G0600M06P04GUP KCU25	C103
3781261	A4G0600M06P08GUP KCU25	C103
3781262	A4G0800M08P08GUP KCU25	C103
3781263	A4G0800M08P12GUP KCU25	C103
3781264	A4G1000M10P08GUP KCU25	C103
3781265	A4G1000M10P12GUP KCU25	C103
3781278	A4G0300M03P02GUP KCU10	C103
3781279	A4G0300M03P04GUP KCU10	C103
3781280	A4G0400M04P02GUP KCU10	C103
3781281	A4G0400M04P04GUP KCU10	C103
3781282	A4G0400M04P08GUP KCU10	C103
3781283	A4G0500M05P04GUP KCU10	C103
3781284	A4G0500M05P08GUP KCU10	C103
3781285	A4G0600M06P04GUP KCU10	C103
3781286	A4G0600M06P08GUP KCU10	C103
3781287	A4G0800M08P08GUP KCU10	C103
3781288	A4G0800M08P12GUP KCU10	C103
3781289	A4G1000M10P08GUP KCU10	C103
3781290	A4G1000M10P12GUP KCU10	C103
3781677	S329	B409
3782185	KT30L	C143, C145
3782458	B978A03000 KC7315	G139
3784063	193.523	H126–129
3784064	193.524	H126–129
3784065	193.525	H126–129
3784066	193.526	H126–129
3784326	170.350	H122
3784327	170.353	H122
3784328	170.355	H122–123
3784329	170.356	H122–123
3784330	170.345	H122
3784331	170.346	H122
3784332	170.347	H122–123
3784473	170.348	H123
3784474	FBSCFCR09CA06F	K116
3784475	FBSCFCL09CA06F	K116
3784476	FBSCLCR09CA06F	K116
3784477	FBSCLCL09CA06F	K116
3787461	RPGV23MP KCS10	B167
3787462	RPGV35MP KCS10	B167
3787483	RPGV45MP KCS10	B167
3787484	RCGV23MP KCS10	B166
3787486	RCGV45MP KCS10	B166
3787488	RPGT23MP KCS10	B245
3787492	RCMT0803M0MP KCS10	B240
3787503	RCMT10T3M0MP KCS10	B240
3787504	RCMT43MP KCS10	B240
3787505	RCMT1606M0MP KCS10	B240
3787507	RCMK23MP KCS10	E69
3787508	RCMK35MP KCS10	E69
3787509	RCMK46MP KCS10	E69
3787512	RCGH43MP KCS10	B238
3789794	KTIP0827R3SS088	H39
3789795	KTIP0866R3SS088	H39
3789796	KTIP0906R3SS094	H39
3789797	KTIP0945R3SS100	H39
3789798	KTIP0984R3SS100	H39
3789799	KTIP0827R5SS088	H39
3789800	KTIP0866R5SS088	H39
3789801	KTIP0906R5SS094	H39
3789802	KTIP0945R5SS100	H39
3789833	KTIP0984R5SS100	H39
3789834	KTIP0827R8SS088	H39
3789835	KTIP0866R8SS088	H39
3789836	KTIP0906R8SS094	H39
3789837	KTIP0945R8SS100	H39
3789838	KTIP0984R8SS100	H39
3790401	KTIP210R3SS25M	H38
3790402	KTIP220R3SS25M	H38
3790443	KTIP230R3SS25M	H38
3790444	KTIP240R3SS25M	H38
3790445	KTIP250R3SS32M	H38
3790446	KTIP210R3SCF25M	H40
3790447	KTIP220R3SCF25M	H40
3790448	KTIP230R3SCF25M	H40
3790449	KTIP240R3SCF25M	H40
3790450	KTIP250R3SCF25M	H40
3790451	KTIP210R5SS25M	H38
3790452	KTIP220R5SS25M	H38
3790453	KTIP230R5SS25M	H38
3790454	KTIP240R5SS25M	H38
3790455	KTIP250R5SS32M	H38
3790456	KTIP210R5SCF25M	H40
3790457	KTIP220R5SCF25M	H40
3790458	KTIP230R5SCF25M	H40
3790459	KTIP240R5SCF25M	H40
3790460	KTIP250R5SCF25M	H40
3790461	KTIP210R8SS25M	H38
3790462	KTIP220R8SS25M	H38
3790463	KTIP230R8SS25M	H38
3790464	KTIP240R8SS25M	H38
3790465	KTIP250R8SS32M	H38
3790466	KTIP210R8SCF25M	H40
3790467	KTIP220R8SCF25M	H40
3790468	KTIP230R8SCF25M	H40
3790469	KTIP240R8SCF25M	H40
3790470	KTIP250R8SCF25M	H40
3791263	A4G0205M02U02GUP KCU10	C102
3791265	A4G0305M03U02GUP KCU10	C102
3791266	A4G0305M03U04GUP KCU10	C102
3791267	A4G0405M04U04GUP KCU10	C102
3791268	A4G0405M04U08GUP KCU10	C102
3791269	A4G0505M05U04GUP KCU10	C102
3791270	A4G0505M05U08GUP KCU10	C102
3791271	A4G0605M06U04GUP KCU10	C102
3791272	A4G0605M06U08GUP KCU10	C102
3791273	A4G0605M06U12GUP KCU10	C102
3791275	A4G0805M08U08GUP KCU10	C102
3791276	A4G0805M08U12GUP KCU10	C102
3791277	A4G1005M10U08GUP KCU10	C102
3791279	A4G0205M02U02GUP KCU25	C102
3791280	A4G0305M03U02GUP KCU25	C102
3791281	A4G0305M03U04GUP KCU25	C102
3791282	A4G0505M05U04GUP KCU25	C102
3791283	A4G0605M06U04GUP KCU25	C102
3791284	A4G0605M06U08GUP KCU25	C102
3791285	A4G0605M06U12GUP KCU25	C102
3791286	A4G0805M08U08GUP KCU25	C102
3791287	A4G1005M10U08GUP KCU25	C102
3791288	A4G1005M10U12GUP KCU25	C102
3791289	A4G0205M02U02GUP KCP10	C102
3791290	A4G0305M03U02GUP KCP10	C102
3791291	A4G0305M03U04GUP KCP10	C102
3791292	A4G0405M04U04GUP KCP10	C102
3791293	A4G0405M04U08GUP KCP10	C102
3791294	A4G0505M05U04GUP KCP10	C102
3791295	A4G0505M05U08GUP KCP10	C102
3791296	A4G0605M06U04GUP KCP10	C102
3791297	A4G0605M06U08GUP KCP10	C102
3791298	A4G0605M06U12GUP KCP10	C102
3791299	A4G0805M08U08GUP KCP10	C102
3791300	A4G0805M08U12GUP KCP10	C102
3791301	A4G1005M10U08GUP KCP10	C102
3791303	A4G0205M02U02GUP KCP25	C102
3791304	A4G0305M03U02GUP KCP25	C102
3791305	A4G0305M03U04GUP KCP25	C102
3791306	A4G0405M04U04GUP KCP25	C102
3791307	A4G0405M04U08GUP KCP25	C102
3791308	A4G0505M05U04GUP KCP25	C102
3791309	A4G0505M05U08GUP KCP25	C102
3791310	A4G0605M06U04GUP KCP25	C102
3791311	A4G0605M06U08GUP KCP25	C102
3791312	A4G0605M06U12GUP KCP25	C102
3791313	A4G0805M08U08GUP KCP25	C102
3791314	A4G0805M08U12GUP KCP25	C102
3791316	A4G1005M10U12GUP KCP25	C102
3791545	B976A11600 KC7315	G137
3793949	KSEMP3320FDS32A1M	H104, H115, H122
3793950	KSEMP3920FDS36A1M	H104, H116, H122
3794291	KSEMP3200FDS32A1M	H104, H115, H122
3794292	KSEMP3400FDS32A1M	H104, H115, H122
3794393	KSEMP3500FDS32A1M	H104, H115, H122
3794394	KSEMP3600FDS36A1M	H104, H116, H122
3794395	KSEMP3700FDS36A1M	H104, H116, H122
3794396	KSEMP3800FDS36A1M	H104, H116, H122
3794397	KSEMP3900FDS36A1M	H104, H116, H122
3794398	KSEMP4000FDS40A1M	H104, H116, H122
3794399	KSEMP4100FDS40A1M	H104, H116, H122
3794400	KSEMP4200FDS40A1M	H104, H116, H122
3794401	KSEMP4300FDS40A1M	H104, H116, H122
3794402	KSEMP4400FDS40A1M	H104, H116, H122
3794403	KSEMP4500FDS45A1M	H105, H116, H122
3794404	KSEMP4600FDS45A1M	H105, H116, H122
3794405	KSEMP4700FDS45A1M	H105, H116, H122
3794406	KSEMP4800FDS45A1M	H105, H116, H122
3794407	KSEMP4900FDS45A1M	H105, H116, H122
3794408	KSEMP5100FDS50A1M	H105, H116, H122
3794409	KSEMP5200FDS50A1M	H105, H116, H122

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3794410	KSEMP5300FDS50A1M	H105, H116, H122
3794411	KSEMP5400FDS50A1M	H105, H116, H122
3794412	KSEMP5500FDS50A1M	H105, H116, H122
3794413	KSEMP5600FDS56A1M	H105, H116, H122
3794414	KSEMP5700FDS56A1M	H105, H116, H122
3794415	KSEMP5800FDS56A1M	H105, H116, H122
3794416	KSEMP5900FDS56A1M	H105, H116, H122
3794417	KSEMP6000FDS56A1M	H105, H116, H122
3794418	KSEMP6100FDS56A1M	H105, H116, H122
3794419	KSEMP6200FDS56A1M	H105, H116, H122
3794420	KSEMP6300FDS63A1M	H105, H116, H122
3794421	KSEMP6400FDS63A1M	H105, H116, H123
3794422	KSEMP6500FDS63A1M	H105, H116, H123
3794423	KSEMP6600FDS63A1M	H105, H116, H123
3794424	KSEMP6700FDS63A1M	H105, H116, H123
3794425	KSEMP6800FDS63A1M	H105, H116, H123
3794426	KSEMP6900FDS63A1M	H105, H116, H123
3794427	KSEMP3750FDS36A1M	H104, H116, H122
3794428	WD32FDS32216M	H127
3794429	WD32FDS32391M	H127
3794430	WD32FDS36244M	H127
3794431	WD32FDS36361M	H127
3794432	WD32FDS36439M	H127
3794443	WD50FDS40271M	H127
3794444	WD50FDS40403M	H127
3794445	WD50FDS40491M	H127
3794446	WD50FDS45304M	H127
3794447	WD50FDS45451M	H127
3794448	WD50FDS45549M	H127
3794449	WD50FDS50338M	H127
3794450	WD50FDS50613M	H127
3794451	WD50FDS56383M	H127
3794452	WD50FDS56569M	H127
3794453	WD50FDS56693M	H127
3794454	WD50FDS63429M	H127
3794455	WD50FDS63639M	H127
3794835	SSF150FDS320850	H129
3794836	SSF150FDS321263	H129
3794837	SSF150FDS321539	H129
3794838	SSF150FDS360960	H129
3794839	SSF150FDS361421	H129
3794840	SSF150FDS361728	H129
3794841	SSF200FDS401066	H129
3794842	SSF200FDS401586	H129
3794903	SSF200FDS401933	H129
3794904	SSF200FDS451196	H129
3794905	SSF200FDS451775	H129
3794906	SSF200FDS452161	H129
3794907	SSF200FDS501330	H129
3794908	SSF200FDS501980	H129
3794909	SSF200FDS502413	H129
3794910	SSF200FDS561507	H129
3794911	SSF200FDS562240	H129
3794912	SSF200FDS562783	H129
3794913	SSF200FDS631688	H129
3794914	SSF200FDS632515	H129
3794915	SSF200FDS633066	H129
3794916	KSEMP1250FDS32A1	H104, H115, H122
3794917	KSEMP1313FDS32A1	H104, H115, H122
3794918	KSEMP1375FDS32A1	H104, H115, H122
3794919	KSEMP1438FDS36A1	H104, H116, H122
3794920	KSEMP1500FDS36A1	H104, H116, H122
3794921	KSEMP1563FDS36A1	H104, H116, H122
3794922	KSEMP1625FDS40A1	H104, H116, H122
3794933	KSEMP1750FDS40A1	H104, H116, H122
3794934	KSEMP1875FDS45A1	H105, H116, H122
3794935	KSEMP2000FDS50A1	H105, H116, H122
3794936	KSEMP2125FDS50A1	H105, H116, H122
3794937	KSEMP2250FDS56A1	H105, H116, H122
3794938	KSEMP2375FDS56A1	H105, H116, H122
3794939	KSEMP2500FDS63A1	H105, H116, H123
3794940	KSEMP2625FDS63A1	H105, H116, H123
3794941	KSEMP2750FDS63A1	H105, H116, H123
3795256	RMB14000H7HF KT6215	K18
3795257	RMB15000H7HF KT6215	K18
3795258	RMB16000H7HF KT6215	K18
3795260	RMB18000H7HF KT6215	K18
3795261	RMB19000H7HF KT6215	K18
3795262	RMB20000H7HF KT6215	K18
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	DNMG443MP KCP10	B81
3830321	B976A08020 KC7315	G136
3838225	WNMG433MP KCP10	B159
3842812	B291A13800YPL KC7315	G90
3842895	H32LSER5	D76
3842897	H40LSER5	D76
3848433	B967A15500 KC7315	G132
3849319	XNGJ535ANFNLDJ3W KC410M	S21
3849320	HNGJ535ANFNLDJ KC410M	S18, S21
3852200	RPET1204M0ELE KC725M	V71
3852233	RPET1204M0SGE KCPK30	V72
3852235	RPET1204M0ELE KCPK30	V71
3852284	RPPT1605M0SHP KC725M	V79
3852285	RPPT1605M0SHP KCPK30	V79
3852395	RPPT1204M0SGP KC725M	V72
3852396	RPPT1204M0SGP KCPK30	V72
3854146	RIR04EDS06 KD1415	K56
3854265	A4SMR2020K0208	C126
3854266	A4SML2020K0208	C126
3854267	A4SMR2020K0308	C126
3854268	A4SML2020K0308	C126
3854269	A4SMR2020K0408	C126
3854270	A4SML2020K0408	C126
3854271	A4SMR2525M0510	C126
3854272	A4SML2525M0510	C126
3854273	A4SMR2525M0610	C126
3854274	A4SML2525M0610	C126
3854277	A4SMR120308	C126
3854281	A4SMR160510	C126
3854632	AADE0250J3B K600	P128
3854739	AADE0312J3A K600	P128
3854756	AADE0375J3B K600	P129
3854759	AADE0500J3B K600	P129
3854761	AADE0625J3A K600	P129
3854762	AADE0750J3B K600	P130
3855176	EP1416SGE KC522M	T58, T69
3855177	EP1416SGE KC725M	T58, T69
3855178	EP1416SGE KCPK30	T58, T69
3855180	EP1431SGE KC725M	T58, T69
3855181	EP1431SGE KCPK30	T58, T69
3855209	EP1404SGE KC522M	T58, T69
3855210	EP1404SGE KC725M	T58, T69
3855211	EP1404SGE KCPK30	T58, T69
3855236	EP1408SGE KC522M	T58, T69
3855237	EP1408SGE KC725M	T58, T69
3855238	EP1408SGE KCPK30	T58, T69
3855240	EP1412SGE KC522M	T58, T69
3855241	EP1412SGE KC725M	T58, T69
3855242	EP1412SGE KCPK30	T58, T69
3855383	B291A04300YPL KC7315	G88
3855561	CNMG432MP KCP10	B51
3855796	CM234R ASSY	B58–60, B67–68, B87–88, B91–92, B98, B109–110, B113, B131, B154, B163
3855854	B291A08800YPL KC7315	G89
3856322	LT27ER4API502 KC5025	D52
3856324	LT27ER4API382 KC5025	D52
3856327	LT27NR4API502 KC5025	D62
3856329	LT27NR4API382 KC5025	D62
3856518	DNGX120712T02020 KYK25	B317
3856520	DNGX453T0820 KYK25	B317
3856521	SNGX453T0820 KYK25	B318
3856522	SNGX454T0820 KYK25	B318
3856532	SNG432T0820 KYK25	B318
3856553	SNG433T0820 KYK25	B318
3856554	SNG453T0820 KYK25	B318
3856558	CNGA432T0820 KYK25	B313
3856559	CNGA433T0820 KYK25	B313
3856560	CNGA434T0820 KYK25	B313
3856561	CNGA432T0420FW KYK25	B313
3856562	CNGA433T0420FW KYK25	B313
3856604	CNGA644T0820 KYK25	B313
3856607	DNGA434T0820 KYK25	B314
3856608	SNGA432T0820 KYK25	B314
3856609	SNGA433T0820 KYK25	B314
3856611	SNGA543T0820 KYK25	B314
3856614	VNGA432T0820 KYK25	B315
3856615	WNGA432T0820 KYK25	B315
3856616	WNGA433T0820 KYK25	B315
3856618	CNGA543T0820 KYK25	B313
3856793	RIR04E1312 KC6005	K56
3856806	RIR02E1312 KC6305	K56
3856807	RIR03E1312 KC6305	K56
3856827	RIRT4C4512 KC6005	K57
3858114	EP1808SGE KCPK30	T84
3858115	EP1808SGE KC522M	T84
3858116	EP1808SGE KC725M	T84
3858210	B978A04200 KC7315	G139
3858724	RIR01E1312 KC6105	K56
3858725	RIR02E1312 KC6105	K56
3858727	RIR01EGU00 KC6105	K56
3858731	RIR05EGU00 KC6105	K56
3858814	KST175CS	K43
3858815	KST200CS	K43
3858817	KST250CS	K43
3858818	KST300CS	K43
3858819	KST350CS	K43
3859000	B292A07400YPL KC7315	G89
3859044	SDET4316SNGB KC725M	T116, T123, U39
3859155	B292A08100YPL KC7315	G89
3860364	RHM20000KST175H7HF KT325	K33
3860365	RHM20640KST175H7HF KT325	K33
3860366	RHM21000KST175H7HF KT325	K33
3860367	RHM22000KST175H7HF KT325	K33
3860368	RHM22230KST175H7HF KT325	K33
3860369	RHM22500KST200H7HF KT325	K33
3860370	RHM23000KST200H7HF KT325	K33
3860371	RHM23810KST200H7HF KT325	K33
3860372	RHM24000KST200H7HF KT325	K33
3860383	RHM25000KST200H7HF KT325	K33
3860384	RHM25400KST200H7HF KT325	K33
3860385	RHM26000KST200H7HF KT325	K33
3860386	RHM26990KST200H7HF KT325	K33
3860387	RHM27000KST200H7HF KT325	K33
3860388	RHM27500KST250H7HF KT325	K33
3860389	RHM28000KST250H7HF KT325	K34
3860390	RHM28580KST250H7HF KT325	K34
3860391	RHM29000KST250H7HF KT325	K34
3860392	RHM30000KST250H7HF KT325	K34
3860393	RHM30160KST250H7HF KT325	K34
3860394	RHM31000KST250H7HF KT325	K34
3860395	RHM31750KST250H7HF KT325	K34
3860396	RHM32000KST250H7HF KT325	K34
3860397	RHM32500KST300H7HF KT325	K34
3860398	RHM33000KST300H7HF KT325	K34
3860399	RHM33340KST300H7HF KT325	K34
3860401	RHM34930KST300H7HF KT325	K34
3860402	RHM35000KST300H7HF KT325	K34
3860403	RHM36000KST300H7HF KT325	K34
3860404	RHM36510KST300H7HF KT325	K34
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3860408	RHM38100KST350H7HF KT325	K34
3860409	RHM39000KST350H7HF KT325	K34
3860410	RHM39690KST350H7HF KT325	K34
3860411	RHM40000KST350H7HF KT325	K34
3860412	RHM41000KST350H7HF KT325	K34
3860413	RHM41280KST350H7HF KT325	K34
3860414	RHM42000KST350H7HF KT325	K34
3860476	RHM20000KST175H7SF KT325	K31
3860477	RHM20640KST175H7SF KT325	K31
3860478	RHM21000KST175H7SF KT325	K31
3860480	RHM22230KST175H7SF KT325	K31
3860481	RHM22500KST200H7SF KT325	K31
3860482	RHM23000KST200H7SF KT325	K31
3860513	RHM23810KST200H7SF KT325	K31
3860514	RHM24000KST200H7SF KT325	K31
3860515	RHM25000KST200H7SF KT325	K31
3860516	RHM25400KST200H7SF KT325	K31
3860517	RHM26000KST200H7SF KT325	K31
3860518	RHM26990KST200H7SF KT325	K31
3860519	RHM27000KST200H7SF KT325	K31
3860520	RHM27500KST250H7SF KT325	K32
3860521	RHM28000KST250H7SF KT325	K32
3860522	RHM28580KST250H7SF KT325	K32
3860523	RHM29000KST250H7SF KT325	K32
3860524	RHM30000KST250H7SF KT325	K32
3860525	RHM30160KST250H7SF KT325	K32
3860526	RHM31000KST250H7SF KT325	K32
3860527	RHM31750KST250H7SF KT325	K32
3860528	RHM32000KST250H7SF KT325	K32
3860529	RHM32500KST300H7SF KT325	K32
3860530	RHM33000KST300H7SF KT325	K32
3860531	RHM33340KST300H7SF KT325	K32
3860532	RHM34000KST300H7SF KT325	K32
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3860534	RHM35000KST300H7SF KT325	K32
3860535	RHM36000KST300H7SF KT325	K32
3860536	RHM36510KST300H7SF KT325	K32
3860537	RHM37000KST300H7SF KT325	K32
3860538	RHM37500KST350H7SF KT325	K32
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3860542	RHM39690KST350H7SF KT325	K32
3860544	RHM41000KST350H7SF KT325	K32
3860545	RHM41280KST350H7SF KT325	K32
3860546	RHM42000KST350H7SF KT325	K32
3860625	RHM20000KST175H7SF KT6215	K31
3860626	RHM20640KST175H7SF KT6215	K31
3860627	RHM21000KST175H7SF KT6215	K31
3860628	RHM22000KST175H7SF KT6215	K31
3860629	RHM22230KST175H7SF KT6215	K31
3860630	RHM22500KST200H7SF KT6215	K31
3860631	RHM23000KST200H7SF KT6215	K31
3860632	RHM23810KST200H7SF KT6215	K31
3860643	RHM24000KST200H7SF KT6215	K31
3860644	RHM25000KST200H7SF KT6215	K31
3860645	RHM25400KST200H7SF KT6215	K31
3860647	RHM26990KST200H7SF KT6215	K31
3860648	RHM27000KST200H7SF KT6215	K31
3860649	RHM27500KST250H7SF KT6215	K32
3860650	RHM28000KST250H7SF KT6215	K32
3860651	RHM28580KST250H7SF KT6215	K32
3860652	RHM29000KST250H7SF KT6215	K32
3860653	RHM30000KST250H7SF KT6215	K32
3860655	RHM31000KST250H7SF KT6215	K32
3860656	RHM31750KST250H7SF KT6215	K32
3860658	RHM32500KST300H7SF KT6215	K32
3860659	RHM33000KST300H7SF KT6215	K32
3860660	RHM33340KST300H7SF KT6215	K32
3860662	RHM34930KST300H7SF KT6215	K32
3860663	RHM35000KST300H7SF KT6215	K32
3860664	RHM36000KST300H7SF KT6215	K32
3860665	RHM36510KST300H7SF KT6215	K32

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3860667	RHM37500KST350H7SF KT6215	K32
3860668	RHM38000KST350H7SF KT6215	K32
3860669	RHM38100KST350H7SF KT6215	K32
3860670	RHM39000KST350H7SF KT6215	K32
3860671	RHM39690KST350H7SF KT6215	K32
3860672	RHM40000KST350H7SF KT6215	K32
3860673	RHM41000KST350H7SF KT6215	K32
3860674	RHM41280KST350H7SF KT6215	K32
3860675	RHM42000KST350H7SF KT6215	K32
3860855	RHM20000KST175H7HF KT6215	K33
3860856	RHM20640KST175H7HF KT6215	K33
3860857	RHM21000KST175H7HF KT6215	K33
3860858	RHM22000KST175H7HF KT6215	K33
3860859	RHM22230KST175H7HF KT6215	K33
3860860	RHM22500KST200H7HF KT6215	K33
3860861	RHM23000KST200H7HF KT6215	K33
3860862	RHM23810KST200H7HF KT6215	K33
3860863	RHM24000KST200H7HF KT6215	K33
3860864	RHM25000KST200H7HF KT6215	K33
3860865	RHM25400KST200H7HF KT6215	K33
3860867	RHM26990KST200H7HF KT6215	K33
3860868	RHM27000KST200H7HF KT6215	K33
3860869	RHM27500KST250H7HF KT6215	K33
3860870	RHM28000KST250H7HF KT6215	K34
3860872	RHM29000KST250H7HF KT6215	K34
3860873	RHM30000KST250H7HF KT6215	K34
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3860893	RHM41000KST350H7HF KT6215	K34
3860894	RHM41280KST350H7HF KT6215	K34
3860895	RHM42000KST350H7HF KT6215	K34
3861185	SS20KST175AR3M	K42
3861186	SS20KST200AR3M	K42
3861187	SS25KST250AR3M	K42
3861188	SS32KST300AR3M	K42
3861189	SS32KST350AR3M	K42
3861190	SS20KST175AR5M	K42
3861191	SS20KST200AR5M	K42
3861192	SS25KST250AR5M	K42
3861193	SS32KST300AR5M	K42
3861194	SS32KST350AR5M	K42
3861195	SS20KST175RR3M	K43
3861196	SS20KST200RR3M	K43
3861197	SS25KST250RR3M	K43
3861198	SS32KST300RR3M	K43
3861199	SS32KST350RR3M	K43
3861200	SS20KST175RR5M	K43
3861201	SS20KST200RR5M	K43
3861202	SS25KST250RR5M	K43
3861203	SS32KST300RR5M	K43
3861204	SS32KST350RR5M	K43
3861630	KST175200RK	K43
3861631	KST250250RK	K43
3861632	KST300350RK	K43
3861774	DNGA434T0820 KYK10	B314
3861775	RNG43T0820 KYK10	B318
3861781	TPG323T0820 KYK10	B320
3862224	KST175200AS	K42
3862225	KST250250AS	K42
3862226	KST300350AS	K42
3864351	B292A06200YPL KC7315	G88
3865852	A4SBR122S12016020	C129
3865903	A4SBR122S12020025	C129
3865905	A4SBR123S14020025	C129
3865906	A4SBR123S14025036	C129
3865910	A4SBR165S19038058	C129
3865911	A4SBL122S12016020	C129
3865920	A4SBR2020K2S12016020	C129
3865921	A4SBR2020K2S12020025	C129
3865922	A4SBR2020K2S12025036	C129
3865923	A4SBR2020K3S14020025	C129
3865924	A4SBR2020K3S14025036	C129
3865926	A4SBR2020K4S14035048	C129
3865927	A4SBR2525M5S19028038	C129
3865928	A4SBR2525M5S19038058	C129
3865929	A4SBL2020K2S12016020	C129
3865931	A4SBL2020K2S12025036	C129
3865932	A4SBL2020K3S14020025	C129
3865934	A4SBL2020K4S14025035	C129
3865937	A4SBL2525M5S19038058	C129
3866058	AADE1000J3D K600	P130
3866065	AADE1000J3GRB K600	P130
3866067	AADE1000J3E K600	P130
3866068	AADE1000J3ERA K600	P130
3866069	AADE1000J3ERB K600	P130
3866072	AADE1000J3ERE K600	P130
3866073	AADE1000J3H K600	P130
3866074	AADE1000J3HRA K600	P130
3866202	AADE0500J3F K600	P129
3866253	AADE0500J3FRA K600	P129
3866254	AADE0500J3FRB K600	P129
3866255	AADE0500J3FRC K600	P129
3866256	AADE0500J3BRA K600	P129
3866257	AADE0500J3G K600	P129
3866259	AADE0500J3GRB K600	P129
3866260	AADE0500J3GRC K600	P129
3866261	AADE0500J3GRD K600	P129
3866262	AADE0500J3CRA K600	P129
3866263	AADE0500J3H K600	P129
3866268	AADE0625J3D K600	P130
3866269	AADE0625J3DRA K600	P129
3866272	AADE0625J3DRE K600	P130
3866273	AADE0625J3E K600	P130
3866274	AADE0625J3F K600	P130
3866275	AADE0625J3FRE K600	P130
3866276	AADE0625J3G K600	P130
3866277	AADE0750J3F K600	P130
3866280	AADE0750J3H K600	P130
3866282	AADE0750J3HRB K600	P130
3866284	AADE0750J3HRD K600	P130
3866286	AADE0750J3CRA K600	P130
3866288	AADE0750J3CRE K600	P130
3866289	AADE0750J3G K600	P130
3866290	AADE0750J3GRA K600	P130
3866291	AADE0750J3GRB K600	P130
3866293	AADE0750J3GRD K600	P130
3866294	AADE0750J3GRE K600	P130
3867457	A4M50R2S12B016020	C141
3867458	A4M50R2S12B020025	C141
3867459	A4M50R2S12B025036	C141
3867460	A4M50R3S14B020025	C141
3867461	A4M50R3S14B025036	C141
3867462	A4M50R4S14B025035	C141
3867464	A4M50R5S17B028038	C141
3867466	A4M50L2S12B016020	C142
3867467	A4M50L2S12B020025	C142
3867468	A4M50L2S12B025036	C142
3867469	A4M50L3S14B020025	C142
3867470	A4M50L3S14B025036	C142
3867472	A4M50L4S14B035048	C142
3867484	A4M50L5S17B028038	C142
3867715	B271Z03000HPS KN25	G68
3867716	B271Z03175HPS KN25	G68
3867717	B271Z03200HPS KN25	G68
3867718	B271Z03500HPS KN25	G68
3867719	B271Z03970HPS KN25	G68
3867720	B271Z04000HPS KN25	G68
3867721	B271Z04500HPS KN25	G68
3867722	B271Z04763HPS KN25	G68
3867753	B271Z05000HPS KN25	G68
3867754	B271Z05500HPS KN25	G68
3867755	B271Z06000HPS KN25	G68
3867756	B271Z06200HPS KN25	G68
3867757	B271Z06350HPS KN25	G68
3867758	B271Z06500HPS KN25	G69
3867759	B271Z06746HPS KN25	G69
3867760	B271Z07000HPS KN25	G69
3867761	B271Z07145HPS KN25	G69
3867762	B271Z07500HPS KN25	G69
3867763	B271Z08000HPS KN25	G69
3867765	B271Z08500HPS KN25	G69
3867766	B271Z08733HPS KN25	G69
3867767	B271Z09000HPS KN25	G69
3867768	B271Z09500HPS KN25	G69
3867769	B271Z09525HPS KN25	G69
3867770	B271Z10000HPS KN25	G69
3867771	B272Z03000HPS KN25	G70
3867772	B272Z03175HPS KN25	G70
3867803	B272Z03300HPS KN25	G70
3867804	B272Z03500HPS KN25	G70
3867805	B272Z03970HPS KN25	G70
3867806	B272Z04000HPS KN25	G70
3867807	B272Z04500HPS KN25	G70
3867808	B272Z04763HPS KN25	G70
3867809	B272Z05000HPS KN25	G70
3867810	B272Z05500HPS KN25	G70
3867811	B272Z06000HPS KN25	G70
3867812	B272Z06200HPS KN25	G70
3867813	B272Z06350HPS KN25	G70
3867814	B272Z06500HPS KN25	G70
3867815	B272Z06746HPS KN25	G70
3867816	B272Z07000HPS KN25	G71
3867817	B272Z07145HPS KN25	G71
3867818	B272Z07500HPS KN25	G71
3867819	B272Z08000HPS KN25	G71
3867820	B272Z08500HPS KN25	G71
3867821	B272Z08733HPS KN25	G71
3867822	B272Z09000HPS KN25	G71
3867823	B272Z09525HPS KN25	G71
3867824	B272Z09750HPS KN25	G71
3867825	B272Z10000HPS KN25	G71
3867828	B274Z03000HPS KN25	G73
3867829	B274Z03175HPS KN25	G73
3867830	B274Z03500HPS KN25	G73
3867831	B274Z04000HPS KN25	G73
3867832	B274Z04500HPS KN25	G73
3867833	B273Z03000HPS KN25	G72
3867834	B273Z03175HPS KN25	G72
3867835	B273Z03500HPS KN25	G72
3867836	B273Z04000HPS KN25	G72
3867837	B273Z04500HPS KN25	G72
3867838	B273Z05000HPS KN25	G72
3867839	B273Z05500HPS KN25	G72
3867840	B273Z06000HPS KN25	G72
3867841	B273Z06350HPS KN25	G72
3867842	B273Z06500HPS KN25	G72
3867843	B273Z06746HPS KN25	G72
3867844	B273Z07000HPS KN25	G72
3867845	B273Z08000HPS KN25	G72
3867846	B273Z08500HPS KN25	G72
3867847	B273Z08733HPS KN25	G72
3867849	B273Z09525HPS KN25	G72
3867850	B273Z10000HPS KN25	G72
3867873	B274Z05000HPS KN25	G73
3867874	B274Z05500HPS KN25	G73
3867875	B274Z06000HPS KN25	G73
3867876	B274Z06350HPS KN25	G73
3867877	B274Z06500HPS KN25	G73
3867878	B274Z06746HPS KN25	G73
3867879	B274Z07000HPS KN25	G73
3867880	B274Z08000HPS KN25	G74
3867881	B274Z08500HPS KN25	G74
3867882	B274Z08733HPS KN25	G74
3867883	B274Z09000HPS KN25	G74
3867884	B274Z09525HPS KN25	G74
3867885	B274Z10000HPS KN25	G74
3868079	T620M030X050R6HX-D1 KM6515	M11
3868080	T620M040X070R6HX-D1 KM6515	M11
3868081	T620M050X080R6HX-D1 KM6515	M11
3868082	T620M060X100R6HX-D1 KM6515	M11
3868093	T620M080X125R6HX-D1 KM6515	M11
3868094	T620M100X150R6HX-D1 KM6515	M11
3868095	T620M120X175R6HX-D6 KM6515	M11
3868096	T620M140X200R6HX-D6 KM6515	M11
3868097	T620M160X200R6HX-D6 KM6515	M11
3868099	T620M200X250R6HX-D6 KM6515	M11
3868110	T620MF080X100R6HX-D4 KM6515	M11
3868111	T620MF100X100R6HX-D4 KM6515	M11
3868114	T620MF120X150R6HX-D4 KM6515	M11
3868116	T620MF140X150R6HX-D4 KM6515	M11
3868117	T620MF160X150R6HX-D4 KM6515	M11
3868118	T620MF180X150R6HX-D4 KM6515	M11
3868174	T620M030X050R6HX-D1 KP6525	M11
3868175	T620M040X070R6HX-D1 KP6525	M11
3868176	T620M050X080R6HX-D1 KP6525	M11
3868177	T620M060X100R6HX-D1 KP6525	M11
3868178	T620M080X125R6HX-D1 KP6525	M11
3868179	T620M100X150R6HX-D1 KP6525	M11
3868180	T620M120X175R6HX-D6 KP6525	M11
3868181	T620M140X200R6HX-D6 KP6525	M11
3868182	T620M160X200R6HX-D6 KP6525	M11
3868204	T620M200X250R6HX-D6 KP6525	M11
3868215	T620MF080X100R6HX-D4 KP6525	M11
3868216	T620MF100X100R6HX-D4 KP6525	M11
3868217	T620MF100X125R6HX-D4 KP6525	M11
3868219	T620MF120X150R6HX-D4 KP6525	M11
3868221	T620MF140X150R6HX-D4 KP6525	M11
3868222	T620MF160X150R6HX-D4 KP6525	M11
3868223	T620MF180X150R6HX-D4 KP6525	M11
3868469	B291A04800YPL KC7315	G88
3868571	T630M030X050R6HX-D1 KP6525	M50
3868572	T630M040X070R6HX-D1 KP6525	M50
3868825	T630M030X050R6HX-D1 KM6515	M50
3868826	T630M040X070R6HX-D1 KM6515	M50
3868827	T630M050X080R6HX-D1 KM6515	M50
3868828	T630M060X100R6HX-D1 KM6515	M50
3868829	T630M080X125R6HX-D1 KM6515	M50
3868830	T630M100X150R6HX-D1 KM6515	M50
3868831	T630M120X175R6HX-D6 KM6515	M50
3868832	T630M140X200R6HX-D6 KM6515	M50
3868843	T630M160X200R6HX-D6 KM6515	M50
3868844	T630M180X250R6HX-D6 KM6515	M50
3868856	T630MF080X100R6HX-D4 KM6515	M50
3868857	T630MF100X100R6HX-D4 KM6515	M50
3868858	T630MF100X125R6HX-D4 KM6515	M50
3868860	T630MF120X150R6HX-D4 KM6515	M50
3868862	T630MF140X150R6HX-D4 KM6515	M50
3868863	T630MF160X150R6HX-D4 KM6515	M50
3868864	T630MF180X150R6HX-D4 KM6515	M50
3868923	T630M050X080R6HX-D1 KP6525	M50
3868924	T630M060X100R6HX-D1 KP6525	M50
3868925	T630M080X125R6HX-D1 KP6525	M50
3868926	T630M100X150R6HX-D1 KP6525	M50
3868927	T630M120X175R6HX-D6 KP6525	M50
3868928	T630M140X200R6HX-D6 KP6525	M50
3868929	T630M160X200R6HX-D6 KP6525	M50
3868930	T630M180X250R6HX-D6 KP6525	M50
3868933	T630M240X300R6HX-D6 KP6525	M54
3868942	T630MF080X100R6HX-D4 KP6525	M50
3868943	T630MF100X100R6HX-D4 KP6525	M50
3868944	T630MF100X125R6HX-D4 KP6525	M50
3868946	T630MF120X150R6HX-D4 KP6525	M50
3868948	T630MF140X150R6HX-D4 KP6525	M50
3868949	T630MF160X150R6HX-D4 KP6525	M50
3868950	T630MF180X150R6HX-D4 KP6525	M50
3868976	T631M050X080R6HX-D1 KP6525	M51
3868977	T631M060X100R6HX-D1 KP6525	M51
3868978	T631M080X125R6HX-D1 KP6525	M51
3868979	T631M100X150R6HX-D1 KP6525	M51
3868980	T631M120X175R6HX-D6 KP6525	M51
3868981	T631M140X200R6HX-D6 KP6525	M51
3868982	T631M160X200R6HX-D6 KP6525	M51
3868993	T631M180X250R6HX-D6 KP6525	M51
3869003	T631MF080X100R6HX-D4 KP6525	M51
3869004	T631MF100X100R6HX-D4 KP6525	M51
3869005	T631MF100X125R6HX-D4 KP6525	M51
3869006	T631MF120X125R6HX-D4 KP6525	M51
3869007	T631MF120X150R6HX-D4 KP6525	M51
3869008	T631MF140X125R6HX-D4 KP6525	M51
3869009	T631MF140X150R6HX-D4 KP6525	M51
3869010	T631MF160X150R6HX-D4 KP6525	M51
3869011	T631MF180X150R6HX-D4 KP6525	M51
3870038	CRGNR244F	B373
3870444	AADE0125J3D K600	P128
3870446	AADE0125J3E K600	P128
3870448	AADE0188J3C K600	P128
3870450	AADE0188J3D K600	P128
3870452	AADE0188J3E K600	P128
3870455	AADE0250J3D K600	P128
3870457	AADE0250J3E K600	P128
3870459	AADE0250J3F K600	P128
3870460	AADE0250J3FRA K600	P128
3870461	AADE0250J3G K600	P128
3870462	AADE0312J3B K600	P128

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3870464	AADE0375J3F K600	P128
3870466	AADE0375J3G K600	P128
3870468	AADE0375J3D K600	P129
3870469	AADE0375J3DRA K600	P129
3870470	AADE0375J3DRB K600	P129
3870472	AADE0375J3E K600	P129
3870473	AADE0375J3ERA K600	P129
3870474	AADE0375J3ERB K600	P129
3870475	AADE0375J3ERC K600	P129
3870476	AADE0375J3H K600	P129
3870477	AADE0375J3J K600	P129
3871002	A4G0205M2SU02GMN KCU10	C109
3871023	A10RA4SAL2S12N017021	C134
3871027	A16RA4SAL3S14N026036	C134
3871028	A10RA4SAR2S12N017021	C134
3871029	A12RA4SAR2S12N021026	C134
3871030	A16RA4SAR2S12N026036	C134
3871032	A16RA4SAR3S14N026036	C134
3871033	A16RA4SAL2S12M017021	C134
3871034	A20RA4SAL2S12M021026	C134
3871035	A25RA4SAL2S12M026036	C134
3871037	A25RA4SAL3S14M026036	C134
3871038	A16RA4SAR2S12M017021	C134
3871039	A20RA4SAR2S12M021026	C134
3871040	A25RA4SAR2S12M026036	C134
3871041	A20RA4SAR3S14M021026	C134
3871042	A25RA4SAR3S14M026036	C134
3871064	A4G0305M3SU04GMN KCU10	C109
3871065	A4G0405M4SU04GMN KCU10	C109
3871067	A4G0505M5SU04GMN KCU10	C109
3871069	A4G0200M2SP02GUP KCU10	C108
3871070	A4G0300M3SP02GUP KCU10	C108
3871071	A4G0300M3SP04GUP KCU10	C108
3871072	A4G0400M4SP04GUP KCU10	C108
3871073	A4G0400M4SP08GUP KCU10	C108
3871075	A4G0500M5SP08GUP KCU10	C108
3871076	A4G0205M2SU02GUP KCU10	C109
3871077	A4G0305M3SU02GUP KCU10	C109
3871078	A4G0305M3SU04GUP KCU10	C109
3871079	A4G0405M4SU04GUP KCU10	C109
3871081	A4G0505M5SU04GUP KCU10	C109
3871083	A4G0205M2SU02GMN KCU25	C109
3871084	A4G0305M3SU02GMN KCU25	C109
3871085	A4G0305M3SU04GMN KCU25	C109
3871086	A4G0405M4SU04GMN KCU25	C109
3871087	A4G0405M4SU08GMN KCU25	C109
3871088	A4G0505M5SU04GMN KCU25	C109
3871090	A4G0200M2SP02GUP KCU25	C108
3871091	A4G0300M3SP02GUP KCU25	C108
3871092	A4G0300M3SP04GUP KCU25	C108
3871105	A4G0500M5SP04GUP KCU25	C108
3871107	A4G0205M2SU02GUP KCU25	C109
3871108	A4G0305M3SU02GUP KCU25	C109
3871109	A4G0305M3SU04GUP KCU25	C109
3871110	A4G0405M4SU04GUP KCU25	C109
3871112	A4G0505M5SU04GUP KCU25	C109
3871114	A4G0505M5SU08GUP KCU25	C109
3871115	A4R0200M2SP00GMP KCU25	C109
3871116	A4R0300M3SP00GMP KCU25	C109
3871118	A4R0500M5SP00GMP KCU25	C109
3872075	WD50FDS40183M	H126
3872079	WD50FDS45206M	H126
3872564	B292A14200YPL KC7315	G90
3873005	B292A07600YPL KC7315	G89
3873028	B976A11800 KC7315	G137
3876021	B967A08700 KC7315	G131
3876314	CNG454T0820 KYK10	B316
3876315	CNGA432T0820 KYK10	B313
3876316	CNGA433T0420FW KYK10	B313
3876317	CNGA433T0820 KYK10	B313
3876318	CNGA433T0820FW KYK10	B313
3876319	CNGA434T0820 KYK10	B313
3876328	SNGX453T0820 KYK10	B318
3876329	SNGX454T0820 KYK10	B318
3876331	TNGA332T0820 KYK10	B314
3876333	WNGX453T0820 KYK10	B319
3876334	SNGA432T0820 KYK10	B314
3876352	AADF0188J2D K600	P126
3876359	AADF0250J2E K600	P126
3876362	AADF0250J2F K600	P126
3876364	AADF0250J2FRB K600	P126
3876365	AADF0250J2G K600	P126
3876374	AADF0375J2D K600	P126
3876375	AADF0375J2DRA K600	P126
3876376	AADF0375J2DRB K600	P126
3876378	AADF0375J2E K600	P126
3876383	AADF0500J2E K600	P126
3876387	AADF0500J2F K600	P127
3876389	AADF0500J2FRB K600	P126
3876391	AADF0500J2BRA K600	P127
3876392	AADF0500J2G K600	P127
3876393	AADF0500J2GRA K600	P127
3876394	AADF0500J2GRB K600	P127
3876395	AADF0500J2GRC K600	P127
3876396	AADF0500J2CRA K600	P127
3876620	AADF0625J2BRB K600	P127
3876623	AADF0625J2FRB K600	P127
3876627	AADF0625J2GRB K600	P127
3876629	AADF0750J2F K600	P127
3876635	AADF0750J2CRA K600	P127
3876637	AADF0750J2GRA K600	P127
3876647	AADF1000J2D K600	P127
3876843	CNGF432 KB1340	B307
3877207	CFM0402R30RHP KCU40	H43
3877688	B272Z11000HPS KN25	G71
3877827	B967A11500 KC7315	G132
3878037	B292A09800YPL KC7315	G89
3878347	HSK63ASIF80063M	K50
3883100	RIQ06E1312 KC6305	K58
3884395	KSEM1250HPCCLM KC7410	H60
3884396	KSEM1300HPCCLM KC7410	H60, H111
3884397	KSEM1350HPCCLM KC7410	H60
3884398	KSEM1400HPCCLM KC7410	H60, H111
3884399	KSEM1450HPCCLM KC7410	H60
3884400	KSEM1500HPCCLM KC7410	H60, H111
3884401	KSEM1550HPCCLM KC7410	H60
3884402	KSEM1600HPCCLM KC7410	H60, H111
3884433	KSEM1650HPCCLM KC7410	H60
3884434	KSEM1700HPCCLM KC7410	H60, H111
3884435	KSEM1750HPCCLM KC7410	H60
3884436	KSEM1800HPCCLM KC7410	H60, H111
3884437	KSEM1850HPCCLM KC7410	H60
3884438	KSEM1900HPCCLM KC7410	H60, H111
3884439	KSEM1950HPCCLM KC7410	H60
3884440	KSEM2000HPCCLM KC7410	H60, H111
3884441	KSEM2050HPCCLM KC7410	H60
3884442	KSEM2100HPCCLM KC7410	H60, H111
3884443	KSEM2150HPCCLM KC7410	H60
3884444	KSEM2200HPCCLM KC7410	H60, H111
3884445	KSEM2250HPCCLM KC7410	H60
3884446	KSEM2300HPCCLM KC7410	H60, H111
3884447	KSEM2350HPCCLM KC7410	H60
3884448	KSEM2400HPCCLM KC7410	H60, H111
3884449	KSEM2450HPCCLM KC7410	H60
3884450	KSEM2500HPCCLM KC7410	H60, H111
3884451	KSEM2550HPCCLM KC7410	H60
3884452	KSEM2600HPCCLM KC7410	H60, H111
3884453	KSEM2650HPCCLM KC7410	H60
3884454	KSEM2700HPCCLM KC7410	H60, H111
3884455	KSEM2750HPCCLM KC7410	H60
3884456	KSEM2800HPCCLM KC7410	H61, H111
3884457	KSEM2850HPCCLM KC7410	H61
3884458	KSEM2900HPCCLM KC7410	H61, H111
3884459	KSEM2950HPCCLM KC7410	H61
3884460	KSEM3000HPCCLM KC7410	H61, H111
3884461	KSEM3050HPCCLM KC7410	H61
3884462	KSEM3100HPCCLM KC7410	H61, H111
3884463	KSEM3200HPCCLM KC7410	H61, H111
3884464	KSEM0500HPCCL KC7410	H60
3884465	KSEM0509HPCCL KC7410	H60
3884466	KSEM0516HPCCL KC7410	H60
3884467	KSEM0547HPCCL KC7410	H60
3884468	KSEM0563HPCCL KC7410	H60
3884469	KSEM0578HPCCL KC7410	H60
3884470	KSEM0609HPCCL KC7410	H60
3884471	KSEM0625HPCCL KC7410	H60
3884472	KSEM0634HPCCL KC7410	H60
3884473	KSEM0641HPCCL KC7410	H60
3884474	KSEM0656HPCCL KC7410	H60
3884475	KSEM0672HPCCL KC7410	H60
3884476	KSEM0688HPCCL KC7410	H60
3884477	KSEM0719HPCCL KC7410	H60
3884478	KSEM0750HPCCL KC7410	H60
3884479	KSEM0759HPCCL KC7410	H60
3884480	KSEM0766HPCCL KC7410	H60
3884481	KSEM0781HPCCL KC7410	H60
3884482	KSEM0797HPCCL KC7410	H60
3884483	KSEM0813HPCCL KC7410	H60
3884484	KSEM0844HPCCL KC7410	H60
3884485	KSEM0875HPCCL KC7410	H60
3884486	KSEM0884HPCCL KC7410	H60
3884487	KSEM0922HPCCL KC7410	H60
3884488	KSEM0938HPCCL KC7410	H60
3884489	KSEM0969HPCCL KC7410	H60
3884490	KSEM1000HPCCL KC7410	H60
3884491	KSEM1011HPCCL KC7410	H60
3884492	KSEM1031HPCCL KC7410	H60
3884493	KSEM1047HPCCL KC7410	H60
3884494	KSEM1094HPCCL KC7410	H60
3884495	KSEM1109HPCCL KC7410	H61
3884496	KSEM1125HPCCL KC7410	H61
3884497	KSEM1156HPCCL KC7410	H61
3884498	KSEM1172HPCCL KC7410	H61
3884499	KSEM1188HPCCL KC7410	H61
3884500	KSEM1250HPCCL KC7410	H61
3884540	B291A06200YPL KC7315	G88
3884541	B291A11800YPL KC7315	G89
3884593	B291A15800YPL KC7315	G90
3884594	B291A19800YPL KC7315	G90
3884596	B291A05200YPL KC7315	G88
3884923	RCMT1204M0MP KCS10	B240
3885499	BMD300R1206S100L200	V70
3885689	B707A03000FBL KCMS15	G110
3885690	B707A03175FBL KCMS15	G110
3885691	B707A03500FBL KCMS15	G110
3885692	B707A04000FBL KCMS15	G110
3885823	B707A04400FBL KCMS15	G110
3885824	B707A04500FBL KCMS15	G110
3885825	B707A04800FBL KCMS15	G110
3885826	B707A05000FBL KCMS15	G110
3885827	B707A05560FBL KCMS15	G110
3885828	B707A05900FBL KCMS15	G110
3885829	B707A06000FBL KCMS15	G110
3885830	B707A06350FBL KCMS15	G110
3885831	B707A06500FBL KCMS15	G110
3885832	B707A06800FBL KCMS15	G110
3885833	B707A07000FBL KCMS15	G110
3885834	B707A07500FBL KCMS15	G111
3885835	B707A07938FBL KCMS15	G111
3885836	B707A08000FBL KCMS15	G111
3885837	B707A08500FBL KCMS15	G111
3885838	B707A08800FBL KCMS15	G111
3885839	B707A09000FBL KCMS15	G111
3885840	B707A09500FBL KCMS15	G111
3885841	B707A09525FBL KCMS15	G111
3885842	B707A10000FBL KCMS15	G111
3885843	B707A10320FBL KCMS15	G111
3885844	B707A10500FBL KCMS15	G111
3885845	B707A11000FBL KCMS15	G111
3885846	B707A11111FBL KCMS15	G111
3885847	B707A11509FBL KCMS15	G111
3885848	B707A11570FBL KCMS15	G111
3885849	B707A11700FBL KCMS15	G111
3885850	B707A11800FBL KCMS15	G111
3885851	B707A12000FBL KCMS15	G111
3885852	B707A12100FBL KCMS15	G111
3885853	B707A12500FBL KCMS15	G111
3885854	B707A12800FBL KCMS15	G111
3885855	B707A13000FBL KCMS15	G111
3885856	B707A13500FBL KCMS15	G111
3885857	B707A14000FBL KCMS15	G111
3885858	B707A14288FBL KCMS15	G111
3885859	B707A14500FBL KCMS15	G111
3885860	B707A15000FBL KCMS15	G111
3885861	B707A15250FBL KCMS15	G112
3885862	B707A15500FBL KCMS15	G112
3885863	B707A15875FBL KCMS15	G112
3885864	B707A16000FBL KCMS15	G112
3885865	B707A16500FBL KCMS15	G112
3885866	B707A17000FBL KCMS15	G112
3885867	B707A17500FBL KCMS15	G112
3885868	B707A18000FBL KCMS15	G112
3885869	B707A19000FBL KCMS15	G112
3885870	B707A19050FBL KCMS15	G112
3885871	B707A20000FBL KCMS15	G112
3885872	B707A21000FBL KCMS15	G112
3886527	B292A13900YPL KC7315	G90
3890197	B967A07500 KC7315	G131
3891349	B272Z16000HPS KN25	G71
3891648	RPET1605M0SGE KCPK30	V78
3891649	RPET1605M0ELE KCPK30	V78
3891661	B271Z10200HPS KN25	G69
3891662	B271Z10500HPS KN25	G69
3891682	B271Z13500HPS KN25	G69
3891683	B271Z10720HPS KN25	G69
3891684	B271Z11000HPS KN25	G69
3891685	B271Z11500HPS KN25	G69
3891686	B271Z12000HPS KN25	G69
3891687	B271Z12500HPS KN25	G69
3891688	B271Z12700HPS KN25	G69
3891689	B271Z13000HPS KN25	G69
3891690	B272Z10200HPS KN25	G71
3891691	B272Z10500HPS KN25	G71
3891692	B272Z10720HPS KN25	G71
3891693	B272Z11500HPS KN25	G71
3891695	B272Z12000HPS KN25	G71
3891696	B272Z12500HPS KN25	G71
3891697	B272Z12700HPS KN25	G71
3891698	B272Z13000HPS KN25	G71
3891700	B273Z10500HPS KN25	G72
3891702	B273Z11000HPS KN25	G72
3891703	B273Z11500HPS KN25	G72
3891704	B273Z12000HPS KN25	G72
3891705	B273Z12500HPS KN25	G72
3891707	B273Z13000HPS KN25	G72
3891708	B274Z10200HPS KN25	G74
3891711	B274Z11000HPS KN25	G74
3891712	B274Z11500HPS KN25	G74
3891713	B274Z12000HPS KN25	G74
3891714	B274Z12500HPS KN25	G74
3891716	B274Z13000HPS KN25	G74
3891733	B271Z14000HPS KN25	G69
3891734	B271Z14290HPS KN25	G69
3891737	B271Z15500HPS KN25	G69
3891738	B271Z15870HPS KN25	G69
3891739	B271Z16000HPS KN25	G69
3891741	B272Z13500HPS KN25	G71
3891742	B272Z14000HPS KN25	G71
3891744	B272Z14500HPS KN25	G71
3891745	B272Z15000HPS KN25	G71
3891746	B272Z15500HPS KN25	G71
3891747	B272Z15870HPS KN25	G71
3891748	B273Z13100HPS KN25	G72
3891750	B273Z14000HPS KN25	G72
3891751	B273Z14290HPS KN25	G72
3891752	B273Z14500HPS KN25	G72
3891882	BMD150R1204S050L158	V70
3891915	BMD150R1204W150L200	V68
3894804	B707A03000FBS KN15	G110
3894805	B707A03175FBS KN15	G110
3894806	B707A03500FBS KN15	G110
3894807	B707A04000FBS KN15	G110
3894808	B707A04400FBS KN15	G110
3894809	B707A04500FBS KN15	G110
3894810	B707A04800FBS KN15	G110
3894811	B707A05000FBS KN15	G110
3894812	B707A05560FBS KN15	G110
3894823	B707A05900FBS KN15	G110

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
3894824	B707A06000FBS KN15	G110
3894825	B707A06350FBS KN15	G110
3894826	B707A06500FBS KN15	G110
3894827	B707A06800FBS KN15	G110
3894828	B707A07000FBS KN15	G110
3894829	B707A07500FBS KN15	G111
3894830	B707A07938FBS KN15	G111
3894831	B707A08000FBS KN15	G111
3894832	B707A08500FBS KN15	G111
3894833	B707A08800FBS KN15	G111
3894834	B707A09000FBS KN15	G111
3894835	B707A09500FBS KN15	G111
3894836	B707A09525FBS KN15	G111
3894837	B707A10000FBS KN15	G111
3894838	B707A10320FBS KN15	G111
3894839	B707A10500FBS KN15	G111
3894840	B707A11000FBS KN15	G111
3894841	B707A11111FBS KN15	G111
3894842	B707A11509FBS KN15	G111
3894843	B707A11570FBS KN15	G111
3894844	B707A11700FBS KN15	G111
3894845	B707A11800FBS KN15	G111
3894846	B707A12000FBS KN15	G111
3894847	B707A12100FBS KN15	G111
3894848	B707A12500FBS KN15	G111
3894849	B707A12800FBS KN15	G111
3894850	B707A13000FBS KN15	G111
3894851	B707A13500FBS KN15	G111
3894852	B707A14000FBS KN15	G111
3894853	B707A14288FBS KN15	G111
3894854	B707A14500FBS KN15	G111
3894855	B707A15000FBS KN15	G111
3894856	B707A15250FBS KN15	G112
3894857	B707A15500FBS KN15	G112
3894858	B707A15875FBS KN15	G112
3894859	B707A16000FBS KN15	G112
3894860	B707A16500FBS KN15	G112
3894861	B707A17000FBS KN15	G112
3894862	B707A17500FBS KN15	G112
3894863	B707A18000FBS KN15	G112
3894864	B707A19000FBS KN15	G112
3894865	B707A19050FBS KN15	G112
3894866	B707A20000FBS KN15	G112
3894867	B707A21000FBS KN15	G112
3895815	B291A09300YPL KC7315	G89
3897779	M1D100E1003C075L480	T31
3897780	M1D100E1004C075L480	T31
3897781	M1D100E1003W075L125	T30
3897782	M1D100E1004W075L125	T30
3899134	UCDE219J5BS KC643M	P30
3899135	UCDE281J5BS KC643M	P30
3899136	UCDE344J5BS KC643M	P30
3899137	UCDE375J5CRA KC643M	P30
3899138	UCDE375J5CRB KC643M	P30
3899139	UCDE438J5BS KC643M	P30
3899140	UCDE500J5BRD KC643M	P30
3899141	UCDE562J5BS KC643M	P30
3899142	UCDE562J5BRA KC643M	P30
3899193	UCDE562J5BRB KC643M	P30
3899194	UCDE625J5BRA KC643M	P30
3899195	UCDE625J5BRD KC643M	P30
3899196	UCDE750J5BRA KC643M	P30
3899197	UCDE750J5CS KC643M	P31
3899198	UCDE750J5CRB KC643M	P31
3899199	UCDE750J5CRD KC643M	P31
3899201	UCDE750J5CRF KC643M	P31
3899202	UCDE1000J5BRA KC643M	P31
3899939	WNMG332FP KCP10	B158
3901561	B292A04700YPL KC7315	G88
3902132	KM40TSNEL2	D31
3902167	B292A07900YPL KC7315	G89
3902171	B291A17900YPL KC7315	G90
3902283	KM40TSNEL3	D31
3902284	KM40TSNEL4	D31
3902285	KM40TSNER2	D31
3902286	KM40TSNER3	D31
3902287	KM40TSNER4	D31
3902288	KM40TSNRL3045M	D33
3902289	KM40TSNRR3045M	D33
3902290	KM40TSNSL2	D33
3902291	KM40TSNSL3	D33
3902292	KM40TSNSL4	D33
3902293	KM40TSNSR2	D33
3902294	KM40TSNSR3	D33
3902295	KM40TSNSR4	D33
3902973	B291A04400YPL KC7315	G88
3903498	B978A03300 KC7315	G139
3903995	B291A08600YPL KC7315	G89
3904143	B291A03454YPL KC7315	G88
3904144	B291A03970YPL KC7315	G88
3904146	B291A04851YPL KC7315	G88
3904147	B291A04915YPL KC7315	G88
3904148	B291A05410YPL KC7315	G88
3904149	B291A06747YPL KC7315	G89
3904150	B291A07144YPL KC7315	G89
3904151	B291A07938YPL KC7315	G89
3904152	B291A08733YPL KC7315	G89
3904153	B291A08900YPL KC7315	G89
3904154	B291A09129YPL KC7315	G89
3904155	B291A09700YPL KC7315	G89
3904156	B291A10716YPL KC7315	G89
3904157	B291A11509YPL KC7315	G89
3904158	B291A11908YPL KC7315	G89
3904159	B291A12300YPL KC7315	G90
3904160	B291A14288YPL KC7315	G90
3904161	B291A15875YPL KC7315	G90
3904162	B291A16100YPL KC7315	G90
3904163	B291A17463YPL KC7315	G90
3904164	B291A17500YPL KC7315	G90
3904165	B291A19050YPL KC7315	G90
3904168	B292A03970YPL KC7315	G88
3904169	B292A04763YPL KC7315	G88
3904170	B292A04851YPL KC7315	G88
3904171	B292A04915YPL KC7315	G88
3904172	B292A08600YPL KC7315	G89
3904173	B292A08900YPL KC7315	G89
3904174	B292A09130YPL KC7315	G89
3904175	B292A09700YPL KC7315	G89
3904176	B292A11509YPL KC7315	G89
3904177	B292A11908YPL KC7315	G89
3904178	B292A12700YPL KC7315	G90
3904179	B292A14288YPL KC7315	G90
3904180	B292A15875YPL KC7315	G90
3904182	B292A17463YPL KC7315	G90
3906105	R82154	K78
3949799	B291A10200YPL KC7315	G89
3949899	A4R1005M10U00GMN KCP25	C107
3950219	WD32FDS32146M	H126
3950220	WD32FDS36166M	H126
3950221	WD50FDS50228M	H126
3950222	WD50FDS56259M	H126
3950333	WD50FDS63289M	H126
3950688	B291A05900YPL KC7315	G88
3950831	KM40TSLSEL16N	D79
3950832	KM40TSLSER16N	D79
3950854	KM40TSLSER22N	D79
3950855	KM40TSLSSL16	D78
3950856	KM40TSLSSL22	D78
3950857	KM40TSLSSR16	D78
3950858	KM40TSLSSR22	D78
3951835	KM40TSE16JNEL2 KWH	D40
3951836	KM40TSE16JNER2 KWH	D40
3952192	SSF150FDS320573	H128
3952343	SSF150FDS360652	H128
3952344	SSF200FDS400721	H128
3952345	SSF200FDS450809	H128
3952346	SSF200FDS500896	H128
3952347	SSF200FDS561020	H128
3952348	SSF200FDS631138	H128
3954092	SNMG644RN KCPK05	B105
3954294	G32TTB41KM40	B410
3954295	G40TTB51KM40	B410
3954296	G48TTB63KM63	B410
3955480	KM40TSS12ENEL2	D39
3955481	KM40TSS12ENER2	D39
3955482	KM40TSS16FNEL2	D39
3955483	KM40TSS16FNER2	D39
3955484	KM40TSS20GNEL2	D39
3955485	KM40TSS20GNER2	D39
3955486	KM40TSS25ENEL2	D39
3955487	KM40TSS25ENER2	D39
3955489	KM40TSS25HNER2	D39
3955490	KM40TSS25ENEL3	D39
3955491	KM40TSS25ENER3	D39
3955492	KM40TSS25HNEL3	D39
3955493	KM40TSS25HNER3	D39
3955495	KM40TSS32JNER3	D39
3955496	KM40TSS32GNEL3	D39
3955497	KM40TSS32GNER3	D39
3955980	B967A12700 KC7315	G132
3956013	B967A06000 KC7315	G130
3956014	B967A07000 KC7315	G131
3956017	B967A07400 KC7315	G131
3956018	B967A06700 KC7315	G131
3958813	EP1812SGE KC522M	T84
3958816	EP1812SGE KCPK30	T84
3958876	EP1832SGE KCPK30	T84
3959399	KM40TSLSER27N	D79
3959400	KM40TSLSSL27	D78
3959401	KM40TSLSSR27	D78
3959611	EC1002ELD KC725M	T36, T45
3959612	EC1002ELD KCPK30	T36, T45
3959613	EC1812EJ KC422M	T82
3959614	EC1816EJ KC422M	T82
3959615	EC1832EJ KC422M	T82
3960761	S-2165-C	S56
3960806	CNGX434S0820 KB1340	B307
3960807	CNGX433S0415 KB1340	B307
3960808	CNGX433S0415FW KB1340	B307
3960812	SNGX434S0820 KB1340	B308
3965546	SSF150HTS130450	J89
3965548	SSF200HTS130450	J89
3965549	SSF200HTS160450	J89
3965550	SSF200HTS220550	J89
3965551	SSF200HTS270550	J89
3965552	SSF200HTS320550	J89
3965603	SSF250HTS400650	J89
3965604	SSF300HTS500700	J89
3967117	A4BHCR32K0217R	C135–136
3967124	A4BHCL32K0317R	C135–136
3967127	A4BHCL26K0317R	C135–136
3967134	A4BHCR26K0317L	C135–136
3967136	A4BHCL32K0217L	C135–136
3967137	A4BHCL32K0317L	C135–136
3987676	RIQ06E1300 KC6305	K58
3993990	KCI1	V156
3993991	KCI2	V155–156
3994022	A10SCTLPL2	B185, B390
3994693	193.537	H126–129
3994709	B291A04900YPL KC7315	G88
3994711	B291A09800YPL KC7315	G89
3997748	BMD300R1607S100L200	V77
3998775	KSEM1735HPGM KC7315	H54
3999270	TRM50R0720M	E71
3999273	TRM50L0932M	E71
3999274	TRM50R0932M	E71
3999275	TRM50L0632M	E71
3999276	TRM50R0632M	E71
3999277	TRM50L0950M	E71
3999278	TRM50R0950M	E71
4000408	KSEMP2800FDS28A1M	H104, H115, H122
4000409	WD32FDS28128M	H126
4000411	WD32FDS28345M	H127
4002349	BMD400R1209S125L200	V70
4003224	KSEM1010HPG KC7315	H55
4003518	RIQ06R0200 KD1415	K57
4003520	B966A17000 KC7315	G132
4003521	B966A17500 KC7315	G132
4003522	B966A18000 KC7315	G132
4004710	CM215R ASSY	B150–151, B154
4005704	LNUX191940RRP KCP10	E58
4005706	LNUX191940RRP KCP25	E58
4006503	B976A19840 KC7315	G138
4006504	B977A19840 KC7315	G138
4006830	KTIP270R8SS32M	H38
4008096	TNMG332FP KCP10	B123
4011180	EC1850FJ KC410M	T81
4011227	B532A06700SPF KDF400	G100
4025911	B978A04800 KC7315	G139
4026180	T631M050X080R6HX-D1 KM6515	M51
4026181	T631M060X100R6HX-D1 KM6515	M51
4026182	T631M080X125R6HX-D1 KM6515	M51
4026223	T631M100X150R6HX-D1 KM6515	M51
4026224	T631M120X175R6HX-D6 KM6515	M51
4026225	T631M140X200R6HX-D6 KM6515	M51
4026226	T631M160X200R6HX-D6 KM6515	M51
4026227	T631M180X250R6HX-D6 KM6515	M51
4026231	T631MF080X100R6HX-D4 KM6515	M51
4026232	T631MF100X100R6HX-D4 KM6515	M51
4026233	T631MF100X125R6HX-D4 KM6515	M51
4026234	T631MF120X125R6HX-D4 KM6515	M51
4026235	T631MF120X150R6HX-D4 KM6515	M51
4026236	T631MF140X125R6HX-D4 KM6515	M51
4026237	T631MF140X150R6HX-D4 KM6515	M51
4026238	T631MF160X150R6HX-D4 KM6515	M51
4026239	T631MF180X150R6HX-D4 KM6515	M51
4027886	T621M050X080R6HX-D1 KM6515	M12
4027887	T621M060X100R6HX-D1 KM6515	M12
4027888	T621M080X125R6HX-D1 KM6515	M12
4027889	T621M100X150R6HX-D1 KM6515	M12
4027890	T621M120X175R6HX-D6 KM6515	M12
4027916	T621M140X200R6HX-D6 KM6515	M12
4027917	T621M160X200R6HX-D6 KM6515	M12
4027918	T621M180X250R6HX-D6 KM6515	M12
4027919	T621MF080X100R6HX-D4 KM6515	M12
4027920	T621MF100X100R6HX-D4 KM6515	M12
4027921	T621MF100X125R6HX-D4 KM6515	M12
4027922	T621MF120X150R6HX-D4 KM6515	M12
4027923	T621MF140X150R6HX-D4 KM6515	M12
4027924	T621MF160X150R6HX-D4 KM6515	M12
4027925	T621MF180X150R6HX-D4 KM6515	M12
4028488	T621M050X080R6HX-D1 KP6525	M12
4028489	T621M060X100R6HX-D1 KP6525	M12
4028490	T621M080X125R6HX-D1 KP6525	M12
4028491	T621M100X150R6HX-D1 KP6525	M12
4028492	T621M120X175R6HX-D6 KP6525	M12
4028503	T621M140X200R6HX-D6 KP6525	M12
4028504	T621M160X200R6HX-D6 KP6525	M12
4028505	T621M180X250R6HX-D6 KP6525	M12
4028506	T621MF080X100R6HX-D4 KP6525	M12
4028507	T621MF100X100R6HX-D4 KP6525	M12
4028508	T621MF100X125R6HX-D4 KP6525	M12
4028509	T621MF120X125R6HX-D4 KP6525	M12
4028510	T621MF120X150R6HX-D4 KP6525	M12
4028511	T621MF140X125R6HX-D4 KP6525	M12
4028512	T621MF140X150R6HX-D4 KP6525	M12
4028513	T621MF160X150R6HX-D4 KP6525	M12
4028514	T621MF180X150R6HX-D4 KP6525	M12
4028861	B271Z02383KMS KN25	G68
4028862	B271Z02400KMS KN25	G68
4028873	B271Z02439KMS KN25	G68
4028874	B271Z02489KMS KN25	G68
4028875	B271Z02500KMS KN25	G68
4028876	B271Z02578KMS KN25	G68
4028877	B271Z02600KMS KN25	G68
4028880	B271Z02779KMS KN25	G68
4028881	B271Z02800KMS KN25	G68
4028882	B271Z02820KMS KN25	G68
4028883	B271Z02870KMS KN25	G68
4028884	B271Z02900KMS KN25	G68
4028885	B271Z02947KMS KN25	G68
4028886	B272Z02383KMS KN25	G70
4028887	B272Z02400KMS KN25	G70
4028888	B272Z02439KMS KN25	G70
4028889	B272Z02489KMS KN25	G70
4028890	B272Z02500KMS KN25	G70
4028896	B272Z02800KMS KN25	G70
4028900	B272Z02947KMS KN25	G70
4028901	B273Z02383KMS KN25	G72
4028903	B273Z02439KMS KN25	G72
4028910	B273Z02779KMS KN25	G72
4028911	B273Z02800KMS KN25	G72
4028912	B273Z02820KMS KN25	G72
4028913	B273Z02870KMS KN25	G72
4028915	B273Z02947KMS KN25	G72
4028916	B274Z02383KMS KN25	G73
4028917	B274Z02400KMS KN25	G73
4028918	B274Z02439KMS KN25	G73
4028920	B274Z02500KMS KN25	G73
4028922	B274Z02600KMS KN25	G73
4028923	B274Z02642KMS KN25	G73
4028925	B274Z02779KMS KN25	G73
4028926	B274Z02800KMS KN25	G73
4028928	B274Z02870KMS KN25	G73
4028929	B274Z02900KMS KN25	G73
4028930	B274Z02947KMS KN25	G73

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4029315	HNPJ755ANSNGD KC725M	S25
4029316	HNPJ755ANSNGD KCPK30	S25
4032274	MEGA45D500LN863M6	S94
4032277	MEGA45D800LN863M10	S94
4032278	MEGA45D1000LN863M10	S94
4032279	MEGA45D1200LN863M10	S94
4033713	B707A12700FBS KN15	G111
4033714	B707A12700FBL KCMS15	G111
4033829	NA4L8 KCU25	D11
4033830	NA4R4 KCU25	D11
4033833	NA6L2 KCU25	D11
4033834	NA6L25 KCU25	D11
4033835	NA6L3 KCU25	D11
4033836	NA6R2 KCU25	D11
4033838	NA6R3 KCU25	D11
4033841	ND4050R KCU25	D12
4033845	NDC38RDL75 KCU25	D13
4033846	NDC38RDR75 KCU25	D13
4033852	NG1031L KCU25	C170
4033853	NG1047L KCU25	C170
4033854	NG1062L KCU25	C170
4033855	NG1094L KCU25	C170
4033856	NG5312R KCU25	C170
4033858	NG6375R KCU25	C170
4033859	NT1L KCU25	D23
4033863	NTB3RB KCU25	D18
4033872	NTC3R12E KCU25	D20
4033877	NTC3R18E KCU25	D20
4033882	NTU4R KCU25	D22
4033883	NU3094L KCU25	C175
4033886	NU3125R KCU25	C175
4033887	NV3RJ KCU25	C176
4033888	NV4LL KCU25	C176
4033889	NV4RL KCU25	C176
4033892	NWC3R14E KCU25	D23
4034717	A4G0200M02P02GMP KCU10	C105
4034718	A4G0205M02U02GMN KCU10	C106
4034720	A4G0250M2BP02GMP KCU10	C105
4034721	A4G0300M03P02GMP KCU10	C105
4034722	A4G0300M03P04GMP KCU10	C105
4034773	A4G0305M03U02GMN KCU10	C106
4034774	A4G0305M03U02GMP KCU10	C105
4034775	A4G0305M03U04GMN KCU10	C106
4034776	A4G0305M03U04GMP KCU10	C105
4034777	A4G0400M04P02GMP KCU10	C105
4034778	A4G0400M04P04GMP KCU10	C105
4034779	A4G0400M04P08GMP KCU10	C105
4034780	A4G0405M04U04GMN KCU10	C106
4034781	A4G0405M04U04GMP KCU10	C105
4034782	A4G0405M04U08GMN KCU10	C106
4034784	A4G0500M05P04GMP KCU10	C105
4034785	A4G0500M05P08GMP KCU10	C105
4034786	A4G0505M05U04GMN KCU10	C106
4034787	A4G0505M05U04GMP KCU10	C105
4034788	A4G0505M05U08GMN KCU10	C106
4034790	A4G0600M06P04GMP KCU10	C105
4034791	A4G0600M06P08GMP KCU10	C105
4034792	A4G0605M06U04GMN KCU10	C106
4034794	A4G0605M06U08GMN KCU10	C106
4034799	A4G0800M08P12GMP KCU10	C105
4034800	A4G0805M08U08GMN KCU10	C106
4034802	A4G094I2BP05GMN KCU10	C107
4034805	A4G1005M10U08GMP KCU10	C105
4034806	A4G125I03P05GMN KCU10	C107
4034807	A4G125I03P1GMN KCU10	C107
4034808	A4G187I04P1GMN KCU10	C107
4034809	A4G187I04P2GMN KCU10	C107
4034810	A4G250I06P1GMN KCU10	C107
4034811	A4G250I06P2GMN KCU10	C107
4034812	A4G375I10P2GMN KCU10	C107
4034813	A4R0200M02P00GMP KCU10	C106
4034815	A4R0300M03P00GMP KCU10	C106
4034816	A4R0305M03U00GMN KCU10	C107
4034817	A4R0400M04P00GMP KCU10	C106
4034818	A4R0405M04U00GMN KCU10	C107
4034819	A4R0500M05P00GMP KCU10	C106
4034820	A4R0505M05U00GMN KCU10	C107
4034821	A4R0600M06P00GMP KCU10	C106
4034822	A4R0605M06U00GMN KCU10	C107
4034823	A4R0800M08P00GMP KCU10	C106
4034824	A4R0805M08U00GMN KCU10	C107
4034825	A4R1005M10U00GMN KCU10	C107
4034826	A4R125I03P00GMN KCU10	C107
4034827	A4R187I04P00GMN KCU10	C107
4034828	A4R250I06P00GMN KCU10	C107
4034829	A4R312I08P00GMN KCU10	C107
4034878	WOEJ090512SRHD KC522M	V39
4034880	WOEJ090512SRHD KC725M	V39
4034881	WOEJ090512SRHD KCPK30	V39
4034882	WOEJ090512SRGD KC522M	V39
4034925	WOEJ090512SRGD KC725M	V39
4034927	WOEJ090512SRGD KCPK30	V39
4035459	T640M040X070R6HX-D1 KP6525	M120
4035460	T640M050X080R6HX-D1 KP6525	M120
4035461	T640M060X100R6HX-D1 KP6525	M120
4035462	T640M080X125R6HX-D1 KP6525	M120
4035463	T640M100X150R6HX-D1 KP6525	M120
4035464	T640M120X175R6HX-D6 KP6525	M120
4035465	T640M140X200R6HX-D6 KP6525	M120
4035466	T640M160X200R6HX-D6 KP6525	M120
4035467	T640M180X250R6HX-D6 KP6525	M120
4035468	T640M200X250R6HX-D6 KP6525	M120
4035469	T640M220X250R6HX-D6 KP6525	M120
4035505	T640NC#10-24R3BX-A KP6525	M117
4035506	T640NF#10-32R3BX-A KP6525	M117
4035507	T640NC02500-20R2BX-A KP6525	M117
4035508	T640NC02500-20R3BX-A KP6525	M117
4035509	T640NF02500-28R2BX-A KP6525	M117
4035510	T640NF02500-28R3BX-A KP6525	M117
4035511	T640NC03125-18R2BX-A KP6525	M117
4035512	T640NC03125-18R3BX-A KP6525	M117
4035525	T641M050X080R6HX-D1 KP6525	M121
4035526	T641M060X100R6HX-D1 KP6525	M121
4035527	T641M080X125R6HX-D1 KP6525	M121
4035528	T641M100X150R6HX-D1 KP6525	M121
4035529	T641M120X175R6HX-D6 KP6525	M121
4035530	T641M140X200R6HX-D6 KP6525	M121
4035531	T641M160X200R6HX-D6 KP6525	M121
4035532	T641M180X250R6HX-D6 KP6525	M121
4035533	T641M200X250R6HX-D6 KP6525	M121
4035543	T640NF03125-24R3BX-A KP6525	M117
4035544	T640NC03750-16R2BX-A KP6525	M117
4035545	T640NC03750-16R3BX-A KP6525	M117
4035546	T640NF03750-24R3BX-A KP6525	M117
4035547	T640NC04375-14R3BX-A KP6525	M117
4035548	T640NF04375-20R3BX-A KP6525	M117
4035549	T640NC05000-13R3BX-A KP6525	M117
4035550	T640NF05000-20R3BX-A KP6525	M117
4035551	T640NC06250-11R3BX-A KP6525	M117
4035552	T640NC07500-10R3BX-A KP6525	M117
4035585	RCMX3209M0RU KCP10	E67
4035586	RCMX3209M0RU KCK20	E67
4035593	RCMX2507M0RU KCK20	E67
4035595	RCMH2507M0RU KCP25	E66
4035698	LNUX191940RRF KCP10	E57
4036621	RPG32E KYSP30	V157
4036916	LNUX191940RRF KCP25	E57
4038003	LNPU863ANSRHD KCPK30	S95
4038004	LNPU863ANSRHD KCK15	S95
4038005	LNPU863ANSRHD KC725M	S95
4039608	SM-906 KC720	S94, S98, S100
4039774	MS2236	V123
4040133	SPGX070308MD KCU25	J103
4040135	SPGX070308HP KCU25	J103
4040138	SPPX09T310MD KCU25	J103
4040139	SPPX120412MD KCU25	J103
4040141	SPPX120412HP KCU25	J103
4040142	SPPX15T512MD KCU25	J103
4040758	RPET1204M0ELEJ KC422M	V71
4040905	KCI3M	V155–156
4041060	ABDF0188J2AS K600	P116
4041061	ABDF0188J2ARA K600	P116
4041062	ABDF0250J2ARA K600	P116
4041073	ABDF0312J2AS K600	P116
4041074	ABDF0312J2ARA K600	P116
4041075	ABDF0500J2ARE K600	P116
4041076	ABDF0625J2BS K600	P116
4041077	ABDF0625J2BRB K600	P116
4041078	ABDF0625J2BRC K600	P116
4041079	ABDF0625J2BRE K600	P116
4041080	ABDF0750J2BS K600	P116
4041081	ABDF0750J2BRB K600	P116
4041082	ABDF0750J2BRC K600	P116
4041084	ABDF1000J2BS K600	P116
4041085	ABDF1000J2BRB K600	P116
4041086	ABDF1000J2BRC K600	P116
4041088	ABDE0188J3AS K600	P117
4041089	ABDE0188J3ARA K600	P117
4041090	ABDE0312J3AS K600	P117
4041091	ABDE0500J3ARE K600	P117
4041092	ABDE0625J3BS K600	P117
4041093	ABDE0625J3BRB K600	P117
4041094	ABDE0750J3BS K600	P117
4041095	ABDE0750J3BRB K600	P117
4041096	ABDE0750J3BRC K600	P117
4041097	ABDE0750J3BRE K600	P117
4041098	ABDE1000J3BS K600	P117
4041099	ABDE1000J3BRB K600	P117
4041100	ABDE1000J3BRC K600	P117
4041101	ABDE1000J3BRE K600	P117
4042538	B976Z02383 KC7315	G134
4042539	B976Z02400 KC7315	G134
4042540	B976Z02439 KC7315	G134
4042541	B976Z02489 KC7315	G134
4042542	B976Z02500 KC7315	G134
4042543	B976Z02578 KC7315	G134
4042544	B976Z02600 KC7315	G134
4042545	B976Z02642 KC7315	G134
4042546	B976Z02705 KC7315	G134
4042547	B976Z02779 KC7315	G134
4042548	B976Z02800 KC7315	G134
4042549	B976Z02820 KC7315	G134
4042550	B976Z02870 KC7315	G134
4042551	B976Z02900 KC7315	G134
4042552	B976Z02947 KC7315	G134
4042688	BMD125R1203M16L150	V68
4042690	BMD150R1204M16L150	V68
4042691	BMD125R1203W125L200	V68
4042692	BMD125R1203C125L700	V69
4042713	BMD150R1203C125L800	V69
4042714	BMD200R1203S075L200	V70
4042715	BMD200R1205S075L200	V70
4042716	BMD250R1207S100L200	V70
4042717	BMD300R1208S100L200	V70
4042718	BMD400R1207S125L200	V70
4042840	SPGX070308FP KCU25	J104
4042841	SPPX09T310FP KCU25	J104
4042842	SPPX09T310HP KCU25	J103
4042887	SPGX070308FP KCPK10	J104
4042888	SPGX070308MD KCPK10	J103
4042889	SPGX070308HP KCPK10	J103
4042890	SPPX09T310FP KCPK10	J104
4042891	SPPX09T310MD KCPK10	J103
4042892	SPPX09T310HP KCPK10	J103
4042903	SPPX120412FP KCPK10	J104
4042904	SPPX120412MD KCPK10	J103
4042905	SPPX120412HP KCPK10	J103
4042906	SPPX15T512FP KCPK10	J104
4042907	SPPX15T512MD KCPK10	J103
4042908	SPPX15T512HP KCPK10	J103
4042913	SPPX120412FP KCU25	J104
4042914	SPPX15T512FP KCU25	J104
4042915	SPPX15T512HP KCU25	J103
4042933	SPGX070308FP KCU40	J104
4042934	SPGX070308MD KCU40	J103
4042935	SPGX070308HP KCU40	J103
4042936	SPPX09T310FP KCU40	J104
4042937	SPPX09T310MD KCU40	J103
4042938	SPPX09T310HP KCU40	J103
4042939	SPPX120412FP KCU40	J104
4042940	SPPX120412MD KCU40	J103
4042941	SPPX120412HP KCU40	J103
4042942	SPPX15T512FP KCU40	J104
4042943	SPPX15T512MD KCU40	J103
4042944	SPPX15T512HP KCU40	J103
4043037	BMD150R1603M16	V75
4043038	BMD150R1603W125L200	V75
4043039	BMD150R1602C125L800	V76
4043040	BMD200R1603S075L200	V77
4043041	BMD200R1604S075L200	V77
4043042	BMD250R1605S100L200	V77
4043053	BMD300R1605S100L200	V77
4043054	BMD400R1608S125L200	V77
4043056	BMD600R1610S150L250	V77
4044264	B532A07200SPF KDF400	G100
4044820	TCGT2150LF KCU10	B256
4044821	TCGT2151HP KCU10	B256
4044822	TCGT2151LF KCU10	B256
4045101	VNGG3305LF KCU10	B144
4045102	VNGG331LF KCU10	B144
4045134	CCGT21505HP KCU10	B189
4045135	CCGT21505LF KCU10	B189
4045136	CCGT2150LF KCU10	B189
4045137	CCGT2151HP KCU10	B189
4045138	CCGT2151LF KCU10	B189
4045140	CCGT2152LF KCU10	B189
4045141	CCGT32505HP KCU10	B189
4045142	CCGT32505LF KCU10	B189
4045143	VNGG332LF KCU10	B144
4045144	VNGG432LF KCU10	B144
4045145	VNGP330 KCU10	B144
4045146	VNGP3305 KCU10	B144
4045147	VNGP431 KCU10	B144
4045148	VNGP432 KCU10	B144
4045149	VNMG331FF KCU10	B146
4045150	VNMG331MP KCU10	B147
4045151	VNMG331P KCU10	B147
4045163	VNMG332FF KCU10	B146
4045164	VNMG332MP KCU10	B147
4045166	VNMG332P KCU10	B147
4045167	VNMG332RP KCU10	B148
4045168	VNMG332UP KCU10	B148
4045169	VNMG333MP KCU10	B147
4045170	WNGG4305LF KCU10	B156
4045172	WNGG431LF KCU10	B156
4045174	WNMG331FW KCU10	B158
4045175	WNMG331MP KCU10	B159
4045176	WNMG332FW KCU10	B158
4045177	WNMG332MP KCU10	B159
4045178	WNMG332RP KCU10	B161
4045179	WNMG431FW KCU10	B158
4045180	WNMG431P KCU10	B160
4045181	WNMG432FW KCU10	B158
4045182	WNMG432MP KCU10	B159
4045184	WNMG432P KCU10	B160
4045185	WNMG432RP KCU10	B161
4045186	WNMG432UP KCU10	B162
4045187	WNMG433MP KCU10	B159
4045188	WNMG433RP KCU10	B161
4045189	WNMG433UP KCU10	B162
4045193	CCGT3250LF KCU10	B189
4045194	CCGT3251HP KCU10	B189
4045195	CCGT3251LF KCU10	B189
4045196	CCGT3252HP KCU10	B189
4045197	CCGT3252LF KCU10	B189
4045198	CCGT4305HP KCU10	B189
4045199	CCGT431HP KCU10	B189
4045200	CCGT432HP KCU10	B189
4045202	CCMT2151FW KCU10	B190
4045204	CCMT3251FW KCU10	B190
4045205	CCMT3251MW KCU10	B192
4045206	CCMT3252FW KCU10	B190
4045207	CCMT3252MW KCU10	B192
4045210	CPGM3250 KCU10	B205
4045211	CPGM32505 KCU10	B205
4045212	CPGM3251 KCU10	B205
4045213	CPGM3252 KCU10	B205
4045214	CPGT21505HP KCU10	B205
4045215	CPGT21505LF KCU10	B206
4045216	CPGT2150LF KCU10	B206
4045217	CPGT2151HP KCU10	B205
4045218	CPGT2151LF KCU10	B206
4045220	CPGT2152LF KCU10	B206
4045221	CPGT32505HP KCU10	B205
4045222	CPGT32505LF KCU10	B206
4045223	CPGT3251HP KCU10	B205
4045224	CPGT3251LF KCU10	B206
4045225	CPGT3252HP KCU10	B205
4045226	CPGT3252LF KCU10	B206
4045228	CPMT2151FW KCU10	B206
4045229	CPMT2152FW KCU10	B206
4045231	CPMT3251MW KCU10	B208
4045232	CPMT3252FW KCU10	B206
4045237	DCGT21505HP KCU10	B224
4045238	DCGT2150LF KCU10	B224
4045239	DCGT2151HP KCU10	B224
4045240	DCGT2152HP KCU10	B224

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4045241	DCGT32505HP KCU10	B224
4045242	DCGT3250LF KCU10	B224
4045245	DPGR431 KCU10	E32
4045246	DPGR432 KCU10	E32
4045248	NPGR51L KCU10	E33
4045249	NPGR51R KCU10	E33
4045250	NPGR52L KCU10	E33
4045251	NPGR52R KCU10	E33
4045263	DCGT3251HP KCU10	B224
4045264	DCGT3252HP KCU10	B224
4045265	DCGT432LF KCU10	B224
4045266	DCMT3251FW KCU10	B225
4045267	DCMT3251MW KCU10	B226
4045268	DCMT3252FW KCU10	B225
4045269	DCMT3252LF KCU10	B225
4045270	DCMT3252MW KCU10	B226
4045272	DPGT21505LF KCU10	B231
4045274	DPGT2151HP KCU10	B231
4045275	DPGT2151LF KCU10	B231
4045277	DPGT32505LF KCU10	B231
4045279	DPGT3251HP KCU10	B231
4045280	DPGT3251LF KCU10	B231
4045281	DPGT3252HP KCU10	B231
4045282	DPGT3252LF KCU10	B231
4045283	DPMT2152FW KCU10	B232
4045284	RCGT10T3M0HP KCU10	B238
4045285	RCGT1204M0HP KCU10	B238
4045286	RCMT0602M0 KCU10	B240
4045288	RCMT10T3M0 KCU10	B240
4045289	RCMT1204M0 KCU10	B240
4045290	RCMT1605M0 KCU10	B240
4045291	RCMT2006M0 KCU10	B240
4045292	RCMT215 KCU10	B240
4045293	RCMT325 KCU10	B240
4045294	SPGT3251LF KCU10	B252
4045295	SPGT3252LF KCU10	B252
4045316	TCGT3251HP KCU10	B256
4045317	TCGT3251LF KCU10	B256
4045318	TCGT3252HP KCU10	B256
4045319	TCGT3252LF KCU10	B256
4045321	TPGT181505LF KCU10	B267
4045322	TPGT18151LF KCU10	B267
4045323	TPGT21505HP KCU10	B267
4045324	TPGT21505LF KCU10	B267
4045325	TPGT2150LF KCU10	B267
4045327	TPGT2151LF KCU10	B267
4045329	TPGT2152LF KCU10	B267
4045330	TPGT32505HP KCU10	B267
4045331	TPGT3251HP KCU10	B267
4045333	TPGT3252HP KCU10	B267
4045334	TPGT3252LF KCU10	B267
4045335	VBGT2205HP KCU10	B280
4045336	VBGT2205LF KCU10	B280
4045337	VBGT220LF KCU10	B280
4045338	VBGT221HP KCU10	B280
4045339	VBGT221LF KCU10	B280
4045340	VBGT3305LF KCU10	B280
4045341	VBGT330LF KCU10	B280
4045342	VBGT331HP KCU10	B280
4045343	VBGT331LF KCU10	B280
4045344	VBGT332HP KCU10	B280
4045345	WPGT15105UF KCU10	B288
4045346	WPGT1510UF KCU10	B288
4045347	WPGT21505UF KCU10	B288
4045406	NPL332F KCU10	E34
4045409	NPL508 KCU10	E35
4045410	NPL51 KCU10	E35
4045412	NPR1305 KCU10	E34
4045413	NPR1308 KCU10	E34
4045415	NPR132F KCU10	E34
4045416	NPR332 KCU10	E34
4045417	NPR505 KCU10	E35
4045418	NPR508 KCU10	E35
4045419	NPR51 KCU10	E35
4045420	NPR52 KCU10	E35
4045425	VCMR332 KCU10	E37
4045426	VPGR3305 KCU10	E38
4045427	VPGR331 KCU10	E38
4045428	VPGR332 KCU10	E38
4045429	VPGR333 KCU10	E38
4045430	VPGR334 KCU10	E38
4046063	B291A04763YPL KC7315	G88
4046064	B291A11113YPL KC7315	G89
4047419	KSHRHF200HN5315C3	S17
4047420	KSHRHF250HN5315C3	S17
4047421	KSHRHF300HN5315C4	S17
4047422	KSHRHF400HN5315C5	S17
4047583	KSHRHF500HN5315C6	S17
4047584	KSHRHF600HN5315C8	S17
4047693	HPHV125S4025 KCPM15	P16
4047694	HPHV125S4025CH KCPM15	P16
4047696	HPHV125S4025LR015 KCPM15	P16
4047697	HPHV125S4050 KCPM15	P16
4047698	HPHV125S4050CH KCPM15	P16
4047699	HPHV125S4050L KCPM15	P16
4047701	HPHV125S4050R015 KCPM15	P16
4047702	HPHV188S4031 KCPM15	P16
4047703	HPHV188S4031CH KCPM15	P16
4047704	HPHV188S4031L KCPM15	P16
4047705	HPHV188S4031LR015 KCPM15	P16
4047706	HPHV188S4063 KCPM15	P16
4047707	HPHV188S4063CH KCPM15	P16
4047708	HPHV188S4063L KCPM15	P16
4047709	HPHV188S4063LR015 KCPM15	P16
4047710	HPHV188S4063LR030 KCPM15	P16
4047711	HPHV188S4063R015 KCPM15	P16
4047712	HPHV188S4063R030 KCPM15	P16
4047713	HPHV250S4038 KCPM15	P16
4047714	HPHV250S4038CH KCPM15	P16
4047716	HPHV250S4038LR015 KCPM15	P16
4047718	HPHV250S4038R030 KCPM15	P16
4047719	HPHV250S4050 KCPM15	P16
4047720	HPHV250S4050R015 KCPM15	P16
4047721	HPHV250S4050R030 KCPM15	P16
4047722	HPHV250S4050R060 KCPM15	P16
4047723	HPHV250S4075 KCPM15	P17
4047724	HPHV250S4075CH KCPM15	P17
4047725	HPHV250S4075R015 KCPM15	P16
4047726	HPHV250S4075R030 KCPM15	P16
4047727	HPHV250S4075R060 KCPM15	P17
4047728	HPHV250S4100 KCPM15	P17
4047729	HPHV250S4100R015 KCPM15	P17
4047731	HPHV250S4125 KCPM15	P17
4047732	HPHV250S4125CH KCPM15	P17
4047734	HPHV250S4125R030 KCPM15	P17
4047735	HPHV250S4175R015 KCPM15	P17
4047736	HPHV250S4175R030 KCPM15	P17
4047737	HPHV312S4050 KCPM15	P17
4047738	HPHV312S4050CH KCPM15	P17
4047739	HPHV312S4050L KCPM15	P17
4047740	HPHV312S4050LR015 KCPM15	P17
4047742	HPHV312S4050R030 KCPM15	P17
4047743	HPHV312S4075 KCPM15	P17
4047744	HPHV312S4075CH KCPM15	P17
4047745	HPHV312S4075R015 KCPM15	P17
4047746	HPHV312S4075R030 KCPM15	P17
4047747	HPHV312S4075R060 KCPM15	P17
4047748	HPHV312S4125R030 KCPM15	P17
4047749	HPHV375S4050 KCPM15	P17
4047750	HPHV375S4050CH KCPM15	P17
4047751	HPHV375S4050L KCPM15	P17
4047752	HPHV375S4050LR015 KCPM15	P17
4047753	HPHV375S4050LR030 KCPM15	P17
4047754	HPHV375S4050R030 KCPM15	P17
4047755	HPHV375S4088 KCPM15	P17
4047756	HPHV375S4088CH KCPM15	P17
4047757	HPHV375S4088L KCPM15	P17
4047758	HPHV375S4088LR015 KCPM15	P17
4047759	HPHV375S4088LR030 KCPM15	P17
4047761	HPHV375S4088LR090 KCPM15	P17
4047811	KSEMP1125FDS28A1	H104, H115, H122
4047812	KSEMP2900FDS28A1M	H104, H115, H122
4047823	KSEMP1156FDS28A1	H104, H115, H122
4047824	KSEMP3000FDS28A1M	H104, H115, H122
4047825	KSEMP1188FDS28A1	H104, H115, H122
4047826	KSEMP1219FDS28A1	H104, H115, H122
4047827	KSEMP3100FDS28A1M	H104, H115, H122
4047829	SPGX060304MD KC7140	J103
4047830	SPGX070304MD KC7140	J103
4047831	SPPX09T308MD KC7140	J103
4047832	SPPX120408MD KC7140	J103
4047843	SPPX15T508MD KC7140	J103
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
4048626	HPFSS1000S5200 KCPM15	P109
4048627	HPFSS1000S5325 KCPM15	P109
4048628	HPFSS188S5056 KCPM15	P109
4048629	HPFSS250S5038 KCPM15	P109
4048630	HPFSS250S5075 KCPM15	P109
4048631	HPFSS250S5125 KCPM15	P109
4048632	HPFSS375S5050 KCPM15	P109
4048643	HPFSS375S5088 KCPM15	P109
4048644	HPFSS375S5150 KCPM15	P109
4048645	HPFSS500S5063 KCPM15	P109
4048646	HPFSS500S5125 KCPM15	P109
4048647	HPFSS500S5200 KCPM15	P109
4048648	HPFSS625S5075 KCPM15	P109
4048649	HPFSS625S5163 KCPM15	P109
4048650	HPFSS750S5088 KCPM15	P109
4048651	HPFSS750S5163 KCPM15	P109
4048652	HPFSS750S5325 KCPM15	P109
4048661	UCDE1000J5BRB KCPM15	P31
4048662	UCDE1000J5BRD KCPM15	P31
4048683	HPRSS250S3075 KCPM15	P90
4048684	HPRSS375S3100 KCPM15	P90
4048685	HPRSS500S3125 KCPM15	P90
4048686	HPRSS625S3163 KCPM15	P90
4048687	HPRSS750S3163 KCPM15	P90
4048688	MDRHEC100S5150 KCPM15	P91
4048689	MDRHEC250S4025 KCPM15	P91
4048690	MDRHEC250S4075 KCPM15	P91
4048691	MDRHEC312S4081 KCPM15	P91
4048692	MDRHEC375S4038 KCPM15	P91
4048693	MDRHEC375S4088 KCPM15	P91
4048694	MDRHEC500S4050 KCPM15	P91
4048695	MDRHEC500S4100 KCPM15	P91
4048696	MDRHEC625S4063 KCPM15	P91
4048697	MDRHEC625S4125 KCPM15	P91
4048698	MDRHEC750S4075 KCPM15	P91
4048699	MDRHEC750S4150 KCPM15	P91
4048703	UCDE1000J5BRE KCPM15	P31
4048704	UCDE1000J5BRF KCPM15	P31
4048705	UCDE1000J5BS KCPM15	P31
4048706	UCDE1000K5BRB KCPM15	P31
4048707	UCDE1000K5BRF KCPM15	P31
4048708	UCDE1000K5BS KCPM15	P31
4048709	UCDE188J5BRA KCPM15	P30
4048710	UCDE188J5BRB KCPM15	P30
4048711	UCDE188J5BS KCPM15	P30
4048712	UCDE250J5BRA KCPM15	P30
4048713	UCDE250J5BRB KCPM15	P30
4048714	UCDE250J5BS KCPM15	P30
4048715	UCDE312J5BRA KCPM15	P30
4048716	UCDE312J5BRB KCPM15	P30
4048717	UCDE312J5BS KCPM15	P30
4048718	UCDE375J5BRA KCPM15	P30
4048719	UCDE375J5BRB KCPM15	P30
4048720	UCDE375J5BS KCPM15	P30
4048721	UCDE500J5BRA KCPM15	P30
4048722	UCDE500J5BRB KCPM15	P30
4048723	UCDE500J5BRF KCPM15	P30
4048724	UCDE500J5BS KCPM15	P30
4048725	UCDE500K5BRA KCPM15	P30
4048726	UCDE500K5BRB KCPM15	P30
4048727	UCDE500K5BRF KCPM15	P30
4048728	UCDE500K5BS KCPM15	P30
4048729	UCDE625J5BRB KCPM15	P30
4048730	UCDE625J5BS KCPM15	P30
4048731	UCDE625K5BRB KCPM15	P30
4048732	UCDE625K5BS KCPM15	P30
4048733	UCDE750J5BRB KCPM15	P30
4048734	UCDE750J5BRD KCPM15	P31
4048735	UCDE750J5BRE KCPM15	P31
4048736	UCDE750J5BRF KCPM15	P31
4048737	UCDE750J5BS KCPM15	P31
4048738	UCDE750K5BRB KCPM15	P30
4048740	UCDE750K5BS KCPM15	P31
4048741	UCDE1000K5ARB KCPM15	P32
4048742	UCDE250J5ARA KCPM15	P32
4048743	UCDE375J5ARA KCPM15	P32
4048744	UCDE500K5ARB KCPM15	P32
4048745	UCDE625K5ARB KCPM15	P32
4048746	UCDE750K5ARB KCPM15	P32
4050057	CNMG432RP KCU25	B53
4050058	RCGT0803M0HP KCU25	B238
4050060	CNGP432 KCU10	B46
4050061	CNMG432FP KCU10	B49
4050062	CNMG433FP KCU10	B49
4050332	KSEM1932HPGM KC7315	H54
4050372	CCGT21505HP KCU25	B189
4050395	CNGG4305FS KCU25	B46
4050397	CNGG431FS KCU25	B46
4050398	CNGG432FS KCU25	B46
4050399	CNMG4305MS KCU25	B52
4050400	CNMG430MS KCU25	B52
4050402	CNMG431MS KCU25	B52
4050403	CCGT2151HP KCU25	B189
4050404	CCGT2152HP KCU25	B189
4050405	CCGT32505HP KCU25	B189
4050406	CCGT3251HP KCU25	B189
4050407	CCGT3252HP KCU25	B189
4050408	CCGT4305HP KCU25	B189
4050410	CCGT432HP KCU25	B189
4050412	CPGM32505 KCU25	B205
4050413	CPGM3251 KCU25	B205
4050414	CPGM3252 KCU25	B205
4050415	CPGT21505HP KCU25	B205
4050416	CPGT2151HP KCU25	B205
4050417	CPGT2152HP KCU25	B205
4050419	CPGT3251HP KCU25	B205
4050420	CPGT3252HP KCU25	B205
4050421	DCGT21505HP KCU25	B224
4050422	DCGT2151HP KCU25	B224
4050424	DCGT32505HP KCU25	B224
4050425	DCGT3251HP KCU25	B224
4050426	DCGT3252HP KCU25	B224
4050428	DPGT2151HP KCU25	B231
4050429	DPGT2152HP KCU25	B231
4050430	DPGT3251HP KCU25	B231
4050431	DPGT3252HP KCU25	B231
4050432	RCGT10T3M0HP KCU25	B238
4050434	TCGT21505HP KCU25	B256
4050435	TCGT2151HP KCU25	B256
4050437	TCGT32505HP KCU25	B256
4050441	TPGT2151HP KCU25	B267
4050444	TPGT3251HP KCU25	B267
4050445	TPGT3252HP KCU25	B267
4050447	VBGT221HP KCU25	B280
4050448	VBGT331HP KCU25	B280
4050449	VBGT332HP KCU25	B280
4050451	CNMG432MP KCU25	B51
4050452	CNMG433MP KCU25	B51
4050453	CNMG431RP KCU25	B53
4050454	CNMG432MS KCU25	B52
4050455	CNMG433MS KCU25	B52
4050456	CNMG433RP KCU25	B53
4050458	CNMG434MS KCU25	B52
4050459	CNMG434RP KCU25	B53
4050460	CNMG542MS KCU25	B52
4050461	CNMG542RP KCU25	B53
4050462	CNMG543MS KCU25	B52
4050463	CNMG543RP KCU25	B53
4050465	CNMG544RP KCU25	B53
4050466	CNMG642MS KCU25	B52
4050468	CNMG643RP KCU25	B53
4050469	CNMG644MS KCU25	B52
4050470	CNMG644RP KCU25	B53
4050475	DNGG432FS KCU25	B77
4050477	DNMG332MS KCU25	B82
4050478	DNMG332RP KCU25	B84
4050479	DNMG4305MS KCU25	B82
4050480	DNMG431MS KCU25	B82
4050481	DNMG432MS KCU25	B82
4050482	DNMG432RP KCU25	B84

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4050484	DNMG433MS KCU25	B82
4050485	DNMG433RP KCU25	B84
4050486	DNMG441MS KCU25	B82
4050487	DNMG442MS KCU25	B82
4050488	DNMG442RP KCU25	B84
4050489	DNMG443MS KCU25	B82
4050490	DNMG443RP KCU25	B84
4050491	DNMG444RP KCU25	B84
4050513	CNMG543MP KCU25	B51
4050514	CNMG643MP KCU25	B51
4050515	DNMG442MP KCU25	B81
4050516	DNMG443MP KCU25	B81
4050517	SNMG433MP KCU25	B102
4050518	SNMG433RP KCU25	B105
4050519	SNMG543RP KCU25	B105
4050520	SNMG643RP KCU25	B105
4050521	DPGR431 KCU25	E32
4050522	DPGR432 KCU25	E32
4050523	DPGR433 KCU25	E32
4050524	NPGR51L KCU25	E33
4050525	NPGR51R KCU25	E33
4050526	NPGR52L KCU25	E33
4050527	NPGR52R KCU25	E33
4050528	NPL131F KCU25	E34
4050529	NPL132F KCU25	E34
4050531	NPL505 KCU25	E35
4050532	NPL508 KCU25	E35
4050533	NPL51 KCU25	E35
4050534	NPL52 KCU25	E35
4050535	NPR131F KCU25	E34
4050536	NPR132F KCU25	E34
4050537	NPR331N KCU25	E34
4050539	NPR508 KCU25	E35
4050540	NPR51 KCU25	E35
4050544	VCMR331 KCU25	E37
4050545	VCMR332 KCU25	E37
4050546	VPGR3305 KCU25	E38
4050547	VPGR331 KCU25	E38
4050548	VPGR332 KCU25	E38
4050549	VPGR333 KCU25	E38
4050607	CDHB120601 KCU25	B199
4050608	CDHB120605 KCU25	B199
4050609	CDHB12061 KCU25	B199
4050611	CDHH120605L KCU25	B199
4050613	CDHH12061L KCU25	B199
4050615	GPCD505 KCU25	B238
4050616	GPCD51 KCU25	B238
4050619	TDHB12807501 KCU25	B263
4050620	TDHB12807505 KCU25	B263
4050621	TDHB1280751 KCU25	B263
4050623	TDHH12807505L KCU25	B263
4050624	TDHH1280751L KCU25	B263
4050628	TPGH321 KCU25	B266
4050632	RCGK152FS KCU10	E69
4050653	RCGK152HP KCU10	E69
4050654	RCGK23FS KCU10	E69
4050655	RCGK23HP KCU10	E69
4050656	RCGK35FS KCU10	E69
4050657	RCGK35HP KCU10	E69
4050658	RCGK46FS KCU10	E69
4050659	RCGK46HP KCU10	E69
4050661	RCMK23 KCU10	E69
4050664	CNGG4305LF KCU10	B46
4050665	CNGG430LF KCU10	B46
4050666	CNGG431LF KCU10	B46
4050667	CNGG432LF KCU10	B46
4050668	CNGG433LF KCU10	B46
4050671	CNGP430 KCU10	B46
4050672	CNGP4305 KCU10	B46
4050673	CNGP431 KCU10	B46
4050674	CNGP433 KCU10	B46
4050676	CNMG322MP KCU10	B51
4050677	CNMG431FF KCU10	B48
4050678	CNMG431FW KCU10	B49
4050679	CNMG431MP KCU10	B51
4050681	CNMG431P KCU10	B52
4050682	CNMG431RP KCU10	B53
4050683	CNMG432CT KCU10	B48
4050684	CNMG432FF KCU10	B48
4050685	CNMG432FW KCU10	B49
4050686	CNMG432MP KCU10	B51
4050688	CNMG432P KCU10	B52
4050689	CNMG432RP KCU10	B53
4050690	CNMG432UP KCU10	B54
4050691	CNMG433FW KCU10	B49
4050692	CNMG433MP KCU10	B51
4050695	CNMG433RP KCU10	B53
4050696	CNMG433UP KCU10	B54
4050699	CNMG434RP KCU10	B53
4050700	CNMG542MP KCU10	B51
4050701	CNMG542RP KCU10	B53
4050702	CNMG543MP KCU10	B51
4050704	CNMG543RP KCU10	B53
4050705	CNMG543UP KCU10	B54
4050709	CNMG643 KCU10	B47
4050711	CNMG643P KCU10	B52
4050712	CNMG643RP KCU10	B53
4050713	CNMG644MP KCU10	B51
4050714	CNMG644RP KCU10	B53
4050743	DNMG332FP KCU10	B80
4050744	DNMG432FF KCU10	B79
4050746	WNMG331FP KCU10	B158
4050748	RCGV23 KCU10	B166
4050764	SPG421 KCU10	B171
4050765	SPG422 KCU10	B171
4050768	SPG433 KCU10	B171
4050769	SPG633 KCU10	B171
4050770	SPGF322 KCU10	B171
4050771	TPG221 KCU10	B177
4050772	TPG222 KCU10	B177
4050774	TPG321 KCU10	B177
4050775	TPG322 KCU10	B177
4050778	TPG431 KCU10	B177
4050779	TPG432 KCU10	B177
4050780	TPG433 KCU10	B177
4050783	TPGF222 KCU10	B177
4050784	TPGF321 KCU10	B177
4050785	TPGF322 KCU10	B177
4050786	TPGF431 KCU10	B177
4050787	TPGF432 KCU10	B177
4050895	D2FIX150504RHP KCU10	E9
4050896	D2FIX150508RHP KCU10	E9
4050899	D2FIX150508LHP KCU10	E9
4051036	C8FIX120505RRP KCU25	E12
4051038	C8FIX120503RMP KCU25	E13
4051039	C8FIX150605LRN KCU25	E12
4051040	C8FIX150608LRN KCU25	E12
4051041	C8FIX150605RRN KCU25	E12
4051042	C8FIX150608RRN KCU25	E12
4051044	C8FIX150603RMP KCU25	E13
4051048	C8FIX180812RRN KCU25	E12
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	E11
4051092	E2FIX100505RHP KCU10	E11
4051104	D2FIX150503LHP KCU10	E9
4051106	D2FIX150503LMS KCU10	E10
4051107	D2FIX150505LMS KCU10	E10
4051109	D2FIX150503RHP KCU10	E9
4051110	D2FIX150505RRN KCU10	E10
4051111	D2FIX150503RMS KCU10	E10
4051112	D2FIX150505RMS KCU10	E10
4051114	C2FIX150505LMN KCU10	E8
4051115	C2FIX180610LMN KCU10	E8
4051121	C8FIX120503LMP KCU10	E13
4051122	C8FIX120503RMP KCU10	E13
4051125	C8FIX150605RRN KCU10	E12
4051128	C8FIX150603RMP KCU10	E13
4051136	WD32FDS28190M	H127
4051137	WD32FDS28283M	H127
4051138	SSF150FDS280502	H128
4051139	SSF150FDS280746	H129
4051140	SSF150FDS281112	H129
4051141	SSF150FDS281356	H129
4051189	D2FIX150505RMN KCP10	E9
4051190	D2FIX150505RRN KCP10	E10
4051203	D4FIX140605RMN KCP10	E11
4051204	D4FIX140603RMN KCP10	E11
4051209	C8FIX120503LMP KCP10	E13
4051213	C8FIX150605RRN KCP10	E12
4051214	C8FIX150608RRN KCP10	E12
4051216	C8FIX150603RMP KCP10	E13
4051515	170.352	H122
4051516	B254A03000YPC KCK10	G52
4051517	B254A03048YPC KCK10	G52
4051519	B254A03200YPC KCK10	G52
4051521	B254A03300YPC KCK10	G52
4051522	B254A03454YPC KCK10	G52
4051797	B255A09300YPC KCK10	G54
4051798	B255A09400YPC KCK10	G54
4051799	B255A09500YPC KCK10	G54
4051800	B255A09525YPC KCK10	G54
4051801	B255A09600YPC KCK10	G54
4051802	B255A09700YPC KCK10	G54
4051826	D4FIX140608RMN KCP10	E11
4051829	C8FIX120504RRP KCP10	E12
4051830	C8FIX120508RRP KCP10	E12
4051837	B254A10200YPC KCK10	G54
4051838	B254A10262YPC KCK10	G54
4051839	B254A10300YPC KCK10	G54
4051840	B254A10320YPC KCK10	G54
4051842	B254A10490YPC KCK10	G54
4051843	B255A09800YPC KCK10	G54
4051844	B255A09921YPC KCK10	G54
4051845	B255A10000YPC KCK10	G54
4051846	B255A10200YPC KCK10	G54
4051847	B255A10262YPC KCK10	G54
4051848	B255A10300YPC KCK10	G54
4051849	B255A10320YPC KCK10	G54
4051850	B255A10400YPC KCK10	G54
4051852	B255A10500YPC KCK10	G54
4051853	B255A10600YPC KCK10	G54
4051854	B255A10716YPC KCK10	G54
4051855	B255A10800YPC KCK10	G54
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4051858	B255A11100YPC KCK10	G54
4051859	B255A11113YPC KCK10	G54
4051860	B255A11200YPC KCK10	G54
4051862	B255A11500YPC KCK10	G54
4051865	B255A11700YPC KCK10	G54
4051866	B255A11800YPC KCK10	G54
4051867	B255A11900YPC KCK10	G54
4051868	B255A11908YPC KCK10	G54
4051869	B255A12000YPC KCK10	G54
4051870	B255A12100YPC KCK10	G54
4051871	B255A12200YPC KCK10	G54
4051872	B255A12251YPC KCK10	G54
4051873	B255A12300YPC KCK10	G54
4051874	B255A12304YPC KCK10	G54
4051875	B255A12500YPC KCK10	G55
4051876	B255A12700YPC KCK10	G55
4051878	B255A13000YPC KCK10	G55
4051879	B255A13096YPC KCK10	G55
4051881	B255A13495YPC KCK10	G55
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4051884	B255A14000YPC KCK10	G55
4051885	B255A14100YPC KCK10	G55
4051886	B255A14288YPC KCK10	G55
4051887	B255A14500YPC KCK10	G55
4051888	B255A14600YPC KCK10	G55
4051889	B255A14684YPC KCK10	G55
4051893	B255A15000YPC KCK10	G55
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4051899	B255A15500YPC KCK10	G55
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4051902	B255A16000YPC KCK10	G55
4051904	B255A16300YPC KCK10	G55
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4051907	B255A16800YPC KCK10	G55
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4051917	B255A18000YPC KCK10	G55
4051918	B255A18258YPC KCK10	G55
4051919	B255A18500YPC KCK10	G55
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4051925	B255A19700YPC KCK10	G55
4051926	B255A19800YPC KCK10	G55
4051927	B255A20000YPC KCK10	G55
4051928	B255A20500YPC KCK10	G55
4051929	B255A20638YPC KCK10	G56
4051930	B255A21000YPC KCK10	G56
4051931	B255A22000YPC KCK10	G56
4051932	B255A22225YPC KCK10	G56
4051933	B255A23416YPC KCK10	G56
4051934	B255A24000YPC KCK10	G56
4051935	B255A25000YPC KCK10	G56
4051963	B254A03500YPC KCK10	G52
4051965	B254A03600YPC KCK10	G52
4051969	B254A03800YPC KCK10	G52
4051970	B254A03861YPC KCK10	G52
4051972	B254A04000YPC KCK10	G52
4051973	B254A04039YPC KCK10	G52
4051974	B254A04100YPC KCK10	G52
4051975	B254A04200YPC KCK10	G52
4051978	B254A04500YPC KCK10	G52
4051979	B254A04572YPC KCK10	G52
4051981	B254A04763YPC KCK10	G52
4051982	B254A04800YPC KCK10	G52
4051983	B254A05000YPC KCK10	G53
4051984	B254A05055YPC KCK10	G53
4051985	B254A05100YPC KCK10	G53
4051986	B254A05106YPC KCK10	G53
4051988	B254A05300YPC KCK10	G53
4051990	B254A05500YPC KCK10	G53
4051991	B254A05558YPC KCK10	G53
4051994	B254A05791YPC KCK10	G53
4051995	B254A05800YPC KCK10	G53
4051998	B254A06000YPC KCK10	G53
4051999	B254A06100YPC KCK10	G53
4052000	B254A06200YPC KCK10	G53
4052002	B254A06500YPC KCK10	G53
4052003	B254A06528YPC KCK10	G53
4052004	B254A06600YPC KCK10	G53
4052005	B254A06700YPC KCK10	G53
4052006	B254A06746YPC KCK10	G53
4052007	B254A06800YPC KCK10	G53
4052008	B254A06900YPC KCK10	G53
4052010	B254A07000YPC KCK10	G53
4052011	B254A07100YPC KCK10	G53
4052012	B254A07366YPC KCK10	G53
4052014	B254A07493YPC KCK10	G53
4052015	B254A07500YPC KCK10	G53
4052017	B254A07600YPC KCK10	G53
4052018	B254A07800YPC KCK10	G53
4052020	B254A07938YPC KCK10	G53
4052021	B254A08000YPC KCK10	G53
4052022	B254A08100YPC KCK10	G53
4052023	B254A08200YPC KCK10	G53
4052024	B254A08334YPC KCK10	G53
4052025	B254A08400YPC KCK10	G54
4052026	B254A08433YPC KCK10	G54
4052027	B254A08500YPC KCK10	G54
4052028	B254A08600YPC KCK10	G54
4052029	B254A08700YPC KCK10	G54
4052031	B254A08800YPC KCK10	G54
4052032	B254A08839YPC KCK10	G54
4052034	B254A09000YPC KCK10	G54
4052036	B254A09100YPC KCK10	G54
4052038	B254A09200YPC KCK10	G54
4052039	B254A09400YPC KCK10	G54
4052040	B254A09500YPC KCK10	G54
4052041	B254A09525YPC KCK10	G54
4052042	B254A09800YPC KCK10	G54
4052043	B254A09921YPC KCK10	G54
4052044	B254A10000YPC KCK10	G54
4052053	B254A10500YPC KCK10	G54
4052054	B254A10700YPC KCK10	G54
4052056	B254A10800YPC KCK10	G54
4052058	B254A11000YPC KCK10	G54
4052059	B254A11100YPC KCK10	G54
4052060	B254A11113YPC KCK10	G54
4052061	B254A11200YPC KCK10	G54
4052062	B254A11500YPC KCK10	G54

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4052064	B254A11800YPC KCK10	G54
4052066	B254A11908YPC KCK10	G54
4052067	B254A12000YPC KCK10	G54
4052068	B254A12200YPC KCK10	G54
4052070	B254A12304YPC KCK10	G54
4052071	B254A12500YPC KCK10	G55
4052073	B254A12800YPC KCK10	G55
4052074	B254A13000YPC KCK10	G55
4052076	B254A13100YPC KCK10	G55
4052077	B254A13200YPC KCK10	G55
4052081	B254A13500YPC KCK10	G55
4052082	B254A13800YPC KCK10	G55
4052083	B254A13891YPC KCK10	G55
4052084	B254A14000YPC KCK10	G55
4052085	B254A14100YPC KCK10	G55
4052086	B254A14288YPC KCK10	G55
4052087	B254A14500YPC KCK10	G55
4052090	B254A14800YPC KCK10	G55
4052091	B254A15000YPC KCK10	G55
4052093	B254A15200YPC KCK10	G55
4052094	B254A15250YPC KCK10	G55
4052095	B254A15400YPC KCK10	G55
4052097	B254A15500YPC KCK10	G55
4052099	B254A15800YPC KCK10	G55
4052101	B254A16000YPC KCK10	G55
4052102	B254A16500YPC KCK10	G55
4052103	B254A16670YPC KCK10	G55
4052104	B254A16800YPC KCK10	G55
4052105	B254A17000YPC KCK10	G55
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4052108	B254A17500YPC KCK10	G55
4052109	B254A17800YPC KCK10	G55
4052110	B254A17859YPC KCK10	G55
4052111	B254A18000YPC KCK10	G55
4052112	B254A18200YPC KCK10	G55
4052113	B254A18258YPC KCK10	G55
4052114	B254A18500YPC KCK10	G55
4052115	B254A18800YPC KCK10	G55
4052116	B254A19000YPC KCK10	G55
4052117	B254A19050YPC KCK10	G55
4052121	B254A19800YPC KCK10	G55
4052122	B254A20000YPC KCK10	G55
4052123	B254A20638YPC KCK10	G56
4052124	B254A21000YPC KCK10	G56
4052125	B254A22000YPC KCK10	G56
4052126	B254A22225YPC KCK10	G56
4052127	B254A23416YPC KCK10	G56
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4052130	B255A03000YPC KCK10	G52
4052131	B255A03048YPC KCK10	G52
4052132	B255A03175YPC KCK10	G52
4052133	B255A03200YPC KCK10	G52
4052134	B255A03250YPC KCK10	G52
4052135	B255A03300YPC KCK10	G52
4052136	B255A03400YPC KCK10	G52
4052138	B255A03500YPC KCK10	G52
4052140	B255A03600YPC KCK10	G52
4052141	B255A03700YPC KCK10	G52
4052143	B255A03797YPC KCK10	G52
4052144	B255A03800YPC KCK10	G52
4052145	B255A03861YPC KCK10	G52
4052146	B255A03970YPC KCK10	G52
4052147	B255A04000YPC KCK10	G52
4052148	B255A04039YPC KCK10	G52
4052149	B255A04100YPC KCK10	G52
4052150	B255A04200YPC KCK10	G52
4052151	B255A04217YPC KCK10	G52
4052152	B255A04300YPC KCK10	G52
4052153	B255A04366YPC KCK10	G52
4052155	B255A04500YPC KCK10	G52
4052156	B255A04572YPC KCK10	G52
4052157	B255A04600YPC KCK10	G52
4052158	B255A04700YPC KCK10	G52
4052160	B255A04800YPC KCK10	G52
4052161	B255A04900YPC KCK10	G52
4052162	B255A05000YPC KCK10	G53
4052163	B255A05055YPC KCK10	G53
4052164	B255A05100YPC KCK10	G53
4052166	B255A05159YPC KCK10	G53
4052167	B255A05200YPC KCK10	G53
4052168	B255A05250YPC KCK10	G53
4052169	B255A05300YPC KCK10	G53
4052170	B255A05400YPC KCK10	G53
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4052180	B255A06000YPC KCK10	G53
4052181	B255A06100YPC KCK10	G53
4052182	B255A06200YPC KCK10	G53
4052183	B255A06300YPC KCK10	G53
4052184	B255A06350YPC KCK10	G53
4052185	B255A06400YPC KCK10	G53
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4052196	B255A07145YPC KCK10	G53
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4052211	B255A08200YPC KCK10	G53
4052212	B255A08300YPC KCK10	G53
4052214	B255A08433YPC KCK10	G54
4052215	B255A08500YPC KCK10	G54
4052216	B255A08600YPC KCK10	G54
4052217	B255A08700YPC KCK10	G54
4052219	B255A08800YPC KCK10	G54
4052220	B255A08839YPC KCK10	G54
4052221	B255A08900YPC KCK10	G54
4052222	B255A09000YPC KCK10	G54
4052223	B255A09093YPC KCK10	G54
4052224	B255A09100YPC KCK10	G54
4052225	B255A09129YPC KCK10	G54
4052226	B255A09200YPC KCK10	G54
4052592	KRM018030CLB004NE	K94
4052845	B256A10200YPC KCK10	G54
4052846	B256A10300YPC KCK10	G54
4052847	B256A10400YPC KCK10	G54
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4052849	B256A10700YPC KCK10	G54
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4052871	B256A12500YPC KCK10	G55
4052872	B256A12700YPC KCK10	G55
4052873	B256A12800YPC KCK10	G55
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4052875	B256A13096YPC KCK10	G55
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4052906	B256A18258YPC KCK10	G55
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4052909	B256A19000YPC KCK10	G55
4052911	B256A19500YPC KCK10	G55
4052912	B256A19800YPC KCK10	G55
4052913	B256A20000YPC KCK10	G55
4052914	B256A20638YPC KCK10	G56
4052915	B256A22000YPC KCK10	G56
4052916	B256A22225YPC KCK10	G56
4052917	B256A25004YPC KCK10	G56
4053226	B256A03000YPC KCK10	G52
4053228	B256A03175YPC KCK10	G52
4053230	B256A03264YPC KCK10	G52
4053232	B256A03500YPC KCK10	G52
4053235	B256A03700YPC KCK10	G52
4053236	B256A03800YPC KCK10	G52
4053238	B256A04000YPC KCK10	G52
4053240	B256A04100YPC KCK10	G52
4053241	B256A04200YPC KCK10	G52
4053242	B256A04300YPC KCK10	G52
4053243	B256A04366YPC KCK10	G52
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4053245	B256A04623YPC KCK10	G52
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4053247	B256A04800YPC KCK10	G52
4053248	B256A04852YPC KCK10	G52
4053249	B256A05000YPC KCK10	G53
4053250	B256A05100YPC KCK10	G53
4053252	B256A05200YPC KCK10	G53
4053254	B256A05500YPC KCK10	G53
4053255	B256A05600YPC KCK10	G53
4053258	B256A05800YPC KCK10	G53
4053259	B256A05900YPC KCK10	G53
4053261	B256A06000YPC KCK10	G53
4053262	B256A06200YPC KCK10	G53
4053263	B256A06350YPC KCK10	G53
4053264	B256A06400YPC KCK10	G53
4053265	B256A06500YPC KCK10	G53
4053266	B256A06600YPC KCK10	G53
4053267	B256A06700YPC KCK10	G53
4053268	B256A06800YPC KCK10	G53
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4053270	B256A07300YPC KCK10	G53
4053271	B256A07500YPC KCK10	G53
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4053273	B256A07800YPC KCK10	G53
4053274	B256A08000YPC KCK10	G53
4053275	B256A08200YPC KCK10	G53
4053276	B256A08300YPC KCK10	G53
4053277	B256A08500YPC KCK10	G54
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4053279	B256A08700YPC KCK10	G54
4053280	B256A08800YPC KCK10	G54
4053281	B256A09000YPC KCK10	G54
4053282	B256A09100YPC KCK10	G54
4053284	B256A09300YPC KCK10	G54
4053285	B256A09347YPC KCK10	G54
4053287	B256A09500YPC KCK10	G54
4053288	B256A09600YPC KCK10	G54
4053289	B256A09700YPC KCK10	G54
4053290	B256A09800YPC KCK10	G54
4053291	B256A10000YPC KCK10	G54
4053312	CDHB1206X0 KCU10	B199
4053323	CDHB120605 KCU10	B199
4053324	CDHB12061 KCU10	B199
4053325	CDHH120605L KCU10	B199
4053326	CDHH120605R KCU10	B199
4053327	CDHH12061L KCU10	B199
4053328	CDHH12061R KCU10	B199
4053336	TDHB12807505 KCU10	B263
4053337	TDHB1280751 KCU10	B263
4053339	TDHH12807505L KCU10	B263
4053340	TDHH12807505R KCU10	B263
4053341	TDHH1280751L KCU10	B263
4053342	TDHH1280751R KCU10	B263
4053344	TPGH321 KCU10	B266
4053352	DNGG4305LF KCU10	B77
4053363	DNGG431LF KCU10	B77
4053364	DNGG432LF KCU10	B77
4053366	DNGP4305 KCU10	B77
4053367	DNGP431 KCU10	B77
4053368	DNGP432 KCU10	B77
4053369	DNGP441 KCU10	B77
4053370	DNGP442 KCU10	B77
4053371	DNMG331FW KCU10	B80
4053372	DNMG332FF KCU10	B79
4053373	DNMG332MP KCU10	B81
4053374	DNMG332RP KCU10	B84
4053376	DNMG431CT KCU10	B79
4053377	DNMG431FF KCU10	B79
4053378	DNMG431FW KCU10	B80
4053379	DNMG431MP KCU10	B81
4053380	DNMG431P KCU10	B83
4053381	DNMG431UP KCU10	B84
4053383	DNMG432FW KCU10	B80
4053384	DNMG432MP KCU10	B81
4053386	DNMG432P KCU10	B83
4053387	DNMG432RP KCU10	B84
4053388	DNMG432UP KCU10	B84
4053389	DNMG433CT KCU10	B79
4053390	DNMG433MP KCU10	B81
4053391	DNMG433RP KCU10	B84
4053393	DNMG434RP KCU10	B84
4053395	DNMG441FW KCU10	B80
4053396	DNMG441MP KCU10	B81
4053399	DNMG442FW KCU10	B80
4053400	DNMG442MP KCU10	B81
4053403	DNMG442RP KCU10	B84
4053404	DNMG442UP KCU10	B84
4053406	DNMG443MP KCU10	B81
4053407	DNMG443RP KCU10	B84
4053408	RNMG43RN KCU10	B97
4053409	RNMG64RN KCU10	B97
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	E12
4054374	C8FIX150605RRN KCP40	E12
4054375	C8FIX150608RRN KCP40	E12
4054377	C8FIX150603RMP KCP40	E13
4054380	C8FIX180808RRN KCP40	E12
4054381	C8FIX180812RRN KCP40	E12
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	E13
4054404	C8FIX120503RMP KCP25	E13
4054405	C8FIX150605LRN KCP25	E12
4054406	C8FIX150608LRN KCP25	E12
4054407	C8FIX150605RRN KCP25	E12
4054408	C8FIX150608RRN KCP25	E12
4054409	C8FIX150603LMP KCP25	E13
4054410	C8FIX150603RMP KCP25	E13
4054412	C8FIX180812LRN KCP25	E12
4054413	C8FIX180808RRN KCP25	E12
4054414	C8FIX180812RRN KCP25	E12

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4054416	C8FIX180805RMP KCP25	E13
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	E12
4054455	C8FIX120508LRP KCP25	E12
4054456	C8FIX150612LRN KCP25	E12
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	D2FIX150505RFN KCP25	E10
4054488	D2FIX150505RMN KCP25	E9
4054490	D2FIX150503RMN KCP25	E9
4054491	C2FIX150505LMN KCP25	E8
4054494	B976A03175 KC7315	G134
4054495	B976A03454 KC7315	G134
4054496	B976A03734 KC7315	G134
4054497	B976A03797 KC7315	G134
4054498	B976A04039 KC7315	G134
4054499	B976A04366 KC7315	G135
4054500	B976A04496 KC7315	G135
4054501	B976A04700 KC7315	G135
4054502	B976A05106 KC7315	G135
4054503	B976A05410 KC7315	G135
4054504	B976A05791 KC7315	G135
4054505	B976A05944 KC7315	G135
4054506	B976A06528 KC7315	G135
4054507	B976A06909 KC7315	G135
4054508	B976A07366 KC7315	G136
4054509	B976A08433 KC7315	G136
4054510	B976A08839 KC7315	G136
4054511	B976A09093 KC7315	G136
4054512	B976A10262 KC7315	G136
4054513	B976A13495 KC7315	G137
4054514	B976A16670 KC7315	G138
4054515	B977A03175 KC7315	G134
4054516	B977A03734 KC7315	G134
4054517	B977A03797 KC7315	G134
4054518	B977A04039 KC7315	G134
4054519	B977A04366 KC7315	G135
4054520	B977A04496 KC7315	G135
4054521	B977A05106 KC7315	G135
4054522	B977A05791 KC7315	G135
4054523	B977A05944 KC7315	G135
4054524	B977A07366 KC7315	G136
4054525	B977A08839 KC7315	G136
4054526	B977A09093 KC7315	G136
4054527	B977A10262 KC7315	G136
4054528	B977A13495 KC7315	G137
4054648	C2FIX150504LMN KCP40	E8
4054651	D4FIX140604RMN KCP40	E11
4054660	C8FIX120508LRP KCP40	E12
4054680	DFR040304D28MD KC7140	H113, J97
4054681	DFR040304D28LD KC7225	H113
4054733	HSK100ASVUBB2124MCLB	K78
4054734	HSK63ASVUBB1095MCLB	K76
4054735	HSK63ASVUBB2116MCLB	K78
4054736	KM50TSSVUBB2100MCLB	K77
4054737	KR32SVUBB1060MCLB	K76
4054738	KR32SVUBB2085MCLB	K77
4054739	KR50SVUBB2075MCLB	K77
4054740	KR80SVU92152MCLB	K88
4054889	A4G0605M06U08GMN KCP10	C106
4054890	A4R0605M06U00GMN KCP10	C107
4056174	SS16KST115AR3M	K42
4056175	SS20KST135AR3M	K42
4056176	SS20KST155AR3M	K42
4056177	SS16KST115AR5M	K42
4056178	SS20KST135AR5M	K42
4056179	SS20KST155AR5M	K42
4056390	RHM14000KST115H7HF KT6215	K33
4056513	RPG43E KYSP30	V157
4056980	RHM14000KST115H7HF KT325	K33
4056981	RHM14288KST115H7HF KT325	K33
4056983	RHM15875KST115H7HF KT325	K33
4056984	RHM16000KST135H7HF KT325	K33
4056985	RHM17000KST135H7HF KT325	K33
4056986	RHM17463KST135H7HF KT325	K33
4056987	RHM18000KST155H7HF KT325	K33
4056988	RHM19000KST155H7HF KT325	K33
4056989	RHM19050KST155H7HF KT325	K33
4056990	RHM14288KST115H7HF KT6215	K33
4056993	RHM16000KST135H7HF KT6215	K33
4056994	RHM17000KST135H7HF KT6215	K33
4056995	RHM17463KST135H7HF KT6215	K33
4056996	RHM18000KST155H7HF KT6215	K33
4056997	RHM19000KST155H7HF KT6215	K33
4056998	RHM19050KST155H7HF KT6215	K33
4057034	RHM14000KST115H7SF KT325	K31
4057035	RHM14288KST115H7SF KT325	K31
4057036	RHM15000KST115H7SF KT325	K31
4057037	RHM15875KST115H7SF KT325	K31
4057038	RHM16000KST135H7SF KT325	K31
4057039	RHM17000KST135H7SF KT325	K31
4057040	RHM17463KST135H7SF KT325	K31
4057041	RHM18000KST155H7SF KT325	K31
4057042	RHM19000KST155H7SF KT325	K31
4057044	RHM14000KST115H7SF KT6215	K31
4057045	RHM14288KST115H7SF KT6215	K31
4057047	RHM15875KST115H7SF KT6215	K31
4057048	RHM16000KST135H7SF KT6215	K31
4057049	RHM17000KST135H7SF KT6215	K31
4057051	RHM18000KST155H7SF KT6215	K31
4057053	RHM19050KST155H7SF KT6215	K31
4057057	HSK63FBHM1696	K132
4057058	DV40FBHM1691	K133
4057059	BT40FBHM1691	K133
4057060	KM50TSFBHM1677	K132
4057061	AFM29115	K135
4057062	AFM47115	K135
4057093	AFM29SCFPR06	K136
4057094	AFM47SCFPR09	K136
4057095	EBM8015086	K136
4057096	886038045	K136
4057097	PKG-8001	K132–134
4057098	HSK63FBHMKIT164M	K127, K131
4057099	DV40FBHMKIT164M	K127, K131
4057100	BT40FBHMKIT164M	K127, K131
4057101	KM50TSFBHMKIT164M	K127, K131
4057204	EB630128650	K144
4057205	EB10801281100	K144
4057206	EB16301281650	K144
4057207	EBSLD1105	K144
4057208	EBSLD2205	K144
4057576	KSHR1000HN7545C10	S24
4057578	KSHR300HN7545M4	S24
4057579	KSHR400HN7545M5	S24
4057580	KSHR500HN7545M6	S24
4057581	KSHR600HN7545M8	S24
4057582	KSHR800HN7545M10	S24
4057583	KSHR1000HN7545M10	S24
4057639	HNPJ75ANSNHD KCPK30	S26
4057640	HNPJ75ANSNHD KCK15	S26
4057641	HNPJ75ANSNHD KC725M	S26
4057828	HNPJ755ANSNHD KCPK30	S26
4057830	HNPJ755ANSNHD KC725M	S26
4057854	HNPJ759ANSNHD KCPK30	S26
4057855	HNPJ759ANSNHD KCK15	S26
4057865	HNGJ75ANENGD KCPK30	S25
4057867	HNGJ75ANENGD KC725M	S25
4058547	LNEQ1235R03 4 KCK15	U20
4058551	LNEU1240R03SGP 4 KC725M	U20
4058763	LNEQ1240R03 4 KCPK30	U20
4059040	T620M240X300R6H-XL KP6525	M14
4059042	T620M300X350R6H-XL KP6525	M14
4059043	T620M330X350R6H-XL KP6525	M14
4059045	T620M360X400R6H-XL KP6525	M14
4059047	T620M420X450R6H-XL KP6525	M14
4059051	T630M240X300R6HX-XL KP6525	M56
4059053	T630M300X350R6HX-XL KP6525	M56
4059054	T630M330X350R6HX-XL KP6525	M56
4059056	T630M360X400R6HX-XL KP6525	M56
4059058	T630M420X450R6HX-XL KP6525	M56
4059062	T631M240X300R6HX-XL KP6525	M57
4059064	T631M300X350R6HX-XL KP6525	M57
4059065	T631M330X350R6HX-XL KP6525	M57
4059067	T631M360X400R6HX-XL KP6525	M57
4059069	T631M420X450R6HX-XL KP6525	M57
4059090	T620M240X300R6HX-D6 KP6525	M13
4059092	T620M300X350R6HX-D6 KP6525	M13
4059113	T620M330X350R6HX-D6 KP6525	M13
4059115	T620M360X400R6HX-D6 KP6525	M13
4059117	T620M420X450R6HX-D6 KP6525	M13
4059121	T630M300X350R6HX-D6 KP6525	M54
4059122	T630M330X350R6HX-D6 KP6525	M54
4059124	T630M360X400R6HX-D6 KP6525	M54
4059126	T630M420X450R6HX-D6 KP6525	M54
4059129	T631M240X300R6HX-D6 KP6525	M55
4059131	T631M300X350R6HX-D6 KP6525	M55
4059132	T631M330X350R6HX-D6 KP6525	M55
4059134	T631M360X400R6HX-D6 KP6525	M55
4059136	T631M420X450R6HX-D6 KP6525	M55
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	K42
4060529	KST135155AS	K42
4061407	XNXF43ZNENW KY3500	S90
4062112	HSK100BT13075	K143
4062443	EBUCW0074	K145
4062902	KTIP260R3SCF25M	H40
4063183	KTIP270R3SCF25M	H40
4063184	KTIP260R5SCF25M	H40
4063185	KTIP270R5SCF25M	H40
4063186	KTIP260R8SCF25M	H40
4063187	KTIP270R8SCF25M	H40
4063188	KTIP260R3SS32M	H38
4063189	KTIP270R3SS32M	H38
4063190	KTIP260R5SS32M	H38
4063191	KTIP270R5SS32M	H38
4063192	KTIP260R8SS32M	H38
4063193	KTIP1024R3SS125	H39
4063194	KTIP1063R3SS125	H39
4063195	KTIP1024R5SS125	H39
4063196	KTIP1063R5SS125	H39
4063197	KTIP1024R8SS125	H39
4063198	KTIP1063R8SS125	H39
4063996	SDB24RBHT06F	K126
4063997	SDB30RBHT06F	K126
4063998	SDB40RBHT09F	K126
4063999	SDB50RBHT09F	K126
4064000	SDB66RBHT12F	K126
4064001	SDB66RBHT12LF	K126
4064002	SDB87RBHT12F	K126
4064203	SDB87RBHT16LF	K126
4064204	SDB115RBHT16LF	K126
4064205	SDB115RBHT12F	K126
4064258	TTP25	S24
4065057	A4G0605M06U08GMN KCP25	C106
4067219	HPHV750S4225CH KCPM15	P19
4067220	HPHV750S4225R030 KCPM15	P19
4067221	HPHV750S4225R060 KCPM15	P19
4067222	HPHV750S4300 KCPM15	P19
4067236	HPHV625S4075 KCPM15	P18
4067237	HPHV625S4075CH KCPM15	P18
4067238	HPHV625S4075L KCPM15	P19
4067239	HPHV625S4075LR015 KCPM15	P18
4067240	HPHV625S4075LR030 KCPM15	P18
4067241	HPHV625S4075LR060 KCPM15	P18
4067253	HPHV625S4075R060 KCPM15	P18
4067255	HPHV625S4125 KCPM15	P19
4067256	HPHV625S4125CH KCPM15	P19
4067257	HPHV625S4125R030 KCPM15	P19
4067258	HPHV625S4125R060 KCPM15	P19
4067259	HPHV625S4125R090 KCPM15	P19
4067261	HPHV625S4163 KCPM15	P19
4067262	HPHV625S4163R030 KCPM15	P19
4067263	HPHV625S4163R060 KCPM15	P19
4067264	HPHV625S4163R120 KCPM15	P19
4067265	HPHV625S4213 KCPM15	P19
4067266	HPHV625S4213R030 KCPM15	P19
4067267	HPHV625S4213R120 KCPM15	P19
4067268	HPHV625S4225R060 KCPM15	P19
4067269	HPHV750S4088 KCPM15	P19
4067270	HPHV750S4088CH KCPM15	P19
4067271	HPHV750S4088L KCPM15	P19
4067272	HPHV750S4088LR030 KCPM15	P19
4067273	HPHV750S4150 KCPM15	P19
4067274	HPHV750S4150CH KCPM15	P19
4067275	HPHV750S4150R015 KCPM15	P19
4067276	HPHV750S4150R030 KCPM15	P19
4067277	HPHV750S4150R060 KCPM15	P19
4067278	HPHV750S4150R090 KCPM15	P19
4067279	HPHV750S4150R120 KCPM15	P19
4067280	HPHV750S4163CH KCPM15	P19
4067281	HPHV750S4163R030 KCPM15	P19
4067282	HPHV750S4163R060 KCPM15	P19
4067283	HPHV750S4163R120 KCPM15	P19
4067286	HPHVBN1000S4150 KCPM15	P23
4067287	HPHVBN438S4088 KCPM15	P23
4067288	HPHVBN500S4100 KCPM15	P23
4067289	HPHVBN500S4125 KCPM15	P23
4067290	HPHVBN625S4125 KCPM15	P23
4067291	HPHVBN750S4150 KCPM15	P23
4067292	HPHVBN125S4050 KCPM15	P23
4067303	HPHV750S4300CH KCPM15	P19
4067304	HPHV750S4400R030 KCPM15	P19
4067305	HPHV750S4400R060 KCPM15	P19
4067306	HPHV1000S4150 KCPM15	P19
4067307	HPHV1000S4150CH KCPM15	P19
4067308	HPHV1000S4150R030 KCPM15	P19
4067311	HPHV1000S4150R120 KCPM15	P19
4067312	HPHV1000S4150R250 KCPM15	P19
4067313	HPHV1000S4200 KCPM15	P20
4067314	HPHV1000S4200R030 KCPM15	P19
4067315	HPHV1000S4200R060 KCPM15	P19
4067316	HPHV1000S4200R120 KCPM15	P19
4067318	HPHV1000S4225 KCPM15	P20
4067319	HPHV1000S4225CH KCPM15	P20
4067320	HPHV1000S4225R030 KCPM15	P20
4067321	HPHV1000S4225R060 KCPM15	P20
4067322	HPHV1000S4263 KCPM15	P20
4067323	HPHV1000S4263CH KCPM15	P20
4067324	HPHV1000S4263R030 KCPM15	P20
4067325	HPHV1000S4300CH KCPM15	P20
4067326	HPHV1000S4300R030 KCPM15	P20
4067327	HPHV1000S4300R060 KCPM15	P20
4067328	HPHV1000S4400CH KCPM15	P20
4067329	HPHV1000S4400R030 KCPM15	P20
4067330	HPHV1000S4400R060 KCPM15	P20
4067331	HPHV1250S4225CH KCPM15	P20
4067332	HPHV1250S4225R030 KCPM15	P20
4067343	HPHVBN188S4063 KCPM15	P23
4067344	HPHVBN250S4075 KCPM15	P23
4067345	HPHVBN312S4075 KCPM15	P23
4067346	HPHVBN375S4088 KCPM15	P23
4068215	UADE0250J4AQA KCPM15	P21
4068216	UADE0250J4AQB KCPM15	P21
4068217	UADE0375J4AQA KCPM15	P21
4068218	UADE0375J4AQB KCPM15	P21
4068220	UADE0500J4AQB KCPM15	P21
4068221	UADE0625J4AQB KCPM15	P21
4068222	UADE0750J4AQB KCPM15	P21
4068233	UADE0750J4BQB KCPM15	P21
4068234	UADE1000J4BQB KCPM15	P21
4068604	RCMH3209M0RU KCP25	E66
4071037	B967A13000 KC7315	G132
4071041	A4G0505M05U08GMN KCP10	C106
4071068	A4R0505M05U00GMN KCP10	C107
4071840	HPHV375S4088R015 KCPM15	P17
4071841	HPHV375S4088R030 KCPM15	P17
4071842	HPHV375S4088R060 KCPM15	P17
4071883	HPHV375S4088R090 KCPM15	P17
4071884	HPHV375S4100 KCPM15	P17
4071885	HPHV375S4100R015 KCPM15	P17
4071886	HPHV375S4100R030 KCPM15	P17
4071887	HPHV375S4100R060 KCPM15	P17
4071888	HPHV375S4125 KCPM15	P17
4071889	HPHV375S4125R015 KCPM15	P17
4071890	HPHV375S4125R030 KCPM15	P17

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4071891	HPHV375S4125R060 KCPM15	P17
4071892	HPHV375S4150 KCPM15	P17
4071893	HPHV375S4150R030 KCPM15	P17
4071894	HPHV375S4150R060 KCPM15	P17
4071895	HPHV375S4250R030 KCPM15	P17
4071896	HPHV375S4250R060 KCPM15	P17
4071897	HPHV438S4063CH KCPM15	P18
4071898	HPHV438S4088CH KCPM15	P18
4071899	HPHV438S4113R015 KCPM15	P18
4071900	HPHV500S4063 KCPM15	P18
4071901	HPHV500S4063CH KCPM15	P18
4071902	HPHV500S4063L KCPM15	P18
4071903	HPHV500S4063LR015 KCPM15	P18
4071904	HPHV500S4063LR030 KCPM15	P18
4071905	HPHV500S4063LR060 KCPM15	P18
4071906	HPHV500S4063R030 KCPM15	P18
4071907	HPHV500S4063R060 KCPM15	P18
4071908	HPHV500S4100 KCPM15	P18
4071909	HPHV500S4100CH KCPM15	P18
4071910	HPHV500S4100R030 KCPM15	P18
4071911	HPHV500S4100R060 KCPM15	P18
4071912	HPHV500S4125 KCPM15	P18
4071913	HPHV500S4125CH KCPM15	P18
4071914	HPHV500S4125R015 KCPM15	P18
4071915	HPHV500S4125R030 KCPM15	P18
4071916	HPHV500S4125R060 KCPM15	P18
4071917	HPHV500S4125R090 KCPM15	P18
4071918	HPHV500S4125R120 KCPM15	P18
4071919	HPHV500S4150 KCPM15	P18
4071920	HPHV500S4150CH KCPM15	P18
4071921	HPHV500S4150R030 KCPM15	P18
4071922	HPHV500S4150R060 KCPM15	P18
4071923	HPHV500S4163 KCPM15	P18
4071924	HPHV500S4163R030 KCPM15	P18
4071925	HPHV500S4163R060 KCPM15	P18
4071926	HPHV500S4163R120 KCPM15	P18
4071927	HPHV500S4200 KCPM15	P18
4071928	HPHV500S4200CH KCPM15	P18
4071929	HPHV500S4200R030 KCPM15	P18
4071930	HPHV500S4250R030 KCPM15	P18
4071932	HPHV500S4300R030 KCPM15	P18
4071933	HPHV500S4300R060 KCPM15	P18
4072204	HPRSHV1000S4700CH KCPM15	P22
4072205	HPRSHV500S4600 KCPM15	P22
4072206	HPRSHV500S4600CH KCPM15	P22
4072207	HPRSHV625S4600 KCPM15	P22
4072208	HPRSHV625S4600CH KCPM15	P22
4072209	HPRSHV750S4500CH KCPM15	P22
4072210	HPRSHV750S4600 KCPM15	P22
4072211	HPRSHV750S4600CH KCPM15	P22
4075269	CNMG433MP KCP10	B51
4075270	DNMG432MP KCP10	B81
4075271	DNMG442MP KCP10	B81
4075304	WNMG432MP KCP10	B159
4075305	CNMG432MP KCP25	B51
4075306	CNMG433MP KCP25	B51
4075307	DNMG432MP KCP25	B81
4075308	DNMG442MP KCP25	B81
4075309	TNMG332MP KCP25	B124
4075310	WNMG332MP KCP25	B159
4075311	WNMG432MP KCP25	B159
4078132	B967A15300 KC7315	G132
4078652	CNMG431FP KCP10	B49
4078704	DNMG332FP KCP10	B80
4078705	DNMG432FP KCP10	B80
4078706	DNMG442FP KCP10	B80
4078708	VNMG332FP KCP10	B146
4078709	WNMG431FP KCP10	B158
4078710	WNMG432FP KCP10	B158
4078711	CNMG432FP KCP25	B49
4078712	DNMG432FP KCP25	B80
4078723	DNMG442FP KCP25	B80
4078724	WNMG431FP KCP25	B158
4078725	WNMG432FP KCP25	B158
4079239	UADE1000J4ARF KC643M	P19
4079241	UADE1000J4ARD KC643M	P19
4079242	UADE1000J4ARC KC643M	P19
4079253	UADE1000J4ARB KC643M	P19
4079254	UADE1000J4ARA KC643M	P19
4079255	UADE750J4BRE KC643M	P19
4079257	UADE750J4BRC KC643M	P19
4079258	UADE750J4BRB KC643M	P19
4079259	UADE750J4BRA KC643M	P19
4079260	UADE750J4ARE KC643M	P19
4079263	UADE750J4ARB KC643M	P19
4079265	UADE625J4ARC KC643M	P19
4079266	UADE625J4ARB KC643M	P19
4079267	UADE500J4CRE KC643M	P18
4079268	UADE500J4CRD KC643M	P18
4079269	UADE500J4CRC KC643M	P18
4079270	UADE500J4CRB KC643M	P18
4079271	UADE500J4CRA KC643M	P18
4079272	UADE500J4BRE KC643M	P18
4079273	UADE500J4BRD KC643M	P18
4079274	UADE500J4BRC KC643M	P18
4079275	UADE500J4BRB KC643M	P18
4079276	UADE500J4BRA KC643M	P18
4079277	UADE500J4ARE KC643M	P18
4079279	UADE500J4ARC KC643M	P18
4079280	UADE500J4ARB KC643M	P18
4079281	UADE500J4ARA KC643M	P18
4079283	UADE375J4BRB KC643M	P18
4079284	UADE375J4BRA KC643M	P18
4079285	UADE375J4ARC KC643M	P18
4079286	UADE375J4ARB KC643M	P17
4079287	UADE375J4ARA KC643M	P17
4079288	UADE250J4ARC KC643M	P17
4079290	UADE250J4ARA KC643M	P16
4080356	B967A10200 KC7315	G131
4080393	B967A12800 KC7315	G132
4080395	B967A15000 KC7315	G132
4081832	RIQ09E1306 KC6005	K58
4086429	B976A05558 KC7315	G135
4086430	B977A03454 KC7315	G134
4086431	B977A16670 KC7315	G138
4086935	A4G0405M04U08GMN KCP10	C106
4086956	A4R0405M04U00GMN KCP10	C107
4089831	B967A11300 KC7315	G131
4105177	MEGA45D1000LN863C10	S94
4105178	MEGA45D1200LN863C10	S94
4106399	B707A07400FBS KN15	G111
4109575	KF2X100W0902M12L138	V36
4109577	KF2X125W0903M16L169	V36
4109579	KF2X150W0904M16L169	V36
4109580	KF2X100W0902C100L600	V37
4109581	KF2X100W0902C100L800	V37
4109582	KF2X125W0903C125L600	V37
4109593	KF2X125W0903C125L800	V37
4109594	KF2X150W0903C125L600	V37
4109595	KF2X150W0903C125L800	V37
4109596	KF2X150W0904S050L157	V38
4109597	KF2X200W0905S075L157	V38
4109598	KF2X200W0906S075L157	V38
4109599	KF2X250W0906S075L175	V38
4109600	KF2X300W0907S100L175	V38
4109624	NA3L10 KCU25	D11
4109625	NA3L4 KCU25	D11
4109626	NA3L5 KCU25	D11
4109627	NA3L6 KCU25	D11
4109628	NA3L8 KCU25	D11
4109629	NA3R10 KCU25	D11
4109630	NA3R4 KCU25	D11
4109631	NA3R5 KCU25	D11
4109632	NA3R6 KCU25	D11
4109633	NA3R8 KCU25	D11
4109636	NAS3L4 KCU25	D12
4109637	NAS3L6 KCU25	D12
4109638	NAS3L8 KCU25	D12
4109640	NAS3R12 KCU25	D12
4109641	NAS3R4 KCU25	D12
4109644	NAS3R8 KCU25	D12
4109645	NF3125LK KCU25	C173
4109646	NF3125RK KCU25	C173
4109647	NF3156LK KCU25	C173
4109648	NF3156RK KCU25	C173
4109649	NF3188L KCU25	C175
4109650	NF3188R KCU25	C175
4109651	NFD3125LK KCU25	C174
4109652	NFD3125LKI KCU25	C174
4109653	NFD3125RK KCU25	C174
4109654	NFD3125RKI KCU25	C174
4109655	NFD3189LKI KCU25	C174
4109656	NFD3189RKI KCU25	C174
4109657	NFD4189LK KCU25	C174
4109658	NFD4189RK KCU25	C174
4109659	NFD4250LK KCU25	C174
4109660	NFD4250RK KCU25	C174
4109661	NG2031L KCU25	C170
4109662	NG2031LK KCU25	C163
4109663	NG2031R KCU25	C170
4109664	NG2031RK KCU25	C162
4109665	NG2041L KCU25	C170
4109666	NG2041R KCU25	C170
4109667	NG2047L KCU25	C170
4109668	NG2047LK KCU25	C163
4109669	NG2047R KCU25	C170
4109670	NG2047RK KCU25	C162
4109671	NG2058L KCU25	C170
4109672	NG2058R KCU25	C170
4109673	NG2062L KCU25	C170
4109674	NG2062LK KCU25	C163
4109675	NG2062R KCU25	C170
4109676	NG2062RK KCU25	C162
4109677	NG2094L KCU25	C170
4109678	NG2094LK KCU25	C163
4109679	NG2094R KCU25	C170
4109680	NG2094RK KCU25	C162
4109681	NG2125L KCU25	C170
4109682	NG2125LK KCU25	C163
4109683	NG2125R KCU25	C170
4109684	NG2125RK KCU25	C162
4109685	NG2M050RK KCU25	C162
4109686	NG2M080LK KCU25	C163
4109687	NG2M080RK KCU25	C162
4109688	NG2M100LK KCU25	C163
4109689	NG2M100RK KCU25	C162
4109690	NG2M120LK KCU25	C163
4109691	NG2M120RK KCU25	C162
4109692	NG2M140LK KCU25	C163
4109698	NG3M100LK KCU25	C163
4109699	NG3M100RK KCU25	C162
4109700	NG3M120LK KCU25	C163
4109701	NG3M120RK KCU25	C162
4109702	NG3M150LK KCU25	C163
4109713	NG3M150RK KCU25	C162
4109714	NG3M175LK KCU25	C163
4109715	NG3M175RK KCU25	C162
4109716	NG3M200LK KCU25	C163
4109717	NG3M200RK KCU25	C162
4109718	NG3M220LK KCU25	C164
4109719	NG3M220RK KCU25	C162
4109720	NG3M225LK KCU25	C164
4109721	NG3M225RK KCU25	C162
4109722	NG3M250LK KCU25	C164
4109723	NG2M140RK KCU25	C162
4109724	NG2M150LK KCU25	C163
4109725	NG2M150RK KCU25	C162
4109726	NG2M170LK KCU25	C163
4109727	NG2M170RK KCU25	C162
4109728	NG2M175LK KCU25	C163
4109729	NG2M175RK KCU25	C162
4109730	NG2M195LK KCU25	C163
4109731	NG2M195RK KCU25	C162
4109732	NG2M200LK KCU25	C163
4109733	NG3M250RK KCU25	C162
4109734	NG3M275LK KCU25	C164
4109735	NG3M275RK KCU25	C162
4109736	NG3M300LK KCU25	C164
4109737	NG3M300RK KCU25	C162
4109738	NG3M320LK KCU25	C164
4109739	NG3M320RK KCU25	C162
4109740	NG3M325LK KCU25	C164
4109741	NG3M325RK KCU25	C162
4109742	NG3M350LK KCU25	C164
4109743	NG2M200RK KCU25	C162
4109744	NG2M220LK KCU25	C163
4109745	NG2M220RK KCU25	C162
4109746	NG2M225LK KCU25	C163
4109747	NG2M225RK KCU25	C162
4109748	NG2M250LK KCU25	C163
4109749	NG2M250RK KCU25	C162
4109750	NG2M275LK KCU25	C163
4109751	NG2M275RK KCU25	C162
4109752	NG2M300LK KCU25	C163
4109753	NG3M350RK KCU25	C162
4109754	NG3M400LK KCU25	C164
4109755	NG3M400RK KCU25	C162
4109756	NG3M425LK KCU25	C164
4109757	NG3M425RK KCU25	C163
4109758	NG3M450LK KCU25	C164
4109759	NG3M450RK KCU25	C163
4109760	NG4125L KCU25	C171
4109761	NG4125LK KCU25	C164
4109762	NG4125R KCU25	C170
4109763	NG2M300RK KCU25	C162
4109764	NG2M325LK KCU25	C163
4109765	NG2M325RK KCU25	C162
4109766	NG3047L KCU25	C170
4109767	NG3047LK KCU25	C163
4109768	NG3047R KCU25	C170
4109769	NG3047RK KCU25	C162
4109770	NG3062L KCU25	C170
4109771	NG3062LK KCU25	C163
4109772	NG3062R KCU25	C170
4109773	NG4125RK KCU25	C163
4109774	NG4189L KCU25	C171
4109775	NG4189LK KCU25	C164
4109776	NG4189R KCU25	C170
4109777	NG4189RK KCU25	C163
4109778	NG4213R KCU25	C170
4109779	NG4250L KCU25	C171
4109780	NG4250LK KCU25	C164
4109781	NG4250R KCU25	C170
4109782	NG4250RK KCU25	C163
4109783	NG3062RK KCU25	C162
4109784	NG3072LK KCU25	C163
4109785	NG3072RK KCU25	C162
4109786	NG3078LK KCU25	C163
4109787	NG3078RK KCU25	C162
4109788	NG3088L KCU25	C170
4109789	NG3088R KCU25	C170
4109790	NG3094L KCU25	C170
4109791	NG3094LK KCU25	C164
4109792	NG3094R KCU25	C170
4109793	NG4M300LK KCU25	C164
4109794	NG4M300RK KCU25	C163
4109795	NG4M350LK KCU25	C164
4109796	NG4M350RK KCU25	C163
4109797	NG4M400LK KCU25	C164
4109798	NG4M400RK KCU25	C163
4109799	NG4M450RK KCU25	C163
4109800	NG4M500LK KCU25	C164
4109801	NG4M500RK KCU25	C163
4109803	NG3094RK KCU25	C162
4109804	NG3097L KCU25	C171
4109805	NG3097R KCU25	C170
4109806	NG3105L KCU25	C171
4109807	NG3105R KCU25	C170
4109808	NG3110L KCU25	C171
4109809	NG3110R KCU25	C170
4109810	NG3122L KCU25	C171
4109811	NG3122R KCU25	C170
4109812	NG3125L KCU25	C171
4109814	NG4M600LK KCU25	C164
4109815	NG4M600RK KCU25	C163
4109823	NG3125LK KCU25	C164
4109824	NG3125R KCU25	C170
4109825	NG3125RK KCU25	C162
4109826	NG3142L KCU25	C171
4109827	NG3142R KCU25	C170
4109828	NG3156L KCU25	C171
4109829	NG3156LK KCU25	C164
4109830	NG3156R KCU25	C170
4109831	NG3156RK KCU25	C162
4109832	NG3178L KCU25	C171
4109833	NG3185R KCU25	C170
4109834	NG3189L KCU25	C171
4109835	NG3189LK KCU25	C164
4109836	NG3189R KCU25	C170
4109837	NG3189RK KCU25	C163
4109838	NGC2C130L055K KCU25	C168
4109839	NGC2C130R055K KCU25	C168
4109840	NGC2C185L125K KCU25	C168
4109841	NGC2C215L150K KCU25	C168
4109842	NGC2C215R150K KCU25	C168
4109844	NGD3062LK KCU25	C165
4109845	NGD3062RK KCU25	C165
4109846	NGD3094LK KCU25	C165

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4109847	NGD3094RK KCU25	C165
4109848	NGD3125LK KCU25	C165
4109849	NGD3125RK KCU25	C165
4109850	NGD3189LK KCU25	C165
4109851	NGD3189RK KCU25	C165
4109852	NGD4125LK KCU25	C165
4109853	NGD4125RK KCU25	C165
4109854	NGD4189LK KCU25	C165
4109855	NGD4189RK KCU25	C165
4109856	NGD4250LK KCU25	C165
4109857	NGD4250RK KCU25	C165
4109858	NJ3010R16 KCU25	D15
4109860	NJ3014R12 KCU25	D15
4109864	NJF3009R18 KCU25	D15
4109866	NJF3012R14 KCU25	D15
4109868	NJK3006R28 KCU25	D16
4109869	NJK3007R24 KCU25	D16
4109871	NJK3008R20 KCU25	D16
4109873	NJK3010R16 KCU25	D16
4109876	NJP3014R12 KCU25	D16
4109878	NJP3020R8 KCU25	D16
4109879	NP2002RK KCU25	C167
4109880	NP2012RK KCU25	C167
4109881	NP3002RK KCU25	C167
4109882	NP3012RK KCU25	C167
4109883	NPD2002RK KCU25	C167
4109884	NPD3002RK KCU25	C167
4109885	NPD3012RK KCU25	C167
4109887	NR2031L KCU25	C172
4109888	NR2031R KCU25	C172
4109889	NR2047L KCU25	C172
4109890	NR2047R KCU25	C172
4109891	NR2062L KCU25	C172
4109892	NR2062R KCU25	C172
4109903	NR2M050L KCU25	C172
4109904	NR2M050R KCU25	C172
4109905	NR3031L KCU25	C172
4109906	NR3031LK KCU25	C166
4109907	NR3031R KCU25	C172
4109908	NR3031RK KCU25	C166
4109909	NR3047L KCU25	C172
4109910	NR3047LK KCU25	C166
4109911	NR3047R KCU25	C172
4109912	NR3047RK KCU25	C166
4109913	NR3062L KCU25	C172
4109914	NR3062LK KCU25	C166
4109915	NR3062R KCU25	C172
4109916	NR3062RK KCU25	C166
4109917	NR3078LK KCU25	C166
4109918	NR3078RK KCU25	C166
4109919	NR3094L KCU25	C172
4109920	NR3094R KCU25	C172
4109921	NR4062LK KCU25	C166
4109922	NR4062RK KCU25	C166
4109923	NR4094LK KCU25	C166
4109924	NR4094RK KCU25	C166
4109925	NR4125L KCU25	C172
4109926	NR4125LK KCU25	C166
4109927	NR4125R KCU25	C172
4109928	NR4125RK KCU25	C166
4109929	NRD3031L KCU25	C173
4109930	NRD3031R KCU25	C173
4109931	NRD3062L KCU25	C173
4109932	NRD3062R KCU25	C173
4109933	NRD4062L KCU25	C173
4109934	NRD4062R KCU25	C173
4109935	NRD4094L KCU25	C173
4109936	NRD4125L KCU25	C173
4109937	NRD4125R KCU25	C173
4109938	NT2L KCU25	D17
4109939	NT2LK KCU25	D22
4109940	NT2R KCU25	D17
4109941	NT2RK KCU25	D22
4109942	NT3L KCU25	D17
4109943	NT3LCK KCU25	D19
4109944	NT3LK KCU25	D22
4109945	NT3R KCU25	D17
4109946	NT3RCK KCU25	D19
4109947	NT3RK KCU25	D22
4109948	NT4L KCU25	D17
4109949	NT4LCK KCU25	D19
4109950	NT4LK KCU25	D22
4109951	NT4R KCU25	D17
4109952	NT4RCK KCU25	D19
4109953	NT4RK KCU25	D22
4109954	NTF2L KCU25	D21
4109955	NTF2R KCU25	D21
4109956	NTF3L KCU25	D21
4109957	NTF3R KCU25	D21
4109958	NTK2L KCU25	D21
4109959	NTK2R KCU25	D21
4109960	NTK3L KCU25	D21
4109961	NTK3R KCU25	D21
4109962	NTP2L KCU25	D22
4109963	NTP2R KCU25	D22
4109964	NTP3L KCU25	D22
4109965	NTP3R KCU25	D22
4109967	NTP4R KCU25	D22
4111714	B221A03048HP KCPK15	G38
4111715	B221A03100HP KCPK15	G38
4111716	B221A03175HP KCPK15	G38
4111717	B221A03200HP KCPK15	G38
4111718	B221A03264HP KCPK15	G38
4111719	B221A03300HP KCPK15	G38
4111720	B221A03400HP KCPK15	G38
4111721	B221A03455HP KCPK15	G38
4111722	B221A03500HP KCPK15	G38
4111727	B221A09600HP KCPK15	G40
4111728	B221A09700HP KCPK15	G40
4111729	B221A09800HP KCPK15	G40
4111730	B221A09900HP KCPK15	G40
4111731	B221A09921HP KCPK15	G40
4111732	B221A10000HP KCPK15	G40
4111733	B221A03571HP KCPK15	G38
4111734	B221A03600HP KCPK15	G38
4111736	B221A03700HP KCPK15	G38
4111737	B221A03734HP KCPK15	G38
4111738	B221A03800HP KCPK15	G38
4111739	B221A03900HP KCPK15	G38
4111740	B221A03970HP KCPK15	G38
4111741	B221A04000HP KCPK15	G38
4111742	B221A04039HP KCPK15	G38
4111743	B221A04090HP KCPK15	G38
4111744	B221A04100HP KCPK15	G38
4111745	B221A04200HP KCPK15	G38
4111746	B221A04217HP KCPK15	G38
4111747	B221A04300HP KCPK15	G38
4111748	B221A04366HP KCPK15	G38
4111749	B221A04400HP KCPK15	G38
4111750	B221A04500HP KCPK15	G38
4111751	B221A04600HP KCPK15	G38
4111752	B221A04623HP KCPK15	G38
4111753	B221A04700HP KCPK15	G38
4111754	B221A04763HP KCPK15	G38
4111755	B221A04800HP KCPK15	G38
4111756	B221A04852HP KCPK15	G38
4111757	B221A04900HP KCPK15	G38
4111758	B221A05000HP KCPK15	G38
4111759	B221A05100HP KCPK15	G38
4111760	B221A05106HP KCPK15	G38
4111761	B221A05159HP KCPK15	G38
4111762	B221A05200HP KCPK15	G38
4111763	B221A05300HP KCPK15	G38
4111764	B221A05400HP KCPK15	G39
4111765	B221A05410HP KCPK15	G39
4111766	B221A05500HP KCPK15	G39
4111767	B221A05558HP KCPK15	G39
4111768	B221A05600HP KCPK15	G39
4111769	B221A05616HP KCPK15	G39
4111770	B221A05700HP KCPK15	G39
4111771	B221A05800HP KCPK15	G39
4111772	B221A05900HP KCPK15	G39
4111774	B221A06000HP KCPK15	G39
4111775	B221A06100HP KCPK15	G39
4111776	B221A06200HP KCPK15	G39
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4111793	B221A07300HP KCPK15	G39
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4111806	B221A08334HP KCPK15	G39
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4111839	B221A10600HP KCPK15	G40
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4111841	B221A10716HP KCPK15	G40
4111842	B221A10800HP KCPK15	G40
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4111846	B221A11113HP KCPK15	G40
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4111848	B221A11300HP KCPK15	G40
4111849	B221A11400HP KCPK15	G40
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4111854	B221A11800HP KCPK15	G40
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4111856	B221A11908HP KCPK15	G40
4111857	B221A12000HP KCPK15	G40
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4111897	B221A15600HP KCPK15	G41
4111898	B221A15700HP KCPK15	G41
4111899	B221A15800HP KCPK15	G41
4111900	B221A15875HP KCPK15	G41
4111901	B221A15900HP KCPK15	G41
4111902	B221A16000HP KCPK15	G41
4111903	B221A16500HP KCPK15	G41
4111904	B221A17000HP KCPK15	G41
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4111906	B221A17500HP KCPK15	G41
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4111908	B221A18000HP KCPK15	G41
4111909	B221A18500HP KCPK15	G41
4111910	B221A19000HP KCPK15	G41
4111911	B221A19050HP KCPK15	G41
4111912	B221A19500HP KCPK15	G41
4111913	B221A20000HP KCPK15	G41
4111914	B221A20500HP KCPK15	G41
4111915	B221A21000HP KCPK15	G41
4111920	B222A03048HP KCPK15	G38
4111921	B222A03000HP KCPK15	G38
4111922	B222A03175HP KCPK15	G38
4111933	B222A03264HP KCPK15	G38
4111934	B222A03300HP KCPK15	G38
4111935	B222A03455HP KCPK15	G38
4111936	B222A03500HP KCPK15	G38
4111937	B222A03571HP KCPK15	G38
4111938	B222A03700HP KCPK15	G38
4111939	B222A03800HP KCPK15	G38
4111940	B222A03970HP KCPK15	G38
4111941	B222A04000HP KCPK15	G38
4111942	B222A04200HP KCPK15	G38
4111943	B222A04366HP KCPK15	G38
4111944	B222A04500HP KCPK15	G38
4111945	B222A04600HP KCPK15	G38
4111946	B222A04763HP KCPK15	G38
4111947	B222A04800HP KCPK15	G38
4111948	B222A05000HP KCPK15	G38
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4111950	B222A05106HP KCPK15	G38
4111951	B222A05159HP KCPK15	G38
4111952	B222A05410HP KCPK15	G39
4111953	B222A05500HP KCPK15	G39
4111954	B222A05558HP KCPK15	G39
4111955	B222A05800HP KCPK15	G39
4111957	B222A05954HP KCPK15	G39
4111958	B222A06000HP KCPK15	G39
4111959	B222A06350HP KCPK15	G39
4111960	B222A06500HP KCPK15	G39
4111961	B222A06528HP KCPK15	G39
4111962	B222A06746HP KCPK15	G39
4111963	B222A06800HP KCPK15	G39
4111964	B222A07000HP KCPK15	G39
4111965	B222A07145HP KCPK15	G39
4111966	B222A07500HP KCPK15	G39
4111967	B222A07541HP KCPK15	G39
4111968	B222A07800HP KCPK15	G39
4111969	B222A07938HP KCPK15	G39
4111970	B222A08000HP KCPK15	G39
4111971	B222A08200HP KCPK15	G39
4111972	B222A08334HP KCPK15	G39
4111973	B222A08433HP KCPK15	G39
4111974	B222A08500HP KCPK15	G39

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4111975	B222A08733HP KCPK15	G39
4111976	B222A08800HP KCPK15	G39
4111977	B222A09000HP KCPK15	G39
4111978	B222A09129HP KCPK15	G40
4111979	B222A09300HP KCPK15	G40
4111982	B222A09500HP KCPK15	G40
4111983	B222A09525HP KCPK15	G40
4111984	B222A09800HP KCPK15	G40
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4112003	B222A14000HP KCPK15	G41
4112004	B222A14288HP KCPK15	G41
4112005	B222A14500HP KCPK15	G41
4112006	B222A15000HP KCPK15	G41
4112007	B222A15500HP KCPK15	G41
4112008	B222A15875HP KCPK15	G41
4112009	B222A16000HP KCPK15	G41
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4112014	B222A18000HP KCPK15	G41
4112015	B222A18500HP KCPK15	G41
4112016	B222A19000HP KCPK15	G41
4112017	B222A19050HP KCPK15	G41
4112018	B222A20000HP KCPK15	G41
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4112417	B224A04700HP KCPK15	G44
4112418	B224A05106HP KCPK15	G45
4112419	B224A05600HP KCPK15	G45
4112420	B224A05791HP KCPK15	G45
4112421	B224A05944HP KCPK15	G45
4112422	B224A06528HP KCPK15	G45
4112443	B224A06700HP KCPK15	G45
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4112446	B224A07400HP KCPK15	G45
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4112448	B224A09093HP KCPK15	G46
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4112458	B225A05944HP KCPK15	G45
4112459	B225A06909HP KCPK15	G45
4112460	B225A07366HP KCPK15	G45
4112461	B225A08839HP KCPK15	G46
4112462	B225A09093HP KCPK15	G46
4112463	B225A12304HP KCPK15	G47
4112464	B225A13495HP KCPK15	G47
4112465	B225A03048HP KCPK15	G44
4112466	B225A03000HP KCPK15	G44
4112467	B225A03100HP KCPK15	G44
4112468	B225A03175HP KCPK15	G44
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4112556	B225A17000HP KCPK15	G48
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4112617	B225A06000HP KCPK15	G45
4112618	B225A06100HP KCPK15	G45
4112619	B225A06200HP KCPK15	G45
4112620	B225A06300HP KCPK15	G45
4112621	B225A06350HP KCPK15	G45
4112622	B225A06400HP KCPK15	G45
4112623	B225A06500HP KCPK15	G45
4112624	B225A06528HP KCPK15	G45
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4112639	B225A07700HP KCPK15	G45
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4112646	B225A08300HP KCPK15	G46
4112647	B225A08334HP KCPK15	G46
4112648	B225A08400HP KCPK15	G46
4112649	B225A08433HP KCPK15	G46
4112650	B225A08500HP KCPK15	G46
4112651	B225A08600HP KCPK15	G46
4112652	B225A08700HP KCPK15	G46
4112653	B225A08733HP KCPK15	G46
4112654	B225A08800HP KCPK15	G46
4112655	B225A08900HP KCPK15	G46
4112656	B225A09000HP KCPK15	G46
4112657	B225A09100HP KCPK15	G46
4112658	B225A09129HP KCPK15	G46
4112659	B225A09200HP KCPK15	G46
4112660	B225A09300HP KCPK15	G46
4112661	B225A09347HP KCPK15	G46
4112662	B225A09400HP KCPK15	G46
4112663	B225A09500HP KCPK15	G46
4112664	B225A09525HP KCPK15	G46
4112665	B225A09600HP KCPK15	G46
4112666	B225A09700HP KCPK15	G46
4112667	B225A09800HP KCPK15	G46
4112668	B225A09900HP KCPK15	G46
4112669	B225A09921HP KCPK15	G46
4112670	B225A10000HP KCPK15	G46
4112672	B224A03048HP KCPK15	G44
4112673	B224A03000HP KCPK15	G44
4112674	B224A03100HP KCPK15	G44
4112675	B224A03175HP KCPK15	G44
4112676	B224A03200HP KCPK15	G44
4112677	B224A03264HP KCPK15	G44
4112678	B224A03300HP KCPK15	G44
4112679	B224A03400HP KCPK15	G44
4112680	B224A03455HP KCPK15	G44
4112681	B224A03500HP KCPK15	G44
4112683	B224A03600HP KCPK15	G44
4112684	B224A03658HP KCPK15	G44
4112685	B224A03700HP KCPK15	G44
4112686	B224A03734HP KCPK15	G44
4112687	B224A03800HP KCPK15	G44
4112688	B224A03900HP KCPK15	G44
4112689	B224A03970HP KCPK15	G44
4112690	B224A04000HP KCPK15	G44
4112691	B224A04039HP KCPK15	G44
4112692	B224A04090HP KCPK15	G44
4112693	B224A04200HP KCPK15	G44
4112694	B224A04217HP KCPK15	G44
4112695	B224A04366HP KCPK15	G44
4112696	B224A04623HP KCPK15	G44
4112697	B224A04763HP KCPK15	G44
4112698	B224A04852HP KCPK15	G44
4112699	B224A05000HP KCPK15	G45
4112700	B224A05100HP KCPK15	G45
4112701	B224A05159HP KCPK15	G45
4112702	B224A05410HP KCPK15	G45
4112703	B224A05500HP KCPK15	G45
4112704	B224A05558HP KCPK15	G45
4112705	B224A05616HP KCPK15	G45
4112706	B224A05954HP KCPK15	G45
4112707	B224A06000HP KCPK15	G45
4112708	B224A06350HP KCPK15	G45
4112709	B224A06500HP KCPK15	G45
4112710	B224A06630HP KCPK15	G45
4112711	B224A06746HP KCPK15	G45
4112712	B224A06800HP KCPK15	G45
4112713	B224A07000HP KCPK15	G45
4112714	B224A07145HP KCPK15	G45
4112715	B224A07500HP KCPK15	G45
4112716	B224A07541HP KCPK15	G45
4112717	B224A07938HP KCPK15	G45
4112718	B224A08000HP KCPK15	G45
4112719	B224A08200HP KCPK15	G45
4112720	B224A08334HP KCPK15	G46
4112721	B224A08433HP KCPK15	G46
4112722	B224A08500HP KCPK15	G46
4112723	B224A08700HP KCPK15	G46
4112724	B224A08733HP KCPK15	G46
4112725	B224A08800HP KCPK15	G46
4112726	B224A09000HP KCPK15	G46
4112727	B224A09129HP KCPK15	G46
4112728	B224A09500HP KCPK15	G46
4112729	B224A09525HP KCPK15	G46
4112730	B224A09921HP KCPK15	G46
4112731	B224A10000HP KCPK15	G46
4112732	B224A10200HP KCPK15	G46
4112733	B224A10300HP KCPK15	G46
4112734	B224A10320HP KCPK15	G46
4112735	B224A10400HP KCPK15	G46
4112736	B224A10500HP KCPK15	G46
4112737	B224A10716HP KCPK15	G46
4112738	B224A10800HP KCPK15	G46
4112739	B224A11000HP KCPK15	G46
4112740	B224A11113HP KCPK15	G46
4112741	B224A11500HP KCPK15	G46
4112742	B224A11509HP KCPK15	G46
4112743	B224A11908HP KCPK15	G46

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4112744	B224A12000HP KCPK15	G46
4112745	B224A12300HP KCPK15	G47
4112746	B224A12304HP KCPK15	G47
4112747	B224A12500HP KCPK15	G47
4112748	B224A12700HP KCPK15	G47
4112749	B224A13000HP KCPK15	G47
4112750	B224A13096HP KCPK15	G47
4112751	B224A13500HP KCPK15	G47
4112752	B224A13891HP KCPK15	G47
4112753	B224A14000HP KCPK15	G47
4112754	B224A14288HP KCPK15	G47
4112755	B224A14684HP KCPK15	G47
4112756	B224A15083HP KCPK15	G47
4112758	B224A15500HP KCPK15	G47
4112759	B224A15600HP KCPK15	G47
4112760	B224A15875HP KCPK15	G47
4112761	B224A16000HP KCPK15	G47
4112762	B224A16500HP KCPK15	G47
4112763	B224A17000HP KCPK15	G48
4112764	B224A17463HP KCPK15	G48
4112765	B224A17500HP KCPK15	G48
4112766	B224A18000HP KCPK15	G48
4112767	B224A19000HP KCPK15	G48
4112768	B224A19050HP KCPK15	G48
4112769	B224A20000HP KCPK15	G48
4113708	A4C0155N00CF01 KCU25	C112
4113709	A4C0155R10CF01 KCU25	C113
4113710	A4C0205L06CF02 KCU25	C113
4113711	A4C0205N00CF02 KCU25	C112
4113712	A4C0205R06CF02 KCU25	C113
4114283	A4C0205R10CF02 KCU25	C113
4114284	A4C0255N00CF02 KCU25	C112
4114285	A4C0305L06CF02 KCU25	C113
4114286	A4C0305L10CF02 KCU25	C113
4114287	A4C0305N00CF02 KCU25	C112
4114288	A4C0305R06CF02 KCU25	C113
4114289	A4C0305R10CF02 KCU25	C113
4114290	A4C0405L06CF02 KCU25	C113
4114291	A4C0405L10CF02 KCU25	C113
4114292	A4C0405N00CF02 KCU25	C112
4114293	A4C0405R06CF02 KCU25	C113
4114294	A4C0405R10CF02 KCU25	C113
4114295	A4G0200M02P02GMP KCU25	C105
4114296	A4G0205M02U02GMN KCU25	C106
4114297	A4G0205M02U02GMP KCU25	C105
4114298	A4G0255M2BU02GMP KCU25	C105
4114299	A4G0300M03P02GMP KCU25	C105
4114300	A4G0300M03P04GMP KCU25	C105
4114301	A4G0305M03U02B KCU25	C108
4114302	A4G0305M03U02GMN KCU25	C106
4114303	A4G0305M03U02GMP KCU25	C105
4114304	A4G0305M03U04GMN KCU25	C106
4114305	A4G0305M03U04GMP KCU25	C105
4114306	A4G0400M04P02GMP KCU25	C105
4114307	A4G0400M04P04GMP KCU25	C105
4114308	A4G0400M04P08GMP KCU25	C105
4114309	A4G0405M04U04GMN KCU25	C106
4114310	A4G0405M04U04GMP KCU25	C105
4114311	A4G0405M04U08GMN KCU25	C106
4114312	A4G0405M04U08GMP KCU25	C105
4114313	A4G0500M05P04GMP KCU25	C105
4114315	A4G0505M05U04B KCU25	C108
4114316	A4G0505M05U04GMN KCU25	C106
4114317	A4G0505M05U04GMP KCU25	C105
4114318	A4G0505M05U08GMN KCU25	C106
4114319	A4G0505M05U08GMP KCU25	C105
4114320	A4G0600M06P04GMP KCU25	C105
4114321	A4G0600M06P08GMP KCU25	C105
4114322	A4G0605M06U04B KCU25	C108
4114323	A4G0605M06U04GMN KCU25	C106
4114325	A4G0605M06U08GMN KCU25	C106
4114328	A4G0800M08P08GMP KCU25	C105
4114329	A4G0805M08U08GMN KCU25	C106
4114330	A4G0805M08U08GMP KCU25	C105
4114331	A4G0805M08U12GMN KCU25	C106
4114333	A4G1005M10U08GMN KCU25	C106
4114334	A4G1005M10U08GMP KCU25	C105
4114335	A4G125I03P05GMN KCU25	C107
4114336	A4G125I03P1GMN KCU25	C107
4114337	A4G187I04P1GMN KCU25	C107
4114338	A4G187I04P2GMN KCU25	C107
4114339	A4G250I06P1GMN KCU25	C107
4114340	A4G250I06P2GMN KCU25	C107
4114341	A4G312I08P1GMN KCU25	C107
4114343	A4R0200M02P00GMP KCU25	C106
4114344	A4R0205M02U00GMN KCU25	C107
4114345	A4R0300M03P00GMP KCU25	C106
4114346	A4R0305M03U00GMN KCU25	C107
4114347	A4R0400M04P00GMP KCU25	C106
4114348	A4R0405M04U00GMN KCU25	C107
4114349	A4R0500M05P00GMP KCU25	C106
4114350	A4R0505M05U00GMN KCU25	C107
4114351	A4R0600M06P00GMP KCU25	C106
4114352	A4R0605M06U00GMN KCU25	C107
4114353	A4R0800M08P00GMP KCU25	C106
4114354	A4R0805M08U00GMN KCU25	C107
4114355	A4R1005M10U00GMN KCU25	C107
4114356	A4R125I03P00GMN KCU25	C107
4114357	A4R187I04P00GMN KCU25	C107
4114358	A4R250I06P00GMN KCU25	C107
4114696	B967A09800 KC7315	G131
4114713	B967A11800 KC7315	G132
4115401	DFR040304ST KD1425	J98
4115433	DFT05T308ST KD1425	J98
4115434	DFT06T308ST KD1425	J98
4115435	DFT070408ST KD1425	J98
4115436	DFT090508ST KD1425	J98
4115437	DFT110508ST KD1425	J98
4116607	T630M030X050R6HX-A KM6515	M49
4116608	T630M040X070R6HX-A KM6515	M49
4116609	T630M050X080R6HX-A KM6515	M49
4116610	T630M060X100R6HX-A KM6515	M49
4116611	T630M080X125R6HX-A KM6515	M49
4116612	T630M100X150R6HX-A KM6515	M49
4116636	T620M030X050R6HX-A KP6525	M10
4116637	T620M040X070R6HX-A KP6525	M10
4116638	T620M050X080R6HX-A KP6525	M10
4116639	T620M060X100R6HX-A KP6525	M10
4116640	T620M080X100R6HX-A KP6525	M10
4116641	T620M080X125R6HX-A KP6525	M10
4116642	T620M100X150R6HX-A KP6525	M10
4116643	T620M120X175R6HX-A KP6525	M10
4116645	T620NC#02-56R2BX-A KM6515	M6
4116646	T620NC#02-56R3BX-A KM6515	M6
4116647	T620NC#04-40R2BX-A KM6515	M6
4116648	T620NC#04-40R3BX-A KM6515	M6
4116649	T620NC#05-40R3BX-A KM6515	M6
4116650	T620NC#06-32R2BX-A KM6515	M6
4116651	T620NC#06-32R3BX-A KM6515	M6
4116652	T620NC#08-32R2BX-A KM6515	M6
4116673	T620NC#08-32R3BX-A KM6515	M6
4116674	T620NC#10-24R3BX-A KM6515	M6
4116675	T620NC#12-24R3BX-A KM6515	M6
4116676	T620NC02500-20R2BX-A KM6515	M6
4116677	T620NC02500-20R3BX-A KM6515	M6
4116678	T620NC03125-18R2BX-A KM6515	M6
4116679	T620NC03125-18R3BX-A KM6515	M6
4116680	T620NC03750-16R2BX-A KM6515	M6
4116681	T620NC03750-16R3BX-A KM6515	M6
4116682	T620NC04375-14R3BX-A KM6515	M7
4116683	T620NC05000-13R3BX-A KM6515	M7
4116684	T620NC06250-11R3BX-A KM6515	M7
4116685	T620NC07500-10R3BX-A KM6515	M7
4116686	T620NF#08-36R3BX-A KM6515	M6
4116687	T620NF#10-32R2BX-A KM6515	M6
4116688	T620NF#10-32R3BX-A KM6515	M6
4116689	T620NF02500-28R2BX-A KM6515	M6
4116690	T620NF02500-28R3BX-A KM6515	M6
4116691	T620NF03125-24R3BX-A KM6515	M6
4116692	T620NF03750-24R3BX-A KM6515	M6
4116693	T620NF04375-20R3BX-A KM6515	M7
4116694	T620NF05000-20R3BX-A KM6515	M7
4116698	T620M030X050R6HX-A KM6515	M10
4116699	T620M040X070R6HX-A KM6515	M10
4116700	T620M050X080R6HX-A KM6515	M10
4116701	T620M060X100R6HX-A KM6515	M10
4116702	T620MF080X100R6HX-A KM6515	M10
4116733	T620M080X125R6HX-A KM6515	M10
4116734	T620M100X150R6HX-A KM6515	M10
4116735	T620M120X175R6HX-A KM6515	M10
4116742	T630NC#02-56R3BX-A KM6515	M46
4116763	T630NC#04-40R2BX-A KM6515	M46
4116764	T630NC#04-40R3BX-A KM6515	M46
4116765	T630NC#06-32R2BX-A KM6515	M46
4116766	T630NC#06-32R3BX-A KM6515	M46
4116767	T630NC#08-32R3BX-A KM6515	M46
4116768	T630NC#10-24R3BX-A KM6515	M46
4116769	T630NC02500-20R2BX-A KM6515	M46
4116770	T630NC02500-20R3BX-A KM6515	M46
4116771	T630NC03125-18R2BX-A KM6515	M46
4116772	T630NC03125-18R3BX-A KM6515	M46
4116773	T630NC03750-16R2BX-A KM6515	M46
4116774	T630NC03750-16R3BX-A KM6515	M46
4116775	T630NC04375-14R3BX-A KM6515	M46
4116776	T630NC05000-13R2BX-A KM6515	M46
4116777	T630NC05000-13R3BX-A KM6515	M46
4116778	T630NC06250-11R2BX-A KM6515	M46
4116779	T630NC06250-11R3BX-A KM6515	M46
4116780	T630NC07500-10R2BX-A KM6515	M46
4116781	T630NC07500-10R3BX-A KM6515	M46
4116782	T630NC10000-08R3BX-A KM6515	M46
4116783	T630NF#10-32R2BX-A KM6515	M46
4116784	T630NF#10-32R3BX-A KM6515	M46
4116785	T630NF02500-28R2BX-A KM6515	M46
4116786	T630NF02500-28R3BX-A KM6515	M46
4116787	T630NF03125-24R2BX-A KM6515	M46
4116788	T630NF03125-24R3BX-A KM6515	M46
4116789	T630NF03750-24R3BX-A KM6515	M46
4116790	T630NF04375-20R3BX-A KM6515	M46
4116791	T630NF05000-20R3BX-A KM6515	M46
4116819	T630M030X050R6HX-A KP6525	M49
4116820	T630M040X070R6HX-A KP6525	M49
4116821	T630M050X080R6HX-A KP6525	M49
4116822	T630M060X100R6HX-A KP6525	M49
4116823	T630M120X175R6HX-A KM6515	M49
4116824	T630M140X200R6HX-A KM6515	M49
4116825	T630M160X200R6HX-A KM6515	M49
4116834	T630NC#02-56R3BX-A KP6525	M46
4116835	T630NC#04-40R2BX-A KP6525	M46
4116836	T630NC#04-40R3BX-A KP6525	M46
4116837	T630NC#06-32R2BX-A KP6525	M46
4116838	T630NC#06-32R3BX-A KP6525	M46
4116839	T630NC#08-32R3BX-A KP6525	M46
4116840	T630NC#10-24R3BX-A KP6525	M46
4116841	T630NC02500-20R2BX-A KP6525	M46
4116842	T630NC02500-20R3BX-A KP6525	M46
4116843	T630M080X125R6HX-A KP6525	M49
4116844	T630M100X150R6HX-A KP6525	M49
4116845	T630M120X175R6HX-A KP6525	M49
4116846	T630M140X200R6HX-A KP6525	M49
4116847	T630M160X200R6HX-A KP6525	M49
4116853	T630NC03125-18R2BX-A KP6525	M46
4116854	T630NC03125-18R3BX-A KP6525	M46
4116855	T630NC03750-16R2BX-A KP6525	M46
4116856	T630NC03750-16R3BX-A KP6525	M46
4116857	T630NC04375-14R3BX-A KP6525	M46
4116858	T630NC05000-13R2BX-A KP6525	M46
4116859	T630NC05000-13R3BX-A KP6525	M46
4116860	T630NC06250-11R2BX-A KP6525	M46
4116861	T630NC06250-11R3BX-A KP6525	M46
4116862	T630NC07500-10R2BX-A KP6525	M46
4116863	T630NC07500-10R3BX-A KP6525	M46
4116864	T630NC10000-08R3BX-A KP6525	M46
4116865	T630NF#10-32R2BX-A KP6525	M46
4116866	T630NF#10-32R3BX-A KP6525	M46
4116867	T630NF02500-28R2BX-A KP6525	M46
4116868	T630NF02500-28R3BX-A KP6525	M46
4116869	T630NF03125-24R2BX-A KP6525	M46
4116870	T630NF03125-24R3BX-A KP6525	M46
4116871	T630NF03750-24R3BX-A KP6525	M46
4116872	T630NF04375-20R3BX-A KP6525	M46
4116873	T630NF05000-20R3BX-A KP6525	M46
4117139	T620NC#02-56R2BX-A KP6525	M6
4117140	T620NC#02-56R3BX-A KP6525	M6
4117141	T620NC#04-40R2BX-A KP6525	M6
4117142	T620NC#04-40R3BX-A KP6525	M6
4117163	T620NC#05-40R3BX-A KP6525	M6
4117164	T620NC#06-32R2BX-A KP6525	M6
4117165	T620NC#06-32R3BX-A KP6525	M6
4117166	T620NC#08-32R2BX-A KP6525	M6
4117167	T620NC#08-32R3BX-A KP6525	M6
4117168	T620NC#10-24R3BX-A KP6525	M6
4117169	T620NC#12-24R3BX-A KP6525	M6
4117170	T620NC02500-20R2BX-A KP6525	M6
4117171	T620NC02500-20R3BX-A KP6525	M6
4117172	T620NC03125-18R2BX-A KP6525	M6
4117173	T620NC03125-18R3BX-A KP6525	M6
4117174	T620NC03750-16R2BX-A KP6525	M6
4117175	T620NC03750-16R3BX-A KP6525	M6
4117176	T620NC04375-14R3BX-A KP6525	M7
4117177	T620NC05000-13R3BX-A KP6525	M7
4117178	T620NC06250-11R3BX-A KP6525	M7
4117179	T620NC07500-10R3BX-A KP6525	M7
4117180	T620NF#08-36R3BX-A KP6525	M6
4117181	T620NF#10-32R2BX-A KP6525	M6
4117182	T620NF#10-32R3BX-A KP6525	M6
4117183	T620NF02500-28R2BX-A KP6525	M6
4117184	T620NF02500-28R3BX-A KP6525	M6
4117185	T620NF03125-24R3BX-A KP6525	M6
4117186	T620NF03750-24R3BX-A KP6525	M6
4117187	T620NF04375-20R3BX-A KP6525	M7
4117188	T620NF05000-20R3BX-A KP6525	M7
4118347	VPGR331 KCP25	E38
4119190	HNGJ43ANENLD KCPK30	S6, S12, S15
4119224	HNGJ43ANENLD KC725M	S6, S12, S15
4119227	HNGJ43ANENLD KCK15	S6, S12, S15
4119228	HNPJ43ANSNHD KCPK30	S7, S13, S16
4119229	HNPJ43ANSNHD KC725M	S7, S13, S16
4119230	HNPJ43ANSNHD KCK15	S7, S13, S16
4119253	XNGJ43ANENLD3W KC725M	S12
4119639	HNGJ438ANENLD KCPK30	S6, S12, S15
4119640	HNGJ438ANENLD KC725M	S6, S12, S15
4119696	HNPJ43ANSNGD KC520M	S7, S13, S16
4119697	HNPJ43ANSNGD KC522M	S7, S13, S16
4119699	HNPJ43ANSNGD KCK15	S7, S13, S16
4119700	HNPJ43ANSNGD KCPK30	S7, S13, S16
4119701	HNPJ43ANSNGD KC725M	S7, S13, S16
4119702	HNPJ43ANSNHD KC520M	S7, S13, S16
4119703	HNPJ43ANSNHD KC522M	S7, S13, S16
4119989	HNPJ438ANSNHD KC522M	S7, S13, S16
4119991	HNPJ438ANSNHD KCK15	S7, S13, S16
4119992	HNPJ438ANSNHD KCPK30	S7, S13, S16
4120003	HNPJ438ANSNHD KC725M	S7, S13, S16
4120661	A4G0305M03U04GMN KCP25	C106
4121491	B051A14000CPG KC7325	G17
4121505	B052A03300CPG KC7325	G15
4121528	B051A03200CPG KC7325	G15
4121529	B051A04000CPG KC7325	G15
4121532	B051A05900CPG KC7325	G15
4121534	B051A06000CPG KC7325	G16
4121574	HNGJ43ANFNLDJ K313	S6, S11, S15
4121575	HNGJ43ANFNLDJ KC410M	S6, S11, S15
4121576	HNGJ43ANENLD KC510M	S6, S12, S15
4121577	HNGJ43ANENLD KC520M	S6, S12, S15
4121578	HNGJ43ANENLD KC522M	S6, S12, S15
4121604	XNGJ43ANFNLDJ3W KC410M	S11
4121605	XNGJ43ANENLD3W KC510M	S12
4121607	XNGJ43ANENLD3W KC522M	S12
4121683	SNMG432MS KCU25	B103
4121684	SNMG432RP KCU25	B105
4121685	SNMG433MS KCU25	B103
4121686	SNMG542MS KCU25	B103
4121687	SNMG543MS KCU25	B103
4121688	SNMG544RP KCU25	B105

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4121689	SNMG643MS KCU25	B103
4121690	SNMG644RP KCU25	B105
4121695	TNMG3305MS KCU25	B125
4121696	TNMG331MS KCU25	B125
4121697	TNMG332MS KCU25	B125
4121698	TNMG332RP KCU25	B127
4121699	TNMG333RP KCU25	B127
4121700	TNMG431MS KCU25	B125
4121701	TNMG432MS KCU25	B125
4121702	TNMG432RP KCU25	B127
4121703	TNMG433MS KCU25	B125
4121704	TNMG433RP KCU25	B127
4121705	TNMG434RP KCU25	B127
4121706	TNMG542MS KCU25	B125
4121707	TNMG543RP KCU25	B127
4121708	VNGG3305FS KCU25	B144
4121710	VNGG331FS KCU25	B144
4121711	VNGG332FS KCU25	B144
4121712	VNMG3305MS KCU25	B147
4121713	VNMG330MS KCU25	B147
4121714	VNMG331MS KCU25	B147
4121715	VNMG332MS KCU25	B147
4121716	VNMG332RP KCU25	B148
4121717	VNMG333RP KCU25	B148
4121718	VNMG431MS KCU25	B147
4121719	VNMG432MS KCU25	B147
4121720	WNMG332MS KCU25	B160
4121721	WNMG332RP KCU25	B161
4121722	WNMG4305MS KCU25	B160
4121723	WNMG431MS KCU25	B160
4121724	WNMG432MS KCU25	B160
4121725	WNMG432RP KCU25	B161
4121726	WNMG433RP KCU25	B161
4121727	WNMG434RP KCU25	B161
4124962	B051A02000CPG KC7325	G14
4125849	A4G0505M05U04GMN KCP10	C106
4129398	RCGV45E KYS25	B351
4129399	RCGV45T0420 KYS25	B351
4129400	RPGV35E KYS25	B352
4129402	RPGV45E KYS25	B352
4129443	KTIP080R1SS10M	H38
4129444	KTIP085R1SS10M	H38
4129445	KTIP090R1SS10M	H38
4129446	KTIP095R1SS10M	H38
4129447	KTIP100R1SS12M	H38
4129448	KTIP105R1SS12M	H38
4129449	KTIP110R1SS12M	H38
4129450	KTIP115R1SS12M	H38
4129451	KTIP120R1SS14M	H38
4129452	KTIP125R1SS14M	H38
4129453	KTIP130R1SS14M	H38
4129454	KTIP135R1SS14M	H38
4129455	KTIP140R1SS16M	H38
4129456	KTIP145R1SS16M	H38
4129457	KTIP150R1SS16M	H38
4129458	KTIP160R1SS18M	H38
4129459	KTIP170R1SS18M	H38
4129460	KTIP180R1SS20M	H38
4129461	KTIP190R1SS20M	H38
4129462	KTIP200R1SS25M	H38
4129463	KTIP210R1SS25M	H38
4129464	KTIP220R1SS25M	H38
4129465	KTIP230R1SS25M	H38
4129466	KTIP240R1SS25M	H38
4129467	KTIP250R1SS32M	H38
4129468	KTIP260R1SS32M	H38
4129469	KTIP270R1SS32M	H38
4129470	KTIP080R1SCF12M	H40
4129471	KTIP085R1SCF12M	H40
4129472	KTIP090R1SCF12M	H40
4129483	KTIP095R1SCF12M	H40
4129484	KTIP100R1SCF16M	H40
4129485	KTIP105R1SCF16M	H40
4129486	KTIP110R1SCF16M	H40
4129487	KTIP115R1SCF16M	H40
4129488	KTIP120R1SCF16M	H40
4129489	KTIP125R1SCF16M	H40
4129490	KTIP130R1SCF16M	H40
4129491	KTIP135R1SCF16M	H40
4129492	KTIP140R1SCF16M	H40
4129493	KTIP145R1SCF16M	H40
4129494	KTIP150R1SCF20M	H40
4129495	KTIP160R1SCF20M	H40
4129496	KTIP170R1SCF20M	H40
4129497	KTIP180R1SCF25M	H40
4129498	KTIP190R1SCF25M	H40
4129499	KTIP200R1SCF25M	H40
4129500	KTIP210R1SCF25M	H40
4129501	KTIP220R1SCF25M	H40
4129502	KTIP230R1SCF25M	H40
4129503	KTIP240R1SCF25M	H40
4129504	KTIP250R1SCF25M	H40
4129505	KTIP260R1SCF25M	H40
4129506	KTIP270R1SCF25M	H40
4129542	CNG434T0420 KYS25	B350
4129546	SNG434T0420 KYS25	B353
4129549	SNG644E KYS25	B353
4129552	TNG433T0420 KYS25	B354
4129553	TNG434T0420 KYS25	B354
4129554	CNGA432E KYS25	B350
4129555	CNGA432T0420 KYS25	B350
4129557	CNGA433T0420 KYS25	B350
4129562	SNGA433T0420 KYS25	B353
4129563	RCGV23E KYS25	B351
4129567	CNG453T0420 KYS25	B350
4129568	CNGX452T0420 KYS25	B350
4129569	CNGX453T0420 KYS25	B350
4129570	DNGX452T0420 KYS25	B351
4129571	DNGX453T0420 KYS25	B351
4129576	RNG45T0425 KYS25	B352
4129577	RCGV45T0425 KYS25	B351
4129769	KHSST28002	M157
4129916	KHSST28003	M128–129
4129917	KHSST28004	M126
4129921	KHSST28008	M129
4129922	KHSST28009	M126
4129952	KHSST28791	M133
4129962	KHSST28787	M102
4129964	KHSST28786	M104
4129966	KHSST28785	M102
4129968	KHSST28784	M38
4129979	KHSST28015	M129
4129982	KHSST28016	M126
4129984	KHSST28781	M133
4129985	KHSST28780	M104
4129986	KHSST28779	M102
4129989	KHSST28776	M38
4129991	KHSST28774	M102
4129998	KHSST28020	M129
4130013	KHSST28021	M126
4130020	KHSST28028	M129
4130021	KHSST28029	M126
4130035	KHSST28032	M129
4130036	KHSST28033	M126
4130058	KHSST28762	M102
4130059	KHSST28761	M102
4130063	KHSST28040	M126
4130066	KHSST28043	M126
4130070	KHSST28047	M102
4130071	KHSST28048	M104
4130072	KHSST28049	M102
4130083	KHSST28757	M36
4130105	KHSST28752	M133
4130368	KHSST28751	M134
4130372	KHSST28747	M102
4130392	RCGV35E KYS25	B351
4130393	KHSST28746	M104
4130394	KHSST28745	M102
4130397	KHSST28744	M38
4130400	KHSST28743	M40
4130403	KHSST28742	M133
4130408	KHSST28740	M102
4130409	KHSST28739	M104
4130411	KHSST28738	M102
4130413	KHSST28737	M38
4130419	KHSST28733	M36
4130421	KHSST28732	M36
4130422	KHSST28731	M36
4130423	RCGV35T0420 KYS25	B351
4130426	KSHR150HN4345M3	S10
4130427	KSHR150HN4345F2	S10
4130428	KSHR200HN4345C3	S10
4130429	KSHR200HN4345M3	S10
4130430	KSHR200HN4345F3	S10
4130431	KSHR250HN4345C3	S10
4130432	KSHR250HN4345M3	S10
4130433	KHSST28730	M40
4130448	KHSST28726	M103
4130493	KSHR250HN4345F3	S10
4130494	KSHR300HN4345C4	S10
4130495	KSHR300HN4345M4	S10
4130496	KSHR300HN4345F4	S10
4130497	KSHR400HN4345C6	S10
4130498	KSHR400HN4345M6	S10
4130499	KSHR400HN4345F6	S10
4130500	KSHR500HN4345C6	S10
4130501	KSHR500HN4345M6	S10
4130502	KSHR500HN4345F6	S10
4130506	KHSST28723	M103
4130509	KHSST28721	M103
4130514	KSHR100D02W075HN06	S8
4130515	KSHR100D03W075HN06	S8
4130516	KSHR125D03W100HN06	S8
4130517	KSHR125D04W100HN06	S8
4130518	KSHR100D02C075HN06L480	S9
4130519	KSHR100D03C075HN06L480	S9
4130520	KSHR125D03C100HN06L520	S9
4130521	KSHR125D04C100HN06L520	S9
4130529	KHSST28053	M132
4130533	KSHR100D03C100HN06L800	S9
4130547	KHSST28716	M103
4130555	KHSST28709	M103
4130557	KHSST28707	M103
4130573	KHSST28700	M103
4130575	KHSST28698	M130
4130578	KHSST28695	M130
4130581	KHSST28692	M103
4130583	KHSST28057	M158
4130584	KHSST28058	M158
4130588	KHSST28060	M157
4130590	KHSST28062	M102
4130592	KHSST28064	M132
4130595	KHSST28067	M158
4130596	KHSST28068	M158
4130600	KHSST28072	M38
4130601	KHSST28073	M104
4130602	KHSST28074	M102
4130610	KHSST28683	M103
4130611	KHSST28682	M130
4130612	KHSST28681	M41
4130615	KHSST28077	M134
4130616	KHSST28078	M133
4130619	KHSST28080	M38
4130620	KHSST28081	M102
4130621	KHSST28082	M104
4130622	KHSST28083	M102
4130634	KHSST28085	M133
4130635	KHSST28086	M132
4130640	KHSST28091	M158
4130641	KHSST28092	M158
4130642	KHSST28093	M158
4130653	KHSST28094	M158
4130662	KHSST28102	M128
4130664	KHSST28104	M158
4130666	KHSST28106	M157
4130667	KHSST28107	M157
4130669	KHSST28109	M157
4130671	KHSST28111	M36
4130672	KHSST28112	M36
4130683	KHSST28113	M36
4130684	KHSST28114	M129
4130685	KHSST28115	M126
4130686	KHSST28116	M125
4130688	KHSST28117	M128
4130689	KHSST28118	M126
4130690	KHSST28119	M128
4130691	KHSST28120	M125
4130692	KHSST28121	M125
4130703	KHSST28122	M128
4130705	KHSST28123	M125
4130706	KHSST28124	M129
4130707	KHSST28125	M126
4130710	KHSST28127	M125
4130711	KHSST28128	M127
4130712	KHSST28129	M124
4130713	KHSST28130	M127
4130714	KHSST28131	M127
4130715	KHSST28132	M124
4130716	KHSST28133	M127
4130719	KHSST28134	M124
4130720	KHSST28135	M127
4130721	KHSST28136	M124
4130722	KHSST28137	M102
4130755	KHSST28139	M157
4130756	KHSST28140	M157
4130757	KHSST28141	M157
4130758	KHSST28142	M157
4130778	KHSST28152	M41
4130788	KHSST28162	M39
4130789	KHSST28163	M104
4130791	KHSST28165	M102
4130803	KHSST28167	M132
4130808	KHSST28172	M158
4130809	KHSST28173	M158
4130813	KHSST28177	M157
4130814	KHSST28178	M157
4130817	KHSST28181	M157
4131016	KHSST28184	M132
4131019	KHSST28187	M102
4131020	KHSST28188	M104
4131043	KHSST28189	M102
4131047	KHSST28192	M38
4131050	KHSST28194	M134
4131052	KHSST28195	M133
4131054	KHSST28196	M158
4131056	KHSST28197	M158
4131061	KHSST28201	M102
4131065	KHSST28204	M38
4131068	KHSST28207	M132
4131070	KHSST28209	M38
4131071	KHSST28210	M102
4131072	KHSST28211	M102
4131073	KHSST28212	M104
4131075	KHSST28213	M102
4131079	KHSST28217	M134
4131080	KHSST28218	M133
4131081	KHSST28219	M40
4131082	KHSST28220	M38
4131103	KHSST28221	M102
4131106	KHSST28223	M102
4131110	KHSST28226	M134
4131113	KHSST28228	M39
4131116	KHSST28231	M102
4131118	KHSST28233	M132
4131121	KHSST28235	M128–129
4131156	KHSST28239	M132
4131159	KHSST28242	M125–126
4131161	KHSST28244	M36
4131162	KHSST28245	M36
4131163	KHSST28246	M37
4131164	KHSST28247	M37
4131165	KHSST28248	M36
4131167	KHSST28249	M36
4131168	KHSST28250	M37
4131169	KHSST28251	M37
4131170	KHSST28252	M36
4131171	KHSST28253	M36
4131172	KHSST28254	M36
4131184	KHSST28255	M36
4131185	KHSST28256	M36
4131186	KHSST28257	M36
4131187	KHSST28258	M36
4131189	KHSST28259	M36
4131190	KHSST28260	M36
4131191	KHSST28261	M36
4131192	KHSST28262	M36
4131213	KHSST28263	M36
4131214	KHSST28264	M36
4131215	KHSST28265	M36
4131216	KHSST28266	M36
4131217	KHSST28267	M36
4131220	KHSST28268	M36
4131221	KHSST28269	M36
4131222	KHSST28270	M36
4131255	KHSST28271	M36
4131257	KHSST28272	M36
4131258	KHSST28273	M36
4131260	KHSST28274	M36

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4131261	KHSST28275	M36
4131262	KHSST28276	M36
4131263	KHSST28277	M36
4131264	KHSST28278	M129
4131265	KHSST28279	M126
4131267	KHSST28281	M126
4131268	KHSST28282	M129
4131269	KHSST28283	M126
4131272	KHSST28286	M126
4131283	KHSST28287	M128
4131285	KHSST28289	M128
4131286	KHSST28290	M128
4131287	KHSST28291	M125
4131289	KHSST28293	M125
4131290	KHSST28294	M128
4131291	KHSST28295	M128
4131292	KHSST28296	M125
4131294	KHSST28298	M125
4131297	KHSST28301	M128
4131298	KHSST28302	M126
4131300	KHSST28304	M128
4131301	KHSST28305	M126
4131315	KHSST28308	M128
4131316	KHSST28309	M125
4131318	KHSST28311	M128
4131320	KHSST28313	M128
4131321	KHSST28314	M125
4131334	KHSST28317	M128
4131335	KHSST28318	M125
4131336	KHSST28319	M128
4131340	KHSST28323	M125
4131357	KHSST28329	M129
4131359	KHSST28330	M126
4131370	KHSST28338	M129
4131371	KHSST28339	M126
4131372	KHSST28340	M128
4131383	KHSST28341	M125
4131384	KHSST28342	M128
4131385	KHSST28343	M125
4131386	KHSST28344	M128
4131388	KHSST28345	M126
4131389	KHSST28346	M126
4131390	KHSST28347	M128
4131391	KHSST28348	M125
4131392	KHSST28349	M125
4131393	KHSST28350	M128
4131395	KHSST28351	M125
4131396	KHSST28352	M126
4131397	KHSST28353	M128
4131400	KHSST28356	M125
4131423	KHSST28358	M125
4131424	KHSST28359	M125
4131427	KHSST28361	M125
4131430	KHSST28364	M125
4131431	KHSST28365	M126
4131432	KHSST28366	M125
4131435	KHSST28368	M127
4131440	KHSST28371	M127
4131442	KHSST28372	M124
4131463	KHSST28373	M127
4131464	KHSST28374	M127
4131465	KHSST28375	M127
4131466	KHSST28376	M124
4131469	KHSST28379	M127
4131470	KHSST28380	M124
4131476	KHSST28384	M127
4131480	KHSST28388	M127
4131481	KHSST28389	M124
4131496	KHSST28394	M127
4131497	KHSST28395	M127
4131498	KHSST28396	M124
4131499	KHSST28397	M124
4131501	KHSST28399	M127
4131502	KHSST28400	M124
4131523	KHSST28401	M124
4131525	KHSST28403	M127
4131529	KHSST28406	M127
4131530	KHSST28407	M124
4131553	KHSST28410	M124
4131556	KHSST28412	M127
4131557	KHSST28413	M124
4131560	KHSST28416	M127
4131561	KHSST28417	M124
4131593	KHSST28419	M127
4131594	KHSST28420	M127
4131599	KHSST28423	M127
4131601	KHSST28425	M124
4131602	KHSST28426	M124
4131613	KHSST28427	M124
4131614	KHSST28428	M124
4131615	KHSST28429	M127
4131742	KHSST28433	M124
4131803	KHSST28440	M124
4131807	KHSST28443	M157
4131809	KHSST28444	M157
4131810	KHSST28445	M157
4131811	KHSST28446	M157
4131812	KHSST28447	M41
4131823	KHSST28448	M41
4131843	KHSST28455	M131
4131846	KHSST28458	M131
4131850	KHSST28462	M131
4131878	KHSST28465	M131
4131943	KHSST28476	M103
4131947	KHSST28478	M103
4131971	KHSST28675	M132
4131972	KHSST28674	M102
4131994	KHSST28672	M102
4131995	KHSST28671	M104
4131997	KHSST28670	M102
4132075	KHSST28526	M39
4132076	KHSST28527	M39
4132077	KHSST28528	M39
4132078	KHSST28529	M39
4132080	KHSST28531	M39
4132081	KHSST28532	M39
4132093	KHSST28534	M39
4132602	1.18025R110	E16
4132633	1.78025L100	E19
4132634	1.78025R100	E19
4132641	1.18025R310Z	E20, E22
4132647	1.38025R021Z	E20, E22
4132649	1.77125R300Z	E21, E23
4132653	1.78025L300Z	E21, E23
4132655	1.78032L400Z	E21, E23
4132877	B977A06150 KC7315	G135
4133732	RNG45T0425 KYS30	B352
4135418	LNPU763PNSRHD KCPK30	S99, S101
4135419	LNPU763PNSRHD KCK15	S99, S101
4135420	LNPU763PNSRHD KC725M	S99, S101
4135435	HNPJ755ANSNGD KC520M	S25
4135438	HNPJ759ANSNHD KC520M	S26
4135574	TM711M030X050R2DHA KCU33	M165
4135575	TM711M040X070R2DHA KCU33	M165
4135576	TM711M050X080R2DHA KCU33	M165
4135577	TM711M060X100R2DHA KCU33	M165
4135578	TM711M080X125R2DHA KCU33	M165
4135579	TM711M100X150R2DHA KCU33	M165
4135580	TM711M120X175R2DHA KCU33	M165
4135581	TM711M140X200R2DHA KCU33	M165
4135582	TM711M160X200R2DHA KCU33	M165
4135663	TM711M180X250R2DHA KCU33	M165
4135664	TM711M200X250R2DHA KCU33	M165
4135665	TM711MF040X050R2DHA KCU33	M165
4135666	TM711MF050X050R2DHA KCU33	M165
4135667	TM711MF060X075R2DHA KCU33	M165
4135668	TM711MF080X075R2DHA KCU33	M165
4135669	TM711MF080X100R2DHA KCU33	M165
4135670	TM711MF100X100R2DHA KCU33	M165
4135671	TM711MF120X100R2DHA KCU33	M165
4135672	TM711MF120X150R2DHA KCU33	M165
4135673	TM711MF140X150R2DHA KCU33	M165
4135674	TM711MF160X150R2DHA KCU33	M165
4135675	TM711MF180X150R2DHA KCU33	M165
4135676	TM711MF200X150R2DHA KCU33	M165
4135763	TM721M060X100R2DHA KCU32	M166
4135764	TM721M080X125R2DHA KCU32	M166
4135765	TM721M100X150R2DHA KCU32	M166
4135766	TM721M120X175R2DHA KCU32	M166
4135767	TM721M140X200R2DHA KCU32	M166
4135768	TM721M160X200R2DHA KCU32	M166
4135770	TM721MF080X100R2DHA KCU32	M166
4135774	TM721MF120X125R2DHA KCU32	M166
4135776	TM721MF140X150R2DHA KCU32	M166
4135778	TM721NC2500-20R2DHA KCU32	M166
4135779	TM721NC3125-18R2DHA KCU32	M166
4135780	TM721NC3750-16R2DHA KCU32	M166
4135781	TM721NC4375-14R2DHA KCU32	M166
4135782	TM721NC0500-13R2DHA KCU32	M166
4135783	TM721NC5625-12R2DHA KCU32	M166
4135784	TM721NC0625-11R2DHA KCU32	M166
4135823	TM731M040X070R2DHA KCU32	M167
4135824	TM731M050X080R2DHA KCU32	M167
4135825	TM731M060X100R2DHA KCU32	M167
4135826	TM731M080X125R2DHA KCU32	M167
4135827	TM731M100X150R2DHA KCU32	M167
4135828	TM731M120X175R2DHA KCU32	M167
4135830	TM731M160X200R2DHA KCU32	M167
4135832	TM731MF080X100R2DHA KCU32	M167
4136208	B269A03000HP KCPK15	G62
4136209	B269A08500HP KCPK15	G63
4136210	B269A14000HP KCPK15	G64
4136381	MEGA90D500LN76M6	S100
4136382	MEGA90D600LN76M8	S100
4136385	MEGA90D1000LN76C10	S100
4136387	MEGA90D1200LN76C10	S100
4136388	MEGA90D1200LN76M10	S100
4136389	KSHRHD150HN43M2	S14
4136390	KSHRHD150HN43F2	S14
4136391	KSHRHD200HN43C3	S14
4136392	KSHRHD200HN43M3	S14
4136394	KSHRHD250HN43M3	S14
4136395	KSHRHD300HN43C4	S14
4136396	KSHRHD300HN43M4	S14
4136397	KSHRHD400HN43C6	S14
4136399	KSHRHD500HN43C6	S14
4136400	KSHRHD500HN43M6	S14
4136407	KSHRHF100D02C075HN43L480	S4
4136408	KSHRHF100D03C075HN43L480	S4
4136410	KSHRHF125D04C100HN43L520	S4
4136411	KSHRHF150HN43F3	S5
4136412	KSHRHF200HN43M3	S5
4136413	KSHRHF250HN43M3	S5
4136414	KSHRHF300HN43M4	S5
4137020	A4G0305M03U02GMN KCP25	C106
4137022	A4G0405M04U04GMN KCP25	C106
4137043	A4G0405M04U08GMN KCP25	C106
4137044	A4G0505M05U04GMN KCP25	C106
4137045	A4G0505M05U08GMN KCP25	C106
4137047	A4G0805M08U08GMN KCP25	C106
4137052	A4G0805M08U12GMN KCP25	C106
4137279	CCNC0500J4AH KCN05	P136
4137280	CCNC0500J4BH KCN05	P136
4137446	CCNC0250J3AH KCN05	P136
4137447	CCNC0250J3BH KCN05	P136
4137448	CCNC0375J4AH KCN05	P136
4137449	CCNC0375J4BH KCN05	P136
4137459	CBDB0250JXAS KCN05	P138
4137460	CBDB0250JXBS KCN05	P138
4137461	CBDB0375JXAS KCN05	P138
4137462	CBDB0375JXBS KCN05	P138
4137473	CBDB0500JXAS KCN05	P138
4137474	CBDB0500JXBS KCN05	P138
4137719	CDDC0250J6AH KCN05	P137
4137720	CDDC0250J6BH KCN05	P137
4137721	CDDC0375J6AH KCN05	P137
4137722	CDDC0375J6BH KCN05	P137
4137733	CDDC0500J6AH KCN05	P137
4137734	CDDC0500J6BH KCN05	P137
4138292	TM741M060X100R2DHA KCU36	M169
4138344	TM741M080X125R2DHA KCU36	M169
4138346	TM741M100X150R2DHA KCU36	M169
4138348	TM741MF120X150R2DHA KCU36	M169
4138349	TM741M120X175R2DHA KCU36	M169
4138350	TM741M140X200R2DHA KCU36	M169
4138351	TM741M160X200R2DHA KCU36	M169
4138352	TM741M180X250R2DHA KCU36	M169
4138353	TM741M200X250R2DHA KCU36	M169
4138354	TM741MF100X125R2DHA KCU36	M169
4138355	TM741MF080X100R2DHA KCU36	M169
4138357	TM741MF100X100R2DHA KCU36	M169
4138366	TM741NC2500-20R2DHA KCU36	M168
4138367	TM741NC3125-18R2DHA KCU36	M168
4138368	TM741NC3750-16R2DHA KCU36	M168
4138370	TM741NC0500-13R2DHA KCU36	M168
4138373	TM741NC0750-10R2DHA KCU36	M168
4138374	TM741NF2500-28R2DHA KCU36	M168
4138375	TM741NF3125-24R2DHA KCU36	M168
4138376	TM741NF3750-24R2DHA KCU36	M168
4138378	TM741NF0500-20R2DHA KCU36	M168
4138380	TM741NF0625-18R2DHA KCU36	M168
4138381	TM741NC0750-16R2DHA KCU36	M168
4139437	KSEM1760HPCCLM KC7410	H60
4140842	KSEM3920HPCCLM KC7410	H61
4141558	SSP8	S104
4142614	KSEM2210HPCCLM KC7410	H60
4146399	WNGA432T0420 KYS30	B354
4146400	WNGA434T0420 KYS30	B354
4146401	CNGA432E KYS30	B350
4146402	CNGA432T0420 KYS30	B350
4146424	CNGA433T0420 KYS30	B350
4146427	DNGA432T0420 KYS30	B351
4146428	DNGA433T0420 KYS30	B351
4146429	SNGA433T0420 KYS30	B353
4146436	CNG453T0420 KYS30	B350
4146437	CNG454T0420 KYS30	B350
4146438	RCGV45T0425 KYS30	B351
4146440	RNG43T0420 KYS30	B352
4146442	RNG45T0225 KYS30	B352
4146443	RNG45T0420 KYS30	B352
4146445	RNG65T0420 KYS30	B352
4146446	SNG432T0420 KYS30	B353
4146447	SNG433T0420 KYS30	B353
4146448	SNG434T0420 KYS30	B353
4146451	SNG454T0420 KYS30	B353
4146453	SNG644T0420 KYS30	B353
4146454	SNG656E KYS30	B353
4146459	CNGX452T0420 KYS30	B350
4146461	CNGX453T0420 KYS30	B350
4146462	CNGX454E KYS30	B350
4146464	DNGX453T0420 KYS30	B351
4146465	DNGX454T0420 KYS30	B351
4146466	SNGX453T0420 KYS30	B353
4146467	SNGX454T0420 KYS30	B353
4146468	RPG32E KYS30	B352, V157
4146469	RCGV23E KYS30	B351
4146470	RCGV35E KYS30	B351
4146471	RCGV35T0225 KYS30	B351
4146472	RCGV35T0420 KYS30	B351
4146473	RCGV45E KYS30	B351
4146474	RCGV45T0420 KYS30	B351
4146475	RPGV35E KYS30	B352
4146476	RPGV35T0420 KYS30	B352
4146477	RPGV45E KYS30	B352
4146478	RPGV45T0420 KYS30	B352
4146482	RNGJ1204M0FLDJ KC422M	V55
4146583	RNGJ1204M0ELD KCPK30	V55
4146584	RNGJ1204M0ELD KC522M	V55
4146585	RNGJ1204M0ELD KC725M	V55
4146586	RNGJ1204M0SGD KCPK30	V55
4146587	RNGJ1204M0SGD KC522M	V55
4146588	RNGJ1204M0SGD KC725M	V55
4147474	RNGJ1204M0SHD KCPK30	V56
4147477	RNGJ1204M0SHD KC725M	V56
4147496	MEGA60D500LN76M6	S98
4147497	MEGA60D600LN76M8	S98
4147499	MEGA60D800LN76M10	S98
4147523	MEGA60D1200LN76M10	S98
4148475	B051A18000CPG KC7325	G18
4148476	B051A18100CPG KC7325	G18
4148477	B051A18200CPG KC7325	G18
4148478	B051A18258CPG KC7325	G18
4148479	B051A18300CPG KC7325	G18
4148480	B051A18400CPG KC7325	G19
4148481	B051A18500CPG KC7325	G19
4148482	B051A18600CPG KC7325	G19
4148583	B051A18654CPG KC7325	G19
4148584	B051A18700CPG KC7325	G19
4148585	B051A18800CPG KC7325	G19
4148586	B051A18900CPG KC7325	G19
4148587	B051A19000CPG KC7325	G19
4148588	B051A19050CPG KC7325	G19
4148589	B051A19100CPG KC7325	G19
4148590	B051A19200CPG KC7325	G19
4148591	B051A19300CPG KC7325	G19
4148592	B051A19400CPG KC7325	G19
4148593	B051A19500CPG KC7325	G19
4148594	B051A19600CPG KC7325	G19

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4148595	B051A197000CPG KC7325	G19
4148596	B051A198000CPG KC7325	G19
4148597	B051A199000CPG KC7325	G19
4148598	B051A200000CPG KC7325	G19
4148804	B051A01500CPG KC7325	G14
4148805	B051A01600CPG KC7325	G14
4148806	B051A01700CPG KC7325	G14
4148807	B051A01800CPG KC7325	G14
4148808	B051A01900CPG KC7325	G14
4148809	B051A01984CPG KC7325	G14
4148810	B051A02100CPG KC7325	G14
4148811	B051A02200CPG KC7325	G14
4148812	B051A02300CPG KC7325	G14
4148843	B051A02383CPG KC7325	G14
4148844	B051A02400CPG KC7325	G14
4148845	B051A02439CPG KC7325	G14
4148846	B051A02489CPG KC7325	G14
4148847	B051A02500CPG KC7325	G14
4148848	B051A02578CPG KC7325	G14
4148849	B051A02600CPG KC7325	G14
4148850	B051A02642CPG KC7325	G14
4148851	B051A02700CPG KC7325	G14
4148852	B051A02705CPG KC7325	G14
4148853	B051A02779CPG KC7325	G14
4148854	B051A02800CPG KC7325	G14
4148855	B051A02820CPG KC7325	G14
4148856	B051A02870CPG KC7325	G14
4148857	B051A02900CPG KC7325	G14
4148858	B051A02947CPG KC7325	G15
4148872	B269A12500HP KCPK15	G63
4149110	B052A10000CPG KC7325	G17
4149111	B052A10100CPG KC7325	G17
4149112	B052A10200CPG KC7325	G17
4149125	B052A03000CPG KC7325	G15
4149126	B052A03048CPG KC7325	G15
4149128	B052A03100CPG KC7325	G15
4149129	B052A03175CPG KC7325	G15
4149130	B052A03200CPG KC7325	G15
4149131	B052A03264CPG KC7325	G15
4149132	B052A03400CPG KC7325	G15
4149143	B052A01500CPG KC7325	G14
4149144	B052A01600CPG KC7325	G14
4149145	B052A01700CPG KC7325	G14
4149146	B052A01800CPG KC7325	G14
4149147	B052A01900CPG KC7325	G14
4149148	B052A01984CPG KC7325	G14
4149149	B052A02000CPG KC7325	G14
4149150	B052A02100CPG KC7325	G14
4149151	B052A02200CPG KC7325	G14
4149152	B052A02300CPG KC7325	G14
4149153	B052A02383CPG KC7325	G14
4149154	B052A02400CPG KC7325	G14
4149155	B052A02439CPG KC7325	G14
4149156	B052A02489CPG KC7325	G14
4149157	B052A02500CPG KC7325	G14
4149158	B052A02578CPG KC7325	G14
4149159	B052A02600CPG KC7325	G14
4149160	B052A02642CPG KC7325	G14
4149161	B052A02700CPG KC7325	G14
4149162	B052A02705CPG KC7325	G14
4149163	B052A02779CPG KC7325	G14
4149164	B052A02800CPG KC7325	G14
4149165	B052A02820CPG KC7325	G14
4149166	B052A02870CPG KC7325	G14
4149167	B052A02900CPG KC7325	G14
4149168	B052A02947CPG KC7325	G15
4149178	B052A18000CPG KC7325	G18
4149179	B052A18100CPG KC7325	G18
4149180	B052A18200CPG KC7325	G18
4149181	B052A18258CPG KC7325	G18
4149182	B052A18300CPG KC7325	G18
4149183	B052A03455CPG KC7325	G15
4149184	B052A03500CPG KC7325	G15
4149185	B052A03571CPG KC7325	G15
4149186	B052A03600CPG KC7325	G15
4149187	B052A03658CPG KC7325	G15
4149188	B052A03700CPG KC7325	G15
4149189	B052A03734CPG KC7325	G15
4149190	B052A03800CPG KC7325	G15
4149191	B052A03900CPG KC7325	G15
4149192	B052A03970CPG KC7325	G15
4149193	B052A04000CPG KC7325	G15
4149194	B052A04039CPG KC7325	G15
4149195	B052A04090CPG KC7325	G15
4149196	B052A04100CPG KC7325	G15
4149197	B052A04200CPG KC7325	G15
4149198	B052A04217CPG KC7325	G15
4149199	B052A04300CPG KC7325	G15
4149200	B052A04366CPG KC7325	G15
4149201	B052A04400CPG KC7325	G15
4149202	B052A04500CPG KC7325	G15
4149203	B052A04600CPG KC7325	G15
4149204	B052A04623CPG KC7325	G15
4149205	B052A04700CPG KC7325	G15
4149206	B052A04763CPG KC7325	G15
4149207	B052A04800CPG KC7325	G15
4149208	B052A04852CPG KC7325	G15
4149209	B052A04900CPG KC7325	G15
4149210	B052A05000CPG KC7325	G15
4149211	B052A05100CPG KC7325	G15
4149212	B052A05106CPG KC7325	G15
4149213	B052A05159CPG KC7325	G15
4149214	B052A05200CPG KC7325	G15
4149215	B052A05300CPG KC7325	G15
4149216	B052A05400CPG KC7325	G15
4149217	B052A05410CPG KC7325	G15
4149218	B052A05500CPG KC7325	G15
4149219	B052A05558CPG KC7325	G15
4149220	B052A05600CPG KC7325	G15
4149221	B052A05616CPG KC7325	G15
4149222	B052A05700CPG KC7325	G15
4149223	B052A05800CPG KC7325	G15
4149224	B052A05900CPG KC7325	G15
4149225	B052A05954CPG KC7325	G15
4149226	B052A06000CPG KC7325	G16
4149227	B052A06100CPG KC7325	G16
4149228	B052A06200CPG KC7325	G16
4149229	B052A06300CPG KC7325	G16
4149230	B052A06350CPG KC7325	G16
4149231	B052A06400CPG KC7325	G16
4149232	B052A06500CPG KC7325	G16
4149233	B052A06528CPG KC7325	G16
4149234	B052A06600CPG KC7325	G16
4149235	B052A06630CPG KC7325	G16
4149236	B052A06700CPG KC7325	G16
4149237	B052A06746CPG KC7325	G16
4149238	B052A06800CPG KC7325	G16
4149239	B052A06900CPG KC7325	G16
4149240	B052A07000CPG KC7325	G16
4149241	B052A07100CPG KC7325	G16
4149242	B052A07145CPG KC7325	G16
4149243	B052A07200CPG KC7325	G16
4149244	B052A07300CPG KC7325	G16
4149245	B052A07400CPG KC7325	G16
4149246	B052A07500CPG KC7325	G16
4149247	B052A07541CPG KC7325	G16
4149248	B052A07600CPG KC7325	G16
4149249	B052A07700CPG KC7325	G16
4149250	B052A07800CPG KC7325	G16
4149251	B052A07900CPG KC7325	G16
4149252	B052A07938CPG KC7325	G16
4149253	B052A08000CPG KC7325	G16
4149254	B052A08100CPG KC7325	G16
4149255	B052A08200CPG KC7325	G16
4149256	B052A08300CPG KC7325	G16
4149257	B052A08334CPG KC7325	G16
4149258	B052A08400CPG KC7325	G16
4149259	B052A08433CPG KC7325	G16
4149260	B052A08500CPG KC7325	G16
4149261	B052A08600CPG KC7325	G16
4149262	B052A08700CPG KC7325	G16
4149263	B052A08733CPG KC7325	G16
4149264	B052A08800CPG KC7325	G16
4149265	B052A08900CPG KC7325	G16
4149266	B052A09000CPG KC7325	G16
4149267	B052A09100CPG KC7325	G16
4149268	B052A09129CPG KC7325	G16
4149269	B052A09200CPG KC7325	G16
4149270	B052A09300CPG KC7325	G16
4149271	B052A09347CPG KC7325	G16
4149272	B052A09400CPG KC7325	G16
4149273	B052A09500CPG KC7325	G16
4149274	B052A09525CPG KC7325	G16
4149275	B052A09600CPG KC7325	G16
4149276	B052A09700CPG KC7325	G16
4149277	B052A09800CPG KC7325	G16
4149278	B052A09900CPG KC7325	G17
4149279	B052A09921CPG KC7325	G17
4149293	B052A10300CPG KC7325	G17
4149294	B052A10320CPG KC7325	G17
4149295	B052A10400CPG KC7325	G17
4149296	B052A10500CPG KC7325	G17
4149297	B052A10600CPG KC7325	G17
4149298	B052A10700CPG KC7325	G17
4149299	B052A10716CPG KC7325	G17
4149300	B052A10800CPG KC7325	G17
4149301	B052A10900CPG KC7325	G17
4149302	B052A11000CPG KC7325	G17
4149303	B052A11100CPG KC7325	G17
4149304	B052A11113CPG KC7325	G17
4149305	B052A11200CPG KC7325	G17
4149306	B052A11300CPG KC7325	G17
4149307	B052A11400CPG KC7325	G17
4149308	B052A11500CPG KC7325	G17
4149309	B052A11509CPG KC7325	G17
4149310	B052A11600CPG KC7325	G17
4149311	B052A11700CPG KC7325	G17
4149312	B052A11800CPG KC7325	G17
4149313	B052A11900CPG KC7325	G17
4149314	B052A11908CPG KC7325	G17
4149315	B052A12000CPG KC7325	G17
4149316	B052A12100CPG KC7325	G17
4149317	B052A12200CPG KC7325	G17
4149318	B052A12300CPG KC7325	G17
4149319	B052A12304CPG KC7325	G17
4149320	B052A12400CPG KC7325	G17
4149321	B052A12500CPG KC7325	G17
4149322	B052A12600CPG KC7325	G17
4149323	B052A12700CPG KC7325	G17
4149324	B052A12800CPG KC7325	G17
4149325	B052A12900CPG KC7325	G17
4149326	B052A13000CPG KC7325	G17
4149327	B052A13096CPG KC7325	G17
4149328	B052A13100CPG KC7325	G17
4149329	B052A13200CPG KC7325	G17
4149330	B052A13300CPG KC7325	G17
4149331	B052A13400CPG KC7325	G17
4149332	B052A13500CPG KC7325	G17
4149333	B052A13600CPG KC7325	G17
4149334	B052A13700CPG KC7325	G17
4149335	B052A13800CPG KC7325	G17
4149336	B052A13891CPG KC7325	G17
4149337	B052A13900CPG KC7325	G17
4149338	B052A14000CPG KC7325	G17
4149339	B052A14100CPG KC7325	G17
4149340	B052A14200CPG KC7325	G18
4149341	B052A14288CPG KC7325	G18
4149342	B052A14300CPG KC7325	G18
4149343	B052A14400CPG KC7325	G18
4149344	B052A14500CPG KC7325	G18
4149345	B052A14600CPG KC7325	G18
4149346	B052A14684CPG KC7325	G18
4149347	B052A14700CPG KC7325	G18
4149348	B052A14800CPG KC7325	G18
4149349	B052A14900CPG KC7325	G18
4149350	B052A15000CPG KC7325	G18
4149351	B052A15083CPG KC7325	G18
4149352	B052A15100CPG KC7325	G18
4149353	B052A15200CPG KC7325	G18
4149354	B052A15300CPG KC7325	G18
4149355	B052A15400CPG KC7325	G18
4149356	B052A15479CPG KC7325	G18
4149357	B052A15500CPG KC7325	G18
4149358	B052A15600CPG KC7325	G18
4149359	B052A15700CPG KC7325	G18
4149360	B052A15800CPG KC7325	G18
4149361	B052A15875CPG KC7325	G18
4149362	B052A15900CPG KC7325	G18
4149363	B052A16000CPG KC7325	G18
4149364	B052A16100CPG KC7325	G18
4149365	B052A16200CPG KC7325	G18
4149366	B052A16271CPG KC7325	G18
4149367	B052A16300CPG KC7325	G18
4149368	B052A16400CPG KC7325	G18
4149369	B052A16500CPG KC7325	G18
4149370	B052A16600CPG KC7325	G18
4149371	B052A16670CPG KC7325	G18
4149372	B052A16700CPG KC7325	G18
4149373	B052A16800CPG KC7325	G18
4149374	B052A16900CPG KC7325	G18
4149375	B052A17000CPG KC7325	G18
4149376	B052A17100CPG KC7325	G18
4149377	B052A17200CPG KC7325	G18
4149378	B052A17300CPG KC7325	G18
4149379	B052A17400CPG KC7325	G18
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4149627	B053A05106CPG KC7325	G15
4149628	B053A05159CPG KC7325	G15
4149629	B053A05200CPG KC7325	G15
4149630	B053A05300CPG KC7325	G15
4149631	B053A05400CPG KC7325	G15
4149632	B053A05410CPG KC7325	G15
4149633	B053A05500CPG KC7325	G15
4149634	B053A05558CPG KC7325	G15
4149635	B053A05600CPG KC7325	G15
4149636	B053A05616CPG KC7325	G15

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4149637	B053A05700CPG KC7325	G15
4149638	B053A05800CPG KC7325	G15
4149639	B053A05900CPG KC7325	G15
4149640	B053A05954CPG KC7325	G15
4149641	B053A06000CPG KC7325	G16
4149642	B053A06100CPG KC7325	G16
4149643	B053A06200CPG KC7325	G16
4149644	B053A06300CPG KC7325	G16
4149645	B053A06350CPG KC7325	G16
4149646	B053A06400CPG KC7325	G16
4149647	B053A06500CPG KC7325	G16
4149648	B053A06528CPG KC7325	G16
4149649	B053A06600CPG KC7325	G16
4149650	B053A06630CPG KC7325	G16
4149651	B053A06700CPG KC7325	G16
4149652	B053A06746CPG KC7325	G16
4149653	B053A06800CPG KC7325	G16
4149654	B053A06900CPG KC7325	G16
4149655	B053A07000CPG KC7325	G16
4149656	B053A07100CPG KC7325	G16
4149657	B053A07145CPG KC7325	G16
4149658	B053A07200CPG KC7325	G16
4149659	B053A07300CPG KC7325	G16
4149660	B053A07400CPG KC7325	G16
4149661	B053A07500CPG KC7325	G16
4149662	B053A07541CPG KC7325	G16
4149663	B053A07600CPG KC7325	G16
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4149665	B053A07800CPG KC7325	G16
4149666	B053A07900CPG KC7325	G16
4149667	B053A07938CPG KC7325	G16
4149668	B053A08000CPG KC7325	G16
4149669	B053A08100CPG KC7325	G16
4149670	B053A08200CPG KC7325	G16
4149671	B053A08300CPG KC7325	G16
4149672	B053A08334CPG KC7325	G16
4149673	B053A08400CPG KC7325	G16
4149674	B053A08433CPG KC7325	G16
4149675	B053A08500CPG KC7325	G16
4149676	B053A08600CPG KC7325	G16
4149677	B053A08700CPG KC7325	G16
4149678	B053A08733CPG KC7325	G16
4149679	B053A08800CPG KC7325	G16
4149680	B053A08900CPG KC7325	G16
4149681	B053A09000CPG KC7325	G16
4149682	B053A09100CPG KC7325	G16
4149683	B053A09129CPG KC7325	G16
4149684	B053A09200CPG KC7325	G16
4149685	B053A09300CPG KC7325	G16
4149686	B053A09347CPG KC7325	G16
4149687	B053A09400CPG KC7325	G16
4149688	B053A09500CPG KC7325	G16
4149689	B053A09525CPG KC7325	G16
4149690	B053A09600CPG KC7325	G16
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4149692	B053A09800CPG KC7325	G16
4149693	B053A09900CPG KC7325	G17
4149694	B053A09921CPG KC7325	G17
4149733	B053A10000CPG KC7325	G17
4149734	B053A10100CPG KC7325	G17
4149735	B053A10200CPG KC7325	G17
4149736	B053A10300CPG KC7325	G17
4149737	B053A10320CPG KC7325	G17
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4149739	B053A10500CPG KC7325	G17
4149740	B053A10600CPG KC7325	G17
4149741	B053A10700CPG KC7325	G17
4149742	B053A10716CPG KC7325	G17
4149743	B053A10800CPG KC7325	G17
4149744	B053A10900CPG KC7325	G17
4149745	B053A11000CPG KC7325	G17
4149746	B053A11100CPG KC7325	G17
4149747	B053A11113CPG KC7325	G17
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4150217	B041A05410CPG KC7325	G9
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4150219	B041A05558CPG KC7325	G9
4150220	B041A05600CPG KC7325	G10
4150221	B041A05616CPG KC7325	G10
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4150224	B041A05900CPG KC7325	G10
4150225	B041A05954CPG KC7325	G10
4150226	B041A06000CPG KC7325	G10
4150227	B041A06100CPG KC7325	G10
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4150230	B041A06350CPG KC7325	G10
4150231	B041A06400CPG KC7325	G10
4150232	B041A06500CPG KC7325	G10
4150233	B041A06528CPG KC7325	G10
4150234	B041A06600CPG KC7325	G10
4150235	B041A06630CPG KC7325	G10
4150236	B041A06700CPG KC7325	G10
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4150245	B041A07400CPG KC7325	G10
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4150247	B041A07541CPG KC7325	G10
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4150252	B041A07938CPG KC7325	G10
4150253	B041A08000CPG KC7325	G10
4150254	B041A08100CPG KC7325	G10
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4150257	B041A08334CPG KC7325	G10
4150258	B041A08400CPG KC7325	G10
4150259	B041A08433CPG KC7325	G10
4150260	B041A08500CPG KC7325	G10
4150261	B041A08600CPG KC7325	G10
4150262	B041A08700CPG KC7325	G10
4150263	B041A08733CPG KC7325	G10
4150264	B041A08800CPG KC7325	G10
4150265	B041A08900CPG KC7325	G10
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4150270	B041A09300CPG KC7325	G10
4150271	B041A09347CPG KC7325	G10
4150272	B041A09400CPG KC7325	G11
4150273	B041A09500CPG KC7325	G11
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4150278	B041A09900CPG KC7325	G11
4150279	B041A09921CPG KC7325	G11
4150293	B041A10600CPG KC7325	G11
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4150295	B041A10716CPG KC7325	G11
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4150297	B041A10900CPG KC7325	G11
4150298	B041A11000CPG KC7325	G11
4150299	B041A11100CPG KC7325	G11
4150300	B041A11113CPG KC7325	G11
4150301	B041A11200CPG KC7325	G11
4150302	B041A11300CPG KC7325	G11
4150303	B041A11400CPG KC7325	G11
4150304	B041A11500CPG KC7325	G11
4150305	B041A11509CPG KC7325	G11
4150306	B041A11600CPG KC7325	G11
4150307	B041A11700CPG KC7325	G11
4150308	B041A11800CPG KC7325	G11
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4150310	B041A11908CPG KC7325	G11
4150311	B041A12000CPG KC7325	G11
4150312	B041A12100CPG KC7325	G11
4150313	B041A12200CPG KC7325	G11
4150314	B041A12300CPG KC7325	G11
4150315	B041A12304CPG KC7325	G11
4150316	B041A12400CPG KC7325	G11
4150317	B041A12500CPG KC7325	G11
4150318	B041A12600CPG KC7325	G11
4150319	B041A12700CPG KC7325	G11
4150320	B041A12800CPG KC7325	G11
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4150322	B041A13000CPG KC7325	G11
4150323	B041A13096CPG KC7325	G11
4150324	B041A13100CPG KC7325	G11
4150325	B041A13200CPG KC7325	G11
4150326	B041A13300CPG KC7325	G11
4150327	B041A13400CPG KC7325	G11
4150328	B041A13500CPG KC7325	G11
4150329	B041A13600CPG KC7325	G11

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4150330	B041A137000CPG KC7325	G12
4150331	B041A138000CPG KC7325	G12
4150332	B041A13891CPG KC7325	G12
4150333	B041A139000CPG KC7325	G12
4150334	B041A140000CPG KC7325	G12
4150335	B041A14100CPG KC7325	G12
4150336	B041A142000CPG KC7325	G12
4150337	B041A14288CPG KC7325	G12
4150338	B041A143000CPG KC7325	G12
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4150351	B041A15400CPG KC7325	G12
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For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4151119	B051A04090CPG KC7325	G15
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4151251	B051A13900CPG KC7325	G17
4151252	B051A14100CPG KC7325	G17
4151253	B051A14200CPG KC7325	G18
4151254	B051A14288CPG KC7325	G18
4151255	B051A14300CPG KC7325	G18
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4151259	B051A14684CPG KC7325	G18
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4151265	B051A15100CPG KC7325	G18
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4151267	B051A15300CPG KC7325	G18
4151268	B051A15400CPG KC7325	G18
4151269	B051A15479CPG KC7325	G18
4151270	B051A15500CPG KC7325	G18
4151271	B051A15600CPG KC7325	G18
4151272	B051A15700CPG KC7325	G18
4151273	B051A15800CPG KC7325	G18
4151274	B051A15875CPG KC7325	G18
4151275	B051A15900CPG KC7325	G18
4151276	B051A16000CPG KC7325	G18
4151277	B051A16100CPG KC7325	G18
4151278	B051A16200CPG KC7325	G18
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4151295	B051A17600CPG KC7325	G18
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4151298	B051A17859CPG KC7325	G18
4151299	B051A17900CPG KC7325	G18
4151623	B041A01000CPG KC7325	G8
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4151653	B041A02642CPG KC7325	G8
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4151655	B041A02705CPG KC7325	G9
4151656	B041A02779CPG KC7325	G9
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4151736	B053A01500CPG KC7325	G14
4151737	B053A01600CPG KC7325	G14
4151738	B053A01700CPG KC7325	G14
4151739	B053A01800CPG KC7325	G14
4151740	B053A01900CPG KC7325	G14
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4151742	B053A02000CPG KC7325	G14
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4151746	B053A02383CPG KC7325	G14
4151747	B053A02400CPG KC7325	G14
4151748	B053A02439CPG KC7325	G14
4151749	B053A02489CPG KC7325	G14
4151750	B053A02500CPG KC7325	G14
4151751	B053A02578CPG KC7325	G14
4151752	B053A02600CPG KC7325	G14
4151753	B053A02642CPG KC7325	G14
4151754	B053A02700CPG KC7325	G14
4151755	B053A02705CPG KC7325	G14
4151756	B053A02779CPG KC7325	G14
4151757	B053A02800CPG KC7325	G14
4151758	B053A02820CPG KC7325	G14
4151759	B053A02870CPG KC7325	G14
4151760	B053A02900CPG KC7325	G14
4151761	B053A02947CPG KC7325	G15
4151774	B042A01000CPG KC7325	G8
4151776	B042A01016CPG KC7325	G8
4151777	B042A01041CPG KC7325	G8
4151778	B042A01067CPG KC7325	G8
4151779	B042A01092CPG KC7325	G8
4151780	B042A01100CPG KC7325	G8
4151781	B042A01181CPG KC7325	G8
4151782	B042A01191CPG KC7325	G8
4151783	B042A01200CPG KC7325	G8
4151784	B042A01300CPG KC7325	G8
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4151796	B042A02200CPG KC7325	G8
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4151799	B042A02400CPG KC7325	G8
4151800	B042A02439CPG KC7325	G8
4151801	B042A02489CPG KC7325	G8
4151802	B042A02500CPG KC7325	G8
4151803	B042A02578CPG KC7325	G8
4151804	B042A02600CPG KC7325	G8
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4151809	B042A02800CPG KC7325	G9
4151810	B042A02820CPG KC7325	G9
4151811	B042A02870CPG KC7325	G9
4151812	B042A02900CPG KC7325	G9
4151813	B042A02947CPG KC7325	G9
4153778	T321M100X150R6HX KC7542	M5
4153779	T321M120X175R6HX KC7542	M5
4153780	T321M140X200R6HX KC7542	M5
4153781	T321M160X200R6HX KC7542	M5
4153782	T321MF120X150R6HX KC7542	M5
4153874	T650M240X300R6HX-D6 KP6525	M58
4153875	T650M300X350R6HX-D6 KP6525	M58
4153876	T650M330X350R6HX-D6 KP6525	M58
4153877	T650M360X400R6HX-D6 KP6525	M58
4153878	T650M420X450R6HX-D6 KP6525	M58
4153879	T650M240X300R6HX-XL KP6525	M60
4153880	T650M300X350R6HX-XL KP6525	M60
4153881	T650M330X350R6HX-XL KP6525	M60
4153882	T650M360X400R6HX-XL KP6525	M60
4153883	T650M420X450R6HX-XL KP6525	M60
4153884	T651M240X300R6HX-D6 KP6525	M59
4153885	T651M300X350R6HX-D6 KP6525	M59
4153886	T651M330X350R6HX-D6 KP6525	M59
4153887	T651M360X400R6HX-D6 KP6525	M59
4153888	T651M420X450R6HX-D6 KP6525	M59
4153889	T651M240X300R6HX-XL KP6525	M61
4153890	T651M300X350R6HX-XL KP6525	M61
4153891	T651M330X350R6HX-XL KP6525	M61
4153892	T651M360X400R6HX-XL KP6525	M61
4153893	T651M420X450R6HX-XL KP6525	M61
4153903	T321MF140X150R6HX KC7542	M5
4154007	T632M050X080R6HX-D1 KP6525	M52
4154008	T632M060X100R6HX-D1 KP6525	M52
4154009	T632M080X125R6HX-D1 KP6525	M52
4154010	T632M100X150R6HX-D1 KP6525	M52
4154011	T632M120X175R6HX-D6 KP6525	M52
4154012	T632M140X200R6HX-D6 KP6525	M52
4154013	T632MF120X150R6HX-D4 KP6525	M52
4154014	T632MF140X150R6HX-D4 KP6525	M52
4154015	T632MF160X150R6HX-D4 KP6525	M52
4154016	T633M050X080R6HX-D1 KP6525	M53
4154017	T633M060X100R6HX-D1 KP6525	M53
4154018	T633M080X125R6HX-D1 KP6525	M53
4154019	T633M100X150R6HX-D1 KP6525	M53
4154020	T633M120X175R6HX-D6 KP6525	M53
4154021	T633M140X200R6HX-D6 KP6525	M53
4154022	T633MF120X150R6HX-D4 KP6525	M53
4154023	T633MF140X150R6HX-D4 KP6525	M53
4154024	T633MF160X150R6HX-D4 KP6525	M53
4154103	T600M030X050R6HX-D1 KSP21	M22
4154104	T600M040X070R6HX-D1 KSP21	M22
4154105	T600M050X080R6HX-D1 KSP21	M22
4154106	T600M060X100R6HX-D1 KSP21	M22
4154107	T600M080X125R6HX-D1 KSP21	M22
4154108	T600M100X150R6HX-D1 KSP21	M22
4154109	T600M120X175R6HX-D6 KSP21	M22
4154110	T600M140X200R6HX-D6 KSP21	M22

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4154111	T600M160X200R6HX-D6 KSP21	M22
4154112	T600M180X250R6HX-D6 KSP21	M22
4154113	T600M200X250R6HX-D6 KSP21	M22
4154114	T600MF080X100R6HX-D4 KSP21	M22
4154115	T600MF100X100R6HX-D4 KSP21	M22
4154116	T600MF100X125R6HX-D4 KSP21	M22
4154117	T600MF120X125R6HX-D4 KSP21	M22
4154118	T600MF120X150R6HX-D4 KSP21	M22
4154119	T600MF140X150R6HX-D4 KSP21	M22
4154120	T600MF160X150R6HX-D4 KSP21	M22
4154647	T622M030X050R6HX-D74 KSN28	M139
4154648	T622M040X070R6HX-D74 KSN28	M139
4154649	T622M050X080R6HX-D74 KSN28	M139
4154650	T622M060X100R6HX-D74 KSN28	M139
4154651	T622M080X125R6HX-D74 KSN28	M139
4154652	T622M100X150R6HX-D74 KSN28	M139
4154693	T622M120X175R6HX-D74 KSN28	M139
4154694	T622M160X200R6HX-D74 KSN28	M139
4154695	T622MF080X100R6HX-D74 KSN28	M139
4154696	T622MF100X100R6HX-D74 KSN28	M139
4154697	T622MF100X125R6HX-D74 KSN28	M139
4154698	T622MF120X125R6HX-D74 KSN28	M139
4154699	T622MF120X150R6HX-D74 KSN28	M139
4154700	T622MF140X150R6HX-D74 KSN28	M139
4154701	T622MF160X150R6HX-D74 KSN28	M139
4155723	EP1408SGD2 KC725M	T59, T70
4155725	EP1408SGD2 KCPK30	T59, T70
4155726	EP1408SGD2 KC520M	T59, T70
4156451	T642M050X080R6HX-D1 KP6525	M122
4156452	T642M060X100R6HX-D1 KP6525	M122
4156543	T642M080X125R6HX-D1 KP6525	M122
4156544	T642M100X150R6HX-D1 KP6525	M122
4156545	T642M120X175R6HX-D6 KP6525	M122
4156546	T642M140X200R6HX-D6 KP6525	M122
4156547	T642MF120X150R6HX-D4 KP6525	M122
4156548	T642MF140X150R6HX-D4 KP6525	M122
4156549	T642MF160X150R6HX-D4 KP6525	M122
4156550	T643M050X080R6HX-D1 KP6525	M123
4156551	T643M060X100R6HX-D1 KP6525	M123
4156552	T643M080X125R6HX-D1 KP6525	M123
4156553	T643M100X150R6HX-D1 KP6525	M123
4156554	T643M120X175R6HX-D6 KP6525	M123
4156555	T643M140X200R6HX-D6 KP6525	M123
4156556	T643MF120X150R6HX-D4 KP6525	M123
4156557	T643MF140X150R6HX-D4 KP6525	M123
4156558	T643MF160X150R6HX-D4 KP6525	M123
4157734	T410M030X050R6HX-D1 KCU36	M116
4157735	T410M040X070R6HX-D1 KCU36	M116
4157736	T410M050X080R6HX-D1 KCU36	M116
4157737	T410M060X100R6HX-D1 KCU36	M116
4157738	T410M080X125R6HX-D1 KCU36	M116
4157739	T410M100X150R6HX-D1 KCU36	M116
4157740	T410M120X175R6HX-D6 KCU36	M116
4157741	T410M140X200R6HX-D6 KCU36	M116
4157742	T410MF080X100R6HX-D4 KCU36	M116
4157963	T410MF100X100R6HX-D4 KCU36	M116
4157964	T410MF120X150R6HX-D4 KCU36	M116
4157965	T410MF140X150R6HX-D4 KCU36	M116
4157966	T410MF160X150R6HX-D4 KCU36	M116
4158449	T622M030X050R6HX-D74 KSP21	M139
4158450	T622M040X070R6HX-D74 KSP21	M139
4158451	T622M050X080R6HX-D74 KSP21	M139
4158452	T622M060X100R6HX-D74 KSP21	M139
4158483	T622M080X125R6HX-D74 KSP21	M139
4158484	T622M100X150R6HX-D74 KSP21	M139
4158485	T622M120X175R6HX-D74 KSP21	M139
4158486	T622M160X200R6HX-D74 KSP21	M139
4158487	T622MF080X100R6HX-D74 KSP21	M139
4158488	T622MF100X100R6HX-D74 KSP21	M139
4158489	T622MF100X125R6HX-D74 KSP21	M139
4158490	T622MF120X125R6HX-D74 KSP21	M139
4158491	T622MF120X150R6HX-D74 KSP21	M139
4158492	T622MF140X150R6HX-D74 KSP21	M139
4158493	T622MF160X150R6HX-D74 KSP21	M139
4158728	KTIP03125HP KCP15	H32
4158729	KTIP0800HPM KCP15	H32
4158730	KTIP0810HPM KCP15	H32
4158731	KTIP03214HP KCP15	H32
4158732	KTIP03230HP KCP15	H32
4158893	KTIP0830HPM KCP15	H32
4158894	KTIP03281HP KCP15	H32
4158895	KTIP0840HPM KCP15	H32
4158896	KTIP03320HP KCP15	H32
4158897	KTIP0850HPM KCP15	H32
4158898	KTIP0860HPM KCP15	H32
4158899	KTIP03390HP KCP15	H32
4158900	KTIP0870HPM KCP15	H32
4158901	KTIP03438HP KCP15	H32
4158902	KTIP0880HPM KCP15	H32
4158903	KTIP03480HP KCP15	H32
4158904	KTIP0890HPM KCP15	H32
4158905	KTIP0900HPM KCP15	H32
4158906	KTIP03580HP KCP15	H32
4158907	KTIP0910HPM KCP15	H32
4158908	KTIP03594HP KCP15	H32
4158909	KTIP0920HPM KCP15	H32
4158910	KTIP0930HPM KCP15	H32
4158911	KTIP03680HP KCP15	H32
4158912	KTIP0940HPM KCP15	H32
4158913	KTIP0950HPM KCP15	H32
4158914	KTIP03750HP KCP15	H32
4158915	KTIP03763HP KCP15	H32
4158916	KTIP03770HP KCP15	H32
4158917	KTIP0960HPM KCP15	H32
4158918	KTIP03820HP KCP15	H32
4158919	KTIP03860HP KCP15	H32
4158920	KTIP0990HPM KCP15	H32
4158921	KTIP03906HP KCP15	H32
4158922	KTIP1000HPM KCP15	H32
4158923	KTIP03946HP KCP15	H32
4158924	KTIP03970HP KCP15	H32
4158925	KTIP1010HPM KCP15	H32
4158926	KTIP1020HPM KCP15	H32
4158927	KTIP04040HP KCP15	H32
4158928	KTIP1030HPM KCP15	H32
4158929	KTIP04063HP KCP15	H32
4158930	KTIP1040HPM KCP15	H32
4158931	KTIP04130HP KCP15	H32
4158932	KTIP1050HPM KCP15	H32
4158933	KTIP1060HPM KCP15	H32
4158934	KTIP1070HPM KCP15	H32
4158935	KTIP04219HP KCP15	H32
4158936	KTIP1080HPM KCP15	H32
4158937	KTIP1090HPM KCP15	H32
4158938	KTIP1100HPM KCP15	H32
4158939	KTIP1110HPM KCP15	H32
4158940	KTIP04375HP KCP15	H32
4158941	KTIP1120HPM KCP15	H32
4158942	KTIP1130HPM KCP15	H32
4158943	KTIP1140HPM KCP15	H32
4158944	KTIP1150HPM KCP15	H32
4158945	KTIP04531HP KCP15	H32
4158946	KTIP1160HPM KCP15	H32
4158947	KTIP1170HPM KCP15	H32
4158948	KTIP1180HPM KCP15	H32
4158949	KTIP1190HPM KCP15	H32
4158950	KTIP04688HP KCP15	H33
4158951	KTIP1200HPM KCP15	H33
4158952	KTIP1210HPM KCP15	H33
4158953	KTIP1220HPM KCP15	H33
4158954	KTIP04844HP KCP15	H33
4158955	KTIP1240HPM KCP15	H33
4158956	KTIP04911HP KCP15	H33
4158957	KTIP1250HPM KCP15	H33
4158958	KTIP1260HPM KCP15	H33
4158959	KTIP05000HP KCP15	H33
4158960	KTIP1280HPM KCP15	H33
4158961	KTIP05080HP KCP15	H33
4158962	KTIP1300HPM KCP15	H33
4158963	KTIP05156HP KCP15	H33
4158964	KTIP1320HPM KCP15	H33
4158965	KTIP1330HPM KCP15	H33
4158966	KTIP1340HPM KCP15	H33
4158967	KTIP05312HP KCP15	H33
4158968	KTIP1350HPM KCP15	H33
4158969	KTIP1360HPM KCP15	H33
4158970	KTIP1370HPM KCP15	H33
4158971	KTIP1380HPM KCP15	H33
4158972	KTIP05469HP KCP15	H33
4158973	KTIP05471HP KCP15	H33
4158974	KTIP1400HPM KCP15	H33
4158975	KTIP1410HPM KCP15	H33
4158976	KTIP1420HPM KCP15	H33
4158977	KTIP05625HP KCP15	H33
4158978	KTIP1430HPM KCP15	H33
4158979	KTIP1440HPM KCP15	H33
4158980	KTIP1450HPM KCP15	H33
4158981	KTIP1460HPM KCP15	H33
4158982	KTIP05774HP KCP15	H33
4158983	KTIP05781HP KCP15	H33
4158984	KTIP1470HPM KCP15	H33
4158985	KTIP1480HPM KCP15	H33
4158986	KTIP1500HPM KCP15	H33
4158987	KTIP05938HP KCP15	H33
4159030	KTIP1520HPM KCP15	H33
4159031	KTIP1530HPM KCP15	H33
4159032	KTIP1540HPM KCP15	H33
4159205	KTIP1510HPM KCP15	H33
4159223	KTIP06094HP KCP15	H33
4159224	KTIP1550HPM KCP15	H33
4159225	KTIP1560HPM KCP15	H33
4159226	KTIP1570HPM KCP15	H33
4159227	KTIP1580HPM KCP15	H33
4159228	KTIP06250HP KCP15	H33
4159229	KTIP1600HPM KCP15	H33
4159230	KTIP06310HP KCP15	H33
4159231	KTIP06330HP KCP15	H33
4159232	KTIP1610HPM KCP15	H33
4159233	KTIP1620HPM KCP15	H33
4159234	KTIP06406HP KCP15	H33
4159235	KTIP1630HPM KCP15	H33
4159236	KTIP1640HPM KCP15	H33
4159237	KTIP1650HPM KCP15	H33
4159238	KTIP1660HPM KCP15	H33
4159239	KTIP06563HP KCP15	H33
4159240	KTIP1670HPM KCP15	H33
4159241	KTIP1680HPM KCP15	H33
4159242	KTIP1690HPM KCP15	H33
4159243	KTIP1700HPM KCP15	H33
4159244	KTIP06719HP KCP15	H33
4159245	KTIP1710HPM KCP15	H33
4159246	KTIP1720HPM KCP15	H33
4159247	KTIP1730HPM KCP15	H33
4159248	KTIP1740HPM KCP15	H33
4159249	KTIP06875HP KCP15	H33
4159250	KTIP1750HPM KCP15	H33
4159251	KTIP1760HPM KCP15	H33
4159252	KTIP1770HPM KCP15	H33
4159253	KTIP1780HPM KCP15	H33
4159254	KTIP07031HP KCP15	H33
4159255	KTIP1790HPM KCP15	H33
4159256	KTIP1800HPM KCP15	H33
4159257	KTIP1810HPM KCP15	H33
4159258	KTIP1820HPM KCP15	H33
4159259	KTIP07188HP KCP15	H33
4159260	KTIP1850HPM KCP15	H33
4159261	KTIP1860HPM KCP15	H33
4159262	KTIP07344HP KCP15	H33
4159263	KTIP1870HPM KCP15	H33
4159264	KTIP1880HPM KCP15	H33
4159265	KTIP1890HPM KCP15	H33
4159266	KTIP1900HPM KCP15	H33
4159267	KTIP07500HP KCP15	H33
4159268	KTIP1910HPM KCP15	H33
4159269	KTIP1920HPM KCP15	H33
4159270	KTIP07570HP KCP15	H33
4159271	KTIP07580HP KCP15	H33
4159272	KTIP1930HPM KCP15	H33
4159273	KTIP1940HPM KCP15	H33
4159274	KTIP07656HP KCP15	H33
4159275	KTIP1950HPM KCP15	H33
4159276	KTIP1960HPM KCP15	H33
4159277	KTIP1970HPM KCP15	H34
4159278	KTIP1980HPM KCP15	H34
4159279	KTIP07813HP KCP15	H34
4159280	KTIP1990HPM KCP15	H34
4159281	KTIP2000HPM KCP15	H34
4159282	KTIP2010HPM KCP15	H34
4159283	KTIP2020HPM KCP15	H34
4159284	KTIP07969HP KCP15	H34
4159285	KTIP2030HPM KCP15	H34
4159286	KTIP2050HPM KCP15	H34
4159287	KTIP2060HPM KCP15	H34
4159288	KTIP08125HP KCP15	H34
4159289	KTIP2070HPM KCP15	H34
4159290	KTIP2080HPM KCP15	H34
4159291	KTIP2090HPM KCP15	H34
4159292	KTIP2099HPM KCP15	H34
4159293	KTIP2100HPM KCP15	H34
4159294	KTIP08438HP KCP15	H34
4159295	KTIP2150HPM KCP15	H34
4159296	KTIP2200HPM KCP15	H34
4159297	KTIP08750HP KCP15	H34
4159298	KTIP2250HPM KCP15	H34
4159299	KTIP2300HPM KCP15	H34
4159300	KTIP2350HPM KCP15	H34
4159301	KTIP09375HP KCP15	H34
4159302	KTIP2400HPM KCP15	H34
4159303	KTIP2450HPM KCP15	H34
4159304	KTIP09688HP KCP15	H34
4159305	KTIP2500HPM KCP15	H34
4159306	KTIP10000HP KCP15	H34
4159307	KTIP2550HPM KCP15	H34
4159308	KTIP10110HP KCP15	H34
4159309	KTIP10160HP KCP15	H34
4159310	KTIP2599HPM KCP15	H34
4159311	KTIP2600HPM KCP15	H34
4159312	KTIP10310HP KCP15	H34
4159313	KTIP2650HPM KCP15	H34
4159314	KTIP10469HP KCP15	H34
4159315	KTIP2700HPM KCP15	H34
4159316	KTIP2750HPM KCP15	H34
4159317	KTIP10938HP KCP15	H34
4159318	KTIP2799HPM KCP15	H34
4159441	T623M050X080R6HX-D74 KSN28	M140
4159442	T623M060X100R6HX-D74 KSN28	M140
4159623	T623M080X125R6HX-D74 KSN28	M140
4159624	T623M100X150R6HX-D74 KSN28	M140
4159625	T623M120X175R6HX-D74 KSN28	M140
4159626	T623M160X200R6HX-D74 KSN28	M140
4159627	T623MF080X100R6HX-D74 KSN28	M140
4159628	T623MF100X100R6HX-D74 KSN28	M140
4159629	T623MF120X150R6HX-D74 KSN28	M140
4159630	T623MF140X150R6HX-D74 KSN28	M140
4159631	T623MF160X150R6HX-D74 KSN28	M140
4159820	T623M050X080R6HX-D74 KSP21	M140
4159821	T623M060X100R6HX-D74 KSP21	M140
4159822	T623M080X125R6HX-D74 KSP21	M140
4159843	T623M100X150R6HX-D74 KSP21	M140
4159844	T623M120X175R6HX-D74 KSP21	M140
4159845	T623M160X200R6HX-D74 KSP21	M140
4159846	T623MF080X100R6HX-D74 KSP21	M140
4159847	T623MF100X100R6HX-D74 KSP21	M140
4159848	T623MF120X150R6HX-D74 KSP21	M140
4159849	T623MF140X150R6HX-D74 KSP21	M140
4159850	T623MF160X150R6HX-D74 KSP21	M140
4160768	RCGT1204M0MS KCU25	B239
4160769	RCGT1606M0MS KCU25	B239

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4161098	T604M030X050R6H-D1 KSH26	M73
4161099	T604M040X070R6H-D1 KSH26	M73
4161100	T604M050X080R6H-D1 KSH26	M73
4161101	T604M060X100R6H-D1 KSH26	M73
4161102	T604M080X125R6H-D1 KSH26	M73
4161343	T604M100X150R6H-D1 KSH26	M73
4161344	T604M120X175R6H-D6 KSH26	M73
4161345	T604M140X200R6H-D6 KSH26	M73
4161346	T604M160X200R6H-D6 KSH26	M73
4161347	T604M180X250R6H-D6 KSH26	M73
4161348	T604M200X250R6H-D6 KSH26	M73
4161349	T604MF080X100R6H-D4 KSH26	M73
4161350	T604MF100X100R6H-D4 KSH26	M73
4161351	T604MF100X125R6H-D4 KSH26	M73
4161352	T604MF120X125R6H-D4 KSH26	M73
4161353	T604MF120X150R6H-D4 KSH26	M73
4161354	T604MF140X150R6H-D4 KSH26	M73
4161355	T604MF160X150R6H-D4 KSH26	M73
4164987	RIQ09E1300 KC6005	K58
4165042	NGD3M350LK KCU25	C165
4167881	CV40FBHM1691	K134
4167882	CV40FBHMKIT645	K127, K131
4168063	EBM1580160162	K136
4168669	A4G0300M03P04S02025ST KB1630	C111
4168670	A4G0400M04P04S02025ST KB1630	C111
4168753	A4G0300M03P04EST KB1630	C111
4168755	A4G0500M05P08EST KB1630	C111
4168756	A4G0600M06P08EST KB1630	C111
4168757	A4R0300M03P00EST KB1630	B355, C112
4168758	A4R0400M04P00EST KB1630	B355, C112
4168759	A4R0500M05P00EST KB1630	B355, C112
4168760	A4R0600M06P00EST KB1630	B355, C112
4168856	A4SCR080214	C127
4168857	A4SCR100217	C127
4168858	A4SCR080314	C127
4168859	A4SCR100317	C127
4168860	A4SCL080214	C127
4168861	A4SCL100217	C127
4168862	A4SCL080314	C127
4168883	A4SCL100317	C127
4168928	A4G0300M03P04S02025ST KB5625	C111
4168929	A4G0400M04P04S02025ST KB5625	C111
4168930	A4G0500M05P08S02025ST KB5625	C111
4168931	A4G0600M06P08S02025ST KB5625	C111
4168932	NG3M200LS02020ST KB5625	C177
4168945	NG3M200RS02020ST KB5625	C177
4168946	NG3M300RS02020ST KB5625	C177
4168947	NG3M400RS02020ST KB5625	C177
4168948	NG3125RS0820ST KB5625	C177
4169239	B269A03175HP KCPK15	G62
4169240	B269A03264HP KCPK15	G62
4169241	B269A03500HP KCPK15	G62
4169242	B269A03970HP KCPK15	G62
4169243	B269A04000HP KCPK15	G62
4169244	B269A04500HP KCPK15	G62
4169245	B269A04600HP KCPK15	G62
4169246	B269A04763HP KCPK15	G62
4169247	B269A04800HP KCPK15	G62
4169248	B269A05000HP KCPK15	G62
4169249	B269A05100HP KCPK15	G62
4169250	B269A05200HP KCPK15	G62
4169251	B269A05300HP KCPK15	G62
4169252	B269A05410HP KCPK15	G62
4169253	B269A05500HP KCPK15	G62
4169254	B269A05558HP KCPK15	G62
4169255	B269A05600HP KCPK15	G62
4169256	B269A05700HP KCPK15	G62
4169257	B269A05800HP KCPK15	G62
4169258	B269A06000HP KCPK15	G62
4169259	B269A06200HP KCPK15	G63
4169260	B269A06350HP KCPK15	G63
4169261	B269A06500HP KCPK15	G63
4169262	B269A06528HP KCPK15	G63
4169263	B269A06600HP KCPK15	G63
4169264	B269A06746HP KCPK15	G63
4169265	B269A06800HP KCPK15	G63
4169266	B269A06909HP KCPK15	G63
4169267	B269A07000HP KCPK15	G63
4169268	B269A07145HP KCPK15	G63
4169269	B269A07500HP KCPK15	G63
4169270	B269A07541HP KCPK15	G63
4169271	B269A07700HP KCPK15	G63
4169272	B269A07800HP KCPK15	G63
4169273	B269A07938HP KCPK15	G63
4169274	B269A08000HP KCPK15	G63
4169275	B269A08100HP KCPK15	G63
4169276	B269A08334HP KCPK15	G63
4169277	B269A08433HP KCPK15	G63
4169278	B269A08700HP KCPK15	G63
4169279	B269A08733HP KCPK15	G63
4169280	B269A09000HP KCPK15	G63
4169281	B269A09100HP KCPK15	G63
4169282	B269A09129HP KCPK15	G63
4169283	B269A09500HP KCPK15	G63
4169284	B269A09525HP KCPK15	G63
4169285	B269A09921HP KCPK15	G63
4169286	B269A10000HP KCPK15	G63
4169287	B269A10200HP KCPK15	G63
4169288	B269A10300HP KCPK15	G63
4169289	B269A10320HP KCPK15	G63
4169290	B269A10500HP KCPK15	G63
4169291	B269A10716HP KCPK15	G63
4169292	B269A10800HP KCPK15	G63
4169293	B269A11000HP KCPK15	G63
4169294	B269A11113HP KCPK15	G63
4169295	B269A11500HP KCPK15	G63
4169296	B269A11800HP KCPK15	G63
4169297	B269A12000HP KCPK15	G63
4169298	B269A12100HP KCPK15	G63
4169299	B269A12304HP KCPK15	G63
4169300	B269A12700HP KCPK15	G63
4169301	B269A13000HP KCPK15	G64
4169302	B269A13100HP KCPK15	G64
4169303	B269A13500HP KCPK15	G64
4169304	B269A14100HP KCPK15	G64
4169305	B269A14288HP KCPK15	G64
4169306	B269A14500HP KCPK15	G64
4169307	B269A14684HP KCPK15	G64
4169308	B269A15000HP KCPK15	G64
4169309	B269A15500HP KCPK15	G64
4169310	B269A15875HP KCPK15	G64
4169311	B269A16000HP KCPK15	G64
4169312	B269A16500HP KCPK15	G64
4169313	B269A17000HP KCPK15	G64
4169314	B269A17463HP KCPK15	G64
4169315	B269A17500HP KCPK15	G64
4169316	B269A18000HP KCPK15	G64
4169317	B269A18500HP KCPK15	G64
4169318	B269A19000HP KCPK15	G64
4169319	B269A19050HP KCPK15	G64
4169320	B269A19500HP KCPK15	G64
4169321	B269A20000HP KCPK15	G64
4169337	NG3M200RS02020ST KB1630	C177
4169338	NG3M300RS02020ST KB1630	C177
4169341	NG3125RS0820ST KB1630	C177
4169343	NG3125LS0820ST KB1630	C177
4169351	UEDE0078J3AS KC643M	P166
4169352	UEDE0094J3AS KC643M	P166
4169513	UEDE0125J3AS KC643M	P166
4169514	UEDE0156J3AS KC643M	P166
4169515	UEDE0188J3AS KC643M	P166
4169516	UEDE0250J3AS KC643M	P166
4169517	UEDE0312J3AS KC643M	P166
4169518	UEDE0375J3AS KC643M	P166
4169519	UEDE0437J3AS KC643M	P166
4169520	UEDE0500J3AS KC643M	P166
4169660	UEBD0078J3A KC643M	P169
4169661	UEBD0094J3A KC643M	P169
4169662	UEBD0125J3A KC643M	P169
4169745	A4SCR1212K0214	C128
4169746	A4SCR1616K0217	C128
4169747	A4SCR1212K0314	C128
4169748	A4SCR1616K0317	C128
4169749	A4SCL1212K0214	C128
4169750	A4SCL1616K0217	C128
4169752	A4SCL1616K0317	C128
4169805	UEDE0156J4AH KC643M	P167
4169806	UEDE0188J4AH KC643M	P167
4169807	UEDE0250J4AH KC643M	P167
4169808	UEDE0312J4AH KC643M	P167
4169809	UEDE0375J4AH KC643M	P167
4169810	UEDE0437J4AH KC643M	P167
4169811	UEDE0500J4AH KC643M	P167
4169833	UEBD0156J3A KC643M	P169
4169834	UEBD0188J3A KC643M	P169
4169835	UEBD0250J3A KC643M	P169
4169836	UEBD0312J3A KC643M	P169
4169837	UEBD0375J3A KC643M	P169
4169838	UEBD0437J3A KC643M	P169
4169839	UEBD0500J3A KC643M	P169
4170385	CM209R ASSY	B58–60, B67–68, B87
4170386	CM210R ASSY	B58–60, B68, B98, B109–110
4170388	CM235R ASSY	B150–151
4170389	CM234RLP ASSY	B67–68, B92, B138
4170408	KSCMCA90QF KD1420	S110
4170410	KSCMCA90UNBF KD1420	S110
4170411	KSCMCA90QFBF KD1420	S110
4171227	LNUX301940RRF KCP10	E57
4171768	RCGT0803M0MS KCU10	B239
4171769	RCGT1204M0MS KCU10	B239
4171770	RCGT1606M0MS KCU10	B239
4171823	CNMG4305FN KCU10	B49
4171824	CNMG431FP KCU10	B49
4171825	DNMG331FF KCU10	B79
4171826	DNMG331FP KCU10	B80
4171827	DNMG431FP KCU10	B80
4171828	DNMG432FP KCU10	B80
4171829	DNMG433FP KCU10	B80
4171830	DNMG441FP KCU10	B80
4171831	DNMG442FP KCU10	B80
4171833	SNMG321FF KCU10	B101
4171835	SNMG431FP KCU10	B101
4171836	SNMG432FP KCU10	B101
4171837	TNMG221FF KCU10	B123
4171838	TNMG331FP KCU10	B123
4171839	TNMG332FP KCU10	B123
4171840	TNMG333FP KCU10	B123
4171841	TNMG431FP KCU10	B123
4171842	TNMG432FP KCU10	B123
4171843	VNMG331FP KCU10	B146
4171844	VNMG332FP KCU10	B146
4171845	WNMG331FF KCU10	B157
4171848	WNMG431FF KCU10	B157
4171849	WNMG431FP KCU10	B158
4171851	WNMG432FP KCU10	B158
4171853	NPL13M05N KCU10	E35
4171854	NPL13M10N KCU10	E35
4171855	NPL5M02 KCU10	E36
4171856	NPL5M05 KCU10	E36
4171857	NPR13M05F KCU10	E35
4171858	NPR13M10N KCU10	E35
4171860	NPR5M05 KCU10	E36
4173826	UEBD0078J2A KC643M	P168
4173827	UEBD0094J2A KC643M	P168
4173828	UEBD0125J2A KC643M	P168
4173829	UEBD0156J2A KC643M	P168
4173830	UEBD0188J2A KC643M	P168
4173831	UEBD0250J2A KC643M	P168
4173832	UEBD0312J2A KC643M	P168
4173913	UEBD0375J2A KC643M	P168
4173914	UEBD0437J2A KC643M	P168
4173915	UEBD0500J2A KC643M	P168
4174419	S459CG	T90, V70
4175270	B731A04200HP KCPK15	G118
4175271	B731A05000HP KCPK15	G118
4175272	B731A06800HP KCPK15	G118
4175403	B731A08500HP KCPK15	G118
4175404	B731A10200HP KCPK15	G118
4175405	B731A10500HP KCPK15	G118
4175406	B731A12000HP KCPK15	G118
4175407	B731A12500HP KCPK15	G118
4175408	B731A14000HP KCPK15	G118
4175409	B732A04200HP KCPK15	G119
4175410	B732A05000HP KCPK15	G119
4175411	B732A06800HP KCPK15	G119
4175412	B732A08500HP KCPK15	G119
4175413	B732A10200HP KCPK15	G119
4175414	B732A10500HP KCPK15	G119
4175415	B732A12000HP KCPK15	G119
4175416	B732A12500HP KCPK15	G119
4175417	B732A14000HP KCPK15	G119
4175418	B731A03734HP KCPK15	G118
4175419	B731A04496HP KCPK15	G118
4175420	B731A05106HP KCPK15	G118
4175421	B731A05410HP KCPK15	G118
4175422	B731A06528HP KCPK15	G118
4175423	B731A06909HP KCPK15	G118
4175424	B731A07938HP KCPK15	G118
4175425	B731A08433HP KCPK15	G118
4175426	B731A09921HP KCPK15	G118
4175427	B731A10716HP KCPK15	G118
4175428	B731A12304HP KCPK15	G118
4175429	B731A13096HP KCPK15	G118
4175430	B731A13495HP KCPK15	G118
4175431	B731A16670HP KCPK15	G118
4175432	B731A17463HP KCPK15	G118
4175433	B731A19446HP KCPK15	G118
4175434	B732A03734HP KCPK15	G119
4175435	B732A04496HP KCPK15	G119
4175436	B732A05106HP KCPK15	G119
4175437	B732A05410HP KCPK15	G119
4175438	B732A06528HP KCPK15	G119
4175439	B732A06909HP KCPK15	G119
4175440	B732A07938HP KCPK15	G119
4175441	B732A08433HP KCPK15	G119
4175442	B732A09921HP KCPK15	G119
4175443	B732A10716HP KCPK15	G119
4175445	B732A13096HP KCPK15	G119
4175446	B732A13495HP KCPK15	G119
4175447	B732A16670HP KCPK15	G119
4175448	B732A17463HP KCPK15	G119
4175834	NGD3125RK KCU10	C165
4175835	NGD3189L KCU10	C171
4175836	NGD3189LK KCU10	C165
4175837	NGD3189R KCU10	C171
4175838	NGD3189RK KCU10	C165
4175839	NGD3M200RK KCU10	C165
4175840	NGP3088L KCU10	C168
4175841	NGP3088R KCU10	C168
4175843	NG2031L KCU10	C170
4175844	NG2031LK KCU10	C163
4175845	NG2031R KCU10	C170
4175846	NG2031RK KCU10	C162
4175847	NG2041R KCU10	C170
4175848	NG2047L KCU10	C170
4175849	NG2047LK KCU10	C163
4175850	NG2047R KCU10	C170
4175851	NG2047RK KCU10	C162
4175852	NG2062L KCU10	C170
4175853	NG2062LK KCU10	C163
4175854	NG2062R KCU10	C170
4175855	NG2062RK KCU10	C162
4175856	NG2094L KCU10	C170
4175857	NG2094LK KCU10	C163
4175858	NG2094R KCU10	C170
4175859	NG2094RK KCU10	C162
4175860	NG2125L KCU10	C170
4175861	NG2125LK KCU10	C163
4175862	NG2125R KCU10	C170
4175863	NG2125RK KCU10	C162
4175864	NG2M080LK KCU10	C163
4175865	NG2M080RK KCU10	C162
4175866	NG2M100LK KCU10	C163
4175867	NG2M100RK KCU10	C162
4175868	NG2M120LK KCU10	C163
4175869	NG2M120RK KCU10	C162
4175870	NG2M140LK KCU10	C163
4175871	NG2M140RK KCU10	C162
4175873	NG2M170RK KCU10	C162
4175875	NG2M195RK KCU10	C162
4175876	NG2M200LK KCU10	C163
4175877	NG2M200RK KCU10	C162
4175878	NG2M225LK KCU10	C163
4175879	NG2M225RK KCU10	C162
4175880	NG2M275RK KCU10	C162

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
4175881	NG2M300LK KCU10	C163
4175882	NG2M300RK KCU10	C162
4175883	NGP3125R KCU10	C168
4175884	NGP3156R KCU10	C168
4175886	NJ3014R12 KCU10	D15
4175888	NJF3005R32 KCU10	D15
4175893	NGP2031L KCU10	C168
4175894	NGP2031R KCU10	C168
4175895	NGP2062L KCU10	C168
4175896	NGP2062R KCU10	C168
4175897	NGP2125L KCU10	C168
4175898	NGP2125R KCU10	C168
4175899	NP2002RK KCU10	C167
4175901	NR2031L KCU10	C172
4175902	NR2031R KCU10	C172
4175903	NR2062L KCU10	C172
4175904	NR2062R KCU10	C172
4175905	NR2M050L KCU10	C172
4175906	NR2M050R KCU10	C172
4175907	NR2M075R KCU10	C172
4175908	NR2M100R KCU10	C172
4175909	NT2L KCU10	D17
4175910	NT2LK KCU10	D22
4175911	NT2R KCU10	D17
4175912	NT2RK KCU10	D22
4175928	NJK3008R20 KCU10	D16
4175932	NJP3010R16 KCU10	D16
4175933	NTF2L KCU10	D21
4175934	NTF2R KCU10	D21
4175935	NTK2L KCU10	D21
4175936	NTK2R KCU10	D21
4175937	NTP2L KCU10	D22
4175938	NTP2R KCU10	D22
4175944	NJP3014R12 KCU10	D16
4175946	NP3002RK KCU10	C167
4175947	NPD3012RK KCU10	C167
4175948	NR3031L KCU10	C172
4175949	NR3031LK KCU10	C166
4175950	NR3031R KCU10	C172
4175951	NR3031RK KCU10	C166
4175952	NR3047L KCU10	C172
4175953	NR3047LK KCU10	C166
4175954	NR3047R KCU10	C172
4175955	NR3047RK KCU10	C166
4175956	NR3062L KCU10	C172
4175957	NR3062LK KCU10	C166
4175958	NR3062R KCU10	C172
4175959	NR3062RK KCU10	C166
4175961	NR3078RK KCU10	C166
4175963	NR3094R KCU10	C172
4175964	NR3M150L KCU10	C172
4175965	NRD3031L KCU10	C173
4175966	NRD3031R KCU10	C173
4175967	NRD3062L KCU10	C173
4175968	NRD3062R KCU10	C173
4175969	NRP3031L KCU10	C169
4175970	NRP3031R KCU10	C169
4175971	NRP3047L KCU10	C169
4175972	NRP3047R KCU10	C169
4175975	NRP3062R KCU10	C169
4175976	NRP3094L KCU10	C169
4175977	NRP3094R KCU10	C169
4175978	NT3L KCU10	D17
4175979	NT3LCK KCU10	D19
4175980	NT3LK KCU10	D22
4175981	NT3R KCU10	D17
4175982	NT3RCK KCU10	D19
4175983	NT3RK KCU10	D22
4175984	NTF3L KCU10	D21
4175985	NTF3R KCU10	D21
4175986	NTK3L KCU10	D21
4175987	NTK3R KCU10	D21
4175988	NTP3L KCU10	D22
4175989	NTP3R KCU10	D22
4176009	NG4125L KCU10	C171
4176010	NG4125LK KCU10	C164
4176011	NG4125R KCU10	C170
4176012	NG4125RK KCU10	C163
4176015	NA3L4 KCU10	D11
4176018	NA3L8 KCU10	D11
4176019	NA3R10 KCU10	D11
4176020	NA3R12 KCU10	D11
4176021	NA3R16 KCU10	D11
4176023	NA3R5 KCU10	D11
4176024	NA3R6 KCU10	D11
4176025	NA3R8 KCU10	D11
4176026	NAS3L10 KCU10	D12
4176027	NAS3L5 KCU10	D12
4176028	NAS3L6 KCU10	D12
4176029	NAS3L8 KCU10	D12
4176030	NAS3R10 KCU10	D12
4176031	NAS3R5 KCU10	D12
4176032	NAS3R6 KCU10	D12
4176033	NAS3R8 KCU10	D12
4176034	NG3047L KCU10	C170
4176035	NG3047LK KCU10	C163
4176036	NG3047R KCU10	C170
4176037	NG3047RK KCU10	C162
4176038	NG3062L KCU10	C170
4176039	NG3062LK KCU10	C163
4176040	NG3062R KCU10	C170
4176041	NG3062RK KCU10	C162
4176042	NG3072L KCU10	C170
4176043	NG3072LK KCU10	C163
4176044	NG3072R KCU10	C170
4176045	NG3072RK KCU10	C162
4176046	NG3078L KCU10	C170
4176047	NG3078LK KCU10	C163
4176048	NG3078R KCU10	C170
4176049	NG3078RK KCU10	C162
4176050	NG3088L KCU10	C170
4176051	NG3088R KCU10	C170
4176052	NG3094L KCU10	C170
4176053	NG3094LK KCU10	C164
4176054	NG3094R KCU10	C170
4176055	NG3094RK KCU10	C162
4176056	NG3097L KCU10	C171
4176057	NG3097R KCU10	C170
4176058	NG3105L KCU10	C171
4176059	NG3105R KCU10	C170
4176060	NG3125L KCU10	C171
4176061	NG3125LK KCU10	C164
4176062	NG3125R KCU10	C170
4176063	NG3125RK KCU10	C162
4176064	NG3142L KCU10	C171
4176065	NG3156LK KCU10	C164
4176066	NG3156R KCU10	C170
4176067	NG3156RK KCU10	C162
4176068	NG3189L KCU10	C171
4176069	NG3189LK KCU10	C164
4176070	NG3189R KCU10	C170
4176071	NG3189RK KCU10	C163
4176072	NG3M120LK KCU10	C163
4176073	NG4189L KCU10	C171
4176074	NG4189LK KCU10	C164
4176075	NG4189R KCU10	C170
4176076	NG4189RK KCU10	C163
4176077	NG4250L KCU10	C171
4176078	NG4250LK KCU10	C164
4176079	NG4250R KCU10	C170
4176081	NG4M400LK KCU10	C164
4176083	NG4M500LK KCU10	C164
4176084	NG4M500RK KCU10	C163
4176085	NGD4125LK KCU10	C165
4176086	NGD4125RK KCU10	C165
4176087	NGD4189LK KCU10	C165
4176088	NGD4189RK KCU10	C165
4176089	NGD4250L KCU10	C171
4176090	NGD4250LK KCU10	C165
4176091	NGD4250R KCU10	C171
4176092	NGD4250RK KCU10	C165
4176093	NG3M120RK KCU10	C162
4176094	NG3M225LK KCU10	C164
4176095	NG3M225RK KCU10	C162
4176096	NG3M275LK KCU10	C164
4176097	NG3M275RK KCU10	C162
4176098	NG3M300LK KCU10	C164
4176099	NG3M300RK KCU10	C162
4176100	NG3M400LK KCU10	C164
4176101	NG3M400RK KCU10	C162
4176102	NG3M425LK KCU10	C164
4176104	NGP4189R KCU10	C168
4176105	NGP4250L KCU10	C168
4176107	NR4062LK KCU10	C166
4176108	NR4062RK KCU10	C166
4176109	NR4094LK KCU10	C166
4176110	NR4094RK KCU10	C166
4176112	NR4125LK KCU10	C166
4176113	NR4125R KCU10	C172
4176114	NR4125RK KCU10	C166
4176115	NRD4062L KCU10	C173
4176116	NRD4062R KCU10	C173
4176117	NRD4094L KCU10	C173
4176118	NRD4094R KCU10	C173
4176119	NRD4125L KCU10	C173
4176121	NT4L KCU10	D17
4176122	NT4LK KCU10	D22
4176123	NG3M425RK KCU10	C163
4176124	NGD3062LK KCU10	C165
4176125	NGD3062RK KCU10	C165
4176126	NGD3094LK KCU10	C165
4176127	NGD3094RK KCU10	C165
4176128	NGD3125LK KCU10	C165
4176133	NT4R KCU10	D17
4176135	NT4RK KCU10	D22
4176137	NTP4R KCU10	D22
4176138	NA4L4 KCU10	D11
4176141	NA6R2 KCU10	D11
4176164	NDC3115VL75 KCU10	D14
4176165	NDC3115VR75 KCU10	D14
4176166	NDC314VR75 KCU10	D14
4176167	NDC327VR75 KCU10	D14
4176177	NDC68RDR75M KCU10	D13
4176178	NDC8115VR75M KCU10	D14
4176180	NDC88VR75M KCU10	D14
4176181	NT1L KCU10	D23
4176182	NTB2LB KCU10	D18
4176186	NTB3LB KCU10	D18
4176187	NTB3RA KCU10	D17
4176188	NTB3RB KCU10	D18
4176190	NTB4RA KCU10	D17
4176191	NTB4RB KCU10	D18
4176192	NTC3L10E KCU10	D20
4176193	NTC3L12E KCU10	D20
4176194	NTC3L16E KCU10	D20
4176195	NTC3MR150E KCU10	D19
4176198	NTC3R11E KCU10	D20
4176204	NTC3R20E KCU10	D20
4176206	NTC3R32E KCU10	D20
4176207	NTC3R8E KCU10	D20
4176208	NTC3R9E KCU10	D20
4177167	KDMB025R394A038HN	V123
4177169	KDMB0312R591A038HN	V123
4177170	KDMB025R394A025HN	V123
4177171	KDMB025R591A025HN	V123
4177172	KDMB025R788A025HN	V123
4177578	KDMT0750SRHF KC515M	V135
4177597	VBMT333LF KCP25	B281
4177635	KDMB0250M0ERGP KC515M	V126
4177637	KDMB0375M0ERGP KC515M	V126
4177638	KDMB0500M0ERGP KC515M	V126
4177639	KDMB0625M0ERGP KC515M	V126
4177640	KDMB0750M0ERGP KC515M	V126
4177641	KDMB1000M0ERGP KC515M	V126
4177642	KDMB1250M0ERGP KC515M	V126
4177643	KDMB0312M0ERGP KC505M	V126
4177644	KDMB0375M0ERGP KC505M	V126
4177645	KDMB0500M0ERGP KC505M	V126
4177646	KDMB0625M0ERGP KC505M	V126
4177647	KDMB0750M0ERGP KC505M	V126
4177648	KDMB1000M0ERGP KC505M	V126
4177649	KDMB1250M0ERGP KC505M	V126
4177650	KDMB0250M0ERLD K115M	V126
4177651	KDMB0312M0ERLD K115M	V126
4177652	KDMB0375M0ERLD K115M	V126
4177653	KDMB0500M0ERLD K115M	V126
4177654	KDMB0625M0ERLD K115M	V126
4177655	KDMB0750M0ERLD K115M	V126
4177656	KDMB1000M0ERLD K115M	V126
4177657	KDMB1250M0ERLD K115M	V126
4177658	KDMB0500M0ERHC KC530M	V126
4177659	KDMB0625M0ERHC KC530M	V126
4177660	KDMB0750M0ERHC KC530M	V126
4177661	KDMB1000M0ERHC KC530M	V126
4178116	KDR150R1204M16L150	V51
4178119	KDR125R1202W100L200	V52
4178120	KDR125R1202C125L900	V53
4178122	KDR150R1204S050L157	V54
4178123	KDR200R1204S075L200	V54
4178124	KDR200R1205S075L200	V54
4178125	KDR250R1207S075L200	V54
4178126	KDR300R1208S100L200	V54
4181068	RIQ09R0400S KB1610	K57
5000493	B707A12600FBG KC7315	G111
5001994	A4R0405M04U00GMN KCP25	C107
5004291	RIQ09R0400FB KT6225	K58
5006833	B978A03800 KC7315	G139
5015690	193.545	H126–129
5023558	B269A03700HP KCPK15	G62
5025597	SF300M1LA1RA	K68
5025598	SF750M1LA1RA	K68
5025599	SF300M1RS	K68
5025670	SF750M1RS	K68
5025671	SFSLRS	K69
5025672	SFSLLS	K69
5025673	SFSLRA	K69
5025674	SFSLLA	K69
5025675	SFMGS	K71
5025676	SFCR20	K71
5025677	SFCRHSK3263	K71
5025678	SFCRHSK63100	K71
5025679	SFCR20S	K71
5025680	SFVB	K69
5025681	SFEBS	K70
5025682	SFEBCH	K70
5025683	SFSLSS	K69
5025684	SFSB450	K70
5025685	SFSB900	K70
5025686	SFCPS	K70
5030114	UJDE0625J6CRB KCSM15	P44
5039055	B269A04300HP KCPK15	G62
5048735	CNMU443MN KCP10	B51
5051283	HPFT500S6063 KC635M	P110
5051285	HPFT250S6038 KC635M	P110
5051327	HPFT750S6300 KC635M	P110
5051382	HPFT750S6400 KC635M	P110
5051389	HPFT1000S6400 KC635M	P110
5051852	AADE0750J3K K600	P130
5051853	AADE1000J3I K600	P130
5051854	AADE1000J3K K600	P130
5051855	AADE0500J3K K600	P129
5051857	AADE0625J3H K600	P130
5051858	AADE0500J3L K600	P129
5051941	AADE0312J3D K600	P128
5051942	AADE0438J3A K600	P129
5051946	AADE0312J3DRB K600	P128
5051949	AADE0375J3KRB K600	P129
5052000	AADE0375J3KRC K600	P129
5052001	AADE0500J3KRB K600	P129
5052002	AADE0500J3KRC K600	P129
5052003	AADE0500J3LRB K600	P129
5052004	AADE0500J3LRC K600	P129
5052007	AADE0625J3HRC K600	P130
5052008	AADE0750J3ARB K600	P130
5052040	AADE0750J3ARC K600	P130
5053664	HPHV750S4225 KCPM15	P19
5057900	B976A10600 KC7315	G137
5058500	KSEM2653HPGM KC7315	H55
5058542	AADF500J2B K600	P127
5058612	AADF500J2F K600	P127
5058615	AADF375J2G K600	P126
5058618	AADF250J2I K600	P126
5058633	AADF375J2H K600	P126
5059163	AADE750J3J K600	P130
5059165	AADE750J3K K600	P130
5059167	AADE500J3H K600	P129
5059202	AADE438J3A K600	P129
5059203	AADE375J3I K600	P129
5059206	AADE250J3H K600	P128
5059209	AADE188J3F K600	P128
5059213	AADE125J3F K600	P128
5059215	AADE625J3I K600	P129
5059218	AADE125J3G K600	P128
5059219	AADE250J3B K600	P128
5059278	B978A03400 KC7315	G139
5059453	UGDE0250J5AE KC643M	P38
5059455	UGDE0250J5ARA KC643M	P38
5059457	UGDE0250J5ARB KC643M	P38

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5059458	UGDE0250J5BE KC643M	P39
5059459	UGDE0250J5BRA KC643M	P39
5059580	UGDE0250J5BRB KC643M	P39
5059582	UGDE0312J5AE KC643M	P38
5059583	UGDE0312J5ARA KC643M	P38
5059584	UGDE0312J5ARB KC643M	P38
5059585	UGDE0312J5BE KC643M	P39
5059589	UGDE0312J5BRA KC643M	P39
5059620	UGDE0312J5BRB KC643M	P39
5059622	UGDE0375J5AE KC643M	P38
5059623	UGDE0375J5ARA KC643M	P38
5059624	UGDE0375J5ARB KC643M	P38
5059625	UGDE0375J5ARC KC643M	P38
5059626	UGDE0375J5BE KC643M	P39
5059627	UGDE0375J5BRA KC643M	P39
5059628	UGDE0375J5BRB KC643M	P39
5059629	UGDE0375J5BRC KC643M	P39
5059670	UGDE0500J5AE KC643M	P38
5059671	UGDE0500J5ARA KC643M	P38
5059672	UGDE0500J5ARB KC643M	P38
5059673	UGDE0500J5ARC KC643M	P38
5059674	UGDE0500J5BE KC643M	P39
5059675	UGDE0500J5BRA KC643M	P39
5059676	UGDE0500J5BRB KC643M	P39
5059677	UGDE0500J5BRC KC643M	P39
5059678	UGDE0625J5AE KC643M	P38
5059697	UGDE0625J5ARA KC643M	P38
5059703	UGDE0625J5ARB KC643M	P38
5059704	UGDE0625J5ARC KC643M	P38
5059705	UGDE0625J5ARD KC643M	P38
5059706	UGDE0625J5BE KC643M	P39
5059707	UGDE0625J5BRA KC643M	P39
5059709	UGDE0625J5BRB KC643M	P39
5059740	UGDE0625J5BRC KC643M	P39
5059741	UGDE0625J5BRD KC643M	P39
5059742	UGDE0750J5AE KC643M	P38
5059743	UGDE0750J5ARA KC643M	P38
5059744	UGDE0750J5ARB KC643M	P38
5059745	UGDE0750J5ARC KC643M	P38
5059746	UGDE0750J5ARD KC643M	P38
5059747	UGDE0750J5BE KC643M	P39
5059748	UGDE0750J5BRA KC643M	P39
5059749	UGDE0750J5BRB KC643M	P39
5059770	UGDE0750J5BRC KC643M	P39
5059771	UGDE0750J5BRD KC643M	P39
5059795	UGDE1000J5AE KC643M	P38
5059798	UGDE1000J5ARA KC643M	P38
5059799	UGDE1000J5ARB KC643M	P38
5060120	UGDE1000J5ARC KC643M	P38
5060121	UGDE1000J5ARD KC643M	P38
5060122	UGDE1000J5BE KC643M	P39
5060123	UGDE1000J5BRA KC643M	P39
5060124	UGDE1000J5BRB KC643M	P39
5060126	UGDE1000J5BRC KC643M	P39
5060127	UGDE1000J5BRD KC643M	P39
5060206	HPFSS156S5056 KC635M	P109
5062104	SNMG322FF KCU10	B101
5062106	SNMG432MP KCU10	B102
5062108	SNMG432RP KCU10	B105
5062109	SNMG433MP KCU10	B102
5062110	SNMG433P KCU10	B104
5062111	SNMG433RP KCU10	B105
5062112	SNMG543MP KCU10	B102
5062113	SNMG543RP KCU10	B105
5062114	SNMG543UP KCU10	B106
5062115	SNMG643 KCU10	B100
5062117	SNMG643RP KCU10	B105
5062120	SNMG644RP KCU10	B105
5062121	SNMG866 KCU10	B100
5062122	SNMG866RM KCU10	B104
5062123	TNGG3305LF KCU10	B121
5062126	TNGP3305 KCU10	B121
5062127	TNGP331 KCU10	B121
5062128	TNGP332 KCU10	B121
5062129	TNMG331FF KCU10	B123
5062130	TNMG331FW KCU10	B124
5062131	TNMG331MP KCU10	B124
5062132	TNMG331P KCU10	B126
5062133	TNMG332FF KCU10	B123
5062135	TNMG332MP KCU10	B124
5062136	TNMG332P KCU10	B126
5062137	TNMG332RP KCU10	B127
5062139	TNMG431P KCU10	B126
5062140	TNMG432MP KCU10	B124
5062141	TNMG432P KCU10	B126
5062142	TNMG432RP KCU10	B127
5062144	TNMG433P KCU10	B126
5062145	TNMG433RP KCU10	B127
5062147	TNMG543RP KCU10	B127
5062148	TNMG666RP KCU10	B127
5062149	CNMG643MS KCU25	B52
5063675	RPET1204M0ELEJ KC522M	V71
5063676	RPET1204M0ELEJ KC725M	V71
5063677	RPET1204M0SGEJ KC522M	V71
5063678	RPET1204M0SGEJ KC725M	V71
5063701	RPET1605M0ELEJ KC725M	V78
5063702	RPET1605M0SGEJ KC522M	V78
5063704	RPET1605M0SGEJ KC725M	V78
5065400	KTIP1338HPM KCP15	H33
5065401	KTIP1538HPM KCP15	H33
5065552	DFR020204LD KCU40	J97
5065554	DFR020204GD KCU40	J97
5065556	DFR020204MD KCU40	J97
5065557	DFR030204LD KCU40	J97
5065558	DFR030204GD KCU40	J97
5065559	DFR030204MD KCU40	J97
5065660	DFR040304LD KCU40	J97
5065661	DFR040304GD KCU40	J97
5065662	DFR040304MD KCU40	J97
5065663	DFT030204HP KCU40	J101
5065664	DFT030204MD KCU40	J101
5065665	DFT030204GD KCU40	J101
5065666	DFT030304HP KCU40	J101
5065667	DFT030304MD KCU40	J101
5065916	DFT030304GD KCU40	J101
5066013	DFT05T308HP KCU40	J101
5066014	DFT05T308MD KCU40	J101
5066015	DFT05T308GD KCU40	J101
5066016	DFT06T308HP KCU40	J101
5066019	DFT06T308MD KCU40	J101
5066064	DFT06T308GD KCU40	J101
5066146	DFT070408HP KCU40	J101
5066147	DFT070408MD KCU40	J101
5066148	DFT070408GD KCU40	J101
5066149	DFT090508HP KCU40	J101
5066190	DFT090508MD KCU40	J101
5066191	DFT090508GD KCU40	J101
5066192	DFR040304D28GD KCU40	H113
5066193	DFT05T308D32HP KCU40	H112
5066195	DFT05T308D33HP KCU40	H112
5066196	DFT06T308D36HP KCU40	H112
5066197	DFT06T308D39HP KCU40	H112
5066198	DFT06T308D44HP KCU40	H112
5066199	DFT070408D45HP KCU40	H112
5066220	DFT070408D50HP KCU40	H112
5066221	DFT090508D56HP KCU40	H112
5066222	DFT090508D63HP KCU40	H112
5066798	DFR020204GD KCU25	J97
5066799	DFR020204MD KCU25	J97
5067312	DFR030204GD KCU25	J97
5067313	DFR030204MD KCU25	J97
5067314	DFR040304GD KCU25	J97
5067316	DFR040304MD KCU25	J97
5067318	DFT030204HP KCU25	J101
5067319	DFT030204MD KCU25	J101
5067401	DFT030204GD KCU25	J101
5067402	DFT030304HP KCU25	J101
5067403	DFT030304MD KCU25	J101
5067404	DFT030304GD KCU25	J101
5067406	DFT05T308HP KCU25	J101
5067408	DFT05T308MD KCU25	J101
5067470	DFT05T308GD KCU25	J101
5067473	DFT06T308HP KCU25	J101
5067474	DFT06T308MD KCU25	J101
5067475	DFT06T308GD KCU25	J101
5067476	DFT070408HP KCU25	J101
5067478	DFT070408MD KCU25	J101
5067479	DFT070408GD KCU25	J101
5067480	DFT090508HP KCU25	J101
5067482	DFT090508MD KCU25	J101
5067485	DFT090508GD KCU25	J101
5067486	DFR040304D28GD KCU25	H113
5067487	DFT05T308D32HP KCU25	H112
5067488	DFT05T308D33HP KCU25	H112
5067489	DFT06T308D36HP KCU25	H112
5067520	DFT06T308D39HP KCU25	H112
5067522	DFT06T308D44HP KCU25	H112
5067523	DFT070408D45HP KCU25	H112
5067524	DFT070408D50HP KCU25	H112
5067526	DFT090508D56HP KCU25	H112
5067527	DFT090508D63HP KCU25	H112
5067567	M1D250E1804S075L157AL	T78
5067568	M1D200E1803S075L157AL	T78
5068267	DFR020204GD KCPK10	J97
5068268	DFR030204GD KCPK10	J97
5068280	DFR040304GD KCPK10	J97
5068281	DFT030204HP KCPK10	J101
5068282	DFT030204GD KCPK10	J101
5068283	DFT030304HP KCPK10	J101
5068284	DFT030304GD KCPK10	J101
5068285	DFT05T308HP KCPK10	J101
5068286	DFT05T308GD KCPK10	J101
5068288	DFT06T308HP KCPK10	J101
5068289	DFT06T308GD KCPK10	J101
5068321	DFT070408HP KCPK10	J101
5068323	DFT070408GD KCPK10	J101
5068325	DFT090508HP KCPK10	J101
5068326	DFT090508GD KCPK10	J101
5069150	A4G0405M04U04GMP KCP25	C105
5069154	A4G0605M06U04GMP KCP25	C105
5069158	A4G0605M06U12GMN KCP25	C106
5069159	A4G1005M10U08GMN KCP25	C106
5069160	A4G1005M10U12GMN KCP25	C106
5069161	A4R0305M03U00GMN KCP25	C107
5069162	A4R0505M05U00GMN KCP25	C107
5069163	A4R0605M06U00GMN KCP25	C107
5069164	A4R0805M08U00GMN KCP25	C107
5069354	A4G0405M04U04GMP KCP10	C105
5069359	A4G0505M05U04GMP KCP10	C105
5069390	A4G0505M05U08GMP KCP10	C105
5069394	A4G0205M02U02GMN KCP10	C106
5069430	A4G0305M03U02GMN KCP10	C106
5069431	A4G0305M03U04GMN KCP10	C106
5069432	A4G0605M06U04GMN KCP10	C106
5069433	A4G0805M08U08GMN KCP10	C106
5069435	A4G0805M08U12GMN KCP10	C106
5069437	A4G1005M10U08GMN KCP10	C106
5069439	A4R0205M02U00GMN KCP10	C107
5069470	A4R0305M03U00GMN KCP10	C107
5069471	A4R0805M08U00GMN KCP10	C107
5077334	B269A03300HP KCPK15	G62
5077336	B269A04200HP KCPK15	G62
5077337	B269A08200HP KCPK15	G63
5078982	NGD2M200LK KCU10	C165
5080992	SPGX060304MD KCPK10	J103
5085676	UJDE0500J6ARB KCSM15	P44
5090284	RPG2150E KYS30	B352, V157
5090285	RPG32T0420 KYS30	B352, V157
5090286	RPG43E KYS30	B352, V157
5090287	RPG43T0420 KYS30	B352, V157
5090494	CNMG4305MS KCU10	B52
5090495	CNMG430MS KCU10	B52
5090496	CNMG431MS KCU10	B52
5090497	CNMG432MS KCU10	B52
5090498	CNMG433MS KCU10	B52
5090499	CNMG434MS KCU10	B52
5090680	CNMG542MS KCU10	B52
5090681	CNMG543MS KCU10	B52
5090682	CNMG642MS KCU10	B52
5090684	CNMG644MS KCU10	B52
5090685	DNMG332MS KCU10	B82
5090686	DNMG4305MS KCU10	B82
5090687	DNMG430MS KCU10	B82
5090688	DNMG431MS KCU10	B82
5090689	DNMG432MS KCU10	B82
5090740	DNMG433MS KCU10	B82
5090741	DNMG441MS KCU10	B82
5090742	DNMG442MS KCU10	B82
5090743	DNMG443MS KCU10	B82
5090744	RCGH43 KCU10	B238
5090760	SNMG432MS KCU10	B103
5090761	SNMG433MS KCU10	B103
5090763	SNMG434RP KCU10	B105
5090764	TNGG331FS KCU10	B121
5090765	TNGG432FS KCU10	B121
5090767	TNMG3305MS KCU10	B125
5090768	TNMG331MS KCU10	B125
5090769	TNMG332MS KCU10	B125
5090810	TNMG431MS KCU10	B125
5090811	TNMG432MS KCU10	B125
5090812	TNMG433MS KCU10	B125
5090815	VNGG3305FS KCU10	B144
5090816	VNGG330FS KCU10	B144
5090817	VNGG331FS KCU10	B144
5090819	VNGG332FS KCU10	B144
5090851	VNMG3305MS KCU10	B147
5090852	VNMG330MS KCU10	B147
5090853	VNMG331MS KCU10	B147
5090854	VNMG332MS KCU10	B147
5090855	VNMG431MS KCU10	B147
5090856	VNMG432MS KCU10	B147
5090857	VNMG333RP KCU10	B148
5090858	WNGG431FS KCU10	B156
5090859	WNGG432FS KCU10	B156
5090890	WNMG332MS KCU10	B160
5090891	WNMG4305MS KCU10	B160
5090892	WNMG430MS KCU10	B160
5090893	WNMG431MS KCU10	B160
5090894	WNMG432MS KCU10	B160
5101798	UJDE0625J6ARA KCSM15	P44
5104314	RNGJ1204M0ENLDJX KC522M	V63
5104318	RNGJ1204M0SNGDJX KC725M	V63
5104420	KDR40Z04S16RN12X	V62
5104421	KDR50Z05S22RN12X	V62
5104424	KDR63Z06S22RN12X	V62
5104426	KDR80Z07S27RN12X	V62
5106643	UJDE0500J6ARC KCSM15	P44
5109130	A4G094I2BP05GUP KCU25	C103
5109131	A4G125I03P05GUP KCU25	C103
5109132	A4G125I03P1GUP KCU25	C103
5109133	A4G187I04P1GUP KCU25	C103
5109135	A4G250I06P1GUP KCU25	C103
5109136	A4G250I06P2GUP KCU25	C103
5109137	A4G312I08P1GUP KCU25	C103
5109138	A4G375I10P1GUP KCU25	C103
5109290	DNGG3305FS KCU10	B77
5109291	DNGG331FS KCU10	B77
5109292	DNGG332FS KCU10	B77
5109293	DNGG430FS KCU10	B77
5109294	DNGG4305FS KCU10	B77
5109295	DNGG441FS KCU10	B77
5109296	DNGG431FS KCU10	B77
5109297	DNGG442FS KCU10	B77
5109298	DNGG432FS KCU10	B77
5115736	KSEMP2800FDS28B1M	H108, H118
5115737	KSEMP1125FDS28B1	H108, H118
5115738	KSEMP2900FDS28B1M	H108, H118
5115739	KSEMP1156FDS28B1	H108, H118
5116010	KSEMP3000FDS28B1M	H108, H118
5116011	KSEMP1188FDS28B1	H108, H118
5116012	KSEMP1219FDS28B1	H108, H118
5116013	KSEMP3100FDS28B1M	H108, H118
5116014	KSEMP1250FDS32B1	H108, H118
5116015	KSEMP3200FDS32B1M	H108, H118
5116016	KSEMP3300FDS32B1M	H108, H118
5116017	KSEMP3320FDS32B1M	H108, H118
5116018	KSEMP1313FDS32B1	H108, H118
5116019	KSEMP3400FDS32B1M	H108, H118
5116030	KSEMP1375FDS32B1	H108, H118
5116031	KSEMP3500FDS32B1M	H108, H118
5116032	KSEMP3600FDS36B1M	H108, H118
5116033	KSEMP1438FDS36B1	H108, H118
5116034	KSEMP3700FDS36B1M	H108, H118
5116035	KSEMP3750FDS36B1M	H108, H118
5116036	KSEMP3800FDS36B1M	H108, H119
5116037	KSEMP1500FDS36B1	H108, H119
5116038	KSEMP3900FDS36B1M	H108, H119
5116039	KSEMP3920FDS36B1M	H108, H119
5116040	KSEMP1563FDS36B1	H108, H119
5116041	KSEMP4000FDS40B1M	H108, H119
5116042	KSEMP4100FDS40B1M	H108, H119
5116043	KSEMP1625FDS40B1	H108, H119
5116044	KSEMP4200FDS40B1M	H108, H119
5116045	KSEMP4300FDS40B1M	H108, H119
5116046	KSEMP4400FDS40B1M	H108, H119
5116047	KSEMP1750FDS40B1	H108, H119
5116098	KSEMP4500FDS45B1M	H109, H119
5116099	KSEMP4600FDS45B1M	H109, H119

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5116110	KSEMP4700FDS45B1M	H109, H119
5116111	KSEMP1875FDS45B1	H109, H119
5116112	KSEMP4800FDS45B1M	H109, H119
5116113	KSEMP4900FDS45B1M	H109, H119
5116114	KSEMP5000FDS50B1M	H109, H119
5116115	KSEMP2000FDS50B1	H109, H119
5116116	KSEMP5100FDS50B1M	H109, H119
5116117	KSEMP5200FDS50B1M	H109, H119
5116118	KSEMP5300FDS50B1M	H109, H119
5116119	KSEMP2125FDS50B1	H109, H119
5116120	KSEMP5400FDS50B1M	H109, H119
5116121	KSEMP5500FDS50B1M	H109, H119
5116122	KSEMP5600FDS56B1M	H109, H119
5116123	KSEMP5700FDS56B1M	H109, H119
5116124	KSEMP2250FDS56B1	H109, H119
5116125	KSEMP5800FDS56B1M	H109, H119
5116126	KSEMP5900FDS56B1M	H109, H119
5116127	KSEMP6000FDS56B1M	H109, H119
5116128	KSEMP2375FDS56B1	H109, H119
5116129	KSEMP6100FDS56B1M	H109, H119
5116130	KSEMP6200FDS56B1M	H109, H119
5116131	KSEMP6300FDS63B1M	H109, H119
5116132	KSEMP2500FDS63B1	H109, H119
5116133	KSEMP6400FDS63B1M	H109, H119
5116134	KSEMP6500FDS63B1M	H109, H119
5116135	KSEMP6600FDS63B1M	H109, H119
5116136	KSEMP2625FDS63B1	H109, H119
5116137	KSEMP6700FDS63B1M	H109, H119
5116138	KSEMP6800FDS63B1M	H109, H119
5116139	KSEMP6900FDS63B1M	H109, H119
5116140	KSEMP2750FDS63B1	H109, H119
5116141	KSEMP7000FDS63B1M	H109, H119
5116887	B224A14200HP KCPK15	G47
5117311	B269A09800HP KCPK15	G63
5118324	DPA07T3D25 KCU40	H114
5118325	DPA09T4D32 KCU40	H114
5118326	DPA13T5D50 KCU40	H114
5118327	DFC040310D28HP KCU25	H114
5118328	DFC05T312D32HP KCU25	H114
5118329	DFC06T312D36HP KCU25	H114
5118450	DFC070416D45HP KCU25	H114
5118451	DFC090520D56HP KCU25	H114
5118452	DFC040310D28HP KCU40	H114
5118453	DFC05T312D32HP KCU40	H114
5118454	DFC06T312D36HP KCU40	H114
5118455	DFC070416D45HP KCU40	H114
5118456	DFC090520D56HP KCU40	H114
5118457	DFC040310D28MD KC7140	H114
5118458	DFC05T312D32MD KC7140	H114
5118459	DFC06T312D36MD KC7140	H114
5118460	DFC070416D45MD KC7140	H114
5118461	DFC090520D56MD KC7140	H114
5120433	UJDE0500J6CRB KCSM15	P44
5120466	UJDE1000J6ARB KCSM15	P45
5120480	UJDE1000J6DRB KCSM15	P45
5123821	KTIP2280HPM KCP15	H34
5124334	SDET4316SNGB KCPK30	T116, T123, U39
5124576	HSK63AAVS00B126MCLB	K83
5124577	HSK63AAVS0B143MCLB	K83
5124578	HSK63AAVS1B127MCLB	K83
5124579	HSK63AAVS2B139MCLB	K83
5124800	HSK63AAVS3B139MCLB	K83
5124801	KM40TSAVS00B111MCLB	K82
5124802	KM40TSAVS0B128MCLB	K82
5124803	KM40TSAVS1B112MCLB	K82
5124804	KM40TSAVS2B127MCLB	K82
5124805	KM50TSAVS00B117MCLB	K82
5124807	KM50TSAVS0B134MCLB	K82
5124808	KM50TSAVS1B118MCLB	K82
5124809	KM50TSAVS2B128MCLB	K82
5124810	KM50TSAVS3B128MCLB	K82
5124811	KM63TSAVS3B130MCLB	K82
5124812	KR32AVS00B099MCLB	K82
5124814	KR32AVS0B116MCLB	K82
5124816	KR32AVS1B100MCLB	K82
5124818	KR32AVS2B115MCLB	K82
5124820	KR32AVS3B115MCLB	K82
5124822	KRCSCFPR061Y	K85
5124823	KRCSCFPR062Y	K85
5124824	KRCSCFPR063Y	K85
5124825	KRCSCFPR061X	K85
5124826	KRCSCFPR062X	K85
5124827	KRCSCFPR063X	K85
5124828	KRCSCFPR061W	K85
5124829	KRCSCFPR062W	K85
5124850	KRCSCFPR063W	K85
5127885	RIQ06R0400S KB1610	K57
5128566	C8FIX150608LRP KCU25	E12
5128598	C8FIX150612LRP KCP25	E12
5129621	B269A10400HP KCPK15	G63
5130229	B707A17900FBL KCMS15	G112
5131942	B269A03600HP KCPK15	G62
5132051	B978A03600 KC7315	G139
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
5133561	RMBE19000H6HF KC6305	K20
5133562	RMBE20000H6HF KC6305	K20
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	K35
5133591	RHME14288KST115H6SF KC6305	K35
5133592	RHME15000KST115H6SF KC6305	K35
5133593	RHME16000KST135H6SF KC6305	K35
5133594	RHME17000KST135H6SF KC6305	K35
5133595	RHME17463KST135H6SF KC6305	K35
5133596	RHME18000KST155H6SF KC6305	K35
5133597	RHME19000KST155H6SF KC6305	K35
5133598	RHME19050KST155H6SF KC6305	K35
5133599	RHME20000KST175H6SF KC6305	K35
5133600	RHME21000KST175H6SF KC6305	K35
5133601	RHME22000KST175H6SF KC6305	K35
5133602	RHME22225KST175H6SF KC6305	K35
5133603	RHME23000KST200H6SF KC6305	K35
5133604	RHME23813KST200H6SF KC6305	K35
5133605	RHME24000KST200H6SF KC6305	K35
5133606	RHME25000KST200H6SF KC6305	K35
5133607	RHME25400KST200H6SF KC6305	K35
5133609	RHME26000KST200H6SF KC6305	K35
5133610	RHME27000KST200H6SF KC6305	K35
5133611	RHME28000KST250H6SF KC6305	K35
5133612	RHME30000KST250H6SF KC6305	K35
5133613	RHME31750KST250H6SF KC6305	K35
5133614	RHME32000KST250H6SF KC6305	K35
5133615	RHME34000KST300H6SF KC6305	K35
5133616	RHME36000KST300H6SF KC6305	K35
5133617	RHME38000KST350H6SF KC6305	K35
5133618	RHME40000KST350H6SF KC6305	K35
5133619	RHME42000KST350H6SF KC6305	K35
5133818	RHME14000KST115H6SF KC6005	K35
5133819	RHME14288KST115H6SF KC6005	K35
5133960	RHME15000KST115H6SF KC6005	K35
5133961	RHME16000KST135H6SF KC6005	K35
5133962	RHME17000KST135H6SF KC6005	K35
5133963	RHME17463KST135H6SF KC6005	K35
5133964	RHME18000KST155H6SF KC6005	K35
5133965	RHME19000KST155H6SF KC6005	K35
5133966	RHME19050KST155H6SF KC6005	K35
5133967	RHME20000KST175H6SF KC6005	K35
5133968	RHME21000KST175H6SF KC6005	K35
5133969	RHME22000KST175H6SF KC6005	K35
5133970	RHME22225KST175H6SF KC6005	K35
5133971	RHME23000KST200H6SF KC6005	K35
5133972	RHME23813KST200H6SF KC6005	K35
5133973	RHME24000KST200H6SF KC6005	K35
5133974	RHME25000KST200H6SF KC6005	K35
5133975	RHME25400KST200H6SF KC6005	K35
5133976	RHME26000KST200H6SF KC6005	K35
5133977	RHME27000KST200H6SF KC6005	K35
5133978	RHME28000KST250H6SF KC6005	K35
5133979	RHME30000KST250H6SF KC6005	K35
5133990	RHME31750KST250H6SF KC6005	K35
5133991	RHME32000KST250H6SF KC6005	K35
5133992	RHME34000KST300H6SF KC6005	K35
5133993	RHME36000KST300H6SF KC6005	K35
5133994	RHME38000KST350H6SF KC6005	K35
5133995	RHME40000KST350H6SF KC6005	K35
5133996	RHME42000KST350H6SF KC6005	K35
5133997	RHME14000KST115H6HF KC6305	K36
5133998	RHME14288KST115H6HF KC6305	K36
5133999	RHME15000KST115H6HF KC6305	K36
5134030	RHME16000KST135H6HF KC6305	K36
5134031	RHME17000KST135H6HF KC6305	K36
5134032	RHME17463KST135H6HF KC6305	K36
5134033	RHME18000KST155H6HF KC6305	K36
5134034	RHME19000KST155H6HF KC6305	K36
5134035	RHME19050KST155H6HF KC6305	K36
5134036	RHME20000KST175H6HF KC6305	K36
5134037	RHME21000KST175H6HF KC6305	K36
5134038	RHME22000KST175H6HF KC6305	K36
5134039	RHME22225KST175H6HF KC6305	K36
5134040	RHME23000KST200H6HF KC6305	K36
5134041	RHME23813KST200H6HF KC6305	K36
5134042	RHME24000KST200H6HF KC6305	K36
5134043	RHME25000KST200H6HF KC6305	K36
5134044	RHME25400KST200H6HF KC6305	K36
5134045	RHME26000KST200H6HF KC6305	K36
5134046	RHME27000KST200H6HF KC6305	K36
5134047	RHME28000KST250H6HF KC6305	K36
5134048	RHME30000KST250H6HF KC6305	K36
5134049	RHME31750KST250H6HF KC6305	K36
5134050	RHME32000KST250H6HF KC6305	K36
5134051	RHME34000KST300H6HF KC6305	K36
5134052	RHME36000KST300H6HF KC6305	K36
5134053	RHME38000KST350H6HF KC6305	K36
5134054	RHME40000KST350H6HF KC6305	K36
5134055	RHME42000KST350H6HF KC6305	K36
5134072	RHME14000KST115H6HF KC6005	K36
5134073	RHME14288KST115H6HF KC6005	K36
5134074	RHME15000KST115H6HF KC6005	K36
5134075	RHME16000KST135H6HF KC6005	K36
5134076	RHME17000KST135H6HF KC6005	K36
5134077	RHME17463KST135H6HF KC6005	K36
5134078	RHME18000KST155H6HF KC6005	K36
5134079	RHME19000KST155H6HF KC6005	K36
5134120	RHME19050KST155H6HF KC6005	K36
5134121	RHME20000KST175H6HF KC6005	K36
5134122	RHME21000KST175H6HF KC6005	K36
5134123	RHME22000KST175H6HF KC6005	K36
5134124	RHME22225KST175H6HF KC6005	K36
5134125	RHME23000KST200H6HF KC6005	K36
5134126	RHME23813KST200H6HF KC6005	K36
5134127	RHME24000KST200H6HF KC6005	K36
5134128	RHME25000KST200H6HF KC6005	K36
5134129	RHME25400KST200H6HF KC6005	K36
5134130	RHME26000KST200H6HF KC6005	K36
5134131	RHME27000KST200H6HF KC6005	K36
5134132	RHME28000KST250H6HF KC6005	K36
5134133	RHME30000KST250H6HF KC6005	K36
5134134	RHME31750KST250H6HF KC6005	K36
5134135	RHME32000KST250H6HF KC6005	K36
5134136	RHME34000KST300H6HF KC6005	K36
5134137	RHME36000KST300H6HF KC6005	K36
5134138	RHME38000KST350H6HF KC6005	K36
5134139	RHME40000KST350H6HF KC6005	K36
5134140	RHME42000KST350H6HF KC6005	K36
5134141	KGIP0125N0189GD KCU45	H101
5134142	KGEM0750R1SS075	H100
5134143	KGEM1905R1WN20M	H100
5134144	KGEM0750R3SS075	H100
5134145	KGEM1905R3WN20M	H100
5135356	M1D300E1804S100L175AL	T78
5136359	A4R0405M04U00GUP KCU25	C102
5136407	A4R0605M06U00GUP KCU25	C102
5136420	A4R0600M06P00GUP KCU10	C104
5136423	A4R0805M08U00GUP KCU25	C102
5140368	B269A12200HP KCPK15	G63
5144597	A4R125I03P00GUP KCU25	C104
5144598	A4R187I04P00GUP KCU25	C104
5144599	A4R250I06P00GUP KCU25	C104
5144664	KSEM0890HPG KC7315	H55
5144793	CNMG433RP KCPK05	B53
5146918	A4R0305M03U00GUP KCU25	C104
5146919	A4R0505M05U00GUP KCU25	C104
5147210	A4R1005M10U00GUP KCU25	C104
5147211	A4R0300M03P00GUP KCU25	C104
5147212	A4R0400M04P00GUP KCU25	C104
5147213	A4R0500M05P00GUP KCU25	C104
5147214	A4R0600M06P00GUP KCU25	C104
5147215	A4R0800M08P00GUP KCU25	C104
5147216	A4R1000M10P00GUP KCU25	C104
5148480	KSEM1619HPGM KC7315	H54
5152563	RNGJ10T3M0FLDJ KC422M	V48
5152566	RNGJ10T3M0ELDJ KC725M	V48
5152600	RNGJ10T3M0SGDJ KC725M	V49
5152606	RNGJ1605M0ELDJ KC522M	V59
5152607	RNGJ1605M0ELDJ KC725M	V59
5154366	KDR100R1003M12L125	V44
5154400	KDR100R1003W100L200	V45
5154402	KDR100R1003C100L600	V46
5154406	KDR150R1005S050L157	V47
5154408	KDR200R1006S075L200	V47
5154910	KDR200R1604S075L200	V58
5154913	KDR300R1607S100L200	V58
5154914	KDR400R1606S150L200	V58
5154915	KDR400R1608S150L200	V58
5154916	KDR500R1608S150L200	V58
5158428	RIQ09E1300 KC6305	K58
5159761	RIQ06R0500FT KT6315	K58
5161120	NA3L16 KCU10	D11
5169173	EP0708SGE KC725M	T25
5169174	EP0708SGE KC522M	T25
5169175	EP0708SGE KCPK30	T25
5172840	RPPT43EGE KCPK30	V84
5172841	RPPT43EGE KC725M	V84
5172843	RPPT43SGE KCPK30	V84
5172844	RPPT43SGE KC725M	V84
5172862	RPPT1204M0SGDX KC725M	V72
5175033	KSRM125R4303M16L150	V81
5175034	KSRM150R4304M16L150	V81
5175035	KSRM125R4302C125L600	V82
5175037	KSRM125R4303C125L1000	V82
5175038	KSRM150R4304C125L600	V82
5175039	KSRM150R4304C125L1000	V82
5175380	KSRM200R4305S075L197	V83
5175381	KSRM250R4306S075L197	V83
5175382	KSRM300R4307S100L197	V83
5182481	KTIP1490HPM KCP15	H33
5182869	SNMG433RN KCPK05	B105
5182893	SNMG543RN KCPK05	B105
5185658	UJDE0500J6CRE KCSM15	P44
5189859	B269A08600HP KCPK15	G63
5190087	M1D050E0702C050L400	T24
5190088	M1D062E0703C062L500	T24
5190089	M1D075E0705C075L600	T24
5194531	M1D150E1803C125L1000AL	T77
5201519	LS103	S104
5202231	SALS50	S104
5202238	SALS25	S104
5202239	SALS30	S104
5202240	SALS40	S104
5202243	SALS6150	S104
5202514	SWSM515	S104
5211960	T630NC#06-32R2BX-D1 KP6525	M47
5211961	T630NC#08-32R2BX-D1 KP6525	M47
5211962	T630NC#10-24R2BX-D1 KP6525	M47
5211964	T630NC02500-20R3BX-D1 KP6525	M47
5211965	T630NC03125-18R3BX-D1 KP6525	M47
5211966	T630NC03750-16R3BX-D1 KP6525	M47
5211967	T630NC04375-14R3BX-D6 KP6525	M47
5211968	T630NC05000-13R3BX-D6 KP6525	M47

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5211981	T630NF#06-40R2BX-D1 KP6525	M47
5211983	T630NF#10-32R2BX-D1 KP6525	M47
5211985	T630NF02500-28R3BX-D1 KP6525	M47
5211987	T630NF03125-24R3BX-D1 KP6525	M47
5211988	T630NF03750-24R3BX-D1 KP6525	M47
5211989	T630NF04375-20R3BX-D6 KP6525	M47
5211990	T630NF05000-20R3BX-D6 KP6525	M47
5211991	T631NC02500-20R3BX-D1 KP6525	M48
5211992	T631NC03125-18R3BX-D1 KP6525	M48
5211993	T631NC03750-16R3BX-D1 KP6525	M48
5211994	T631NC04375-14R3BX-D6 KP6525	M48
5211995	T631NC05000-13R3BX-D6 KP6525	M48
5211996	T631NF02500-28R3BX-D1 KP6525	M48
5211997	T631NF03125-24R3BX-D1 KP6525	M48
5211998	T631NF03750-24R3BX-D1 KP6525	M48
5211999	T631NF04375-20R3BX-D6 KP6525	M48
5212000	T631NF05000-20R3BX-D6 KP6525	M48
5212152	T620NC#06-32R2BX-D1 KP6525	M8
5212155	T620NC#08-32R2BX-D1 KP6525	M8
5212156	T620NC#10-24R2BX-D1 KP6525	M8
5212158	T620NC02500-20R3BX-D1 KP6525	M8
5212159	T620NC03125-18R3BX-D1 KP6525	M8
5212210	T620NC03750-16R3BX-D1 KP6525	M8
5212211	T620NC04375-14R3BX-D6 KP6525	M8
5212212	T620NC05000-13R3BX-D6 KP6525	M8
5212213	T620NF#06-40R2BX-D1 KP6525	M8
5212215	T620NF#10-32R2BX-D1 KP6525	M8
5212217	T620NF02500-28R3BX-D1 KP6525	M8
5212218	T620NF03125-24R3BX-D1 KP6525	M8
5212219	T620NF03750-24R3BX-D1 KP6525	M8
5212230	T620NF04375-20R3BX-D6 KP6525	M8
5212231	T620NF05000-20R3BX-D6 KP6525	M8
5212232	T621NC02500-20R3BX-D1 KP6525	M9
5212233	T621NC03125-18R3BX-D1 KP6525	M9
5212234	T621NC03750-16R3BX-D1 KP6525	M9
5212235	T621NC04375-14R3BX-D6 KP6525	M9
5212236	T621NC05000-13R3BX-D6 KP6525	M9
5212237	T621NF02500-28R3BX-D1 KP6525	M9
5212238	T621NF03125-24R3BX-D1 KP6525	M9
5212239	T621NF03750-24R3BX-D1 KP6525	M9
5212240	T621NF04375-20R3BX-D6 KP6525	M9
5212241	T621NF05000-20R3BX-D6 KP6525	M9
5212248	T640NC#06-32R2BX-D1 KP6525	M118
5212249	T640NC#08-32R2BX-D1 KP6525	M118
5212270	T640NC#10-24R2BX-D1 KP6525	M118
5212272	T640NC02500-20R3BX-D1 KP6525	M118
5212273	T640NC03125-18R3BX-D1 KP6525	M118
5212274	T640NC03750-16R3BX-D1 KP6525	M118
5212275	T640NC04375-14R3BX-D6 KP6525	M118
5212276	T640NC05000-13R3BX-D6 KP6525	M118
5212277	T640NF#06-40R2BX-D1 KP6525	M118
5212279	T640NF#10-32R2BX-D1 KP6525	M118
5212281	T640NF02500-28R3BX-D1 KP6525	M118
5212282	T640NF03125-24R3BX-D1 KP6525	M118
5212283	T640NF03750-24R3BX-D1 KP6525	M118
5212284	T640NF04375-20R3BX-D6 KP6525	M118
5212285	T640NF05000-20R3BX-D6 KP6525	M118
5212286	T641NC02500-20R3BX-D1 KP6525	M119
5212287	T641NC03125-18R3BX-D1 KP6525	M119
5212288	T641NC03750-16R3BX-D1 KP6525	M119
5212289	T641NC04375-14R3BX-D6 KP6525	M119
5212290	T641NC05000-13R3BX-D6 KP6525	M119
5212291	T641NF02500-28R3BX-D1 KP6525	M119
5212292	T641NF03125-24R3BX-D1 KP6525	M119
5212293	T641NF03750-24R3BX-D1 KP6525	M119
5212294	T641NF04375-20R3BX-D6 KP6525	M119
5212295	T641NF05000-20R3BX-D6 KP6525	M119
5214053	B269A03800HP KCPK15	G62
5274660	RNPJ10T3M0SGD KCPK30	V49
5274661	RNPJ10T3M0SGD KC522M	V49
5274663	RNPJ10T3M0SHD KCPK30	V49
5274665	RNPJ10T3M0SHD KCK15	V49
5274690	RNPJ1204M0SGD KCPK30	V56
5274691	RNPJ1204M0SGD KC522M	V56
5274693	RNPJ1204M0SHD KCPK30	V56
5274699	RNPJ1605M0SGD KCPK30	V59
5274720	RNPJ1605M0SGD KC725M	V59
5274721	RNPJ1605M0SGD KC522M	V59
5274722	RNPJ1605M0SHD KCPK30	V59
5274724	RNPJ1605M0SHD KCK15	V59
5274725	RNPJ1605M0SHD KC520M	V59
5299680	RPET43SGEJ KC725M	V85
5302954	KSRM200R4303S075L197	V83
5302955	KSRM250R4304S075L197	V83
5302956	KSRM300R4305S100L197	V83
5307642	KTIP0313R3SCF050	H41
5307643	KTIP0335R3SCF050	H41
5307644	KTIP0354R3SCF050	H41
5307645	KTIP0374R3SCF050	H41
5307646	KTIP0394R3SCF063	H41
5307647	KTIP0413R3SCF063	H41
5307648	KTIP0433R3SCF063	H41
5307649	KTIP0453R3SCF063	H41
5307680	KTIP0472R3SCF063	H41
5307681	KTIP0492R3SCF063	H41
5307682	KTIP0512R3SCF063	H41
5307683	KTIP0532R3SCF063	H41
5307684	KTIP0551R3SCF063	H41
5307685	KTIP0571R3SCF063	H41
5307686	KTIP0591R3SCF075	H41
5307687	KTIP0630R3SCF075	H41
5307688	KTIP0669R3SCF075	H41
5307689	KTIP0709R3SCF075	H41
5307691	KTIP0748R3SCF075	H41
5307692	KTIP0787R3SCF100	H41
5307693	KTIP0827R3SCF100	H41
5307694	KTIP0866R3SCF100	H41
5307695	KTIP0906R3SCF100	H41
5307696	KTIP0945R3SCF100	H41
5307697	KTIP0984R3SCF100	H41
5307698	KTIP1024R3SCF100	H41
5307699	KTIP1063R3SCF100	H41
5307700	KTIP0313R5SCF050	H41
5307701	KTIP0335R5SCF050	H41
5307702	KTIP0354R5SCF050	H41
5307703	KTIP0374R5SCF050	H41
5307704	KTIP0394R5SCF063	H41
5307705	KTIP0413R5SCF063	H41
5307706	KTIP0433R5SCF063	H41
5307707	KTIP0453R5SCF063	H41
5307708	KTIP0472R5SCF063	H41
5307709	KTIP0492R5SCF063	H41
5307710	KTIP0512R5SCF063	H41
5307711	KTIP0532R5SCF063	H41
5307712	KTIP0551R5SCF063	H41
5307713	KTIP0571R5SCF063	H41
5307816	KTIP0591R5SCF075	H41
5307817	KTIP0630R5SCF075	H41
5307818	KTIP0669R5SCF075	H41
5307819	KTIP0709R5SCF075	H41
5307840	KTIP0748R5SCF075	H41
5307841	KTIP0787R5SCF100	H41
5307842	KTIP0827R5SCF100	H41
5307843	KTIP0866R5SCF100	H41
5307844	KTIP0906R5SCF100	H41
5307845	KTIP0945R5SCF100	H41
5307846	KTIP0984R5SCF100	H41
5307847	KTIP1024R5SCF100	H41
5307848	KTIP1063R5SCF100	H41
5307849	KTIP0313R8SCF050	H41
5307860	KTIP0335R8SCF050	H41
5307861	KTIP0354R8SCF050	H41
5307862	KTIP0374R8SCF050	H41
5307863	KTIP0394R8SCF063	H41
5307864	KTIP0413R8SCF063	H41
5307865	KTIP0433R8SCF063	H41
5307866	KTIP0453R8SCF063	H41
5307867	KTIP0472R8SCF063	H41
5307868	KTIP0492R8SCF063	H41
5307869	KTIP0512R8SCF063	H41
5307871	KTIP0532R8SCF063	H41
5307872	KTIP0551R8SCF063	H41
5307873	KTIP0571R8SCF063	H41
5307874	KTIP0591R8SCF075	H41
5307875	KTIP0630R8SCF075	H41
5307876	KTIP0669R8SCF075	H41
5307877	KTIP0709R8SCF075	H41
5307878	KTIP0748R8SCF075	H41
5307879	KTIP0787R8SCF100	H41
5307880	KTIP0827R8SCF100	H41
5307881	KTIP0866R8SCF100	H41
5307882	KTIP0906R8SCF100	H41
5307883	KTIP0945R8SCF100	H41
5307884	KTIP0984R8SCF100	H41
5307885	KTIP1024R8SCF100	H41
5307886	KTIP1063R8SCF100	H41
5309298	B977A16300 KC7315	G138
5314920	KTIP2110HPM KCP15	H34
5314951	B707A03800FBL KCMS15	G110
5317764	UJDE0375J6BQE KCSM15	P46
5324450	DPGR431FP KCP25	E32
5324453	DPGR431FP KCU10	E32
5324456	DPGR432FP KCP10	E32
5324458	DPGR432FP KCM25	E32
5324773	NPGR51LFP KCP10	E33
5324774	NPGR51LFP KCP25	E33
5324775	NPGR51LFP KCM25	E33
5324777	NPGR51LFP KCU25	E33
5324778	NPGR51RFP KCP10	E33
5324780	NPGR51RFP KCP25	E33
5324782	NPGR51RFP KCM25	E33
5324786	NPGR52LFP KCP10	E33
5324787	NPGR52LFP KCP25	E33
5324791	NPGR52RFP KCP10	E33
5324794	NPGR52RFP KCU10	E33
5324906	VBMR2205FP KCP25	E36
5324911	VBMR221FP KCP10	E36
5324912	VBMR221FP KCP25	E36
5324915	VBMR221FP KCU25	E36
5324916	VBMR222FP KCP10	E36
5324921	VBMR222FP KCU10	E36
5324923	VCMR331FP KCP10	E37
5324924	VCMR331FP KCP25	E37
5324925	VCMR331FP KCM25	E37
5324927	VCMR331FP KCU10	E37
5324928	VCMR331FP KCU25	E37
5324929	VCMR332FP KCP10	E37
5324930	VCMR332FP KCP25	E37
5324931	VCMR332FP KCM25	E37
5324932	VCMR332FP KCK05	E37
5327662	A4R0305M03U00GUP KCU10	C104
5327663	A4R0505M05U00GUP KCU10	C104
5327664	A4R1005M10U00GUP KCU10	C104
5327665	A4R0300M03P00GUP KCU10	C104
5327666	A4R1000M10P00GUP KCU10	C104
5327684	A4R125I03P00GUP KCU10	C104
5327686	A4R250I06P00GUP KCU10	C104
5327687	A4R312I08P00GUP KCU10	C104
5327912	VPGR331HP K313	E39
5327919	VPGR3305FP KCP10	E39
5327936	VPGR331FP KCP10	E39
5327937	VPGR331FP KCP25	E39
5327938	VPGR331FP KCM25	E39
5327940	VPGR331FP KCU10	E39
5327942	VPGR332FP KCP10	E39
5327943	VPGR332FP KCP25	E39
5327944	VPGR332FP KCM25	E39
5327945	VPGR332FP KCK05	E39
5327948	VPGR333FP KCP10	E39
5327949	VPGR333FP KCP25	E39
5327961	VPGR333FP KCK05	E39
5327965	VPGR334FP KCP25	E39
5328738	DNGA432S0525MT KBH20	B334
5329836	WNGA431S0415MT KBH20	B343
5329837	WNGA432S0415MT KBH20	B343
5329838	WNGA432S0525MT KBH20	B343
5329839	WNGA432S0735MT KBH20	B343
5330130	WNGA432S0415FWMT KBH20	B343
5330131	CCGW21505S0525MT KBH20	B328
5330132	CCGW2151S0525MT KBH20	B328
5330133	CCGW32505S0525MT KBH20	B328
5330134	CCGW3251S0525MT KBH20	B328
5330135	CCGW3251S0415MT KBH20	B328
5330136	CCGW3251S0415FWMT KBH20	B328
5330137	CCGW3252S0525MT KBH20	B328
5330138	CCGW3252S0415MT KBH20	B328
5330139	CCGW3252S0415FWMT KBH20	B328
5330140	CCGW432S0415MT KBH20	B328
5330141	DCGW21505S0525MT KBH20	B332
5330142	DCGW2151S0525MT KBH20	B332
5330143	DCGW2151S0415MT KBH20	B332
5330144	DCGW32505S0525MT KBH20	B332
5330145	DCGW3251S0525MT KBH20	B332
5330146	DCGW3251S0415MT KBH20	B332
5330147	DCGW3252S0525MT KBH20	B332
5330148	DCGW3252S0415MT KBH20	B332
5330149	DCGW3252S0415FWMT KBH20	B332
5330150	TPGW21505S0415MT KBH20	B341
5330151	TPGW2151S0415MT KBH20	B341
5330152	TPGW2152S0415MT KBH20	B341
5330153	TCGW21505S0415MT KBH20	B338
5330154	TCGW2151S0415MT KBH20	B338
5330155	TCGW2152S0415MT KBH20	B338
5330156	TCGW181505S0415MT KBH20	B338
5330157	TCGW18151S0415MT KBH20	B338
5330159	TPGW3251S0415MT KBH20	B341
5330160	TPGW3252S0525MT KBH20	B341
5330161	TPGW3252S0415MT KBH20	B341
5330162	VBGW221S0525MT KBH20	B341
5330163	VBGW221S0415MT KBH20	B341
5330164	VBGW332S0415MT KBH20	B341
5330165	VBGW333S0415MT KBH20	B341
5330166	VBGW222S0525MT KBH20	B341
5330167	VCGW331S0525MT KBH20	B342
5330168	VCGW331S0415MT KBH20	B342
5330169	VCGW332S0525MT KBH20	B342
5330180	VCGW332S0415MT KBH20	B342

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5330695	CNGA431S0525MT KBH20	B330
5330696	CNGA431S0415MT KBH20	B330
5330697	CNGA431S0735MT KBH20	B330
5330698	CNGA431S0415FWMT KBH20	B330
5330699	CNGA432S0525MT KBH20	B330
5330830	CNGA432S0415MT KBH20	B330
5330831	CNGA432S0735MT KBH20	B330
5330832	CNGA432S0415FWMT KBH20	B330
5330833	CNGA433S0525MT KBH20	B330
5330834	CNGA433S0415MT KBH20	B330
5330835	CNGA433S0735MT KBH20	B330
5330836	CNGA433S0415FWMT KBH20	B330
5330837	DNGA431S0525MT KBH20	B334
5330838	DNGA431S0415MT KBH20	B334
5330839	DNGA431S0735MT KBH20	B334
5330840	DNGA432S0415MT KBH20	B334
5330841	DNGA432S0735MT KBH20	B334
5330842	DNGA433S0525MT KBH20	B334
5330843	DNGA433S0415MT KBH20	B334
5330844	DNGA433S0735MT KBH20	B334
5330845	DNGA432S0415FWMT KBH20	B333
5330846	DNGA433S0415FWMT KBH20	B333
5330847	DNGA441S0525MT KBH20	B334
5330848	DNGA441S0415MT KBH20	B334
5330849	DNGA441S0735MT KBH20	B334
5330850	DNGA442S0525MT KBH20	B334
5330851	DNGA442S0415MT KBH20	B334
5330852	DNGA442S0735MT KBH20	B334
5330853	DNGA443S0525MT KBH20	B334
5330854	DNGA443S0415MT KBH20	B334
5330855	DNGA443S0735MT KBH20	B334
5330856	SNGA432S0525MT KBH20	B337
5330857	SNGA433S0525MT KBH20	B337
5330858	TNGA331S0525MT KBH20	B339
5330859	TNGA331S0415MT KBH20	B339
5330860	TNGA331S0735MT KBH20	B339
5330861	TNGA332S0525MT KBH20	B339
5330862	TNGA332S0415MT KBH20	B339
5330863	TNGA332S0735MT KBH20	B339
5330864	TNGA333S0525MT KBH20	B339
5330865	TNGA333S0415MT KBH20	B339
5330866	TNGA333S0735MT KBH20	B339
5330867	VNGA331S0525MT KBH20	B342
5330868	VNGA331S0415MT KBH20	B342
5330869	VNGA331S0735MT KBH20	B342
5330870	VNGA332S0525MT KBH20	B342
5330871	VNGA332S0415MT KBH20	B342
5330872	VNGA332S0735MT KBH20	B342
5330873	VNGA333S0525MT KBH20	B342
5337754	KM4X100NEL3	D32
5337755	KM4X100NEL4	D32
5337756	KM4X100NEL5	D32
5337757	KM4X100NEL6	D32
5337758	KM4X100NER3	D32
5337759	KM4X100NER4	D32
5337770	KM4X100NER5	D32
5337771	KM4X100NER6	D32
5341813	KSEM3125HPGM KC7315	H55
5348571	CNGM432S0525MTCB1 KBH20	B330
5348572	CNGM433S0525MTCB1 KBH20	B330
5348573	CNGM431S0525MTCB1 KBH20	B330
5348574	DNGM432S0525MTCB1 KBH20	B334
5348575	DNGM433S0525MTCB1 KBH20	B334
5348576	DNGM442S0525MTCB1 KBH20	B334
5348577	DNGM443S0525MTCB1 KBH20	B334
5348579	TNGM332S0525MTCB1 KBH20	B340
5348582	VNGM332S0525MTCB1 KBH20	B342
5348583	VNGM333S0525MTCB1 KBH20	B342
5348584	CCGM3251S0525MTCB1 KBH20	B328
5348585	CCGM3252S0525MTCB1 KBH20	B328
5348586	DCGM3251S0525MTCB1 KBH20	B331
5350437	RIQ06E1306 KC6005	K58
5351811	UJDE375J6CRA KCSM15	P44
5351812	UJDE375J6CRB KCSM15	P44
5351814	UJDE375J6CRC KCSM15	P44
5351815	UJDE375J6CS KCSM15	P44
5351816	UJDE375J6BQA KCSM15	P46
5351817	UJDE500J6BRA KCSM15	P44
5351818	UJDE500J6BRB KCSM15	P44
5351819	UJDE500J6BRC KCSM15	P44
5351820	UJDE500J6BRE KCSM15	P44
5351821	UJDE500J6BS KCSM15	P44
5351823	UJDE500N6BRA KCSM15	P44
5351824	UJDE500N6BRB KCSM15	P44
5351825	UJDE500N6BRC KCSM15	P44
5351826	UJDE500N6BRE KCSM15	P44
5351827	UJDE500N6BS KCSM15	P44
5351828	UJDE500N6BQB KCSM15	P46
5351829	UJDE625J6BRB KCSM15	P44
5351830	UJDE625J6BRC KCSM15	P44
5351831	UJDE625J6BS KCSM15	P44
5351832	UJDE625N6BRB KCSM15	P44
5351833	UJDE625N6BRC KCSM15	P44
5351834	UJDE625N6BS KCSM15	P44
5351835	UJDE625N6BQB KCSM15	P46
5351838	UJDE750J6BRB KCSM15	P44
5351839	UJDE750J6BRC KCSM15	P44
5351890	UJDE750J6BRD KCSM15	P44
5351891	UJDE750J6BRE KCSM15	P44
5351892	UJDE750J6BS KCSM15	P44
5351893	UJDE750N6BRB KCSM15	P44
5351894	UJDE750N6BRC KCSM15	P44
5351895	UJDE750N6BRD KCSM15	P44
5351896	UJDE750N6BRE KCSM15	P44
5351897	UJDE750N6BS KCSM15	P44
5351898	UJDE750N6BQB KCSM15	P46
5351899	UJDE750J6CRB KCSM15	P45
5351900	UJDE750J6CRC KCSM15	P45
5351901	UJDE750J6CRD KCSM15	P45
5351902	UJDE750J6CRE KCSM15	P45
5351903	UJDE750J6CS KCSM15	P45
5351904	UJDE750N6CRB KCSM15	P45
5351905	UJDE750N6CRC KCSM15	P45
5351906	UJDE750N6CRD KCSM15	P45
5351907	UJDE750N6CRE KCSM15	P45
5351908	UJDE750N6CS KCSM15	P45
5351930	UJDE1000J6BRC KCSM15	P45
5351931	UJDE1000J6BRE KCSM15	P45
5351932	UJDE1000J6BRF KCSM15	P45
5351933	UJDE1000J6BS KCSM15	P45
5351934	UJDE1000N6BRB KCSM15	P45
5351935	UJDE1000N6BRC KCSM15	P45
5351936	UJDE1000N6BRE KCSM15	P45
5351937	UJDE1000N6BRF KCSM15	P45
5351938	UJDE1000N6BS KCSM15	P45
5351939	UJDE1000N6BQB KCSM15	P46
5351940	UJDE1250J6BRB KCSM15	P45
5351942	UJDE1250N6BRB KCSM15	P45
5351943	UJDE1250N6BRE KCSM15	P45
5351944	UJDE1250N6BS KCSM15	P45
5352319	EADE0178J4AQX KYS40	P156
5352350	EADE0188J4AQX KYS40	P156
5352351	EADE0238J4AQB KYS40	P156
5352352	EADE0250J4AQB KYS40	P156
5352353	EADE0297J4AQX KYS40	P156
5352354	EADE0313J4AQX KYS40	P156
5352355	EADE0356J4AQX KYS40	P156
5352356	EADE0375J4AQX KYS40	P156
5352357	EADE0475J4AQC KYS40	P156
5352358	EADE0500J4AQC KYS40	P156
5352359	EADE0188J6ARX KYS40	P157
5352360	EADE0250J6ARB KYS40	P157
5352361	EADE0313J6ARX KYS40	P157
5352362	EADE0375J6ARX KYS40	P157
5352363	EADE0500J6ARC KYS40	P157
5358938	KSOM125Z03C1000F53X	S44
5359020	KSOM150Z040F53S050X	S45
5359021	KSOM200Z060F53S075X	S45
5359023	KSOM250Z070F53S075X	S45
5359024	KSOM300Z090F53S100X	S45
5360214	KDR300R1607S125L200	V58
5360215	KDR300R1208S125L200	V54
5360377	UBDE0500N4AQA KCSM15	P21
5360378	UBDE0500N4AQB KCSM15	P21
5360379	UBDE0625N4AQB KCSM15	P21
5360380	UBDE0625N4AQC KCSM15	P21
5360381	UBDE0750N4AQB KCSM15	P21
5360382	UBDE0750N4AQC KCSM15	P21
5360383	UBDE0750N4AQD KCSM15	P21
5360384	UBDE0750N4AQE KCSM15	P21
5360385	UBDE0750N4BQB KCSM15	P21
5360386	UBDE0750N4BQC KCSM15	P21
5360387	UBDE0750N4BQD KCSM15	P21
5360388	UBDE0750N4BQE KCSM15	P21
5360389	UBDE1000N4BQB KCSM15	P21
5360390	UBDE1000N4BQC KCSM15	P21
5360391	UBDE1000N4BQE KCSM15	P21
5362754	CCMT3253MP KCU10	B191
5366566	B269A17100HP KCPK15	G64
5367199	UJDE0750J6BRH KCSM15	P44
5374997	UJDE0625J6CRE KCSM15	P44
5377581	B269A04700HP KCPK15	G62
5377582	B269A06100HP KCPK15	G63
5378294	B269A11200HP KCPK15	G63
5387230	CNMG433FM KCP10B	B50
5387231	CNMG433FM KCP25B	B50
5387540	DNMG443CT KCP25B	B79
5387541	DNMG443MN KCP25B	B81
5387542	DNMG443RN KCP25B	B83
5387543	DNMG443RP KCP25B	B84
5387544	DNMG444RN KCP25B	B83
5387545	DNMG444RP KCP25B	B84
5387547	DPMT3252LF KCP25B	B232
5387550	SCMT3251LF KCP25B	B246
5387551	SCMT3252FP KCP25B	B246
5387553	SCMT3252MF KCP25B	B247
5387554	SCMT3252MP KCP25B	B247
5387555	SCMT3253MF KCP25B	B247
5387556	SCMT432FP KCP25B	B246
5387557	SCMT432MF KCP25B	B247
5387558	SCMT433LF KCP25B	B246
5387559	SCMT433MF KCP25B	B247
5387563	SNMG433RP KCP25B	B105
5387567	SNMG543RP KCP25B	B105
5387571	SPMT3252LF KCP25B	B252
5387575	TNMG333RP KCP25B	B127
5387577	TNMG434RP KCP25B	B127
5387579	TPMT2152LF KCP25B	B268
5387580	TPMT2152MF KCP25B	B268
5387581	TPMT3252LF KCP25B	B268
5387584	VBMT331FP KCP25B	B281
5387587	VBMT332MP KCP25B	B281
5387588	VBMT333FP KCP25B	B281
5387610	WNMG332RN KCP25B	B161
5387611	WNMG432MN KCP25B	B159
5387612	WNMG432MW KCP25B	B160
5387614	WNMG433MN KCP25B	B159
5387615	WNMG433MW KCP25B	B160
5387616	WNMG433RN KCP25B	B161
5387618	WNMG434RN KCP25B	B161
5387627	CCMT3251LF KCP25B	B191
5387628	CCMT3252LF KCP25B	B191
5387629	CCMT3252MF KCP25B	B191
5387661	CCMT432MF KCP25B	B191
5387662	CNMG432MN KCP25B	B50
5387663	CNMG432MW KCP25B	B52
5387664	CNMG432RN KCP25B	B53
5387665	CNMG432RP KCP25B	B53
5387667	CNMG433MN KCP25B	B50
5387668	CNMG433RN KCP25B	B53
5387681	CNMG434RN KCP25B	B53
5387688	CNMG643MN KCP25B	B50
5387689	CNMG643RN KCP25B	B53
5387691	CNMG644RN KCP25B	B53
5387692	CNMM433RM KCP25B	B55
5387693	CNMM433RP KCP25B	B56
5387694	CNMM434RP KCP25B	B56
5387695	CNMM543RM KCP25B	B55
5387696	CNMM544RP KCP25B	B56
5387697	CNMM644RM KCP25B	B55
5387698	CNMM646RH KCP25B	B55
5387699	CNMM646RM KCP25B	B55
5387727	DCMT3252LF KCP25B	B225
5387729	DCMT3253MF KCP25B	B226
5387732	DNMG432MN KCP25B	B81
5387733	DNMG432RN KCP25B	B83
5387737	DNMG442MN KCP25B	B81
5387753	CNMG432FN KCK15B	B49
5387754	VNMG332FN KCK15B	B146
5387755	CNMG432MW KCK15B	B52
5387801	CNMG433UN KCK15B	B54
5387802	CNMG432UN KCK15B	B54
5387804	TNMG332UN KCK15B	B127
5387805	SNMG433UN KCK15B	B106
5387806	RNMG43UN KCK15B	B97
5387807	TNMG333UN KCK15B	B127
5387808	WNMG432UN KCK15B	B162
5387809	WNMG434UN KCK15B	B162
5387810	DNMG332UN KCK15B	B84
5387811	CNMG544UN KCK15B	B54
5387812	DNMG444UN KCK15B	B84
5387851	DNMG444RP KCP10B	B84
5387853	DPMT3252LF KCP10B	B232
5387856	SCMT3251LF KCP10B	B246
5387858	SCMT3252MF KCP10B	B247
5387864	SCMT433LF KCP10B	B246
5387874	SNMG433RP KCP10B	B105
5387882	SNMG543RP KCP10B	B105
5387884	SPMT3252LF KCP10B	B252
5387896	TNMG333RP KCP10B	B127
5387901	TNMG438RP KCP10B	B127
5387903	TPMT2152LF KCP10B	B268
5387905	TPMT3252LF KCP10B	B268
5387907	VBMT331FP KCP10B	B281
5387910	VBMT333FP KCP10B	B281
5387915	WNMG432RP KCP10B	B161
5387919	WNMG433RP KCP10B	B161
5388031	CCMT3251LF KCP10B	B191
5388032	CCMT3252LF KCP10B	B191
5388033	CCMT3252MF KCP10B	B191
5388035	CCMT432MF KCP10B	B191
5388036	CNMG432MN KCP10B	B50
5388037	CNMG432MW KCP10B	B52
5388038	CNMG432RN KCP10B	B53
5388039	CNMG432RP KCP10B	B53
5388061	CNMG433MN KCP10B	B50
5388062	CNMG433RN KCP10B	B53
5388064	CNMG434RN KCP10B	B53
5388082	CNMG643RN KCP10B	B53
5388084	CNMG644RN KCP10B	B53
5388085	CNMM433RM KCP10B	B55
5388086	CNMM433RP KCP10B	B56
5388088	CNMM543RM KCP10B	B55
5388089	CNMM544RP KCP10B	B56
5388090	CNMM644RM KCP10B	B55
5388095	DCMT3252LF KCP10B	B225
5388097	DCMT3253MF KCP10B	B226
5388111	DNMG432MN KCP10B	B81
5388112	DNMG432RN KCP10B	B83
5388116	DNMG442FN KCP10B	B79
5388117	DNMG442MN KCP10B	B81
5390730	UJDE1000J6DS KCSM15	P45
5390731	UJDE1000J6CRC KCSM15	P45
5390732	UJDE1000J6CRH KCSM15	P45
5393242	CNMG432RN KCK15B	B53
5393244	CNMG432RN KCP40B	B53
5394869	UJDE1000J6CRD KCSM15	P45
5397385	KSEM0500HPG KCPM45	H57
5397386	KSEM0509HPG KCPM45	H57
5397387	KSEM1400HPGM KCPM45	H57
5397388	KSEM0563HPG KCPM45	H57
5397389	KSEM0634HPG KCPM45	H57
5397470	KSEM1620HPGM KCPM45	H57
5397471	KSEM0656HPG KCPM45	H57
5397473	KSEM0688HPG KCPM45	H57
5397474	KSEM1800HPGM KCPM45	H57
5397475	KSEM0719HPG KCPM45	H57
5397476	KSEM1900HPGM KCPM45	H57
5397477	KSEM1920HPGM KCPM45	H57
5397478	KSEM0750HPG KCPM45	H57
5397479	KSEM0758HPG KCPM45	H57
5397480	KSEM0759HPG KCPM45	H57
5397481	KSEM1950HPGM KCPM45	H57
5397482	KSEM0781HPG KCPM45	H57
5397483	KSEM2000HPGM KCPM45	H57
5397484	KSEM0813HPG KCPM45	H57
5397485	KSEM2100HPGM KCPM45	H57
5397486	KSEM2200HPGM KCPM45	H57
5397487	KSEM0875HPG KCPM45	H57
5397488	KSEM2300HPGM KCPM45	H57
5397489	KSEM0938HPG KCPM45	H57
5397490	KSEM2400HPGM KCPM45	H57
5397491	KSEM2500HPGM KCPM45	H58
5397492	KSEM1000HPG KCPM45	H58
5397493	KSEM1008HPG KCPM45	H58
5397494	KSEM1010HPG KCPM45	H58
5397495	KSEM1011HPG KCPM45	H58
5397496	KSEM1016HPG KCPM45	H58

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5397497	KSEM2600HPGM KCPM45	H58
5397498	KSEM1031HPG KCPM45	H58
5397499	KSEM2700HPGM KCPM45	H58
5397500	KSEM2800HPGM KCPM45	H58
5397501	KSEM1125HPG KCPM45	H58
5397502	KSEM3000HPGM KCPM45	H58
5397503	KSEM1188HPG KCPM45	H58
5397504	KSEM1250HPG KCPM45	H58
5397505	KSEM3200HPGM KCPM45	H58
5397506	KSEM3300HPGM KCPM45	H58
5397507	KSEM1313HPG KCPM45	H58
5397508	KSEM3600HPGM KCPM45	H58
5397509	KSEM1500HPG KCPM45	H58
5397510	KSEM4000HPGM KCPM45	H58
5397513	KSEMP7200FDS71A1M	H106, H116, H123
5397514	KSEMP7400FDS71A1M	H106, H116, H123
5397515	KSEMP7600FDS71A1M	H106, H117, H123
5397516	KSEMP3000FDS71A1	H106, H117, H123
5397517	KSEMP7800FDS71A1M	H106, H117, H123
5397518	KSEMP8000FDS80A1M	H106, H117, H123
5397519	KSEMP8200FDS80A1M	H106, H117, H123
5397550	KSEMP3250FDS80A1	H106, H117, H123
5397551	KSEMP8400FDS80A1M	H106, H117, H123
5397552	KSEMP8600FDS80A1M	H106, H117, H123
5397553	KSEMP8800FDS80A1M	H106, H117, H123
5397554	KSEMP3500FDS80A1	H106, H117, H123
5397555	KSEMP9000FDS90A1M	H106, H117, H123
5397556	KSEMP9200FDS90A1M	H106, H117, H123
5397557	KSEMP9400FDS90A1M	H106, H117, H123
5397558	KSEMP3750FDS90A1	H106, H117, H123
5397559	KSEMP9600FDS90A1M	H106, H117, H123
5397560	KSEMP9800FDS90A1M	H106, H117, H123
5397561	KSEMP4000FDS90A1	H106, H117, H123
5397562	KSEMP3000FDS71B1	H110, H119
5397563	KSEMP3250FDS80B1	H110, H120
5397564	KSEMP3500FDS80B1	H110, H120
5397565	KSEMP3750FDS90B1	H110, H120
5397566	KSEMP4000FDS90B1	H110, H120
5397942	WD50FDS71292M	H126
5397943	WD50FDS71452M	H127
5397944	WD50FDS80327M	H126
5397945	WD50FDS80507M	H127
5397946	WD50FDS90362M	H126
5397947	WD50FDS90562M	H127
5397948	SSF200FDS711150	H128
5397949	SSF200FDS711780	H129
5398010	SSF200FDS801287	H128
5398011	SSF200FDS801996	H129
5398012	SSF200FDS901425	H128
5398013	SSF200FDS902213	H129
5400814	B272Z06400HPS KN25	G70
5402877	SNMG433MR KCM25	B103
5402879	SNMG433MR KCP10B	B103
5402920	SNMG433MR KCP25B	B103
5402924	TNMG332MR KCM25	B125
5402926	TNMG332MR KCP10B	B125
5402927	TNMG332MR KCP25B	B125
5402930	TNMG333MR KCP10B	B125
5402931	TNMG333MR KCP25B	B125
5402932	TNMG333MR KCK15B	B125
5402935	WNMG432MR KCM25	B159
5402936	WNMG432MR KCM35	B159
5402937	WNMG432MR KCP10B	B159
5402938	WNMG432MR KCP25B	B159
5402960	WNMG432MR KCK15B	B159
5402963	WNMG433MR KCM35	B159
5402964	WNMG433MR KCP10B	B159
5402965	WNMG433MR KCP25B	B159
5402966	DNMG432MR KCM15	B82
5402969	DNMG432MR KCP10B	B82
5402980	DNMG432MR KCP25B	B82
5402983	DNMG442MR KCM25	B82
5402985	DNMG442MR KCP10B	B82
5402986	DNMG442MR KCP25B	B82
5402987	DNMG442MR KCK15B	B82
5402990	DNMG433MR KCP10B	B82
5402995	DNMG444MR KCP25B	B82
5403016	CNMG432MR KCM15	B51
5403017	CNMG432MR KCM25	B51
5403018	CNMG432MR KCM35	B51
5403019	CNMG432MR KCP10B	B51
5403090	CNMG432MR KCP25B	B51
5403091	CNMG432MR KCP40	B51
5403092	CNMG432MR KCK15B	B51
5403093	CNMG433MR KCM15	B51
5403094	CNMG433MR KCM25	B51
5403095	CNMG433MR KCM35	B51
5403096	CNMG433MR KCP10B	B51
5403097	CNMG433MR KCP25B	B51
5403099	CNMG433MR KCK15B	B51
5403103	CNMG543MR KCP10B	B51
5403104	CNMG543MR KCP25B	B51
5403105	CNMG543MR KCP40	B51
5403108	CNMG434MR KCP10B	B51
5403112	CNMG544MR KCP10B	B51
5403113	CNMG544MR KCP25B	B51
5403116	CNMG643MR KCM25	B51
5403119	CNMG643MR KCP25B	B51
5405652	PSC50KGMER65C	C73, C151
5405653	PSC50KGMEL65C	C73, C151
5405654	PSC50KGMSR65C	C72, C150
5405655	PSC50KGMSL65C	C72, C150
5406563	170.365	H123
5408657	KGEM1588R1WN20M	H100
5413058	CNMG434UN KCK15B	B54
5413059	CNMM866RH KCP25B	B55
5413170	CCMT3253MF KCP25B	B191
5413171	CNMG433CT KCP10B	B48
5413172	CNMG433CT KCP25B	B48
5413173	CNMG433MW KCK15B	B52
5413174	CNMG433RP KCP10B	B53
5413175	CNMG433RP KCP25B	B53
5413176	CNMG434RP KCP10B	B53
5413177	CNMG434RP KCP25B	B53
5413178	CNMG543MN KCP10B	B50
5413179	CNMG543MN KCP25B	B50
5413180	CNMG543RP KCP10B	B53
5413181	CNMG543RP KCP25B	B53
5413182	CNMG544RP KCP10B	B53
5413183	CNMG544RP KCP25B	B53
5413184	CPMT2152MP KCP25B	B207
5413185	CPMT3252LF KCP10B	B207
5413186	CPMT3252LF KCP25B	B207
5413187	CPMT3252MF KCP10B	B207
5413188	CPMT3252MF KCP25B	B207
5413189	CPMT3252MP KCP25B	B207
5413190	DCMT3252MF KCP10B	B226
5413191	DCMT3252MF KCP25B	B226
5413193	DNMG333MN KCP25B	B81
5413194	DNMG431CT KCP25B	B79
5413195	DNMG433RP KCP10B	B84
5413196	DNMG433RP KCP25B	B84
5413197	DNMG442RP KCP10B	B84
5413198	DNMG442RP KCP25B	B84
5413199	DNMG443CT KCP10B	B79
5413200	DNMG443MN KCP10B	B81
5413201	DNMG443RN KCP10B	B83
5413202	DNMG443RP KCP10B	B84
5413203	SNMG433RP KCK15B	B105
5413205	VNMG333RP KCK15B	B148
5413206	WNMG432RP KCP25B	B161
5413207	WNMG433RP KCP25B	B161
5413208	WNMG434RP KCP25B	B161
5413209	DNMM444RP KCP10B	B85
5413210	CNMM866RM KCP25B	B55
5413211	SNMM856RH KCP25B	B106
5413212	SNMM866RH KCP25B	B106
5413242	SCMT3252LF KCP10B	B246
5413249	TNMG332FN KCP10B	B123
5413250	TNMG332MN KCP10B	B124
5413251	TNMG333FN KCP10B	B123
5413255	VBMT221LF KCP10B	B281
5413256	VBMT331LF KCP10B	B281
5413257	VBMT332LF KCP10B	B281
5413260	WNMG432MN KCP10B	B159
5413261	WNMG432MW KCP10B	B160
5413263	WNMG433MW KCP10B	B160
5413269	SCMT3252LF KCP25B	B246
5413276	SNMM644RM KCP25B	B107
5413277	TNMG332MN KCP25B	B124
5413291	VBMT221LF KCP25B	B281
5413292	VBMT331LF KCP25B	B281
5413293	VBMT332LF KCP25B	B281
5413746	RNPJ10T3M0SHD KC725M	V49
5413747	RNPJ1204M0SGD KC725M	V56
5413748	RNPJ1204M0SHD KC725M	V56
5413749	RNPJ1605M0SHD KC725M	V59
5415049	RIQ06EGR06 KD1415	K59
5415819	UJDE0500J6DQB KCSM15	P46
5415936	UJDE1000J6CRF KCSM15	P45
5415950	UJDE0625J6CRC KCSM15	P44
5415951	UJDE0625J6CRD KCSM15	P44
5415953	UJDE0625J6DQB KCSM15	P46
5415954	UJDE0750J6ARB KCSM15	P44
5415956	UJDE1000J6ARC KCSM15	P45
5415957	UJDE1000J6ARE KCSM15	P45
5415959	UJDE1000J6AS KCSM15	P45
5415970	UJDE1000J6CRB KCSM15	P45
5415971	UJDE1000J6CRE KCSM15	P45
5415973	UJDE1000J6CS KCSM15	P45
5416851	T820NC02500-20RH2-A KSP39	M24
5416852	T820NC02500-20RH3-A KSP32	M24
5416853	T820NC02500-20RH3-A KSMN34	M24
5416854	T820NC02500-20RH3-A KSP39	M24
5416855	T820NC02500-20RH5-A KSP39	M24
5416856	T820NC02500-20RH7-A KSP39	M24
5416857	T820NF02500-28RH2-A KSP39	M24
5416858	T820NF02500-28RH3-A KSP32	M24
5416859	T820NF02500-28RH3-A KSMN34	M24
5416880	T820NF02500-28RH3-A KSP39	M24
5416881	T820NF02500-28RH4-A KSP39	M24
5416882	T820NF02500-28RH5-A KSP39	M24
5416883	T820NF02500-28RH6-A KSP39	M24
5416884	T820NF02500-28RH7-A KSP39	M24
5416885	T820NC03125-18RH3-A KSP32	M24
5416886	T820NC03125-18RH3-A KSMN34	M24
5416887	T820NC03125-18RH3-A KSP39	M24
5416888	T820NC03125-18RH5-A KSP39	M24
5416889	T820NC03125-18RH7-A KSP39	M24
5416890	T820NF03125-24RH3-A KSP32	M24
5416891	T820NF03125-24RH3-A KSMN34	M24
5416892	T820NF03125-24RH3-A KSP39	M24
5416893	T820NF03125-24RH4-A KSP39	M24
5416894	T820NF03125-24RH5-A KSP39	M24
5416895	T820NF03125-24RH6-A KSP39	M24
5416896	T820NF03125-24RH7-A KSP39	M24
5416897	T820NC03750-16RH3-A KSP32	M24
5416898	T820NC03750-16RH3-A KSMN34	M24
5416899	T820NC03750-16RH3-A KSP39	M24
5416900	T820NC03750-16RH5-A KSP39	M24
5416901	T820NC03750-16RH7-A KSP39	M24
5416902	T820NF03750-24RH3-A KSP32	M24
5416903	T820NF03750-24RH3-A KSMN34	M24
5416904	T820NF03750-24RH3-A KSP39	M24
5416905	T820NF03750-24RH4-A KSP39	M24
5416906	T820NF03750-24RH5-A KSP39	M24
5416907	T820NF03750-24RH6-A KSP39	M24
5416908	T820NF03750-24RH7-A KSP39	M24
5416909	T820NC04375-14RH3-A KSMN34	M24
5416910	T820NC04375-14RH3-A KSP39	M24
5416911	T820NC04375-14RH5-A KSP39	M24
5416912	T820NF04375-20RH3-A KSMN34	M24
5416913	T820NF04375-20RH3-A KSP39	M24
5416914	T820NF04375-20RH5-A KSP39	M24
5416915	T820NF04375-20RH6-A KSP39	M24
5416916	T820NF04375-20RH7-A KSP39	M24
5416917	T820NC05000-13RH3-A KSP32	M24
5416918	T820NC05000-13RH3-A KSMN34	M24
5416919	T820NC05000-13RH3-A KSP39	M24
5416930	T820NC05000-13RH5-A KSP39	M24
5416931	T820NC05000-13RH7-A KSP39	M24
5416932	T820NF05000-20RH3-A KSP32	M24
5416933	T820NF05000-20RH3-A KSMN34	M24
5416934	T820NF05000-20RH3-A KSP39	M24
5416935	T820NF05000-20RH5-A KSP39	M24
5416936	T820NF05000-20RH6-A KSP39	M24
5416937	T820NF05000-20RH7-A KSP39	M24
5416938	T820NC05625-12RH3-A KSP32	M24
5416939	T820NC05625-12RH3-A KSP39	M24
5416940	T820NF05625-18RH3-A KSMN34	M24
5416941	T820NF05625-18RH3-A KSP39	M24
5416942	T820NC06250-11RH3-A KSP32	M24
5416943	T820NC06250-11RH3-A KSMN34	M24
5416944	T820NC06250-11RH3-A KSP39	M24
5416945	T820NC06250-11RH5-A KSP39	M24
5416946	T820NC06250-11RH7-A KSP39	M24
5416947	T820NF06250-18RH3-A KSP32	M24
5416948	T820NF06250-18RH3-A KSP39	M24
5416949	T820NF06250-18RH5-A KSP32	M24
5416950	T820NF06250-18RH5-A KSP39	M24
5416951	T820NF06250-18RH6-A KSP39	M24
5416952	T820NC07500-10RH3-A KSP32	M24
5416953	T820NC07500-10RH3-A KSMN34	M24
5416954	T820NC07500-10RH3-A KSP39	M24
5416955	T820NF07500-16RH3-A KSP32	M25
5416956	T820NF07500-16RH3-A KSMN34	M25
5416957	T820NF07500-16RH3-A KSP39	M25
5416958	T820NC08750-9RH4-A KSP32	M25
5416959	T820NC08750-9RH4-A KSMN34	M25
5416961	T820NF08750-14RH4-A KSP39	M25
5416962	T820NC10000-8RH5-A KSP32	M25
5416963	T820NC10000-8RH5-A KSMN34	M25
5416964	T820NC10000-8RH5-A KSP39	M25
5416965	T820NF10000-12RH4-A KSP39	M25
5416966	T820NC11250-7RH6-A KSP39	M25
5416967	T820NF11250-12RH5-A KSP39	M25
5416968	T820NC12500-7RH6-A KSP39	M25
5416994	T830NC#02-56RH2-A KSP39	M74
5416995	T830NC#03-48RH2-A KSP39	M74
5416996	T830NC#04-40RH2-A KSP32	M74
5416997	T830NC#04-40RH2-A KSMN34	M74
5416998	T830NC#04-40RH2-A KSP39	M74
5416999	T830NC#04-40RH3-A KSP39	M74
5417000	T830NC#04-40RH4-A KSP39	M74
5417001	T830NC#04-40RH5-A KSP39	M74
5417002	T830NF#04-48RH2-A KSP39	M74
5417003	T830NC#05-40RH2-A KSP39	M74
5417004	T830NC#06-32RH2-A KSP39	M74
5417005	T830NC#06-32RH3-A KSP32	M74
5417006	T830NC#06-32RH3-A KSMN34	M74
5417007	T830NC#06-32RH3-A KSP39	M74
5417008	T830NC#06-32RH4-A KSP39	M74
5417009	T830NC#06-32RH5-A KSP39	M74
5417010	T830NC#06-32RH7-A KSP39	M74
5417012	T830NF#06-40RH2-A KSP39	M74
5417014	T830NF#06-40RH3-A KSP39	M74
5417016	T830NC#08-32RH2-A KSP39	M74
5417018	T830NC#08-32RH3-A KSP32	M74
5417020	T830NC#08-32RH3-A KSMN34	M74
5417021	T830NC#08-32RH3-A KSP39	M74
5417022	T830NC#08-32RH4-A KSP39	M74
5417023	T830NC#08-32RH5-A KSP39	M74
5417024	T830NC#08-32RH6-A KSP39	M74
5417025	T830NC#08-32RH7-A KSP39	M74
5417026	T830NC#10-24RH2-A KSP39	M74
5417027	T830NC#10-24RH3-A KSP32	M74
5417028	T830NC#10-24RH3-A KSP39	M74
5417029	T830NC#10-24RH3-A KSMN34	M74
5417040	T830NC#10-24RH4-A KSP39	M74
5417041	T830NC#10-24RH5-A KSP39	M75
5417042	T830NC#10-24RH7-A KSP39	M75
5417043	T830NF#10-32RH2-A KSP39	M75
5417044	T830NF#10-32RH3-A KSP32	M75
5417045	T830NF#10-32RH3-A KSMN34	M75
5417046	T830NF#10-32RH3-A KSP39	M75
5417047	T830NF#10-32RH4-A KSP39	M75
5417048	T830NF#10-32RH5-A KSP39	M75
5417049	T830NF#10-32RH6-A KSP39	M75
5417050	T830NF#10-32RH7-A KSP39	M75

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5417051	T830NC#12-24RH3-A KSP39	M75
5417052	T830NF#12-28RH3-A KSP39	M75
5417110	T830NC02500-20RH2-A KSP39	M75
5417111	T830NC02500-20RH3-A KSP32	M75
5417112	T830NC02500-20RH3-A KSMN34	M75
5417113	T830NC02500-20RH3-A KSP39	M75
5417114	T830NC02500-20RH5-A KSP39	M75
5417115	T830NC02500-20RH7-A KSP39	M75
5417116	T830NF02500-28RH2-A KSP39	M75
5417117	T830NF02500-28RH3-A KSP32	M75
5417118	T830NF02500-28RH3-A KSMN34	M75
5417119	T830NF02500-28RH3-A KSP39	M75
5417120	T830NF02500-28RH4-A KSP39	M75
5417121	T830NF02500-28RH5-A KSP39	M75
5417122	T830NF02500-28RH6-A KSP39	M75
5417123	T830NF02500-28RH7-A KSP39	M75
5417124	T830NC03125-18RH3-A KSP32	M75
5417125	T830NC03125-18RH3-A KSMN34	M75
5417126	T830NC03125-18RH3-A KSP39	M75
5417127	T830NC03125-18RH5-A KSP39	M75
5417128	T830NC03125-18RH7-A KSP39	M75
5417129	T830NF03125-24RH3-A KSP32	M75
5417130	T830NF03125-24RH3-A KSMN34	M75
5417131	T830NF03125-24RH3-A KSP39	M75
5417132	T830NF03125-24RH5-A KSP39	M75
5417133	T830NF03125-24RH7-A KSP39	M75
5417134	T830NC03750-16RH3-A KSP32	M75
5417135	T830NC03750-16RH3-A KSMN34	M75
5417136	T830NC03750-16RH3-A KSP39	M75
5417137	T830NC03750-16RH5-A KSP39	M75
5417138	T830NC03750-16RH7-A KSP39	M75
5417139	T830NF03750-24RH3-A KSP32	M75
5417140	T830NF03750-24RH3-A KSMN34	M75
5417141	T830NF03750-24RH3-A KSP39	M75
5417142	T830NF03750-24RH4-A KSP39	M75
5417143	T830NF03750-24RH5-A KSP39	M75
5417144	T830NF03750-24RH6-A KSP39	M75
5417145	T830NC04375-14RH3-A KSP32	M75
5417146	T830NC04375-14RH3-A KSMN34	M75
5417147	T830NC04375-14RH3-A KSP39	M75
5417148	T830NC04375-14RH5-A KSP39	M75
5417149	T830NC04375-14RH7-A KSP39	M75
5417150	T830NF04375-20RH3-A KSP32	M75
5417151	T830NF04375-20RH3-A KSMN34	M75
5417152	T830NF04375-20RH3-A KSP39	M75
5417153	T830NF04375-20RH5-A KSP39	M75
5417154	T830NF04375-20RH6-A KSP39	M75
5417155	T830NF04375-20RH7-A KSP39	M75
5417156	T830NC05000-13RH3-A KSP32	M75
5417157	T830NC05000-13RH3-A KSMN34	M75
5417158	T830NC05000-13RH3-A KSP39	M75
5417159	T830NC05000-13RH5-A KSP39	M75
5417160	T830NC05000-13RH7-A KSP39	M75
5417161	T830NF05000-20RH3-A KSP32	M75
5417162	T830NF05000-20RH3-A KSMN34	M75
5417163	T830NF05000-20RH3-A KSP39	M75
5417164	T830NF05000-20RH5-A KSP39	M75
5417165	T830NF05000-20RH6-A KSP39	M75
5417166	T830NF05000-20RH7-A KSP39	M75
5417167	T830NC05625-12RH3-A KSMN34	M75
5417168	T830NC05625-12RH3-A KSP39	M75
5417169	T830NC05625-12RH3-A KSP32	M75
5417170	T830NC05625-12RH5-A KSP39	M76
5417171	T830NF05625-18RH3-A KSMN34	M76
5417172	T830NF05625-18RH3-A KSP39	M76
5417173	T830NF05625-18RH5-A KSP39	M76
5417174	T830NC06250-11RH3-A KSP32	M76
5417175	T830NC06250-11RH3-A KSMN34	M76
5417176	T830NC06250-11RH3-A KSP39	M76
5417177	T830NC06250-11RH5-A KSP39	M76
5417178	T830NC06250-11RH7-A KSP39	M76
5417179	T830NF06250-18RH3-A KSP32	M76
5417180	T830NF06250-18RH3-A KSMN34	M76
5417181	T830NF06250-18RH3-A KSP39	M76
5417182	T830NF06250-18RH5-A KSP39	M76
5417183	T830NF06250-18RH6-A KSP39	M76
5417184	T830NF06250-18RH7-A KSP39	M76
5417185	T830NC07500-10RH3-A KSP32	M76
5417186	T830NC07500-10RH3-A KSMN34	M76
5417187	T830NC07500-10RH3-A KSP39	M76
5417189	T830NF07500-16RH3-A KSP32	M76
5417190	T830NF07500-16RH3-A KSMN34	M76
5417191	T830NF07500-16RH3-A KSP39	M76
5417192	T830NC07500-10RH5-A KSP39	M76
5417193	T830NF07500-16RH5-A KSP39	M76
5417194	T830NC08750-9RH4-A KSMN34	M76
5417195	T830NC08750-9RH4-A KSP39	M76
5417196	T830NF08750-14RH4-A KSMN34	M76
5417197	T830NF08750-14RH4-A KSP39	M76
5417198	T830NC10000-8RH4-A KSMN34	M76
5417199	T830NC10000-8RH5-A KSP32	M76
5417200	T830NC10000-8RH5-A KSP39	M76
5417202	T830NF1000-12RH4-A KSP39	M76
5417203	T830NC11250-7RH6-A KSP39	M76
5417205	T820M020X040R6H-D1 KSP32	M31
5417206	T820M020X040R6H-D1 KSP39	M31
5417207	T820M020X040R6G-D1 KSP39	M31
5417208	T820M025X045R6H-D1 KSP39	M31
5417209	T820M025X045R6G-D1 KSP39	M31
5417220	T820M030X050R6H-D1 KSP32	M31
5417221	T820M030X050R6H-D1 KSP39	M31
5417222	T820M030X050R6G-D1 KSP39	M31
5417223	T820M035X060R6H-D1 KSP39	M31
5417224	T820M040X070R6H-D1 KSP32	M31
5417225	T820M040X070R6H-D1 KSP39	M31
5417226	T820MF040X050R6H-D4 KSP39	M31
5417227	T820M040X070R6G-D1 KSP39	M31
5417228	T820M050X080R6H-D1 KSP32	M31
5417229	T820M050X080R6H-D1 KSP39	M31
5417230	T820MF050X050R6H-D4 KSP39	M31
5417231	T820M050X080R6G-D1 KSP39	M31
5417232	T820M060X100R6H-D1 KSP32	M31
5417233	T820M060X100R6H-D1 KSP39	M31
5417234	T820MF060X050R6H-D4 KSP39	M31
5417235	T820MF060X075R6H-D4 KSP39	M31
5417236	T820M060X100R6G-D1 KSP39	M31
5417237	T820M070X100R6H-D1 KSP32	M31
5417238	T820M070X100R6H-D1 KSP39	M31
5417239	T820M070X100R6G-D1 KSP39	M31
5417240	T820M080X125R6H-D1 KSP32	M31
5417241	T820M080X125R6H-D1 KSP39	M31
5417242	T820MF080X100R6H-D4 KSP39	M31
5417243	T820M080X125R6G-D1 KSP39	M31
5417244	T820M100X150R6H-D1 KSP32	M31
5417245	T820M100X150R6H-D1 KSP39	M31
5417246	T820MF100X125R6H-D4 KSP39	M31
5417247	T820M100X150R6G-D1 KSP39	M32
5417248	T820M060X100R6H-D6 KSP39	M31
5417249	T820M080X125R6H-D6 KSP39	M31
5417250	T820M100X150R6H-D6 KSP39	M31
5417251	T820M120X175R6H-D6 KSP32	M32
5417252	T820M120X175R6H-D6 KSP39	M32
5417253	T820MF120X125R6H-D4 KSP39	M32
5417254	T820MF120X150R6H-D4 KSP39	M32
5417255	T820M120X175R6G-D6 KSP39	M32
5417256	T820M140X200R6H-D6 KSP32	M32
5417257	T820M140X200R6H-D6 KSP39	M32
5417258	T820MF140X125R6H-D4 KSP39	M32
5417259	T820MF140X150R6H-D4 KSP39	M32
5417260	T820M140X200R6G-D6 KSP39	M32
5417261	T820M160X200R6H-D6 KSP32	M32
5417262	T820M160X200R6H-D6 KSP39	M32
5417263	T820MF160X150R6H-D4 KSP39	M32
5417264	T820M160X200R6G-D6 KSP39	M32
5417265	T820M180X250R6H-D6 KSP32	M32
5417266	T820M180X250R6H-D6 KSP39	M32
5417267	T820MF180X150R6H-D4 KSP39	M32
5417268	T820M200X250R6H-D6 KSP32	M32
5417269	T820M200X250R6H-D6 KSP39	M32
5417270	T820M220X250R6H-D6 KSP39	M32
5417271	T820M240X300R6H-D6 KSP39	M32
5417272	T820M270X300R6H-D6 KSP39	M32
5417273	T820M300X350R6H-D6 KSP39	M32
5417274	T820M330X350R6H-D6 KSP39	M32
5417275	T820M360X400R6H-D6 KSP39	M32
5417276	T830M020X040R6H-D1 KSP39	M92
5417277	T830M020X040R6G-D1 KSP39	M92
5417278	T830M025X045R6H-D1 KSP39	M92
5417279	T830M025X045R6G-D1 KSP39	M92
5417280	T830M030X050R6H-D1 KSP32	M92
5417281	T830M030X050R6H-D1 KSP39	M92
5417282	T830M030X050R6G-D1 KSP39	M92
5417283	T830M035X060R6H-D1 KSP39	M92
5417284	T830M040X070R6H-D1 KSP32	M92
5417285	T830M040X070R6H-D1 KSP39	M92
5417286	T830M040X070R6G-D1 KSP39	M92
5417287	T830M050X080R6H-D1 KSP32	M92
5417288	T830M050X080R6H-D1 KSP39	M92
5417289	T830M050X080R6G-D1 KSP39	M92
5417290	T830M060X100R6H-D1 KSP32	M92
5417291	T830M060X100R6H-D1 KSP39	M92
5417292	T830M060X100R6G-D1 KSP39	M92
5417293	T830M070X100R6H-D1 KSP39	M92
5417294	T830M080X125R6H-D1 KSP32	M92
5417295	T830M080X125R6H-D1 KSP39	M92
5417296	T830MF080X100R6H-D4 KSP32	M92
5417297	T830MF080X100R6H-D4 KSP39	M92
5417298	T830M080X125R6G-D1 KSP39	M92
5417299	T830M100X150R6H-D1 KSP32	M92
5417300	T830M100X150R6H-D1 KSP39	M92
5417301	T830MF100X125R6H-D4 KSP32	M92
5417302	T830MF100X125R6H-D4 KSP39	M92
5417303	T830M100X150R6G-D1 KSP39	M92
5417304	T830M060X100R6H-D6 KSP39	M92
5417305	T830M080X125R6H-D6 KSP39	M92
5417306	T830M100X150R6H-D6 KSP39	M92
5417307	T830M120X175R6H-D6 KSP32	M93
5417308	T830M120X175R6H-D6 KSP39	M93
5417309	T830MF120X125R6H-D4 KSP39	M93
5417310	T830MF120X150R6H-D4 KSP32	M93
5417311	T830MF120X150R6H-D4 KSP39	M93
5417312	T830M120X175R6G-D6 KSP39	M93
5417313	T830M140X200R6H-D6 KSP32	M93
5417314	T830M140X200R6H-D6 KSP39	M93
5417315	T830MF140X150R6H-D4 KSP32	M93
5417316	T830MF140X150R6H-D4 KSP39	M93
5417317	T830M140X200R6G-D6 KSP39	M93
5417318	T830M160X200R6H-D6 KSP39	M93
5417319	T830MF160X150R6H-D4 KSP39	M93
5417330	T830M160X200R6G-D6 KSP39	M93
5417331	T830M180X250R6H-D6 KSP39	M93
5417332	T830MF180X150R6H-D4 KSP39	M93
5417333	T830M200X250R6H-D6 KSP39	M93
5417334	T830M220X250R6H-D6 KSP39	M93
5417335	T830M240X300R6H-D6 KSP39	M93
5417336	T830M270X300R6H-D6 KSP39	M93
5417337	T830M300X350R6H-D6 KSP39	M93
5417338	T830M330X350R6H-D6 KSP39	M93
5417339	T830M360X400R6H-D6 KSP39	M93
5417350	T820M030X050R6H-J KSU31	M33
5417351	T820M030X050R6H-J KSU30	M33
5417352	T820M040X070R6H-J KSU31	M33
5417353	T820M040X070R6H-J KSU30	M33
5417354	T820M050X080R6H-J KSU31	M33
5417355	T820M050X080R6H-J KSU30	M33
5417356	T820M060X100R6H-J KSU31	M33
5417357	T832M030X050R6H-D1 KSP32	M94
5417358	T820M060X100R6H-J KSU30	M33
5417359	T832M030X050R6H-D1 KSP39	M94
5417370	T820M080X125R6H-J KSU31	M33
5417371	T832M040X070R6H-D1 KSP32	M94
5417372	T820M080X125R6H-J KSU30	M33
5417373	T832M040X070R6H-D1 KSP39	M94
5417374	T820M100X150R6H-J KSU31	M33
5417375	T832M050X080R6H-D1 KSP32	M94
5417376	T820M100X150R6H-J KSU30	M33
5417377	T832M050X080R6H-D1 KSP39	M94
5417378	T820M120X175R6H-J KSU30	M33
5417379	T832M060X100R6H-D1 KSP32	M94
5417380	T820MF120X125R6H-J KSU30	M33
5417381	T832M060X100R6H-D1 KSP39	M94
5417382	T820MF120X150R6H-J KSU30	M33
5417383	T832M080X125R6H-D1 KSP32	M94
5417384	T820M140X200R6H-J KSU30	M33
5417385	T832M080X125R6H-D1 KSP39	M94
5417386	T820MF140X150R6H-J KSU30	M33
5417387	T832MF080X100R6H-D4 KSP32	M94
5417388	T820M160X200R6H-J KSU30	M33
5417389	T832MF080X100R6H-D4 KSP39	M94
5417390	T820MF160X150R6H-J KSU30	M33
5417391	T832M100X150R6H-D1 KSP32	M94
5417392	T820M180X250R6H-J KSU30	M33
5417393	T832M100X150R6H-D1 KSP39	M94
5417394	T820M200X250R6H-J KSU30	M33
5417395	T832MF100X125R6H-D4 KSP32	M94
5417396	T832MF100X125R6H-D4 KSP39	M94
5417397	T832M120X175R6H-D6 KSP32	M94
5417398	T832M120X175R6H-D6 KSP39	M94
5417399	T832MF120X150R6H-D4 KSP32	M94
5417400	T832MF120X150R6H-D4 KSP39	M94
5417401	T832M140X200R6H-D6 KSP32	M94
5417402	T832M140X200R6H-D6 KSP39	M94
5417403	T832MF140X150R6H-D4 KSP32	M94
5417404	T832MF140X150R6H-D4 KSP39	M94
5417405	T832M160X200R6H-D6 KSP39	M94
5417406	T832M180X250R6H-D6 KSP32	M94
5417407	T832M180X250R6H-D6 KSP39	M94
5417408	T832M200X250R6H-D6 KSP32	M94
5417409	T832M200X250R6H-D6 KSP39	M94
5417410	T830M030X050R6H-J KSU31	M98
5417411	T830M030X050R6H-J KSU30	M98
5417412	T830M040X070R6H-J KSU31	M98
5417413	T830M040X070R6H-J KSU30	M98
5417414	T830M050X080R6H-J KSU31	M98
5417415	T830M050X080R6H-J KSU30	M98
5417416	T830M060X100R6H-J KSU31	M98
5417417	T830M060X100R6H-J KSU30	M98
5417418	T830M080X125R6H-J KSU30	M98
5417419	T830M080X125R6H-J KSU31	M98
5417420	T830M100X150R6H-J KSU30	M98
5417421	T830M100X150R6H-J KSU31	M98
5417422	T830M120X175R6H-J KSU30	M98
5417423	T830MF120X125R6H-J KSU30	M98
5417424	T830MF120X150R6H-J KSU30	M98
5417425	T830MF140X150R6H-J KSU30	M98
5417426	T830M140X200R6H-J KSU30	M98
5417427	T830MF160X150R6H-J KSU30	M98
5417428	T830M160X200R6H-J KSU30	M98
5417429	T830M180X250R6H-J KSU30	M98
5417430	T830M200X250R6H-J KSU30	M98
5418689	SNHJ444ENLD KC520M	S59
5418800	SNHJ444ENLD KC725M	S59
5418801	SNHJ444ENLD KCK15	S59
5418802	SNHJ444ENLD KCPK30	S59
5418803	SNHJ442ENLD KC520M	S59
5418804	SNHJ442ENLD KC725M	S59
5418805	SNHJ442ENLD KCK15	S59
5418806	SNHJ442ENLD KCPK30	S59
5418807	SNHJ31252ENLD KC520M	S57
5418808	SNHJ31252ENLD KC725M	S57
5418809	SNHJ31252ENLD KCK15	S57
5418810	SNHJ31252ENLD KCPK30	S57
5418811	SNHJ31253ENLD KC725M	S57
5418812	SNHJ31253ENLD KCK15	S57
5420150	KSSM87D200SN440S075Z05	S58
5420154	KSSM87D300SN440S100Z07	S58
5420155	KSSM87D300SN440S100Z09	S58
5420156	KSSM87D400SN440S150Z08	S58
5420157	KSSM87D400SN440S150Z11	S58
5420160	KSSM87D600SN440S150Z12	S58
5420161	KSSM87D600SN440S150Z16	S58
5420251	KSSM88D200SN3125S075Z05	S56
5420252	KSSM88D200SN3125S075Z06	S56
5420255	KSSM88D300SN3125S100Z07	S56
5420257	KSSM88D300SN3125S100Z09	S56
5420258	KSSM88D400SN3125S150Z08	S56
5420672	B551A04763DAL KN15	G104
5420673	B551A06350DAL KN15	G104
5420674	B551A07938DAL KN15	G104
5420675	B551A09525DAL KN15	G104
5420676	B551A11113DAL KN15	G104
5420677	B551A12700DAL KN15	G104
5420678	B551A14288DAL KN15	G104
5420679	B551A15875DAL KN15	G104
5420800	B556A04763DAL KN15	G104
5420801	B556A04826DAL KN15	G104
5420802	B556A06350DAL KN15	G104
5420803	B556A06375DAL KN15	G104
5420804	B556A07938DAL KN15	G104
5420805	B556A09525DAL KN15	G104
5420806	B556A11113DAL KN15	G104
5420807	B556A12700DAL KN15	G104
5420808	B556A14288DAL KN15	G104
5420809	B556A15875DAL KN15	G104
5420832	HNGX5358MCI KCK15	S79
5420836	SNXF433ENLD KCK15	S89
5420837	SNXF43ZNENLD KCK15	S89
5420838	SNXF433SNGP KCK15	S89

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5420839	SNXF43ZNSNGP KCK15	S89
5420840	SNXF433SNHE KCK15	S89
5420841	SNXF43ZNSNHE KCK15	S89
5420842	XNXF43ZNENLDW KCK15	S90
5424912	WNMG432RN KCP25B	B161
5425545	CNMG543RN KCP25B	B53
5425546	CNMG544RN KCP25B	B53
5425547	CNMG644MN KCP25B	B50
5425548	DNMG433MN KCP25B	B81
5425549	DNMG433RN KCP25B	B83
5425581	RNMG43RN KCP10B	B97
5425582	SNMG322MN KCP10B	B102
5425583	SNMG433MN KCP10B	B102
5425584	SNMG433RN KCP10B	B105
5425585	SNMG434RN KCP10B	B105
5425586	SNMG543MN KCP10B	B102
5425587	SNMG543RN KCP10B	B105
5425588	TNMG333MN KCP10B	B124
5425589	TNMG333RN KCP10B	B126
5425591	VNMG332MN KCP10B	B146
5425592	WNMG332RN KCP10B	B161
5425593	WNMG433MN KCP10B	B159
5425594	WNMG433RN KCP10B	B161
5425595	WNMG434RN KCP10B	B161
5425596	RNMG32RN KCP25B	B97
5425597	RNMG43RN KCP25B	B97
5425598	SNMG322MN KCP25B	B102
5425599	SNMG433MN KCP25B	B102
5425600	SNMG433RN KCP25B	B105
5425601	SNMG434RN KCP25B	B105
5425602	SNMG543MN KCP25B	B102
5425603	SNMG543RN KCP25B	B105
5425604	TNMG333MN KCP25B	B124
5425605	TNMG333RN KCP25B	B126
5425606	TNMG434RN KCP25B	B126
5425607	VNMG332MN KCP25B	B146
5430965	WNMG433RP KCK15B	B161
5430966	CNMG543RN KCP10B	B53
5430967	CNMG544RN KCP10B	B53
5430968	CNMG644MN KCP10B	B50
5430969	DNMG431MN KCP10B	B81
5431070	DNMG433MN KCP10B	B81
5431071	DNMG433RN KCP10B	B83
5431193	HSFS0500	H128–129
5431591	CW16	S30–31
5431656	T820M030X050RD3-A KSP32	M29
5431657	T820M030X050RD3-A KSMN34	M29
5431658	T820M030X050RD3-A KSP39	M29
5431659	T820M035X060RD4-A KSP39	M29
5431700	T820M040X070RD4-A KSP32	M29
5431701	T820M040X070RD4-A KSMN34	M29
5431702	T820M040X070RD4-A KSP39	M29
5431703	T820M050X080RD4-A KSP32	M29
5431704	T820M050X080RD4-A KSMN34	M29
5431705	T820M050X080RD4-A KSP39	M29
5431706	T820M060X100RD5-A KSP32	M29
5431707	T820M060X100RD5-A KSMN34	M29
5431708	T820M060X100RD5-A KSP39	M29
5431710	T820M070X100RD5-A KSP39	M29
5431711	T820M080X125RD5-A KSP32	M29
5431712	T820M080X125RD5-A KSMN34	M29
5431713	T820M080X125RD5-A KSP39	M29
5431715	T820M100X150RD6-A KSP32	M29
5431716	T820M100X150RD6-A KSMN34	M29
5431717	T820M100X150RD6-A KSP39	M29
5431719	T820M120X175RD6-A KSP32	M29
5431730	T820M120X175RD6-A KSMN34	M29
5431731	T820M120X175RD6-A KSP39	M29
5431732	T820M140X200RD7-A KSP39	M29
5431733	T820M160X200RD7-A KSP32	M29
5431734	T820M160X200RD7-A KSMN34	M29
5431735	T820M160X200RD7-A KSP39	M29
5431737	T820MF080X100RD5-A KSP39	M29
5431738	T820MF100X125RD5-A KSP39	M29
5431739	T820MF120X125RD6-A KSP39	M29
5431740	T820MF120X150RD6-A KSP39	M29
5431741	T820MF140X150RD6-A KSP39	M29
5431742	T820MF160X150RD6-A KSMN34	M29
5431743	T820MF160X150RD6-A KSP39	M29
5434658	PDC251A04763DA KD1415	G106
5434659	PDC251A06350DA KD1415	G106
5434690	PDC251A07938DA KD1415	G106
5434691	PDC251A09525DA KD1415	G106
5434692	PDC251A11113DA KD1415	G106
5434693	PDC251A12700DA KD1415	G106
5434697	B284D03000HPS KN15	G82
5434699	B284D03175HPS KN15	G82
5434700	B284D03200HPS KN15	G82
5434701	B284D03300HPS KN15	G82
5434703	B284D03500HPS KN15	G82
5434704	B284D03571HPS KN15	G82
5434706	B284D03970HPS KN15	G82
5434707	B284D04000HPS KN15	G82
5434709	B284D04200HPS KN15	G82
5434710	B284D04366HPS KN15	G82
5434712	B284D04500HPS KN15	G82
5434713	B284D04763HPS KN15	G82
5434714	B284D04800HPS KN15	G82
5434715	B284D05000HPS KN15	G82
5434716	B284D05100HPS KN15	G82
5434717	B284D05159HPS KN15	G82
5434718	B284D05558HPS KN15	G82
5434719	B284D05600HPS KN15	G83
5434721	B284D05800HPS KN15	G83
5434722	B284D05954HPS KN15	G83
5434723	B284D06000HPS KN15	G83
5434724	B284D06400HPS KN15	G83
5434725	B284D06500HPS KN15	G83
5434726	B284D06746HPS KN15	G83
5434727	B284D06800HPS KN15	G83
5434728	B284D07000HPS KN15	G83
5434729	B284D07145HPS KN15	G83
5434730	B284D07400HPS KN15	G83
5434731	B284D07500HPS KN15	G83
5434732	B284D07541HPS KN15	G83
5434733	B284D07938HPS KN15	G83
5434734	B284D08000HPS KN15	G83
5434735	B284D08334HPS KN15	G83
5434736	B284D08500HPS KN15	G83
5434737	B284D08733HPS KN15	G83
5434738	B284D09000HPS KN15	G83
5434739	B284D09129HPS KN15	G83
5434740	B284D09500HPS KN15	G83
5434741	B284D09525HPS KN15	G83
5434742	B284D09921HPS KN15	G83
5434743	B284D10000HPS KN15	G83
5434744	B284D10200HPS KN15	G83
5434745	B284D10320HPS KN15	G83
5434746	B284D10500HPS KN15	G83
5434747	B284D10716HPS KN15	G84
5434748	B284D11000HPS KN15	G84
5434749	B284D11113HPS KN15	G84
5434750	B284D11908HPS KN15	G84
5434751	B284D12000HPS KN15	G84
5434752	B284D12500HPS KN15	G84
5434753	B284D12700HPS KN15	G84
5434754	B284D14000HPS KN15	G84
5434755	B284D14288HPS KN15	G84
5434756	B284D15875HPS KN15	G84
5434757	B284D19050HPS KN15	G84
5434758	B284D20000HPS KN15	G84
5434759	B285D03000HPS KN15	G82
5434760	B285D03175HPS KN15	G82
5434761	B285D03200HPS KN15	G82
5434762	B285D03300HPS KN15	G82
5434763	B285D03970HPS KN15	G82
5434764	B285D04000HPS KN15	G82
5434765	B285D04200HPS KN15	G82
5434766	B285D04500HPS KN15	G82
5434767	B285D04763HPS KN15	G82
5434768	B285D04800HPS KN15	G82
5434769	B285D04900HPS KN15	G82
5434770	B285D05000HPS KN15	G82
5434771	B285D05100HPS KN15	G82
5434772	B285D05200HPS KN15	G82
5434773	B285D05500HPS KN15	G82
5434774	B285D05558HPS KN15	G82
5434775	B285D05600HPS KN15	G83
5434776	B285D06000HPS KN15	G83
5434777	B285D06300HPS KN15	G83
5434778	B285D06400HPS KN15	G83
5434779	B285D06500HPS KN15	G83
5434780	B285D06600HPS KN15	G83
5434781	B285D06700HPS KN15	G83
5434782	B285D07000HPS KN15	G83
5434783	B285D07145HPS KN15	G83
5434785	B285D07700HPS KN15	G83
5434786	B285D07800HPS KN15	G83
5434787	B285D07938HPS KN15	G83
5434788	B285D08334HPS KN15	G83
5434789	B285D08400HPS KN15	G83
5434790	B285D08500HPS KN15	G83
5434791	B285D08733HPS KN15	G83
5434792	B285D09000HPS KN15	G83
5434793	B285D09300HPS KN15	G83
5434794	B285D09500HPS KN15	G83
5434795	B285D09525HPS KN15	G83
5434796	B285D10000HPS KN15	G83
5434797	B285D10500HPS KN15	G83
5434798	B285D11000HPS KN15	G84
5434799	B285D11113HPS KN15	G84
5434800	B285D11500HPS KN15	G84
5434801	B285D12000HPS KN15	G84
5434802	B285D14000HPS KN15	G84
5434803	B285D14500HPS KN15	G84
5434804	B285D18000HPS KN15	G84
5443804	T832NC#04-40RH2-A KSP39	M77
5443805	T832NC#04-40RH3-A KSP39	M77
5443806	T832NC#04-40RH5-A KSP39	M77
5443807	T832NC#05-40RH2-A KSP39	M77
5443820	T832NC#06-32RH2-A KSP39	M77
5443821	T832NC#06-32RH3-A KSP39	M77
5443822	T832NC#06-32RH5-A KSP39	M77
5443823	T832NF#06-40RH2-A KSP39	M77
5443824	T832NF#06-40RH3-A KSP39	M77
5443826	T832NC#08-32RH2-A KSP39	M77
5443827	T832NC#08-32RH3-A KSP39	M77
5443828	T832NC#08-32RH5-A KSP39	M77
5443829	T832NC#10-24RH3-A KSP39	M77
5443830	T832NC#10-24RH5-A KSP39	M77
5443831	T832NF#10-32RH3-A KSP39	M77
5443833	T832NF#10-32RH5-A KSP39	M77
5443834	T832NC02500-20RH3-A KSP39	M77
5443835	T832NC02500-20RH5-A KSP39	M77
5443836	T832NF02500-28RH3-A KSP39	M77
5443837	T832NF02500-28RH5-A KSP39	M77
5443838	T832NC03125-18RH3-A KSP39	M77
5443839	T832NC03125-18RH5-A KSP39	M77
5443840	T832NF03125-24RH3-A KSP39	M77
5443841	T832NF03125-24RH5-A KSP39	M77
5443842	T832NC03750-16RH3-A KSP39	M77
5443843	T832NC03750-16RH5-A KSP39	M77
5443844	T832NF03750-24RH3-A KSP39	M77
5443845	T832NF03750-24RH4-A KSP39	M77
5443846	T832NF03750-24RH5-A KSP39	M78
5443847	T832NC04375-14RH3-A KSP39	M78
5443848	T832NC04375-14RH5-A KSP39	M78
5443849	T832NF04375-20RH3-A KSP39	M78
5443850	T832NF04375-20RH5-A KSP39	M78
5443851	T832NC05000-13RH3-A KSP39	M78
5443852	T832NC05000-13RH5-A KSP39	M78
5443854	T832NF05000-20RH3-A KSP39	M78
5443856	T832NC05625-12RH3-A KSP39	M78
5443857	T832NC05625-12RH5-A KSP39	M78
5443858	T832NF05625-18RH3-A KSP39	M78
5443859	T832NC06250-11RH3-A KSP39	M78
5443870	T832NC06250-11RH5-A KSP39	M78
5443871	T832NF06250-18RH3-A KSP39	M78
5443872	T832NF06250-18RH5-A KSP39	M78
5443873	T832NC07500-10RH3-A KSP39	M78
5443874	T832NF07500-16RH3-A KSP39	M78
5443876	T832M030X050RD3-A KSP39	M89
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5443878	T832M040X070RD4-A KSP39	M89
5443879	T832M050X080RD4-A KSP39	M89
5443910	T832M060X100RD5-A KSP39	M89
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5443912	T832MF080X100RD5-A KSP39	M89
5443913	T832M080X125RD5-A KSP39	M89
5443914	T832MF100X125RD5-A KSP39	M89
5443915	T832M100X150RD6-A KSP39	M89
5443916	T832MF120X125RD5-A KSP39	M89
5443917	T832MF120X150RD5-A KSP39	M89
5443918	T832M120X175RD6-A KSP39	M89
5443919	T832MF140X150RD6-A KSP39	M89
5443920	T832M140X200RD7-A KSP39	M89
5443921	T832MF160X150RD6-A KSP39	M89
5443922	T832M160X200RD7-A KSP39	M89
5443923	T832MF180X150RD6-A KSP39	M89
5453538	T830M030X050RD3-A KSP32	M88
5453539	T830M030X050RD3-A KSP39	M88
5455180	T830M035X060RD4-A KSP39	M88
5455181	T830M040X070RD4-A KSP32	M88
5455182	T830M040X070RD4-A KSP39	M88
5455183	T830M050X080RD4-A KSP32	M88
5455184	T830M050X080RD4-A KSMN34	M88
5455185	T830M050X080RD4-A KSP39	M88
5455186	T830M060X100RD5-A KSP32	M88
5455187	T830M060X100RD5-A KSMN34	M88
5455188	T830M060X100RD5-A KSP39	M88
5455189	T830M070X100RD5-A KSP39	M88
5455200	T830MF080X100RD5-A KSP39	M88
5455201	T830M080X125RD5-A KSP32	M88
5455202	T830M080X125RD5-A KSMN34	M88
5455203	T830M080X125RD5-A KSP39	M88
5455204	T830MF100X125RD5-A KSP39	M88
5455205	T830M100X150RD6-A KSP32	M88
5455206	T830M100X150RD6-A KSMN34	M88
5455207	T830M100X150RD6-A KSP39	M88
5455208	T830MF120X125RD5-A KSP39	M88
5455209	T830MF120X150RD5-A KSP39	M88
5455220	T830M120X175RD6-A KSP32	M88
5455221	T830M120X175RD6-A KSMN34	M88
5455222	T830M120X175RD6-A KSP39	M88
5455224	T830MF140X150RD6-A KSP39	M88
5455225	T830M140X200RD7-A KSP39	M88
5455226	T830MF160X150RD6-A KSP39	M88
5455227	T830M160X200RD7-A KSP39	M88
5455229	T830MF180X150RD6-A KSP39	M88
5455230	T830M180X250RD7-A KSP39	M88
5455233	T820NC#02-56RH2-A KSP39	M23
5455234	T820NC#02-56RH3-A KSP39	M23
5455235	T820NC#02-56RH4-A KSP39	M23
5455236	T820NC#03-48RH2-A KSP39	M23
5455237	T820NC#04-40RH2-A KSP32	M23
5455238	T820NC#04-40RH2-A KSMN34	M23
5455239	T820NC#04-40RH2-A KSP39	M23
5455830	T820NC#04-40RH3-A KSP39	M23
5455831	T820NC#04-40RH4-A KSP39	M23
5455832	T820NF#04-48RH4-A KSP39	M23
5455833	T820NC#04-40RH5-A KSP32	M23
5455834	T820NC#04-40RH5-A KSP39	M23
5455835	T820NC#04-40RH6-A KSP39	M23
5455836	T820NF#04-48RH2-A KSP39	M23
5455837	T820NC#05-40RH2-A KSP39	M23
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5455839	T820NC#06-32RH3-A KSP32	M23
5455840	T820NC#06-32RH3-A KSMN34	M23
5455841	T820NC#06-32RH3-A KSP39	M23
5455842	T820NC#06-32RH4-A KSP39	M23
5455843	T820NC#06-32RH5-A KSP39	M23
5455844	T820NC#06-32RH6-A KSP39	M23
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5455849	T820NC#08-32RH3-A KSP32	M23
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5455862	T820NC#08-32RH4-A KSP32	M23
5455863	T820NC#08-32RH5-A KSP39	M23
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5455865	T820NC#08-32RH7-A KSP39	M23
5455866	T820NF#08-36RH2-A KSP39	M23
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5455869	T820NC#10-24RH3-A KSP39	M24
5455881	T820NF#10-32RH3-A KSP32	M23
5455882	T820NF#10-32RH3-A KSMN34	M23
5455883	T820NF#10-32RH3-A KSP39	M23
5455884	T820NF#10-32RH4-A KSP39	M23
5455885	T820NC#10-24RH5-A KSP39	M24
5455886	T820NF#10-32RH5-A KSP39	M23
5455887	T820NF#10-32RH6-A KSP39	M23
5455888	T820NC#10-24RH7-A KSP39	M24
5455889	T820NF#10-32RH7-A KSP39	M23
5455891	T820NF#12-28RH3-A KSP39	M24
5477295	EP1408EHD2 KC725M	T58, T69

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5477296	EP1408EHD2 KCPK30	T58, T69
5477297	EP1408EHD2 KCK15	T58, T69
5477299	EP1408EHD2 KC522M	T58, T69
5479648	T820NC#04-40R2B-D1 KSP39	M26
5479649	T820NC#04-40R3B-D1 KSP39	M27
5479690	T820NC#05-40R2B-D1 KSP39	M26
5479691	T820NC#06-32R2B-D1 KSP39	M26
5479692	T820NC#06-32R3B-D1 KSP39	M27
5479693	T820NF#06-40R2B-D1 KSP39	M26
5479694	T820NC#08-32R2B-D1 KSP39	M26
5479695	T820NC#08-32R3B-D1 KSP39	M27
5479696	T820NC#10-24R2B-D1 KSP39	M26
5479697	T820NF#10-32R2B-D1 KSP39	M26
5479698	T820NF#10-32R3B-D1 KSP39	M27
5479699	T820NC02500-20R2B-D1 KSP39	M26
5479700	T820NF02500-28R2B-D1 KSP39	M26
5479701	T820NF02500-28R3B-D1 KSP39	M27
5479702	T820NC03125-18R2B-D1 KSP39	M26
5479703	T820NF03125-24R2B-D1 KSP39	M26
5479704	T820NF03125-24R3B-D1 KSP39	M27
5479705	T820NC03750-16R2B-D1 KSP39	M26
5479706	T820NF03750-24R2B-D1 KSP39	M26
5479707	T820NF03750-24R3B-D1 KSP39	M27
5479708	T820NC04375-14R2B-D6 KSP39	M26
5479709	T820NF04375-20R2B-D6 KSP39	M26
5479710	T820NF04375-20R3B-D6 KSP39	M27
5479711	T820NC05000-13R2B-D6 KSP39	M26
5479712	T820NF05000-20R2B-D6 KSP39	M26
5479713	T820NF05000-20R3B-D6 KSP39	M27
5479714	T820NC05625-12R2B-D6 KSP39	M26
5479715	T820NF05625-18R2B-D6 KSP39	M26
5479716	T820NC06250-11R2B-D6 KSP39	M26
5479717	T820NF06250-18R2B-D6 KSP39	M26
5479718	T820NC07500-10R2B-D6 KSP39	M26
5479719	T820NF07500-16R2B-D6 KSP39	M26
5479720	T820NC08750-9R2B-D6 KSP39	M26
5479721	T820NF08750-14R2B-D6 KSP39	M26
5479722	T820NC10000-8R2B-D6 KSP39	M26
5479723	T820NF10000-12R2B-D6 KSP39	M26
5479724	T830NC#04-40R2B-D1 KSP39	M84
5479725	T830NC#04-40R3B-D1 KSP39	M87
5479726	T830NC#05-40R2B-D1 KSP39	M84
5479727	T830NC#06-32R2B-D1 KSP39	M84
5479728	T830NC#06-32R3B-D1 KSP39	M87
5479729	T830NF#06-40R2B-D1 KSP39	M84
5479730	T830NC#08-32R2B-D1 KSP39	M84
5479732	T830NC#08-32R3B-D1 KSP39	M87
5479733	T830NC#10-24R2B-D1 KSP39	M84
5479734	T830NF#10-32R2B-D1 KSP39	M84
5479735	T830NF#10-32R3B-D1 KSP39	M87
5479736	T830NC02500-20R2B-D1 KSP39	M84
5479737	T830NF02500-28R2B-D1 KSP39	M84
5479738	T830NF02500-28R3B-D1 KSP39	M87
5479739	T830NC03125-18R2B-D1 KSP39	M84
5479760	T830NF03125-24R2B-D1 KSP39	M84
5479761	T830NF03125-24R3B-D1 KSP39	M87
5479762	T830NC03750-16R2B-D1 KSP39	M84
5479763	T830NF03750-24R2B-D1 KSP39	M84
5479764	T830NF03750-24R3B-D1 KSP39	M87
5479765	T830NC04375-14R2B-D6 KSP39	M84
5479766	T830NF04375-20R2B-D6 KSP39	M84
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5479770	T830NF05000-20R3B-D6 KSP39	M87
5479771	T830NC05625-12R2B-D6 KSP39	M84
5479772	T830NF05625-18R2B-D6 KSP39	M84
5479773	T830NC06250-11R2B-D6 KSP39	M84
5479774	T830NF06250-18R2B-D6 KSP39	M84
5479775	T830NC07500-10R2B-D6 KSP39	M84
5479776	T830NF07500-16R2B-D6 KSP39	M84
5479777	T830NF08750-9R2B-D6 KSP39	M84
5479778	T830NF08750-14R2B-D6 KSP39	M84
5479779	T830NC10000-8R2B-D6 KSP39	M84
5479780	T830NF10000-12R2B-D6 KSP39	M84
5479781	T820MF100X100R6H-D4 KSP39	M31
5479782	T820MF120X100R6H-D4 KSP39	M32
5479783	T820MF140X100R6H-D4 KSP39	M32
5479784	T820MF160X100R6H-D4 KSP39	M32
5479785	T820MF180X200R6H-D4 KSP39	M32
5479786	T820MF200X150R6H-D4 KSP39	M32
5479787	T820MF200X200R6H-D4 KSP39	M32
5479788	T820MF220X150R6H-D4 KSP39	M32
5479789	T820MF220X200R6H-D4 KSP39	M32
5479790	T820MF240X150R6H-D4 KSP39	M32
5479864	KTIP0983HPM KCP15	H32
5489410	WNMG434MN KCP25B	B159
5490089	CNMG644RP KCPK05	B53
5491717	RIQ06EDR06 KD1415	K59
5492520	B269A04550HP KCPK15	G62
5497332	RIQ09EDR06 KD1415	K59
5497351	CFM0402R00RHP KCU40	H43
5505778	B271Z02383KMG KCPK20	G68
5505779	B271Z02500KMG KCPK20	G68
5505938	KTMDUSCREW1	W29–31
5506030	B271Z02642KMG KCPK20	G68
5506031	B271Z02705KMG KCPK20	G68
5506032	B271Z02779KMG KCPK20	G68
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5506152	B271Z16000HPG KCPK20	G69
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5506370	B272Z15875HPG KCPK20	G71
5506371	B272Z16000HPG KCPK20	G71
5507556	TNMG432MP KCP10B	B124
5507610	TNMG432FN KCP10B	B123
5507611	WNMG432FW KCP10B	B158
5507612	WNMG432RN KCP10B	B161
5511788	B273Z02383KMG KCPK20	G72
5511789	B273Z02500KMG KCPK20	G72
5511930	B273Z02600KMG KCPK20	G72
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5513477	CNMG432RP KCPK05	B53
5513478	CNMG543RP KCPK05	B53
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5515172	KSEM3300HPCCLM KC7410	H61, H111
5515173	KSEM3400HPCCLM KC7410	H61, H111
5515174	KSEM3500HPCCLM KC7410	H61, H111
5515175	KSEM3600HPCCLM KC7410	H61, H111
5515176	KSEM3700HPCCLM KC7410	H61, H111
5515177	KSEM3800HPCCLM KC7410	H61, H111
5515178	KSEM3900HPCCLM KC7410	H61, H111
5515179	KSEM4000HPCCLM KC7410	H61, H111
5515220	KSEMP3500HPGM KC7315	H111
5515221	KSEMP3600HPGM KC7315	H111
5515222	KSEMP3700HPGM KC7315	H111
5515223	KSEMP3800HPGM KC7315	H111
5515224	KSEMP3900HPGM KC7315	H111
5515225	KSEMP4000HPGM KC7315	H111
5515226	KSEM2900HPGM KCPM45	H58
5515746	LNGU543SRGE KC520M	T19
5515747	LNGU543SRGE KC522M	T19
5515748	LNGU543SRGE KC725M	T19
5515749	LNGU543SRGE KCK15	T19

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5515759	LNGU542SRGE KC520M	T19
5515890	LNGU542SRGE KC522M	T19
5515891	LNGU542SRGE KC725M	T19
5515892	LNGU542SRGE KCK15	T19
5515893	LNGU542SRGE KCPK30	T19
5516070	LNGU543SRGE KCPK30	T19
5516073	LNGU541SRGE KC520M	T19
5516074	LNGU541SRGE KC522M	T19
5516075	LNGU541SRGE KC725M	T19
5516076	LNGU541SRGE KCK15	T19
5516077	LNGU541SRGE KCPK30	T19
5517479	RCGT64ELFJ KCSM30	V89
5517600	SNMM646RW KCP25B	B107
5517760	RPET1204M0ELEJ KCSM30	V71
5517761	RPET1204M0SGEJ KCSM30	V71
5517764	RPET1605M0SGEJ KCSM30	V78
5517767	WOEJ090512SRGD KCSM30	V39
5517773	RNGJ1204M0ELDJ KCSM30	V55
5517778	RNGJ10T3M0SGDJ KCSM30	V49
5518566	DNMG443MR KCP25B	B82
5519287	EP0708SGE KCSM30	T25
5519923	SDET43PDSR8GB KCSM30	T116, T123, U39
5519967	SDCT438ENLD2 KCSM30	T115, T122
5519983	EP1431EHD KCSM30	T57, T68
5520493	EP1416EHD KCSM30	T57, T68
5520494	EP1440EHD KCSM30	T57, T68
5520684	EP1016EHD KCSM30	T36
5520687	SPCT31254ENLD2 KCSM30	T111, U30
5520736	T353M040X070R6HX-D1 KCK17	M113
5520737	T353M050X080R6HX-D1 KCK17	M113
5520738	T353M060X100R6HX-D1 KCK17	M113
5520739	T353M080X125R6HX-D1 KCK17	M113
5520790	T353M100X150R6HX-D1 KCK17	M113
5520791	T353M120X175R6HX-D6 KCK17	M113
5520792	T353M140X200R6HX-D6 KCK17	M113
5520793	T351M060X100R6HX-D1 KCK17	M112
5520794	T351M070X100R6HX-D1 KCK17	M112
5520795	T351M080X125R6HX-D1 KCK17	M112
5520796	T351M090X125R6HX-D1 KCK17	M112
5520798	T351M100X150R6HX-D1 KCK17	M112
5520799	T351MF100X100R6HX-D4 KCK17	M112
5520800	T351MF100X125R6HX-D4 KCK17	M112
5520801	T351M120X175R6HX-D6 KCK17	M112
5520802	T351MF120X125R6HX-D4 KCK17	M112
5520803	T351MF120X150R6HX-D4 KCK17	M112
5520804	T351M140X2006RHX-D6 KCK17	M112
5520805	T351MF140X125R6HX-D4 KCK17	M112
5520806	T351MF140X150R6HX-D4 KCK17	M112
5520807	T471M060X100R6HX-D1 KCN14	M115
5520808	T471M080X125R6HX-D1 KCN14	M115
5520809	T471M100X150R6HX-D1 KCN14	M115
5520810	T491M060X100R6HX-D74 KCN14	M138
5520811	T491M080X125R6HX-D74 KCN14	M138
5520812	T491M100X150R6HX-D74 KCN14	M138
5523116	RIQ06EGR06 KC6305	K59
5523306	CNMG322FN KCP10B	B49
5523588	DNMG443MR KCP10B	B82
5524447	KTIP04571HP KCP15	H32
5524448	KTIP1830HPM KCP15	H33
5524449	KTIP1840HPM KCP15	H33
5524610	KTIP07620HP KCP15	H33
5528977	OFKT64AFEN6GB KCSM30	S52
5531233	CNGG430FS KCU10	B46
5531234	CNGG4305FS KCU10	B46
5531235	CNGG431FS KCU10	B46
5531236	CNGG432FS KCU10	B46
5531238	CNMG643MS KCU10	B52
5531240	SNMG544MP KCU10	B102
5531241	TCGT3250LF KCU10	B256
5531835	CNMG431FP KCP25B	B49
5531836	CNMG431FN KCP10B	B49
5531837	CNMG431FN KCK15B	B49
5531838	CNMG431FN KCP25B	B49
5531839	CNMG432FN KCP10B	B49
5531890	CNMG432FN KCP25B	B49
5531891	CNMG432FP KCP10B	B49
5531892	CNMG432FP KCP25B	B49
5531893	CNMG433FN KCP25B	B49
5531894	CNMG433FN KCP10B	B49
5531896	DNMG331FN KCP10B	B79
5531897	DNMG332FN KCP25B	B79
5531898	DNMG431FN KCK15B	B79
5531899	DNMG431FN KCP25B	B79
5531900	DNMG432FN KCP10B	B79
5531901	DNMG441FN KCP10B	B79
5531902	DNMG441FN KCK15B	B79
5531903	DNMG441FN KCP25B	B79
5531904	DNMG442FP KCP10B	B80
5531905	DNMG442FP KCP25B	B80
5531906	DNMG442FN KCP25B	B79
5531907	DNMG442FN KCK15B	B79
5531908	DNMG443FN KCP10B	B79
5531909	SNMG322FN KCK15B	B101
5531910	SNMG431FN KCP10B	B101
5532930	EG0212M02U02GUP KCU25	C17
5532931	EG0251M02U02GUP KCU25	C17
5532936	EG0212M02U02GUN KCU25	C20
5532937	EG0251M02U02GUN KCU25	C20
5532941	EG0812M08U08GUP KCU25	C17
5532942	EG0812M08U12GUP KCU25	C17
5532944	EG0812M08U08GUN KCU25	C20
5532945	EG0812M08U12GUN KCU25	C20
5533012	EG255I06U1GUP KCU25	C18
5533013	EG255I06U2GUP KCU25	C18
5533015	EG255I06U1GUN KCU25	C21
5533016	EG255I06U2GUN KCU25	C21
5533080	EC030M03N00CL02 KCU25	C23
5533081	EC014M1BN00CF01 KCU25	C22
5533082	EC020M02N00CF02 KCU25	C22
5533089	EC014M1BN00CM01 KCU25	C24
5533090	EC020M02N00CM02 KCU25	C24
5533093	EC060M06N00CM03 KCU25	C24
5533096	EC060M06N00CR03 KCU25	C25
5533097	EC080M08N00CR04 KCU25	C25
5533120	EG0612M06U04GUP KCU25	C17
5533124	EG0612M06U08GUP KCU25	C17
5533125	EG0612M06U04GUN KCU25	C20
5533127	EG0612M06U08GUN KCU25	C20
5533134	EG317I08U3GUP KCU25	C18
5533136	EG317I08U3GUN KCU25	C21
5533137	EC014M1BN00CL01 KCU25	C23
5533138	EC020M02N00CL02 KCU25	C23
5533139	EC040M04N00CL02 KCU25	C23
5533150	EC020M02L06CF02 KCU25	C22
5533151	EC020M02R06CF02 KCU25	C22
5533156	EC020M02N00CR02 KCU25	C25
5533171	EC060M06L06CR04 KCU25	C25
5533172	EC060M06R06CR04 KCU25	C25
5533173	EC080M08L06CR04 KCU25	C25
5533174	EC080M08R06CR04 KCU25	C25
5533178	EG380I10U3GUP KCU25	C18
5533179	EG063I1FU05GUN KCU25	C21
5533210	EG380I10U3GUN KCU25	C21
5533212	EG0512M05U04GUP KCU25	C17
5533214	EG0512M05U08GUP KCU25	C17
5533216	EG0712M06U08GUP KCU25	C17
5533220	EG1012M10U12GUP KCU25	C17
5533221	EG0512M05U04GUN KCU25	C20
5533222	EG0512M05U08GUN KCU25	C20
5533223	EG1012M10U12GUN KCU25	C20
5533361	ER130I03U00GUP KCU25	C19
5533363	ER192I04U00GUP KCU25	C19
5533365	ER255I06U00GUP KCU25	C19
5533367	ER317I08U00GUP KCU25	C19
5533368	ER130I03U00GUN KCU25	C22
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5533513	EC030M03R06CL02 KCU25	C23
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5533515	EC040M04R06CL02 KCU25	C23
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5533517	EC014M1BR06CF01 KCU25	C22
5533518	EC050M05N00CF03 KCU25	C22
5533519	EC014M1BL06CM01 KCU25	C24
5533520	EC014M1BR06CM01 KCU25	C24
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5533522	EC020M02R06CM02 KCU25	C24
5533523	EC050M05N00CM03 KCU25	C24
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5533525	EC080M08N00CM04 KCU25	C24
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5533529	EC020M02R06CR02 KCU25	C25
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5533547	DFR030204LD KCU25	J97
5533548	DFR040304LD KCU25	J97
5533549	DFR020204LD KCPK10	J97
5533630	DFR030204LD KCPK10	J97
5533631	DFR040304LD KCPK10	J97
5533632	DFR030204LD KC7140	J97
5533633	DFR040304LD KC7140	J97
5533634	SPHX060204R21 KCPK10	J116
5533635	SPHX070304R21 KCPK10	J116
5533636	SPHX070308R21 KCPK10	J116
5533637	SPHX090304R21 KCPK10	J116
5533638	SPHX090308R21 KCPK10	J116
5533639	SPHX120404R21 KCPK10	J116
5533640	SPHX060204R20 KCU25	J115
5533641	SPHX070304R20 KCU25	J115
5533642	SPHX090304R20 KCU25	J115
5533643	SPHX090308R20 KCU25	J115
5533644	SPHX120404R20 KCU25	J115
5533645	SPHX120408R20 KCU25	J115
5533646	SPHX150504R20 KCU25	J115
5533647	SPHX150508R20 KCU25	J115
5533648	SPHX060204R20 KCU40	J115
5533649	SPHX060204R21 KCU40	J116
5533650	SPHX070304R20 KCU40	J115
5533651	SPHX070304R21 KCU40	J116
5533652	SPHX070308R21 KCU40	J116
5533653	SPHX090304R20 KCU40	J115
5533654	SPHX090304R21 KCU40	J116
5533655	SPHX090308R20 KCU40	J115
5533656	SPHX090308R21 KCU40	J116
5533657	SPHX120404R20 KCU40	J115
5533658	SPHX120404R21 KCU40	J116
5533659	SPHX120408R20 KCU40	J115
5533660	SPHX150504R20 KCU40	J115
5533661	SPHX150508R20 KCU40	J115
5534147	SPGX060304FP KCU40	J104
5534148	SPGX060304RHP KCU40	J103
5534149	SPGX060304MD KCU40	J103
5534230	SPGX070304FP KCU40	J104
5534231	SPGX070304RHP KCU40	J103
5534232	SPGX070304MD KCU40	J103
5534233	SPPX09T308FP KCU40	J104
5534234	SPPX09T308RHP KCU40	J103
5534235	SPPX09T308MD KCU40	J103
5534236	SPPX120408FP KCU40	J104
5534237	SPPX120408RHP KCU40	J103
5534238	SPPX120408MD KCU40	J103
5534239	SPPX15T508FP KCU40	J104
5534250	SPPX15T508RHP KCU40	J103
5534251	SPPX15T508MD KCU40	J103
5534252	SPGX060304FP KCU25	J104
5534253	SPGX060304RHP KCU25	J103
5534254	SPGX060304MD KCU25	J103
5534255	SPGX070304FP KCU25	J104
5534256	SPGX070304RHP KCU25	J103
5534257	SPGX070304MD KCU25	J103
5534258	SPPX09T308FP KCU25	J104
5534259	SPPX09T308RHP KCU25	J103
5534260	SPPX09T308MD KCU25	J103
5534261	SPPX120408FP KCU25	J104
5534262	SPPX120408RHP KCU25	J103
5534263	SPPX120408MD KCU25	J103
5534264	SPPX15T508FP KCU25	J104
5534265	SPPX15T508RHP KCU25	J103
5534266	SPPX15T508MD KCU25	J103
5534267	SPGX060304FP KCPK10	J104
5534268	SPGX070304FP KCPK10	J104
5534269	SPPX09T308FP KCPK10	J104
5534270	SPPX120408FP KCPK10	J104
5534271	SPPX15T508FP KCPK10	J104
5534274	ER0312M03U00GUP KCU25	C19
5534276	ER0412M04U00GUP KCU25	C19
5534278	ER0512M05U00GUP KCU25	C19
5534290	ER0612M06U00GUP KCU25	C19
5534292	ER0812M08U00GUP KCU25	C19
5534293	ER0312M03U00GUN KCU25	C21
5534294	ER0412M04U00GUN KCU25	C21
5534295	ER0512M05U00GUN KCU25	C21
5534296	ER0612M06U00GUN KCU25	C21
5534297	ER0812M08U00GUN KCU25	C21
5534828	CNMG431FF KCP10B	B48
5535020	CNMG432CT KCP25B	B48
5535021	CNMG432CT KCP10B	B48
5535022	CNMG432FF KCP10B	B48
5535025	DNMG332CT KCP10B	B79
5535026	DNMG332FF KCP10B	B79
5535027	DNMG432CT KCP10B	B79
5535028	DNMG432FW KCP10B	B80
5535029	DNMG441FF KCP10B	B79
5535040	DNMG441FW KCP10B	B80
5535041	DNMG442CT KCP10B	B79
5535042	DNMG442FF KCP10B	B79
5535043	DNMG442FW KCK15B	B80
5535044	DNMG442FW KCP10B	B80
5535045	DNMP441K KCP25B	B86
5535046	DNMP442K KCP25B	B86
5537375	CCMT2151FP KCP10B	B190
5537376	CCMT2151FP KCP25B	B190
5537378	CCMT2152FP KCP25B	B190
5537379	CCMT32505FP KCP25B	B190
5537420	CCMT3251FP KCP10B	B190
5537421	CCMT3251FP KCP25B	B190
5537422	CCMT3252FP KCP10B	B190
5537423	CCMT3252FP KCP25B	B190
5537425	CCMT431FP KCP10B	B190
5537426	CCMT431FP KCP25B	B190
5537427	CCMT432FP KCP25B	B190
5537429	CPMT2151FP KCP25B	B206
5537430	CPMT2151UF KCP25B	B208
5537431	CPMT2151UF KCP10B	B208
5537432	CPMT3251FP KCP25B	B206
5537433	CPMT3251UF KCP25B	B208
5537435	CPMT3252FP KCP25B	B206
5537436	DCMT21505FP KCP25B	B225
5537437	DCMT2152FP KCP25B	B225
5537438	DCMT32505FP KCP25B	B225
5537439	DCMT32505FP KCP10B	B225
5537442	DCMT3251FP KCP10B	B225
5537443	DCMT3251FP KCP25B	B225
5537444	DCMT3251UF KCP10B	B226
5538857	DCMT3251UF KCP25B	B226
5538858	DCMT3252FP KCP10B	B225
5538891	TCMT18151FP KCP25B	B257
5538894	TCMT221FP KCP10B	B257
5538900	TPMT221FP KCP10B	B267
5538903	VBMT332FP KCP10B	B281
5538904	VBMT332FP KCP25B	B281
5542022	SDET433PDENGDZ KCPM40	V143
5542023	SDET433PDSNGDZ KCPM40	V143
5542024	SDPT433PDENHPZ KCPM40	V143
5542025	SDPT433PDSNHPZ KCPM40	V143
5542028	RNPJ10T3M0SGD KCPM40	V49
5542029	RNPJ10T3M0SHD KCPM40	V49
5542179	CNMA433 KCK15B	B47
5542190	RNPJ1204M0SGD KCPM40	V56
5542191	RNPJ1204M0SHD KCPM40	V56
5542192	RNPJ1605M0SGD KCPM40	V59
5542193	RNPJ1605M0SHD KCPM40	V59
5542210	CNMA543 KCK15B	B47
5542242	WOEJ090512SRHD KCPM40	V39
5542243	WOEJ090512SRGD KCPM40	V39
5542246	RPPT1204M0SGP KCPM40	V72
5542247	RPPT1204M0SGDX KCPM40	V72
5542248	RPPT1605M0SHP KCPM40	V79
5542249	RCGT86SHFJ KCPM40	V92
5542320	RCGT64SHFJ KCPM40	V89
5542322	RCGT64SGFJ KCPM40	V89
5542323	RCGT86SGFJ KCPM40	V92
5543553	KM4X63KGMEL65C	C71, C149
5543555	KM4X63KGMER65C	C71, C149
5543558	KM4X63KGMSL65C	C71, C148
5543560	KM4X63KGMSR65C	C71, C148
5544143	SS20RBHT24	K124
5544144	SS20FBHS24	K139
5544145	SS25RBHT30	K124
5544146	SS25FBHS31	K139

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5544148	ER25RBHT40	K123
5544149	ER25FBHS40	K138
5544190	ER32RBHT50	K123
5544191	ER32FBHS51	K138
5544192	ER40RBHT66	K123
5544193	ER40FBHS67	K138
5544366	M4D100L1502W100L175	T15
5544367	M4D125L1503W100L225	T15
5544368	M4D150L1504W125L225	T15
5544369	M4D100L1502C100L800	T16
5544400	M4D125L1503C125L800	T16
5544401	M4D150L1504C125L800	T16
5544402	M4D150L1505S050L157	T17
5544403	M4D200L1505S075L157	T17
5544404	M4D200L1506S075L157	T17
5544405	M4D250L1506S075L157	T17
5544406	M4D300L1507S100L175	T17
5544407	M4D300L1508S125L200	T17
5544408	M4D400L1511S150L200	T17
5544755	DNMG333FN KCP10B	B79
5545061	EP1408SGD2 KCPM40	T59, T70
5545066	EP1412SGD KCPM40	T58, T70
5545067	EC1408EGD KCPM40	T57, T68
5545068	EC1404EGD KCPM40	T57, T68
5545069	EP1412EHD KCPM40	T57, T68
5545160	EP1408EHD KCPM40	T57, T68
5545161	EP1408SGE KCPM40	T58, T69
5545162	SDET43PDSR8GB KCPM40	T116, T123, U39
5545163	SDCT43PDER8LD2 KCPM40	T115, T122, U38
5545164	SDET43PDER8GB2 KCPM40	T115, T122, U39
5545167	SPCT3125PPER8LD2 KCPM40	T111, U30
5545168	SPET3125PPER8GB2 KCPM40	T111, U31
5545169	EP0708SGE KCPM40	T25
5545214	EP1008EHD KCPM40	T36
5545215	EP1004EHD KCPM40	T36
5545216	EP1008SGD KCPM40	T37
5545217	EC1008ELD KCPM40	T36
5545398	EP1816E KCPM40	T83
5545399	EP1808E KCPM40	T83
5545400	EP1812E KCPM40	T83
5545401	EP1812S KCPM40	T85
5545402	EP1808S KCPM40	T85
5545403	EP1816S KCPM40	T85
5545562	EP1408EHD2 KCPM40	T58, T69
5546298	VNMG333MN KCP25B	B146
5547848	LNPU542SRGE KC520M	T19
5547849	LNPU542SRGE KC522M	T19
5548040	LNPU542SRGE KC725M	T19
5548041	LNPU542SRGE KCK15	T19
5548042	LNPU542SRGE KCPK30	T19
5548378	B967A09300 KC7315	G131
5550701	HNGJ43ANENLD KCPM40	S6, S12, S15
5550702	HNPJ43ANSNHD KCPM40	S7, S13, S16
5550703	HNPJ43ANSNGD KCPM40	S7, S13, S16
5550793	HNGJ535ANSNGD KCPM40	S18, S22
5550794	HNGJ535ANSNHD KCPM40	S19, S22
5550795	HNPJ535ANSNGD KCPM40	S19, S22
5550796	HNPJ535ANSNHD KCPM40	S19, S23
5550797	HNPJ53511ANSNHD KCPM40	S19, S23
5550815	HNPJ75ANSNHD KCPM40	S26
5550816	HNPJ755ANSNHD KCPM40	S26
5550817	HNGJ75ANENGD KCPM40	S25
5550819	OFPT64AFEN6GB KCPM40	S52
5550901	OFPT53AFEN4GB KCPM40	S48
5551030	T340NC#6-32R3BX KCK17	M108
5551031	T340NC#8-32R3BX KCK17	M108
5551032	T340NC#10-24R3BX KCK17	M108
5551033	T340NF#10-32R3BX KCK17	M108
5551034	T340NC02500-20R3BX KCK17	M108
5551035	T340NC03125-18R3BX KCK17	M108
5551036	T340NC03750-16R3BX KCK17	M108
5551037	T340NF03750-24R3BX KCK17	M108
5551038	T340NC05000-13R3BX KCK17	M108
5551039	T340NF05000-20R3BX KCK17	M108
5551040	T340NF05625-18R3BX KCK17	M108
5551041	T340M040X070R6HX KCK17	M109
5551042	T340M050X080R6HX KCK17	M109
5551043	T340M060X100R6HX KCK17	M109
5551044	T340M080X125R6HX KCK17	M109
5551045	T340MF100X100R6HX KCK17	M109
5551046	T340M100X150R6HX KCK17	M109
5551047	T340MF120X150R6HX KCK17	M109
5551048	T340M120X175R6HX KCK17	M109
5551049	T340MF140X150R6HX KCK17	M109
5551050	T340M140X200R6HX KCK17	M109
5551051	T340M160X200R6HX KCK17	M109
5551052	T340M200X250R6HX KCK17	M109
5551053	T351NC#6-32R3BX KCK17	M110
5551054	T351NC#8-32R3BX KCK17	M110
5551055	T351NF#10-32R3BX KCK17	M110
5551056	T351NC02500-20R3BX KCK17	M110
5551057	T351NC03125-18R3BX KCK17	M110
5551058	T351NC03750-16R3BX KCK17	M110
5551059	T351NC04375-14R3BX KCK17	M110
5551060	T351NC05000-13R3BX KCK17	M110
5551061	T351NC06250-11R3BX KCK17	M110
5551062	T351NC07500-10R3BX KCK17	M110
5551063	T351M040X070R6HX KCK17	M111
5551064	T351M050X080R6HX KCK17	M111
5551065	T351M060X100R6HX KCK17	M111
5551066	T351M080X125R6HX KCK17	M111
5551067	T351MF100X100R6HX KCK17	M111
5551068	T351M100X150R6HX KCK17	M111
5551069	T351MF120X150R6HX KCK17	M111
5551070	T351M120X175R6HX KCK17	M111
5551071	T351MF140X150R6HX KCK17	M111
5551072	T351M140X200R6HX KCK17	M111
5551073	T351M160X200R6HX KCK17	M111
5551077	T471M060X100R6HX KCN14	M114
5551078	T471M080X125R6HX KCN14	M114
5551079	T471M100X150R6HX KCN14	M114
5551080	T471M120X175R6HX KCN14	M114
5551081	T471M140X200R6HX KCN14	M114
5551082	T491M050X080R6HX KCN14	M138
5551083	T491M060X100R6HX KCN14	M138
5551084	T491M080X125R6HX KCN14	M138
5551085	T491M100X150R6HX KCN14	M138
5551086	T491M120X175R6HX KCN14	M138
5551479	RIQ09EGR06 KD1415	K59
5555716	B224A04100HP KCPK15	G44
5556965	SDET4316SNGB KCSM30	T116, T123, U39
5558957	S2165C	S10, S14, S58, T17, T53, T78
5565491	T660NC#02-56RH2-A KSS20	M18
5565492	T660NC#02-56RH2-A KSSM24	M18
5565493	T660NC#04-40RH2-A KSS20	M18
5565494	T660NC#04-40RH2-A KSSM24	M18
5565495	T660NC#06-32RH2-A KSS20	M18
5565496	T660NC#06-32RH2-A KSSM24	M18
5565497	T660NC#06-32RH3-A KSS20	M18
5565498	T660NC#06-32RH3-A KSSM24	M18
5565499	T660NF#06-40RH2-A KSS20	M18
5565510	T660NF#06-40RH2-A KSSM24	M18
5565511	T660NC#08-32RH2-A KSS20	M18
5565512	T660NC#08-32RH2-A KSSM24	M18
5565513	T660NC#08-32RH3-A KSS20	M18
5565514	T660NC#08-32RH3-A KSSM24	M18
5565515	T660NF#08-36RH2-A KSS20	M18
5565516	T660NF#08-36RH2-A KSSM24	M18
5565517	T660NC#10-24RH3-A KSS20	M18
5565518	T660NC#10-24RH3-A KSSM24	M18
5565519	T660NF#10-32RH2-A KSS20	M18
5565520	T660NF#10-32RH2-A KSSM24	M18
5565523	T660NF#10-32RH3-A KSS20	M18
5565524	T660NF#10-32RH3-A KSSM24	M18
5565525	T660NC02500-20RH3-A KSS20	M18
5565526	T660NC02500-20RH3-A KSSM24	M18
5565527	T660NC02500-20RH5-A KSS20	M18
5565528	T660NC02500-20RH5-A KSSM24	M18
5565529	T660NF02500-28RH3-A KSS20	M18
5565550	T660NF02500-28RH3-A KSSM24	M18
5565551	T660NF02500-28RH4-A KSS20	M18
5565552	T660NF02500-28RH4-A KSSM24	M18
5565553	T660NC03125-18RH3-A KSS20	M18
5565554	T660NC03125-18RH3-A KSSM24	M18
5565555	T660NC03125-18RH5-A KSS20	M18
5565556	T660NC03125-18RH5-A KSSM24	M18
5565557	T660NF03125-24RH3-A KSS20	M18
5565558	T660NF03125-24RH3-A KSSM24	M18
5565559	T660NF03125-24RH4-A KSS20	M18
5565560	T660NF03125-24RH4-A KSSM24	M18
5565561	T660NC03750-16RH3-A KSS20	M18
5565562	T660NC03750-16RH3-A KSSM24	M18
5565563	T660NC03750-16RH5-A KSS20	M18
5565564	T660NC03750-16RH5-A KSSM24	M18
5565565	T660NF03750-24RH3-A KSS20	M18
5565566	T660NF03750-24RH3-A KSSM24	M18
5565567	T660NF03750-24RH4-A KSS20	M18
5565568	T660NF03750-24RH4-A KSSM24	M18
5565569	T660NC04375-14RH3-A KSS20	M18
5565570	T660NC04375-14RH3-A KSSM24	M18
5565571	T660NF04375-20RH3-A KSS20	M18
5565572	T660NF04375-20RH3-A KSSM24	M18
5565573	T660NC05000-13RH3-A KSS20	M18
5565575	T660NC05000-13RH3-A KSSM24	M18
5565576	T660NF05000-20RH3-A KSS20	M18
5565577	T660NF05000-20RH3-A KSSM24	M18
5565578	T660NF05625-18RH3-A KSSM24	M18
5565579	T660NF05625-18RH5-A KSSM24	M18
5565580	T660NC06250-11RH3-A KSSM24	M18
5565581	T660NF06250-18RH3-A KSSM24	M18
5565582	T660NF06250-18RH5-A KSSM24	M18
5565583	T660NC07500-10RH5-A KSSM24	M18
5565584	T660NF07500-16RH3-A KSSM24	M18
5565585	T660NF07500-16RH5-A KSSM24	M18
5565586	T660NC10000-08RH5-A KSSM24	M18
5565587	T660M025X045RD3-A KSS20	M19
5565588	T660M025X045RD3-A KSSM24	M19
5565589	T660M030X050RD3-A KSS20	M19
5565590	T660M030X050RD3-A KSSM24	M19
5565591	T660M040X070RD4-A KSS20	M19
5565592	T660M040X070RD4-A KSSM24	M19
5565593	T660M050X080RD4-A KSS20	M19
5565594	T660M050X080RD4-A KSSM24	M19
5565595	T660M060X100RD5-A KSS20	M19
5565596	T660M060X100RD5-A KSSM24	M19
5565597	T660M070X100RD5-A KSS20	M19
5565598	T660M070X100RD5-A KSSM24	M19
5565599	T660M080X125RD5-A KSS20	M19
5565610	T660M080X125RD5-A KSSM24	M19
5565611	T660MF100X125RD5-A KSS20	M19
5565612	T660MF100X125RD5-A KSSM24	M19
5565613	T660M100X150RD6-A KSS20	M19
5565614	T660M100X150RD6-A KSSM24	M19
5565615	T660M120X175RD6-A KSS20	M19
5565616	T660M120X175RD6-A KSSM24	M19
5565954	T662NC#02-56RH2-A KSS20	M66
5565955	T662NC#02-56RH2-A KSSM24	M66
5565956	T662NC#04-40RH2-A KSS20	M66
5565957	T662NC#04-40RH2-A KSSM24	M66
5565958	T662NC#06-32RH2-A KSS20	M66
5565959	T662NC#06-32RH2-A KSSM24	M66
5566060	T662NC#06-32RH3-A KSS20	M66
5566061	T662NC#06-32RH3-A KSSM24	M66
5566062	T662NF#06-40RH2-A KSS20	M66
5566063	T662NF#06-40RH2-A KSSM24	M66
5566064	T662NC#08-32RH2-A KSS20	M66
5566065	T662NC#08-32RH2-A KSSM24	M66
5566066	T662NC#08-32RH3-A KSS20	M66
5566067	T662NC#08-32RH3-A KSSM24	M66
5566068	T662NF#08-36RH2-A KSS20	M66
5566069	T662NF#08-36RH2-A KSSM24	M66
5566070	T662NC#10-24RH3-A KSS20	M66
5566071	T662NC#10-24RH3-A KSSM24	M66
5566072	T662NF#10-32RH2-A KSS20	M66
5566073	T662NF#10-32RH2-A KSSM24	M66
5566074	T662NF#10-32RH3-A KSS20	M66
5566075	T662NF#10-32RH3-A KSSM24	M66
5566076	T662NC02500-20RH3-A KSS20	M66
5566077	T662NC02500-20RH3-A KSSM24	M66
5566078	T662NC02500-20RH5-A KSS20	M66
5566079	T662NC02500-20RH5-A KSSM24	M66
5566090	T662NF02500-28RH3-A KSS20	M66
5566091	T662NF02500-28RH3-A KSSM24	M66
5566092	T662NF02500-28RH4-A KSS20	M66
5566093	T662NF02500-28RH4-A KSSM24	M66
5566094	T662NF02500-28RH5-A KSS20	M66
5566095	T662NF02500-28RH5-A KSSM24	M66
5566096	T662NC03125-18RH3-A KSS20	M66
5566097	T662NC03125-18RH3-A KSSM24	M66
5566098	T662NC03125-18RH5-A KSS20	M66
5566099	T662NC03125-18RH5-A KSSM24	M66
5566100	T662NF03125-24RH3-A KSS20	M66
5566101	T662NF03125-24RH3-A KSSM24	M66
5566102	T662NF03125-24RH4-A KSS20	M66
5566103	T662NF03125-24RH4-A KSSM24	M66
5566104	T662NC03750-16RH3-A KSS20	M66
5566105	T662NC03750-16RH3-A KSSM24	M66
5566106	T662NC03750-16RH5-A KSS20	M66
5566107	T662NC03750-16RH5-A KSSM24	M66
5566108	T662NF03750-24RH3-A KSS20	M66
5566109	T662NF03750-24RH3-A KSSM24	M66
5566110	T662NF03750-24RH4-A KSS20	M66
5566111	T662NF03750-24RH4-A KSSM24	M66
5566112	T662NC04375-14RH3-A KSS20	M66
5566113	T662NC04375-14RH3-A KSSM24	M66
5566114	T662NC04375-14RH5-A KSS20	M66
5566115	T662NC04375-14RH5-A KSSM24	M66
5566116	T662NF04375-20RH3-A KSS20	M66
5566117	T662NF04375-20RH3-A KSSM24	M66
5566118	T662NF04375-20RH5-A KSS20	M66
5566130	T662NF04375-20RH5-A KSSM24	M66
5566131	T662NC05000-13RH3-A KSS20	M67
5566132	T662NC05000-13RH3-A KSSM24	M67
5566133	T662NC05000-13RH5-A KSS20	M67
5566134	T662NC05000-13RH5-A KSSM24	M67
5566135	T662NF05000-20RH3-A KSS20	M67
5566136	T662NF05000-20RH3-A KSSM24	M67
5566137	T662NF05000-20RH5-A KSS20	M67
5566138	T662NF05000-20RH5-A KSSM24	M67
5566139	T662NF05625-18RH3-A KSSM24	M67
5566140	T662NF05625-18RH5-A KSSM24	M67
5566141	T662NC06250-11RH3-A KSSM24	M67
5566142	T662NF06250-18RH3-A KSSM24	M67
5566143	T662NF06250-18RH5-A KSSM24	M67
5566144	T662NC07500-10RH5-A KSSM24	M67
5566145	T662NF07500-16RH3-A KSSM24	M67
5566146	T662NF07500-16RH5-A KSSM24	M67
5566147	T662NC10000-08RH5-A KSSM24	M67
5566148	T662M025X045RD3-A KSS20	M68
5566149	T662M025X045RD3-A KSSM24	M68
5566150	T662M030X050RD3-A KSS20	M68
5566151	T662M030X050RD3-A KSSM24	M68
5566152	T662M040X070RD4-A KSS20	M68
5566153	T662M040X070RD4-A KSSM24	M68
5566154	T662M050X080RD4-A KSS20	M68
5566155	T662M050X080RD4-A KSSM24	M68
5566156	T662M060X100RD5-A KSS20	M68
5566157	T662M060X100RD5-A KSSM24	M68
5566158	T662M070X100RD5-A KSS20	M68
5566159	T662M070X100RD5-A KSSM24	M68
5566160	T662M080X125RD5-A KSS20	M68
5566161	T662M080X125RD5-A KSSM24	M68
5566162	T662MF100X125RD5-A KSS20	M68
5566163	T662MF100X125RD5-A KSSM24	M68
5566164	T662M100X150RD6-A KSS20	M68
5566165	T662M100X150RD6-A KSSM24	M68
5566166	T662M120X175RD6-A KSS20	M68
5566167	T662M120X175RD6-A KSSM24	M68
5566274	RCMT1204M0RP KCP25B	B242
5568064	M4D100L1502M12L125	T14
5568065	M4D125L1503M16L175	T14
5568066	M4D150L1504M16L175	T14
5568067	M4D100L1502W075L175	T15
5568068	M4D125L1503W125L225	T15
5568069	M4D150L1503W125L225	T15
5568080	M4D100L1502C100L1000	T16
5568081	M4D125L1503C125L1000	T16
5568082	M4D150L1504C125L1000	T16
5568083	M4D250L1505S075L157	T17
5568084	M4D250L1507S100L175	T17
5568085	M4D300L1509S100L175	T17
5568086	M4D400L1508S150L200	T17
5572826	SDPT43PDER8GB2 KCPM40	T116, T123, U39
5572827	SDPT43PDSR8GB2 KCPM40	T116, T123, U39
5573990	DCMT432LF KCP10B	B225
5575827	LNGU542SRGEM KC520M	T19
5575828	LNGU542SRGEM KCK15	T19
5575829	LNGU542SRGEM KCPK30	T19

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5576320	VNMG332FF KCP25B	B146
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	WNMG433MP KCP25B	B159
5585495	B224A05050HP KCPK15	G45
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	E57
5588385	LNGU542ERGE KC725M	T18
5588386	LNGU542ERGE KCSM30	T18
5588387	LNGU542ERGE KCPM40	T18
5588388	LNGU542ERGE KC522M	T18
5588513	LNGU541ERGE KC725M	T18
5588514	LNGU541ERGE KCSM30	T18
5588515	LNGU541ERGE KCPM40	T18
5588516	LNGU541ERGE KC522M	T18
5588517	LNGU543ERGE KC725M	T18
5588518	LNGU543ERGE KCSM30	T18
5588519	LNGU543ERGE KCPM40	T18
5588550	LNGU543ERGE KC522M	T18
5588937	DFT110508MD KC7140	J101
5588973	RIQ09EDR00 KC6005	K59
5589680	LNPU763PNSRHD KCPM40	S99, S101
5590137	410.091	E18–19, E21, E23
5590777	EP1808EHD KCPM40	T84
5591123	DCMT3252FP KCM25B	B225
5591124	DCMT3251FP KCM25B	B225
5591126	CCMT2152FP KCM25B	B190
5591127	DCMT2152FP KCM25B	B225
5591128	CCMT3251FP KCM25B	B190
5591129	DCMT32505FP KCM25B	B225
5591140	CCMT2151FP KCM25B	B190
5591141	CCMT21505FP KCM25B	B190
5591142	CCMT3252FP KCM25B	B190
5591143	DCMT2151FP KCM25B	B225
5591144	CCMT32505FP KCM25B	B190
5591146	CCMT431FP KCM25B	B190
5591149	TCMT2151LF KCM25B	B257
5591151	DCMT2151LF KCM25B	B225
5591152	SCMT432LF KCM25B	B246
5591154	VBMT221LF KCM25B	B281
5591155	DPMT3251LF KCM25B	B232
5591156	TCMT3251LF KCM25B	B257
5591157	CPMT3251LF KCM25B	B207
5591158	SCMT431LF KCM25B	B246
5591159	TCMT3252LF KCM25B	B257
5591160	TCMT2152LF KCM25B	B257
5591161	TPMT3251LF KCM25B	B268
5591162	TPMT2151LF KCM25B	B268
5591164	TPMT3252MF KCM25B	B268
5591166	SCMT432MF KCM25B	B247
5591167	TCMT3252MF KCM25B	B258
5591168	SPMT3252MF KCM25B	B253
5591169	CPMT3252MF KCM25B	B207
5591170	TCMT3253MF KCM25B	B258
5591172	CCMT3251MF KCM25B	B191
5591173	DCMT3251MF KCM25B	B226
5591174	CCMT2151MF KCM25B	B191
5591175	SCMT3252MF KCM25B	B247
5591256	CCMT3253MF KCM25B	B191
5591610	TNMG431FP KCM25B	B123
5591611	SNMG432FP KCM25B	B101
5591612	SNMM856RH KCP40B	B106
5591613	SNMM866RH KCP40B	B106
5591615	CNMM644RH KCP40B	B55
5591616	SNMM646RH KCP40B	B106
5591617	SNMM646RM KCP40B	B107
5591633	CNMM646RP KCM25B	B56
5591634	SNMM866RP KCM25B	B107
5591711	CPMT2152MF KCM25B	B207
5591712	CPMT3253MF KCM25B	B207
5591713	TCMT2152MF KCM25B	B258
5591714	SNMG432MN KCP40B	B102
5591716	CNMG433MN KCP40B	B50
5591718	WNMG433MN KCP40B	B159
5591720	TNMG433MN KCP40B	B124
5591721	DNMG433MN KCP40B	B81
5591727	DNMG443MN KCP40B	B81
5591773	CNMG431MN KCP40B	B50
5591774	WNMG432MP KCM25B	B159
5591775	CNMG544MP KCM25B	B51
5591776	SCMT3252MP KCM25B	B247
5591777	CCMT432MP KCM25B	B191
5591778	VBMT332MP KCM25B	B281
5591779	CNMG431MP KCM25B	B51
5591780	CNMG543MP KCM25B	B51
5591781	VNMG332MP KCM25B	B147
5591782	DNMG432MP KCM25B	B81
5591783	CCMT3252MP KCM25B	B191
5591784	DCMT3252MP KCM25B	B226
5591785	TNMG331MP KCM25B	B124
5591786	VBMT331MP KCM25B	B281
5591787	CNMG642MP KCM25B	B51
5591788	DNMG441MP KCM25B	B81
5591789	VNMG331MP KCM25B	B147
5591790	WNMG433MP KCM25B	B159
5591791	DNMG332MP KCM25B	B81
5591792	CCMT3251MP KCM25B	B191
5591793	CCMT433MP KCM25B	B191
5591794	SCMT432MP KCM25B	B247
5591795	DNMG443MP KCM25B	B81
5591796	TNMG433MP KCM25B	B124
5591799	CNMG643MP KCM25B	B51
5591900	DNMG442MP KCM25B	B81
5591901	CNMG433MP KCM25B	B51
5591902	DNMG431MP KCM25B	B81
5591903	DNMG443RN KCP40B	B83
5591904	TCMT3251MP KCM25B	B258
5591906	TCMT3252MP KCM25B	B258
5591907	SNMG432MP KCM25B	B102
5591908	DNMG434RN KCP40B	B83
5591910	TNMG432MP KCM25B	B124
5591911	SNMG866RN KCP40B	B105
5591912	WNMG332MP KCM25B	B159
5591913	CNMG544RN KCP40B	B53
5591914	CCMT2151MP KCM25B	B191
5591916	CPMT3252MP KCM25B	B207
5591919	CNMG543RP KCM25B	B53
5591930	DNMG333MP KCM25B	B81
5591931	CNMG643RP KCM25B	B53
5591932	DNMG442RP KCM25B	B84
5591933	SNMG433MP KCM25B	B102
5591934	SNMG643MP KCM25B	B102
5591935	SNMG643RP KCM25B	B105
5591936	SNMG644RP KCM25B	B105
5591937	WNMG331MP KCM25B	B159
5591938	WNMG433RP KCM25B	B161
5591939	SNMG542MP KCM25B	B102
5591950	CNMG431RP KCM25B	B53
5591952	SNMG434MP KCM25B	B102
5591953	SNMG544RP KCM25B	B105
5591954	SNMG543MP KCM25B	B102
5591955	CNMG644RP KCM25B	B53
5591956	TNMG333MP KCM25B	B124
5591957	CNMG434RP KCM25B	B53
5591959	WNMG432RP KCM25B	B161
5591960	CNMG544RP KCM25B	B53
5591962	TNMG432RP KCM25B	B127
5591963	CNMG432MW KCM25B	B52
5591964	TNMG433RP KCM25B	B127
5591967	TNMG543RP KCM25B	B127
5591968	SNMG543RN KCP40B	B105
5591970	TNMG666RN KCP40B	B126
5591971	CNMG643RP KCP40B	B53
5591972	WNMG432RP KCP40B	B161
5591973	CNMG643RN KCP40B	B53
5591974	TNMG666RP KCP40B	B127
5591975	CNMG644RN KCP40B	B53
5591976	DNMG432RP KCM25B	B84
5591977	SNMG644RN KCP40B	B105
5591979	WNMG433RN KCP40B	B161
5591982	SNMG433RP KCM25B	B105
5591983	CNMG543RN KCP40B	B53
5591986	TNMG432RN KCP40B	B126
5591987	CNMG432UP KCM25B	B54
5591988	SNMG433RN KCP40B	B105
5591989	CNMG643UP KCM25B	B54
5591990	SNMG434RN KCP40B	B105
5591991	CNMG433UP KCM25B	B54
5591992	TNMG544RN KCP40B	B126
5591993	CNMG431UP KCM25B	B54
5591995	DNMG432UP KCM25B	B84
5591998	DNMG444RN KCP40B	B83
5592000	SNMG432RN KCP40B	B105
5592003	WNMG332UP KCM25B	B162
5592005	WNMG432UP KCM25B	B162
5592006	RNMG64RN KCP40B	B97
5592007	DNMG442UP KCM25B	B84
5592008	DNMG442RN KCP40B	B83
5592010	TNMG433RN KCP40B	B126
5592012	CNMG543UP KCM25B	B54
5592103	CNMG542MR KCP25B	B51
5592107	WNMG332MR KCP25B	B159
5592121	TNMG432MR KCP25B	B125
5592123	TNMG432MR KCM25	B125
5592124	SNMG432MR KCP25B	B103
5592128	CNMG644MR KCP25B	B51
5592141	DNMG332MR KCP25B	B82
5592142	DNMG332MR KCP10B	B82
5592146	TNMG543MR KCP25B	B125
5592160	VNMG333MR KCM15	B147
5592162	WNMG434MR KCP10B	B159
5592163	WNMG434MR KCP25B	B159
5593105	KTMDUWD058L157Z1	W29
5593106	KTMDUWD081L236Z2	W29
5593107	KTMDUWD091L276Z2	W29
5593108	KTMDUWD102L315Z3	W29
5593109	KTMDUWD144L374Z3	W34
5593120	KTMDUWD122L374Z4	W29
5593121	KTMDUWD165L472Z4	W34
5593125	KTMDUCD058L236Z1	W30
5593126	KTMDUCD068L256Z2	W30
5593127	KTMDUCD081L315Z2	W30
5593132	KTMDUED091L300Z2	W31
5593133	KTMDUED102L415Z3	W31
5593134	KTMDUED144L512Z3	W34
5593135	KTMDUED122L452Z4	W31
5593139	KTMDUSD169L158Z4	W35
5593140	KTMDUSD209L158Z5	W35
5593141	TMS25D52L40Z8	W10
5593142	TMS25D36L34Z5	W10
5593143	TMS25D44L38Z6	W10
5593145	TMS25D232L158Z9	W12
5593146	TMS25D193L138Z7	W12
5593147	TMS25D154L126Z5	W12
5593148	TMST25D154L126Z5	W13
5593154	TM24D053L102Z1	W4
5593155	TM24D059L118Z1	W4
5593156	TM24D063L110Z2	W4
5593157	TM24D063L142Z1	W4
5593158	TMT24D055L102Z1	W5
5593177	TM41D083L177Z1	W24
5593178	TM41D097L169Z2	W24
5593179	TM41D118L256Z3	W24
5593180	TM41D142L169Z5	W24
5593181	TM41D142L256Z4	W24
5593182	TMS41D210L200Z5	W25
5593183	TMS41D250L200Z6	W25
5593191	TM40D087L169Z3	W17
5593192	TM40D087L256Z3	W17
5593193	TM40D118L215Z4	W17
5593194	TM40D118L315Z3	W17
5593195	TMS40D193L197Z7	W18
5593196	TMS40D232L200Z9	W18
5593197	TMST40D193L197Z7	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

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
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	CNMG432MR KCU10	B51
5593887	DNMG432MR KCU10	B82
5593888	CNMG433MR KCU10	B51
5593931	WNMG432MR KCU10	B159
5593933	SNMG432MR KCU10	B103
5593934	SNMG433MR KCU10	B103
5593937	DNMG442MR KCU10	B82
5595038	VNMG332FF KCP10B	B146
5596414	CCMT432LF KCM25B	B191
5596415	CCMT3252LF KCM25B	B191
5596416	VBMT332LF KCM25B	B281
5596417	DCMT3252LF KCM25B	B225
5596418	VBMT331LF KCM25B	B281
5596419	DCMT3251LF KCM25B	B225
5596450	CCMT3251LF KCM25B	B191
5596451	CCMT2151LF KCM25B	B191
5596455	CCMT3252MF KCM25B	B191
5596456	CCMT432MF KCM25B	B191
5596457	CNMG432MN KCP40B	B50
5596460	CNMG432MP KCM25B	B51
5596461	TNMG332MP KCM25B	B124
5596462	CNMM646RH KCP40B	B55
5596463	SNMM644RM KCP40B	B107
5596465	CNMG433RN KCP40B	B53
5596466	CNMG434RN KCP40B	B53
5596468	CNMG432RP KCM25B	B53
5596469	CNMG433RP KCM25B	B53
5596480	TNMM433RP KCM25B	B129
5596481	CNMM432RP KCM25B	B56
5596483	SNMM644RP KCM25B	B107
5596485	CNMM644RP KCM25B	B56
5596488	CNMM543RP KCM25B	B56
5596489	CNMM643RP KCM25B	B56
5596859	KTIP1328HPM KCP15	H33
5596899	LNUX301940RRP KCP25	E58
5602422	KSEM3234HPGM KC7315	H55
5604719	B269A13800HP KCPK15	G64
5607204	UJBE0375J6B KCSM15	P52
5607205	UJBE0500J6B KCSM15	P52
5607206	UJBE0500J6C KCSM15	P52
5607207	UJBE0625J6B KCSM15	P52
5607208	UJBE0750J6B KCSM15	P52
5607209	UJBE1000J6B KCSM15	P52
5607300	UJBE0375J6AL KCSM15	P53
5607301	UJBE0500J6AL KCSM15	P53
5607302	UJBE0625J6AL KCSM15	P53
5607304	UJBE0750J6AL KCSM15	P53
5607305	UJBE1000J6AL KCSM15	P53
5607996	LNPU543SRGE KC520M	T19
5607997	LNPU543SRGE KC522M	T19
5607998	LNPU543SRGE KC725M	T19
5608030	LNPU543SRGE KCPK30	T19
5608034	LNPU541SRGE KC520M	T19
5608035	LNPU541SRGE KC522M	T19
5608036	LNPU541SRGE KC725M	T19
5608037	LNPU541SRGE KCK15	T19
5608038	LNPU541SRGE KCPK30	T19
5608090	CNMM644RP KCP25B	B56
5608588	T830NC#04-40RH2-XL6 KSP39	M100
5608589	T830NC#06-32RH3-XL6 KSP39	M100
5608630	T830NC#08-32RH3-XL6 KSP39	M100
5608631	T830NC#10-24RH3-XL6 KSP39	M100
5608632	T830NF#10-32RH3-XL6 KSP39	M100
5608633	T830NC02500-20RH3-XL6 KSP39	M100
5608634	T860NF02500-28RH3-XL6 KSP39	M100
5608635	T830NC03125-18RH3-XL6 KSP39	M100
5608636	T830NF03125-24RH3-XL6 KSP39	M100
5608637	T830NC03750-16RH3-XL6 KSP39	M100
5608638	T830NF03750-24RH3-XL6 KSP39	M100
5608639	T830NC04375-14RH3-XL6 KSP39	M100
5608640	T830NF04375-20RH3-XL6 KSP39	M100
5608642	T830NC05000-13RH3-XL6 KSP39	M100
5608644	T830NF05000-20RH3-XL6 KSP39	M100
5608645	T830NC06250-11RH3-XL6 KSP39	M100
5608646	T830NC#04-40RH2-XL4 KSP39	M99
5608647	T830NC#06-32RH3-XL4 KSP39	M99
5608648	T830NC#08-32RH3-XL4 KSP39	M99
5608661	T830NF#10-32RH3-XL4 KSP39	M99
5608662	T830NC02500-20RH3-XL4 KSP39	M99
5608663	T832NC#04-40RH2-XL6 KSP39	M101
5608664	T832NC#06-32RH3-XL6 KSP39	M101
5608665	T832NC#08-32RH3-XL6 KSP39	M101
5608666	T832NF#10-32RH3-XL6 KSP39	M101
5608667	T832NC02500-20RH3-XL6 KSP39	M101
5608668	T832NF02500-28RH3-XL6 KSP39	M101
5608669	T832NC03125-18RH3-XL6 KSP39	M101
5608680	T832NC03750-16RH3-XL6 KSP39	M101
5608681	T832NF03750-24RH3-XL6 KSP39	M101
5608682	T832NC04375-14RH3-XL6 KSP39	M101
5608745	T820NC#04-40RH2-XL6 KSP39	M35
5608746	T820NC#06-32RH3-XL6 KSP39	M35
5608747	T820NC#08-32RH3-XL6 KSP39	M35
5608748	T820NC#10-24RH3-XL6 KSP39	M35
5608749	T820NF#10-32RH3-XL6 KSP39	M35
5608750	T820NC02500-20RH3-XL6 KSP39	M35
5608751	T820NF02500-28RH3-XL6 KSP39	M35
5608752	T820NC03125-18RH3-XL6 KSP39	M35
5608753	T820NF03125-24RH3-XL6 KSP39	M35
5608754	T820NC03750-16RH3-XL6 KSP39	M35
5608755	T820NF03750-24RH3-XL6 KSP39	M35
5608756	T820NC04375-14RH3-XL6 KSP39	M35
5608757	T820NF04375-20RH3-XL6 KSP39	M35
5608758	T820NC05000-13RH3-XL6 KSP39	M35
5608759	T820NF05000-20RH3-XL6 KSP39	M35
5608760	T820NC06250-11RH3-XL6 KSP39	M35
5608761	T820NC#04-40RH2-XL4 KSP39	M34
5608762	T820NC#06-32RH3-XL4 KSP39	M34
5608764	T820NC#08-32RH3-XL4 KSP39	M34
5608765	T820NC#10-24RH4-XL4 KSP39	M34
5608766	T820NF#10-32RH3-XL4 KSP39	M34
5608767	T820NC02500-20RH3-XL4 KSP39	M34
5613026	M4D500L1509S150L238	T17
5613027	M4D500L1512S150L238	T17
5613028	M4D600L1510S200L238	T17
5615509	HNHX5354ENLE KCK15	S78
5615514	HNPX5358SNGE KCK15	S80
5615518	HNHX5354SNGE KCK15	S79
5615519	HNHX5354SNGE KC514M	S79
5615534	VNMP332K KCP10B	B149
5615608	VNMG332FP KCP25B	B146
5615609	VNMG332FN KCP10B	B146
5615610	HNHX5354ENLE KC514M	S78
5615650	VNMG332FN KCP25B	B146
5615680	HNPX5355SNGE KCK15	S80
5615682	HNHX5355SNGE KCK15	S79
5615683	HNHX5355SNGE KC514M	S79
5615684	HNPX5354SNGE KCK15	S80
5615687	HNHX5358SNGE KCK15	S79
5616165	HNHX5355ENLE KCK15	S78
5616166	HNHX5355ENLE KC514M	S78
5616167	HNHX53ANSNGE KCK15	S78
5616168	HNHX53ANSNGE KC514M	S78
5618002	SNMM543RM KCP25B	B107
5619961	SDET4316ENGB KC725M	T116, T123, U39
5619962	SDET4312SNGB KC725M	T116, T123, U39
5619963	SDET4312ENGB KC725M	T116, T123, U39
5619964	SDET438ENGB KC725M	T116, T123, U39
5620156	LNPU763PNSLHD2 KC520M	S99, S101
5620157	LNPU763PNSLHD2 KCPK30	S99, S101
5620158	LNPU763PNSRHD2 KCPM40	S99, S101
5620360	LNPU763PNSRHD2 KCPK30	S99, S101
5620745	LNPU863ANSRHD2 KCPM40	S95
5620747	LNPU863ANSRHD2 KCPK30	S95
5620748	SM-906LH KC720	S94, S98, S100
5626642	KSEM1250HPGM KCPM45	H57
5626643	KSEM1280HPGM KCPM45	H57
5626644	KSEM1300HPGM KCPM45	H57
5626645	KSEM1350HPGM KCPM45	H57
5626647	KSEM1360HPGM KCPM45	H57
5626648	KSEM1380HPGM KCPM45	H57
5626649	KSEM0547HPG KCPM45	H57
5626700	KSEM1410HPGM KCPM45	H57
5626701	KSEM1450HPGM KCPM45	H57
5626702	KSEM0578HPG KCPM45	H57
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5629699	T846NPT02500-18R-A KSU30	M153
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5630741	SNPJ31252SNGD KCPM40	S57
5630742	SNPJ31252SNGD KCK15	S57
5630743	SNPJ31252SNGD KCPK30	S57

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5630744	SNPJ31253SNGD KCPM40	S57
5630745	SNPJ31253SNGD KCK15	S57
5630746	SNPJ442SNGD KC520M	S60
5630747	SNPJ442SNGD KCPM40	S60
5630748	SNPJ442SNGD KCK15	S60
5630749	SNPJ442SNGD KCPK30	S60
5630751	SNPJ444SNGD KCPM40	S60
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5650848	TPU322 KCK15B	B178
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5651222	XDLW090408SRD X500	V16
5651223	XDLW120508SRD X400	V23
5651479	RPHT1204M0E421X4 X500	V104
5651903	CXE0750MN4-C SP4060	P84
5652140	SDHT120412EN422 SP6519	T132
5652239	XDLW090408SRD X400	V16
5652248	XDLT120512ERD411 X500	V22
5652249	XDLT090412ERD411 SP6519	V15
5652466	CXER0125NTN4-F SP4060	P85
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5652476	CXER0500NN4-K SP4060	P85
5652477	CXER0625NN4-C SP4060	P85
5652478	CXER0625NN4-J SP4060	P85
5652479	CXER0750NN4-F SP4060	P85
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5652490	XDLT090408ERD41 SP6519	V14
5652729	XDLT120508ERD41 SC6525	V21
5652800	RPEX10T3M0F701X4 SP4019	V99
5652874	XPNT101043RF SP6519	V115
5652899	XDLT120512ERD411 SP6519	V22
5653062	XPNT050522RF SP6519	V115
5653063	XPNT121254RF SP6519	V115
5653064	XPNT161654RF SP6519	V115
5653106	XDLT090408ERD41 SC6525	V14
5653137	SDHT120412EN423 X500	T132
5653138	SDHT09T308EN422 X500	T129
5653139	XELT160512ERD41 X500	V28
5653140	XELT160512ERD41 SP6519	V28
5653360	CXER0500NN4-J SP4060	P85
5653362	CXER0750NN4-C SP4060	P85
5653364	CXER1000NN4-L SP4060	P85
5653576	SDHT09T308EN422 SP6519	T129
5653639	CXER0469NTN4-E SP4060	P85
5653642	CXER1000NN4-F SP4060	P85
5653777	CXER0125NTN4-C SP4060	P85
5653779	CXER0375NN4-C SP4060	P85
5653885	SDHT120412EN422 X500	T132
5653890	SDHT09T3AEEN422 SP6519	T129
5653930	XDLT120508ERD41 X500	V21
5653967	XELW160512SRD X400	V28
5653971	CXE0125MTN4-C SP4060	P84
5653973	CXE0500MN4-C SP4060	P84
5654214	XPNT080832RF SP6519	V115
5654218	CXE0375MN4-C SP4060	P84
5654220	XDLT120508ERD41 SP6519	V21
5654267	XPLT060308ERD41 SP6519	V7
5654371	RPHT1204M0TX4 X500	V105
5654377	XPLT060308ERD41 X400	V7
5654397	XPLT060308ERD41 X500	V7
5654405	SDHT09T308EN423 X500	T129
5654496	CXER0750NN4-L SP4060	P85

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5654552	CXE0250MN4-C SP4060	P84
5654558	CXER0500NN4-C SP4060	P85
5654563	CXER0375NN4-E SP4060	P85
5654578	CXE0187MTN4-C SP4060	P84
5654744	RPMT1204M0E41X4 SP6519	V104
5654896	XDLT090408ERD41 X500	V14
5655031	SDHT120412EN423 SP6519	T132
5655035	RPHT10T3M0TX4 SP6519	V100
5655041	CXER0250NN4-E SP4060	P85
5655043	CXER0500NN4-L SP4060	P85
5655044	CXER1000NN4-C SP4060	P85
5655104	XELT160512ERD41 SC6525	V28
5655105	SDHT09T308EN423 SP6519	T129
5655109	XDLW120508SRD X500	V23
5655128	RPHT10T3M0TX4 X500	V100
5655171	XPNT06062515RF SP6519	V115
5655172	XDLT090412ERD411 X500	V15
5655210	CXER0500NN4-F SP4060	P85
5655255	XDLW090408SRD SC6525	V16
5655265	XPLT060308ERD41 SC6525	V7
5655472	XDLT090408ERD721 GH2	V14
5655817	XELW160512SRD SC3025	V28
5656081	XDLW090408SRD SC3025	V16
5656214	XDLW120508SRD SC3025	V23
5656242	RPEX10T3M0F701X4 GH1	V99
5656252	XDLT120508ERD721 GH2	V21
5656378	C7792VXD12-A4.00Z9R	V19–20
5656381	RPMT10T3M0E41X4 X500	V100
5656382	C7792VXD12-A2.00Z5R	V19–20
5656533	SDMT120412EN41 MP91M	T133
5656731	C7792VXD09-A1.50Z4R	V12–13
5656732	C7792VXD12-A2.50Z5R	V19–20
5656765	SDMT09T308EN41 X500	T130
5656911	RPHT10T3M0E421X4 X700	V99
5656915	C7792VXD12-6.00Z12R	V19–20
5656917	RPMW10T3M0TX4 X500	V100
5656919	C7792VXD12-A3.00Z8R	V19–20
5657226	RPMT1204M0E41X4 X500	V104
5657237	C7792VXD12-A2.00Z3R	V19–20
5657271	SDMT120412EN41 X500	T133
5657681	RPHT1204M0E442X5 X500	V104
5657863	F3510T S	V9–12
5657877	D6018S S	V112
5658075	C7792VXD09WA1.00Z2R	V10, V13
5658170	C7792VXD09-A1.50Z5R	V12–13
5658171	C7792VXD12-A5.00Z11R	V19–20
5658324	RPHT1204M0E442X5 SP6519	V104
5658507	C7792VXP06CA.75Z3R6.1	V5–6
5658650	ZDET16M540ER721 GH1	T100
5659264	RPHT1204M0E442X4 SP6519	V105
5659355	SDMW120412TN SP6519	T133
5659561	RPHT1204M0E442X5 X700	V104
5659562	RPHT10T3M0E422X8 X700	V99
5659564	C7792VXE16CA1.50Z2R4	V25
5659603	ZDET16M525ER721 GH1	T100
5659736	C7792VXD12-6.30Z8R	V19–20
5659840	A7792VXD09SA1.0Z2R1.4 S	V9, V13
5659867	RPHT10T3M0E422X4 SP6519	V99
5659912	ZDET16M520FR721 GH1	T100
5659913	ZDET16M532FR721 GH1	T100
5659914	ZDET16M560FR721 GH1	T100
5659929	A7792VXD12SA1.25Z2R2 S	V17, V20
5659948	C7792VXD09CA1.25Z3R3	V11, V13
5660042	RPMW1204M0TX4 SP6519	V105
5660060	A7792VXP06SA.75Z2R1.4 S	V4, V6
5660351	RPHT1204M0E442X4 X500	V105
5660449	A7792VXD09SA1.25Z3R2 S	V9, V13
5660462	RPHT10T3M0E422X4 X500	V99
5660778	RPHT10T3M0E422X8 SP6519	V99
5661029	C7792VXE16-A3.00Z6R	V26–27
5661030	C7792VXE16-A5.00Z10R	V26–27
5661037	ZDET16M512FR721 GH1	T100
5661186	SDMT09T308EN41 SP6519	T130
5661212	C7792VXP06CA1.0Z4R6.1	V5–6
5661213	A7792VXP06SA.625Z2R1 S	V4, V6
5661214	A7792VXP06SA.75Z3R1.4	V4, V6
5661215	A7792VXP06SA1.0Z4R1.4 S	V4, V6
5665491	RPHT10T3M0E422X4 X700	V99
5665708	C7792VXD12-A3.00Z5R	V19–20
5665740	SDMT120412EN41 SP6519	T133
5665786	RPMW1204M0TX4 X500	V105
5665795	C7792VXD09-A2.00Z6R	V12–13
5665804	ZDET16M5PDFR721 GH1	T100
5665812	C7792VXE16-A2.50Z5R	V26–27
5665832	C7792VXD12CA1.2/1.5Z3	V18, V20
5665928	RPEX1204M0E701X4 X500	V104
5665949	ZDET16M508FR721 GH1	T100
5665950	ZDET16M540FR721 GH1	T100
5666016	RPHT10T3M0E421X4 X500	V99
5666067	C7792VXD09WA1.25Z3R	V10, V13
5666264	SDMT09T308EN41 MP91M	T130
5666376	ZDET16M516FR721 GH1	T100
5666394	RPMT10T3M0E41X4 MP91M	V100
5666415	C7792VXE16CA2.00Z3R4	V25, V27
5666519	RPHT10T3M0E422X8 X500	V99
5666596	C7792VXD12CA1.25Z2R3	V18, V20
5667132	RPMT10T3M0E41X4 SP6519	V100
5667399	RPMT1204M0E41X4 MP91M	V104
5667400	RPMW1204M0TX4 MP91M	V105
5667404	C7792VXD12-A2.00Z4R	V19–20
5667476	C7792VXD12-A5.00Z8R	V19–20
5667487	A7792VXD12SA1.5Z3R1.7 S	V17, V20
5667498	ZDET16M530FR721 GH1	T100
5667564	C7792VXD09CA1.00Z2R2	V11, V13
5667570	C7792VXE16-6.00Z12R	V26–27
5667588	C7792VXP06CA.62Z2R5.5	V5–6
5667809	C7792VXD12-A2.50Z4R	V19–20
5667832	C7792VXD09-A2.00Z5R	V12–13
5667833	C7792VXD12-A4.00Z6R S	V19–20
5667922	ZDET16M525FR721 GH1	T100
5667941	C7792VXE16-A4.00Z8R	V26–27
5667946	ZDET16M504FR721 GH1	T100
5667958	A7792VXP06SA1.0Z3R1.4 S	V4, V6
5668072	RPHT1204M0E442X4 X700	V105
5671362	#1/4-28X3/4SHCSA S	T98, V12, V98, V103
5671373	#3/4-16X1-3/4SHCSA S	V19, V26
5671374	#3/8-24X1SHCSA S	T98, V12, V19, V98, V103
5671375	#5/8-18X1-1/2SHCSA S	T131, V19, V26
5671599	#1/2-20X1-1/4SHCSA S	T98, T128, T131, V19, V26, V103
5671642	TB15	V12, V19, V97–98, V102–103
5671687	#1/2-20X1-1/4 LHCSA S	V19, V26
5672329	D6014T S	V112
5672332	FP2506T	V4–5
5672365	SB3230	T131
5672367	SB3413	T128
5672374	D4008T S	V97–98, V102–103
5672375	D4010T S	V17–19, V103, V111–112, V114
5672376	D5013T S	V111–112, V114
5672378	F4011T S	T131
5672381	T9 S	T127–128, T131
5672387	D4012T S	V19
5672404	FP3007T S	V111, V114
5672405	TP20	T96–99, V25–26
5672409	D4007T S	V97
5672410	NLW12SP	T131
5672412	SB3232	T131
5672414	FP3006T	V111, V114
5672415	TP7	V4–5
5672416	SB3621	T128
5672469	M-13-M8-CA.625-5.118 S	V32
5672470	M-18-M10-CA.750-4.331 S	V32
5672471	M-21-M12-CA1-9.094 S	V32
5672481	C5230VS12-A2.5Z4R3.70	T131
5672512	A5720VZ16SA1.00Z2R2	T96
5672521	A5720VZ16SA1.25Z3R2	T96
5672623	C7713VR12CA1.00Z2R2.0	V102–103
5672624	A7713VR12SA1.00Z2R1.4	V102–103
5672718	C5720VZ16CA1.0Z02R2.7	T97
5672719	A5720VZ16SA1.25Z02R2	T96
5672766	5720VZ16HA032Z3R75	T99
5672803	C7713VR10CA1.00Z3R2.0	V97–98
5672804	C7713VR10CA1.25Z4R2.7	V97–98
5672805	C7713VR10-A2.00Z7R	V98
5672808	C7713VR12-A2.00Z5R	V103
5672809	C7713VR12-A3.00Z8R	V103
5672810	A7713VR12SA1.25Z3R1.7	V102–103
5672833	M-13-M8-CA.625-6.693 S	V32
5672834	M-18-M10-CA.750-5.118 S	V32
5672835	M-21-M12-CA1-5.157 S	V32
5672836	M-29-M16-CA1.25-8.27 S	V32
5672838	C5505VX10WA1.25R3.00	V112
5672839	C5505VX12WA1.50R4.00	V112
5672840	C5505VX16WA2.00R4.00	V112
5672841	A5505VX10SA1.25R1.968	V111
5672846	C5505VX05CA.75/.62R1	V114
5672847	C5505VX06CA.75R1.7	V114
5672848	C5505VX08CA1.00R2.2	V114
5672871	C5720VZ16-A2.00Z04R	T98
5672872	C5720VZ16-A2.50Z05R	T98
5672885	C5720VZ16CA1.25Z3R3.0	T97
5672990	M-18-M10-CA.750-6.693 S	V32
5672991	M-21-M12-CA1-6.142 S	V32
5672992	M-29-M16-CA1.25-6.3 S	V32
5672993	M-29-M16-CA1.25-10.2 S	V32
5673041	C5230VS09CA2.0Z04R4.0	T127
5673042	C7713VR10-A2.50Z8R	V98
5673043	A7713VR10SA1.25Z4R1.7	V97–98
5673044	C7713VR12-A2.00Z4R	V103
5673045	C7713VR12-A2.00Z6R	V103
5673046	C7713VR12-A2.50Z7R	V103
5673110	C5505VX12WA1.50R6.00	V112
5673111	C5505VX16WA2.00R6.00 S	V112
5673142	C5505VX10CA1.25R2.2	V114
5673175	C5720VZ16-A2.50Z04R	T98
5673176	C5230VS09-A2.0Z4R2.0	T128
5673296	C5505VX06WA.750R2.00	V113
5673338	C5720VZ16-A3.00Z04R	T98
5673343	FP2507T	V4–5
5673344	TP15	V114
5673353	M-21-M12-CA1-7.126 S	V32
5673499	C7713VR12CA1.25Z3R2.7	V102–103
5673530	C5230VS09-A2.0Z04R3.1	T128
5673542	TP8	V111, V113–114
5673544	T20 S	T131, V111–112
5673546	T15 S	T127–128, V9–12, V17–19, V102–103, V111–112
5673548	DP5009A S	T96–99
5673549	C5720VZ16CA1.25Z2R3.0	T97
5673588	M-21-M12-CA1-8.110 S	V32
5673595	C5505VX08WA1.00R2.37	V112
5673597	C7713VR10-A1.50Z05R	V98
5673598	A7713VR12SA1.50Z5R1.7	V102–103
5673603	A5505VX06SA.750R1.377	V111
5673617	C5230VS12-A3.0Z5R4.33	T131
5673624	A5505VX08SA1.00R1.575	V111
5673629	5720VZ16HA040Z4R75	T99
5673633	C5505VX05CA.62R1.6	V114
5673704	M-13-M8-CA.625-3.543 S	V32
5673705	M-13-M8-CA.625-4.331 S	V32
5673706	M-29-M16-CA1.25-12.2 S	V32
5673709	C5505VX10WA1.25R4.00	V112
5673710	A5505VX05SA.625R1.00	V111
5673745	C5720VZ16-A3.00Z05R	T98
5673747	C5230VS12-A3.0Z5R2.56	T131
5673766	C7713VR12-A1.50Z5R	V103
5673767	A7713VR12SA1.50Z4R1.7	V102
5673786	C5505VX06CA1/.75R1.5	V114
5673796	DP5013T S	V25–26
5673797	C5230VS12-A2.5Z4R2.24	T131
5673799	C5720VZ16-A2.00Z03R	T98
5673826	C7713VR12-A1.50Z4R	V103
5673827	C7713VR12-A2.50Z6R	V103
5673899	F3508T S	T127–128, V9–11
5674437	RPHT1204M0E442X5 SC6525	V104
5674698	RPPT1204M0E432X5 SC6525	V106
5674780	RPHT1204M0E442X8 SC6525	V105
5674803	RPPT1204M0E432X5 X700	V106
5674959	RPPT1204M0E432X8 X500	V106
5675037	RPPT1204M0E432X5 SP6519	V106
5675038	RPPT1204M0E432X5 X500	V106
5675140	RPPT1204M0E432X8 SP6519	V106
5675237	ZDET16M530ER721 GH1	T100
5676726	RIR01E1306 KC6105	K56
5676727	RIR04E1312 KC6105	K56
5676728	RIQ06E1306 KC6105	K58
5676729	RIQ06R0400FB KT6225	K58
5676760	RIQ06E1300 KC6005	K58
5676761	RIQ06E1300 KC6105	K58
5676762	RIQ06E1312 KC6005	K58
5676763	RIQ06E1312 KC6105	K58
5676764	RIQ09E1300 KC6105	K58
5676765	RIQ09E1306 KC6105	K58
5676766	RIQ09E1312 KC6005	K58
5676767	RIQ09E1312 KC6105	K58
5676768	RIQ06EGR00 KC6105	K59
5676769	RIQ06EGR00 KC6305	K59
5676770	RIQ06EGR00 KC6005	K59
5676771	RIQ06EGR06 KC6005	K59
5676772	RIQ06EGR06 KC6105	K59
5676773	RIQ06EGR12 KC6005	K59
5676774	RIQ06EGR12 KC6105	K59
5676775	RIQ06EGR12 KC6305	K59
5676776	RIQ09EGR00 KC6105	K59
5676777	RIQ09EGR00 KC6305	K59
5676778	RIQ09EGR00 KC6005	K59
5676779	RIQ09EGR06 KC6005	K59
5676780	RIQ09EGR06 KC6105	K59
5676781	RIQ09EGR06 KC6305	K59
5676782	RIQ09EGR12 KC6005	K59
5676783	RIQ09EGR12 KC6105	K59
5676784	RIQ09EGR12 KC6305	K59
5676785	RIQ06EDR00 KC6105	K59
5676786	RIQ06EDR00 KC6305	K59
5676787	RIQ06EDR00 KC6005	K59
5676788	RIQ06EDR06 KC6005	K59
5676790	RIQ06EDR06 KC6105	K59
5676791	RIQ06EDR06 KC6305	K59
5676792	RIQ06EDR12 KC6005	K59
5676794	RIQ06EDR12 KC6105	K59
5676795	RIQ06EDR12 KC6305	K59
5676796	RIQ09EDR06 KC6005	K59
5676797	RIQ09EDR06 KC6105	K59
5676798	RIQ09EDR06 KC6305	K59
5676799	RIQ09EDR12 KC6005	K59
5676800	RIQ09EDR12 KC6105	K59
5676801	RIQ09EDR12 KC6305	K59
5681114	A7792VXP06SA1.25Z5R2 S	V4, V6
5681117	C7792VXP06CA1.25Z5R8	V5–6
5681118	C5720VZ16-A1.50Z03R	T98
5682154	ZDET16M550FR721 GH1	T100
5682563	RPEX1204M0F701X4 GH1	V104
5682757	TB20	V26
5682897	NLW-0.375 S	T128, T131
5684657	LNPU542SRGE KCPM40	T19
5684744	RNGN43TGN KYSP30	V150
5684745	RNGN43EGN KYSP30	V150
5684746	RNGN43TGN KYS30	V150
5684747	RNGN43EGN KYS30	V150
5685937	CNMG432MN KCPK05	B50
5687543	KSEM1938HPLM KC7320	H62
5689447	DFSP240R5WD32M	J30
5689448	DFSP250R5WD32M	J30–31
5689449	DFSP260R5WD32M	J30
5689500	DFSP265R5WD32M	J30
5689501	DFSP270R5WD32M	J30
5689502	DFSP280R5WD32M	J30
5689503	DFSP290R5WD32M	J30
5689504	DFSP300R5WD32M	J30
5689505	DFSP310R5WD32M	J30
5689506	DFSP320R5WD32M	J30–31
5689507	DFSP330R5WD32M	J30
5689508	DFSP340R5WD32M	J30
5689509	DFSP350R5WD32M	J30
5689510	DFSP360R5WD32M	J30
5689511	DFSP370R5WD32M	J30
5689512	DFSP375R5WD32M	J30
5689513	DFSP380R5WD32M	J30
5689514	DFSP390R5WD32M	J30
5689515	DFSP400R5WD32M	J30–31
5689516	DFSP410R5WD32M	J30
5689517	DFSP420R5WD32M	J30
5689518	DFSP430R5WD32M	J30–31
5689519	DFSP440R5WD32M	J30
5689530	DFSP450R5WD40M	J30
5689531	DFSP460R5WD40M	J30
5689532	DFSP470R5WD40M	J30
5689533	DFSP480R5WD40M	J30–31
5689534	DFSP490R5WD40M	J30

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5689535	DFSP500R5WD40M	J30
5689536	DFSP510R5WD40M	J30
5689537	DFSP140R2WD20M	J24
5689538	DFSP520R5WD40M	J30
5689539	DFSP145R2WD20M	J24
5689540	DFSP530R5WD40M	J30
5689541	DFSP150R2WD20M	J24
5689542	DFSP540R5WD40M	J30
5689543	DFSP155R2WD20M	J24
5689544	DFSP550R5WD50M	J30–31
5689545	DFSP160R2WD20M	J24
5689546	DFSP165R2WD32M	J24
5689548	DFSP170R2WD32M	J24–25
5689549	DFSP175R2WD32M	J24
5689550	DFSP180R2WD32M	J24
5689551	DFSP185R2WD32M	J24
5689552	DFSP190R2WD32M	J24
5689553	DFSP195R2WD32M	J24
5689554	DFSP200R2WD32M	J24
5689555	DFSP210R2WD32M	J24–25
5689556	DFSP220R2WD32M	J24
5689557	DFSP230R2WD32M	J24
5689602	DFSP0563R2SSF075	J32
5689603	DFSP0594R2SSF075	J32
5689604	DFSP0625R2SSF075	J32
5689605	DFSP0656R2SSF075	J32
5689606	DFSP0688R2SSF075	J32–33
5689607	DFSP0703R2SSF075	J32
5689608	DFSP0734R2SSF075	J32
5689609	DFSP0750R2SSF100	J32
5689620	DFSP0781R2SSF100	J32
5689621	DFSP0813R2SSF100	J32
5689622	DFSP0844R2SSF100	J32–33
5689623	DFSP0875R2SSF100	J32
5689624	DFSP0906R2SSF100	J32
5689625	DFSP0938R2SSF100	J32
5689626	DFSP0969R2SSF100	J32
5689627	DFSP0984R2SSF100	J32
5689630	DFSP140R3WD20M	J26
5689631	DFSP145R3WD20M	J26
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5689643	DFSP210R3WD32M	J26–27
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5689690	DFSP210R4WD32M	J28–29
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5689692	DFSP230R4WD32M	J28
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5689906	DFSP210R5WD32M	J30–31
5689907	DFSP220R5WD32M	J30
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5689993	T686M040X070R6H-DA KSMN34	M72
5689994	T686M050X080R6H-DA KSMN34	M72
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5689998	T686MF120X150R6H-DA KSMN34	M72
5691735	DFSP1000R3SSF100	J34
5691736	DFSP1000R3SSF125	J34
5691737	DFSP1000R3SSF150	J34–35
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5691792	DFSP1156R3SSF125	J34
5691793	DFSP1188R3SSF125	J34
5691794	DFSP1219R3SSF125	J34
5691795	DFSP1250R3SSF125	J34
5691796	DFSP1281R3SSF125	J34–35
5691797	DFSP1313R3SSF125	J34
5691798	DFSP1313R3SSF150	J34
5691799	DFSP1375R3SSF125	J34
5691800	DFSP1375R3SSF150	J34
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5691802	DFSP1469R3SSF125	J34
5691803	DFSP1500R3SSF125	J34
5691804	DFSP1500R3SSF150	J34
5691805	DFSP1563R3SSF150	J34–35
5691806	DFSP1625R3SSF125	J34
5691807	DFSP1625R3SSF150	J34
5691808	DFSP1656R3SSF150	J34
5691809	DFSP1688R3SSF150	J34–35
5691810	DFSP1750R3SSF150	J34
5691811	DFSP1813R3SSF150	J34
5691812	DFSP1875R3SSF150	J34–35
5691813	DFSP1938R3SSF150	J34
5691814	DFSP2000R3SSF150	J34
5691815	DFSP2000R3SSF200	J34
5691816	DFSP2125R3SSF150	J34
5691817	DFSP2125R3SSF200	J34–35
5691818	DFSP1000R2SSF100	J32
5691819	DFSP1000R2SSF125	J32
5691830	DFSP1000R2SSF150	J32–33
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5691847	DFSP1563R2SSF125	J32
5691848	DFSP1563R2SSF150	J32–33
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5691851	DFSP1656R2SSF150	J32
5691852	DFSP1688R2SSF150	J32–33
5691853	DFSP1750R2SSF150	J32
5691854	DFSP1813R2SSF150	J32
5691855	DFSP1875R2SSF150	J32–33
5691856	DFSP1938R2SSF150	J32
5691857	DFSP2000R2SSF150	J32
5691858	DFSP2000R2SSF200	J32
5691859	DFSP2125R2SSF150	J32
5691860	DFSP2125R2SSF200	J32–33
5691861	DFSP240R3WD32M	J26
5691862	DFSP250R3WD32M	J26–27
5691863	DFSP260R3WD32M	J26
5691864	DFSP265R3WD32M	J26
5691865	DFSP270R3WD32M	J26
5691866	DFSP280R3WD32M	J26
5691867	DFSP290R3WD32M	J26
5691868	DFSP300R3WD32M	J26
5691869	DFSP310R3WD32M	J26
5691870	DFSP320R3WD32M	J26–27
5691871	DFSP330R3WD32M	J26
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5691899	DFSP1000R4SSF150	J36–37
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5692158	DFSP1250R4SSF125	J36
5692159	DFSP1250R4SSF150	J36–37
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5692203	DFSP1406R4SSF150	J36
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5692208	DFSP1563R4SSF150	J36
5692209	DFSP1625R4SSF150	J36–37
5692210	DFSP1656R4SSF150	J36–37
5692211	DFSP1750R4SSF150	J36
5692212	DFSP1813R4SSF150	J36
5692213	DFSP1875R4SSF150	J36–37

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5692214	DFSP1938R4SSF150	J36
5692215	DFSP2000R4SSF150	J36
5692216	DFSP2000R4SSF200	J36
5692217	DFSP2125R4SSF150	J36
5692218	DFSP2125R4SSF200	J36–37
5692238	DFSP240R4WD32M	J28
5692239	DFSP250R4WD32M	J28–29
5692271	DFSP260R4WD32M	J28
5692272	DFSP265R4WD32M	J28
5692273	DFSP270R4WD32M	J28
5692274	DFSP280R4WD32M	J28
5692275	DFSP290R4WD32M	J28
5692277	DFSP300R4WD32M	J28
5692278	DFSP310R4WD32M	J28
5692279	DFSP320R4WD32M	J28–29
5692291	DFSP330R4WD32M	J28
5692292	DFSP340R4WD32M	J28
5692294	DFSP350R4WD32M	J28
5692295	DFSP360R4WD32M	J28
5692296	DFSP370R4WD32M	J28
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5692299	DFSP380R4WD32M	J28
5692300	DFSP390R4WD32M	J28
5692302	DFSP400R4WD32M	J28–29
5692303	DFSP410R4WD32M	J28
5692304	DFSP420R4WD32M	J29
5692305	DFSP430R4WD32M	J29
5692306	DFSP440R4WD32M	J29
5692307	DFSP450R4WD40M	J29
5692308	DFSP460R4WD40M	J29
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5692316	DFSP540R4WD40M	J29
5692317	DFSP550R4WD50M	J29
5692319	DFSP240R2WD32M	J24
5692320	DFSP250R2WD32M	J24–25
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5692322	DFSP265R2WD32M	J24
5692323	DFSP270R2WD32M	J24
5692324	DFSP280R2WD32M	J24
5692325	DFSP290R2WD32M	J24
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5692327	DFSP310R2WD32M	J24
5692329	DFSP320R2WD32M	J24–25
5692330	DFSP330R2WD32M	J24
5692331	DFSP340R2WD32M	J24
5692332	DFSP350R2WD32M	J24
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5692337	DFSP390R2WD32M	J24
5692338	DFSP400R2WD32M	J24–25
5692339	DFSP410R2WD32M	J24
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5692341	DFSP430R2WD32M	J25
5692342	DFSP440R2WD32M	J25
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5692354	DFSP550R2WD50M	J25
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5692356	DFSP1000R5SSF125	J38
5692357	DFSP1000R5SSF150	J38–39
5692358	DFSP1031R5SSF125	J38
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5692395	DFSP1219R5SSF125	J38
5692396	DFSP1250R5SSF125	J38
5692397	DFSP1250R5SSF150	J38–39
5692398	DFSP1313R5SSF125	J38
5692399	DFSP1375R5SSF125	J38
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5692401	DFSP1438R5SSF125	J38
5692402	DFSP1500R5SSF125	J38
5692403	DFSP1500R5SSF150	J38
5692404	DFSP1563R5SSF150	J38–39
5692405	DFSP1625R5SSF150	J38
5692406	DFSP1656R5SSF150	J38–39
5692407	DFSP1750R5SSF150	J38
5692408	DFSP1813R5SSF150	J38
5692409	DFSP1875R5SSF150	J38–39
5692420	DFSP1938R5SSF150	J38
5692421	DFSP2000R5SSF150	J38
5692422	DFSP2000R5SSF200	J38
5692423	DFSP2125R5SSF150	J38
5692424	DFSP2125R5SSF200	J38–39
5692727	SPGX050204HP KCU25	J103
5692728	SPGX050204MD KCU25	J103
5692729	SPGX050204HP KCU40	J103
5692800	SPGX050204MD KCU40	J103
5692801	SPGX050204HP KC7140	J103
5692802	SPGX050204MD KC7140	J103
5692803	DFTX20204HP KCU25	J101
5692804	DFTX20204MD KCU25	J101
5692805	DFTX20204HP KCU40	J101
5692806	DFTX20204MD KCU40	J101
5692807	DFTX20204HP KC7140	J101
5692808	DFTX20204MD KC7140	J101
5692809	SPHX060204R21 KCU25	J116
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5697013	CNMM544RM KCP10B	B55
5697014	CNMM644RH KCP10B	B55
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5697016	CNMM646RH KCP10B	B55
5697017	CNMM646RW KCP10B	B56
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5697019	DCMT3251LF KCP10B	B225
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5697021	DNMG431FN KCP10B	B79
5697022	DNMG432FF KCP10B	B79
5697023	DNMG433FN KCP10B	B79
5697027	SNMG432FN KCP10B	B101
5697029	TNMG331FN KCP10B	B123
5697030	TNMG332RP KCP10B	B127
5697031	TNMG433FN KCP10B	B123
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5697914	CCMT3252UF KCP10B	B192
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5697982	DPMT3251LF KCP10B	B232
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5698083	RNMG64RN KCP25B	B97
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5698086	SNMG432MN KCP25B	B102
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5698118	TCMT2152LF KCP25B	B257
5698119	TCMT2152MF KCP25B	B258
5698120	TCMT3251LF KCP25B	B257
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5698123	TCMT3253MF KCP25B	B258
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5698126	TNMG332MW KCP25B	B126
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5698128	TNMG431MN KCP25B	B124
5698129	TNMG432MN KCP25B	B124
5698130	TNMG432RN KCP25B	B126
5698131	TNMG432RP KCP25B	B127
5698133	TNMG433MN KCP25B	B124

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5698134	TNMG433RN KCP25B	B126
5698135	TNMG433RP KCP25B	B127
5698136	TNMG438RP KCP25B	B127
5698137	TNMG542RN KCP25B	B126
5698139	TNMG544RN KCP25B	B126
5698140	TNMG544RP KCP25B	B127
5698141	TNMG666RN KCP25B	B126
5698146	CCMT2151LF KCP25B	B191
5698147	CCMT431LF KCP25B	B191
5698148	CCMT432LF KCP25B	B191
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5698161	CNMM432RM KCP25B	B55
5698162	CNMM432RP KCP25B	B56
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5698167	CNMM644RH KCP25B	B55
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5698186	SNMM646RP KCP25B	B107
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5698193	TNMM332RM KCP25B	B128
5698194	TNMM433RM KCP25B	B128
5698195	TNMM434RM KCP25B	B128
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5698198	WNMG431FN KCP25B	B157
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5698215	CCMT3251LF KCK15B	B191
5698216	CCMT3252LF KCK15B	B191
5698217	CCMT3252MF KCK15B	B191
5698218	CCMT431LF KCK15B	B191
5698260	CCMT432MF KCK15B	B191
5698261	CNMA431 KCK15B	B47
5698262	CNMA432 KCK15B	B47
5698263	CNMA434 KCK15B	B47
5698265	CNMA643 KCK15B	B47
5698266	CNMA644 KCK15B	B47
5698268	CNMG432RP KCK15B	B53
5698269	CNMG433RP KCK15B	B53
5698270	CPMT2151LF KCK15B	B207
5698272	DCMT3252LF KCK15B	B225
5698277	RCMT1204M0 KCK15B	B240
5698278	SCMT3252LF KCK15B	B246
5698279	SNMA432 KCK15B	B100
5698280	SNMA433 KCK15B	B100
5698281	SNMA543 KCK15B	B100
5698284	TNMA332 KCK15B	B122
5698287	TNMA433 KCK15B	B122
5698288	TNMG331FN KCK15B	B123
5698289	TNMG332FN KCK15B	B123
5698300	VBMT331LF KCK15B	B281
5698301	VBMT332LF KCK15B	B281
5698302	VNMG331FN KCK15B	B146
5698305	WNMG332FN KCK15B	B157
5698306	WNMG432FN KCK15B	B157
5698307	WNMG432MW KCK15B	B160
5698743	CCMT2152LF KCK15B	B191
5698744	CCMT3251MF KCK15B	B191
5698747	CNMG432FW KCK15B	B49
5698770	CPMT3251LF KCK15B	B207
5698772	CPMT3252LF KCK15B	B207
5698773	CPMT3252MF KCK15B	B207
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5698794	TCMT3252MF KCK15B	B258
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5698800	TPMR321 KCK15B	B177
5698801	TPMR322 KCK15B	B177
5698802	TPMT2151LF KCK15B	B268
5698804	TPMT3252LF KCK15B	B268
5698806	TPU222 KCK15B	B178
5698807	TPU432 KCK15B	B178
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5699584	TNMG332MR KCM25B	B125
5699586	TNMG433MR KCM25B	B125
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5699591	WNMG433MR KCM25B	B159
5700484	SCMT3252MF KCK15B	B247
5700485	WNMA433 KCK15B	B157
5700487	VNMA332 KCK15B	B145
5701293	MS2263	T4–7
5702495	M4D300L1505S100L175	T17
5702496	M4D400L1506S150L200	T17
5702497	M4D600L1508S200L238	T17
5702498	M4D600L1512S200L238	T17
5702499	M4D200L1504S075L175	T17
5702500	M4D500L1507S150L238	T17
5703876	T694NC#04-40RH2-A KSS29	M65
5703877	T694NC#08-32RH3-A KSS29	M65
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5703932	T694NF04375-20RH3-A KSS29	M65
5703935	KCRA150RN4303C125L400	V148
5703936	KCRA200RN4304S075L175	V149
5703937	KCRA200RN4306S075L175	V149
5703938	KCRA250RN4306S075L175	V149
5703939	KCRA250RN4309S075L175	V149
5704050	KCRA300RN4308S100L200	V149
5704051	KCRA300RN4311S100L200	V149
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5704849	T694NC#10-24RH3-A KSP27	M65
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5705111	T694NC02500-20RH5-A KSS29	M65
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5705113	T694NF02500-28RH4-A KSS29	M65
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5705115	T694NC03750-16RH3-A KSP27	M65
5705116	T694NC03750-16RH5-A KSS29	M65
5705117	T694NF03750-24RH3-A KSS29	M65
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5705127	T694NF06250-18RH3-A KSS29	M65
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5705129	T694NC04375-14RH5-A KSS29	M65
5705130	T694NF04375-20RH3-A KSP27	M65
5705131	T694NF04375-20RH5-A KSS29	M65
5705385	T690NF#10-32RH3-A KSP27	M15
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5705387	T690NF#10-32RH5-A KSS29	M15
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5705414	T690NF05000-20RH3-A KSS29	M16
5705415	T690NC02500-20RH3-A KSP27	M15
5705416	T690NF02500-28RH3-A KSP27	M15
5705417	T690NF02500-28RH4-A KSS29	M15
5705418	T690NC07500-10RH3-A KSS29	M16
5705419	T690NC03750-16RH3-A KSS29	M16
5705420	T690NC03750-16RH3-A KSP27	M16
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5705422	T690NF03750-24RH3-A KSP27	M16
5705423	T690NC03125-18RH3-A KSS29	M15
5705424	T690NC03125-18RH3-A KSP27	M15
5705425	T690NF03125-24RH3-A KSS29	M15
5705426	T690NF06250-18RH3-A KSS29	M16
5705427	T690NC04375-14RH3-A KSS29	M16
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5705436	T690M080X125RD5-A KSS29	M17
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5705471	T692NC#06-32RH3-A KSS29	M62
5705472	T692NC#08-32RH3-A KSS29	M62
5705473	T692NC05000-13RH3-A KSS29	M63
5705474	T692NF05000-20RH3-A KSS29	M63
5705475	T692NF05000-20RH7-A KSS29	M63
5705476	T692NC02500-20RH3-A KSP27	M62
5705477	T692NF02500-28RH3-A KSP27	M62
5705478	T692NC03125-18RH3-A KSS29	M62
5705479	T692NC06250-11RH3-A KSS29	M63
5705480	T692NF04375-20RH3-A KSS29	M63
5705481	T692M100X150RD6-A KSP27	M64
5705482	T692M100X150RD6-A KSS29	M64
5705483	T692M120X175RD6-A KSS29	M64
5705484	T692M025X045RD3-A KSS29	M64
5705485	T692M040X070RD4-A KSS29	M64
5705486	T692M050X080RD4-A KSP27	M64
5705487	T692M050X080RD4-A KSS29	M64
5705488	T692M060X100RD5-A KSS29	M64
5705489	T692M080X125RD5-A KSS29	M64
5705674	T690NC#10-24RH3-A KSS29	M15
5705675	T690NC#10-24RH3-A KSP27	M15
5705676	T690NC#10-24RH5-A KSS29	M15
5705677	T690NF#10-32RH2-A KSS29	M15
5705678	T690NF#10-32RH2-A KSP27	M15
5705679	T690NF#10-32RH3-A KSS29	M15
5705850	T690NF#10-32RH4-A KSP27	M15
5705851	T690NF#10-32RH5-A KSP27	M15
5705852	T690NF#10-32RH6-A KSS29	M15
5705853	T690NF#10-32RH6-A KSP27	M15
5705854	T690NC#02-56RH2-A KSP27	M15
5705855	T690NC#04-40RH2-A KSP27	M15
5705856	T690NC#04-40RH3-A KSS29	M15
5705857	T690NC#04-40RH3-A KSP27	M15
5705858	T690NC#04-40RH4-A KSS29	M15
5705859	T690NF#04-48RH2-A KSS29	M15
5705860	T690NF#04-48RH2-A KSP27	M15
5705861	T690NC#05-40RH2-A KSS29	M15
5705862	T690NC#05-40RH2-A KSP27	M15
5705863	T690NC#06-32RH3-A KSS29	M15
5705864	T690NC#06-32RH5-A KSS29	M15
5705865	T690NC#06-32RH5-A KSP27	M15
5705866	T690NF#06-40RH2-A KSS29	M15
5705867	T690NC#08-32RH3-A KSP27	M15
5705868	T690NC#08-32RH4-A KSP27	M15
5705869	T690NC#08-32RH5-A KSS29	M15
5705870	T690NC#08-32RH6-A KSS29	M15
5705871	T690NC05000-13RH3-A KSS29	M16
5705872	T690NC05000-13RH5-A KSS29	M16
5705873	T690NC05000-13RH7-A KSS29	M16
5705874	T690NF05000-20RH3-A KSP27	M16
5705875	T690NF05000-20RH5-A KSS29	M16
5705876	T690NF05000-20RH7-A KSS29	M16
5705877	T690NC02500-20RH3-A KSS29	M15
5705878	T690NC02500-20RH5-A KSS29	M15
5705879	T690NC02500-20RH5-A KSP27	M15
5705880	T690NF02500-28RH3-A KSS29	M15
5705881	T690NF02500-28RH4-A KSP27	M15
5705882	T690NF02500-28RH5-A KSS29	M15
5705883	T690NF02500-28RH5-A KSP27	M15
5705884	T690NF02500-28RH6-A KSS29	M15
5705885	T690NF02500-28RH6-A KSP27	M15
5705886	T690NF02500-28RH7-A KSS29	M15
5705887	T690NF07500-16RH3-A KSS29	M16
5705888	T690NC03750-16RH5-A KSS29	M16
5705889	T690NC03750-16RH5-A KSP27	M16
5705890	T690NC03750-16RH7-A KSS29	M16
5705891	T690NF03750-24RH4-A KSS29	M16
5705892	T690NF03750-24RH5-A KSS29	M16
5705893	T690NF03750-24RH6-A KSS29	M16
5705894	T690NF03750-24RH7-A KSS29	M16
5705895	T690NC03125-18RH5-A KSS29	M15
5705896	T690NC03125-18RH5-A KSP27	M15
5705897	T690NC03125-18RH7-A KSS29	M15
5705898	T690NF03125-24RH3-A KSP27	M15
5705899	T690NF03125-24RH4-A KSS29	M15
5705900	T690NF03125-24RH5-A KSS29	M16
5705901	T690NF03125-24RH6-A KSS29	M16
5705902	T690NF03125-24RH7-A KSS29	M16
5705903	T690NC06250-11RH3-A KSS29	M16
5705904	T690NC06250-11RH3-A KSP27	M16
5705905	T690NF06250-18RH3-A KSP27	M16
5705906	T690NC04375-14RH3-A KSP27	M16
5705907	T690NF04375-20RH3-A KSS29	M16
5705908	T690NF04375-20RH5-A KSS29	M16
5705909	T690NF04375-20RH5-A KSP27	M16
5705920	T690M100X150RD6-A KSP27	M17
5705921	T690M100X150RD6-A KSS29	M17
5705922	T690M120X175RD6-A KSP27	M17
5705923	T690M025X045RD3-A KSP27	M17
5705924	T690M035X060RD4-A KSS29	M17
5705925	T690M035X060RD4-A KSP27	M17
5705926	T690M030X050RD3-A KSP27	M17
5705927	T690M040X070RD4-A KSP27	M17
5705928	T690M050X080RD4-A KSP27	M17
5705929	T690M050X080RD4-A KSS29	M17
5705930	T690MF080X100RD5-A KSS29	M17
5705931	T690MF080X100RD5-A KSP27	M17
5707893	TNMG332MP KCP25B	B124
5708200	T692NC#10-24RH5-A KSS29	M62
5708202	T692NC#10-24RH5-A KSP27	M62
5708204	T692NF#10-32RH2-A KSP27	M62
5708206	T692NF#10-32RH3-A KSS29	M62
5708208	T692NF#10-32RH3-A KSP27	M62
5708210	T692NF#10-32RH5-A KSS29	M62
5708212	T692NF#10-32RH7-A KSS29	M62
5708214	T692NC#02-56RH2-A KSS29	M62
5708216	T692NC#02-56RH2-A KSP27	M62
5708218	T692NC#03-48RH2-A KSS29	M62
5708220	T692NC#04-40RH2-A KSS29	M62
5708222	T692NC#04-40RH2-A KSP27	M62
5708224	T692NC#04-40RH3-A KSP27	M62
5708226	T692NF#04-40RH5-A KSS29	M62
5708228	T692NC#05-40RH2-A KSS29	M62
5708240	T692NC#06-32RH3-A KSP27	M62
5708242	T692NC#06-32RH5-A KSS29	M62

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5708244	T692NC#06-32RH7-A KSS29	M62
5708246	T692NC#06-32RH7-A KSP27	M62
5708248	T692NF#06-40RH2-A KSS29	M62
5708250	T692NC#08-32RH2-A KSS29	M62
5708252	T692NC#08-32RH3-A KSP27	M62
5708254	T692NC#08-32RH4-A KSS29	M62
5708256	T692NC#08-32RH4-A KSP27	M62
5708258	T692NC#08-32RH5-A KSS29	M62
5708260	T692NC#08-32RH5-A KSP27	M62
5708262	T692NC#08-32RH6-A KSS29	M62
5708264	T692NC05000-13RH3-A KSP27	M63
5708266	T692NC05000-13RH5-A KSS29	M63
5708268	T692NC05000-13RH5-A KSP27	M63
5708270	T692NF05000-20RH3-A KSP27	M63
5708272	T692NF05000-20RH5-A KSS29	M63
5708274	T692NF05000-20RH5-A KSP27	M63
5708276	T692NC02500-20RH3-A KSS29	M62
5708278	T692NC02500-20RH5-A KSS29	M62
5708280	T692NF02500-28RH3-A KSS29	M62
5708282	T692NF02500-28RH5-A KSS29	M62
5708284	T692NF02500-28RH6-A KSS29	M62
5708286	T692NF02500-28RH7-A KSS29	M62
5708288	T692NC07500-10RH3-A KSS29	M63
5708300	T692NC07500-10RH5-A KSS29	M63
5708302	T692NF07500-16RH3-A KSS29	M63
5708304	T692NF07500-16RH5-A KSS29	M63
5708306	T692NC03750-16RH3-A KSS29	M63
5708308	T692NC03750-16RH3-A KSP27	M63
5708310	T692NC03750-16RH5-A KSS29	M63
5708312	T692NC03750-16RH5-A KSP27	M63
5708314	T692NF03750-24RH3-A KSS29	M63
5708316	T692NF03750-24RH3-A KSP27	M63
5708318	T692NF03750-24RH4-A KSS29	M63
5708320	T692NF03750-24RH4-A KSP27	M63
5708322	T692NF03750-24RH5-A KSS29	M63
5708324	T692NF03750-24RH5-A KSP27	M63
5708326	T692NF03750-24RH6-A KSS29	M63
5708328	T692NC03125-18RH3-A KSP27	M62
5708330	T692NC03125-18RH5-A KSS29	M62
5708332	T692NC03125-18RH5-A KSP27	M62
5708334	T692NC03125-18RH7-A KSS29	M62
5708336	T692NF03125-24RH3-A KSS29	M62
5708338	T692NF03125-24RH3-A KSP27	M62
5708340	T692NF03125-24RH4-A KSS29	M63
5708342	T692NF03125-24RH5-A KSS29	M63
5708344	T692NF03125-24RH6-A KSS29	M63
5708346	T692NF03125-24RH7-A KSS29	M63
5708348	T692NC06250-11RH3-A KSP27	M63
5708360	T692NC06250-11RH5-A KSS29	M63
5708362	T692NC06250-11RH7-A KSS29	M63
5708363	T692NF06250-18RH3-A KSS29	M63
5708364	T692NC04375-14RH3-A KSS29	M63
5708365	T692NC04375-14RH5-A KSS29	M63
5708366	T692NF04375-20RH3-A KSP27	M63
5708367	T692NF04375-20RH5-A KSS29	M63
5708368	T692MF100X125RD5-A KSS29	M64
5708369	T692MF100X125RD5-A KSP27	M64
5708380	T692M120X175RD6-A KSP27	M64
5708381	T692M025X045RD3-A KSP27	M64
5708382	T692M030X050RD3-A KSP27	M64
5708383	T692M030X050RD3-A KSS29	M64
5708384	T692M040X070RD4-A KSP27	M64
5708385	T692M060X100RD5-A KSP27	M64
5708386	T692MF080X100RD5-A KSS29	M64
5708387	T692MF080X100RD5-A KSP27	M64
5708388	T692M080X125RD5-A KSP27	M64
5709281	DNMG432FN KCPK05	B79
5712913	KW1008	V148–149
5720114	B285D08000HPS KN15	G83
5824029	4BN0031IR008A KC633M	Q26
5824030	4BN0047IR012A KC633M	Q26
5824333	4CH0125IS025A KC633M	Q22
5824334	4CH0125IR050A KC633M	Q22
5824335	4CH0125IL075A KC633M	Q22
5824336	4CH0125IX100A KC633M	Q22
5824337	4CH0140IR056A KC633M	Q22
5824338	4CH0156IR056A KC633M	Q22
5824339	4CH0187IR062A KC633M	Q22
5824340	4CH0187IS075A KC633M	Q22
5824341	4CH0187IL075A KC633M	Q22
5824342	4CH0187IX112A KC633M	Q22
5824343	4CH0203IR062A KC633M	Q22
5824344	4CH0218IR043A KC633M	Q22
5824345	4CH0218IL062A KC633M	Q22
5824346	4CH0234IR075A KC633M	Q23
5824347	4CH0250IS050A KC633M	Q23
5824348	4CH0250IR075A KC633M	Q23
5824349	4CH0250IL112A KC633M	Q23
5824350	4CH0250IX150A KC633M	Q23
5824352	4CH0265IR075A KC633M	Q23
5824353	4CH0281IR075A KC633M	Q23
5824354	4CH0296IR081A KC633M	Q23
5824355	4CH0312IS050A KC633M	Q23
5824356	4CH0312IR081A KC633M	Q23
5824357	4CH0312IL112A KC633M	Q23
5824358	4CH0312IX162A KC633M	Q23
5824359	4CH0328IR100A KC633M	Q23
5824360	4CH0343IR100A KC633M	Q23
5824371	4CH0359IR100A KC633M	Q23
5824372	4CH0375IS062A KC633M	Q23
5824373	4CH0375IR100A KC633M	Q23
5824374	4CH0375IL112A KC633M	Q23
5824375	4CH0375IX175A KC633M	Q23
5824376	4CH0390IR100A KC633M	Q23
5824377	4CH0406IR100A KC633M	Q23
5824378	4CH0421IR100A KC633M	Q23
5824379	4CH0437IS100A KC633M	Q23
5824380	4CH0437IR100A KC633M	Q23
5824381	4CH0437IL200A KC633M	Q23
5824382	4CH0437IX300A KC633M	Q23
5824383	4CH0453IR100A KC633M	Q24
5824384	4CH0468IR100A KC633M	Q24
5824385	4CH0484IR100A KC633M	Q24
5824386	4CH0500IS062A KC633M	Q24
5824387	4CH0500IR100A KC633M	Q24
5824388	4CH0500IL200A KC633M	Q24
5824389	4CH0500IX300A KC633M	Q24
5824390	4CH0562IR075A KC633M	Q24
5824401	4CH0562IL125A KC633M	Q24
5824402	4CH0562IX225A KC633M	Q24
5824403	4CH0625IS075A KC633M	Q24
5824404	4CH0625IR125A KC633M	Q24
5824405	4CH0625IL225A KC633M	Q24
5824406	4CH0625IX400A KC633M	Q24
5824407	4CH0687IR137A KC633M	Q24
5824409	4CH0750IR150A KC633M	Q24
5824410	4CH0750IR225A KC633M	Q24
5824411	4CH0750IL300A KC633M	Q24
5824412	4CH0750IX400A KC633M	Q24
5824413	4CH0875IR150A KC633M	Q25
5824414	4CH0875IL225A KC633M	Q25
5824415	4CH1000IS150A KC633M	Q25
5824416	4CH1000IR225A KC633M	Q25
5824417	4CH1000IL300A KC633M	Q25
5824418	4CH1000IX400A KC633M	Q25
5824420	4CH0500IR100B KC633M	Q24
5824421	4CH0500IL200B KC633M	Q24
5824422	4CH0562IL125B KC633M	Q24
5824423	4CH0625IR125B KC633M	Q24
5824424	4CH0625IL225B KC633M	Q24
5824425	4CH0750IR150B KC633M	Q24
5824426	4CH0750IR225B KC633M	Q24
5824427	4CH0750IL300B KC633M	Q24
5824428	4CH0875IR150B KC633M	Q25
5824429	4CH0875IL225B KC633M	Q25
5824430	4CH1000IR225B KC633M	Q25
5824431	4CH1000IL300B KC633M	Q25
5824501	4BN0062IR019A KC633M	Q26
5824502	4BN0078IR019A KC633M	Q26
5824503	4BN0094IR019A KC633M	Q26
5824504	4BN0094IL037A KC633M	Q26
5824505	4BN0109IR037A KC633M	Q26
5824506	4BN0125IS025A KC633M	Q26
5824507	4BN0125IR050A KC633M	Q26
5824508	4BN0125IL075A KC633M	Q26
5824509	4BN0125IX075A KC633M	Q26
5824510	4BN0141IR056A KC633M	Q26
5824511	4BN0156IR056A KC633M	Q26
5824512	4BN0172IR062A KC633M	Q26
5824513	4BN0187IR031A KC633M	Q26
5824514	4BN0187IL062A KC633M	Q26
5824515	4BN0187IX100A KC633M	Q26
5824516	4BN0203IR062A KC633M	Q26
5824517	4BN0219IR062A KC633M	Q26
5824518	4BN0234IR075A KC633M	Q26
5824519	4BN0250IS050A KC633M	Q26
5824520	4BN0250IR075A KC633M	Q26
5824521	4BN0250IR112A KC633M	Q26
5824522	4BN0250IL150A KC633M	Q26
5824523	4BN0250IX150A KC633M	Q26
5824524	4BN0281IR075A KC633M	Q26
5824525	4BN0312IS050A KC633M	Q26
5824526	4BN0312IR081A KC633M	Q26
5824527	4BN0312IL112A KC633M	Q26
5824528	4BN0312IX162A KC633M	Q26
5824529	4BN0344IR100A KC633M	Q26
5824530	4BN0375IS100A KC633M	Q26
5824531	4BN0375IR100A KC633M	Q27
5824532	4BN0375IL112A KC633M	Q27
5824533	4BN0375IX150A KC633M	Q27
5824534	4BN0437IR100A KC633M	Q27
5824535	4BN0500IS100A KC633M	Q27
5824536	4BN0500IR100A KC633M	Q27
5824537	4BN0500IX150A KC633M	Q27
5824538	4BN0500IR200A KC633M	Q27
5824539	4BN0500IL200A KC633M	Q27
5824540	4BN0500IX300A KC633M	Q27
5824551	4BN0562IR125A KC633M	Q27
5824552	4BN0625IR125A KC633M	Q27
5824553	4BN0625IL225A KC633M	Q27
5824554	4BN0750IR150A KC633M	Q27
5824555	4BN0750IL300A KC633M	Q27
5824556	4BN0875IR150A KC633M	Q27
5824557	4BN1000IR150A KC633M	Q27
5824558	4BN1000IL225A KC633M	Q27
5826308	RIQ09EDR00 KC6105	K59
5826309	RIQ09EDR00 KC6305	K59
5826310	RIQ09R0506FT KT6315	K58
5874646	CNMM546RP KCP10B	B56
5876721	2BN0031IR007A KC633M	Q9
5876722	2BN0063IR018A KC633M	Q9
5876723	2BN0047IR018A KC633M	Q9
5876724	2BN0094IR018A KC633M	Q9
5876725	2BN0094IL037A KC633M	Q9
5876726	2BN0109IR037A KC633M	Q9
5876727	2BN0125IS025A KC633M	Q9
5876728	2BN0125IR050A KC633M	Q9
5876729	2BN0125IL075A KC633M	Q9
5876730	2BN0125IX075A KC633M	Q9
5876741	2BN0156IR031A KC633M	Q9
5876742	2BN0156IL056A KC633M	Q9
5876743	2BN0187IS031A KC633M	Q9
5876744	2BN0187IR062A KC633M	Q9
5876745	2BN0187IL075A KC633M	Q9
5876746	2BN0187IX100A KC633M	Q9
5876747	2BN0219IR062A KC633M	Q9
5876748	2BN0250IS050A KC633M	Q9
5876749	2BN0250IR075A KC633M	Q9
5876750	2BN0250IR112A KC633M	Q9
5876751	2BN0250IL150A KC633M	Q9
5876752	2BN0250IX150A KC633M	Q9
5876753	2BN0312IR081A KC633M	Q9
5876754	2BN0312IL112A KC633M	Q9
5876755	2BN0312IX150A KC633M	Q9
5876756	2BN0375IS062A KC633M	Q9
5876757	2BN0375IR087A KC633M	Q9
5876758	2BN0375IL112A KC633M	Q9
5876759	2BN0375IX300A KC633M	Q9
5876760	2BN0406IR100A KC633M	Q9
5876761	2BN0437IR100A KC633M	Q9
5876762	2BN0500IS062A KC633M	Q9
5876763	2BN0500IR100A KC633M	Q10
5876764	2BN0500IX150A KC633M	Q10
5876765	2BN0500IL200A KC633M	Q10
5876766	2BN0500IX300A KC633M	Q10
5876767	2BN0625IR125A KC633M	Q10
5876768	2BN0625IL225A KC633M	Q10
5876769	2BN0625IX300A KC633M	Q10
5876770	2BN0750IS100A KC633M	Q10
5876771	2BN0750IR150A KC633M	Q10
5876772	2BN0750IL200A KC633M	Q10
5876773	2BN0750IX300A KC633M	Q10
5876774	2BN0875IR150A KC633M	Q10
5876775	2BN1000IR150A KC633M	Q10
5876776	2BN1000IL300A KC633M	Q10
5876860	2CH0125IR025A KC633M	Q6
5876861	2CH0125IL050A KC633M	Q6
5876862	2CH0125IX075A KC633M	Q6
5876863	2CH0140IR056A KC633M	Q6
5876864	2CH0156IR031A KC633M	Q6
5876865	2CH0156IL056A KC633M	Q6
5876866	2CH0171IR062A KC633M	Q6
5876867	2CH0187IR062A KC633M	Q6
5876868	2CH0187IL075A KC633M	Q6
5876869	2CH0187IX112A KC633M	Q6
5876870	2CH0218IR043A KC633M	Q6
5876871	2CH0218IL062A KC633M	Q7
5876872	2CH0250IS050A KC633M	Q7
5876873	2CH0250IR075A KC633M	Q7
5876874	2CH0250IL112A KC633M	Q7
5876875	2CH0250IX150A KC633M	Q7
5876876	2CH0281IR075A KC633M	Q7
5876877	2CH0312IS050A KC633M	Q7
5876878	2CH0312IR081A KC633M	Q7
5876879	2CH0312IL112A KC633M	Q7
5876880	2CH0312IX162A KC633M	Q7
5876881	2CH0343IR100A KC633M	Q7
5876882	2CH0375IS062A KC633M	Q7
5876883	2CH0375IR100A KC633M	Q7
5876884	2CH0375IL112A KC633M	Q7
5876885	2CH0375IX175A KC633M	Q7
5876886	2CH0406IR100A KC633M	Q7
5876887	2CH0437IR062A KC633M	Q7
5876888	2CH0437IL100A KC633M	Q7
5876889	2CH0437IX200A KC633M	Q7
5876890	2CH0468IR100A KC633M	Q7
5876891	2CH0500IS062A KC633M	Q7
5876892	2CH0500IR100A KC633M	Q7
5876893	2CH0500IL200A KC633M	Q7
5876894	2CH0500IX300A KC633M	Q7
5876895	2CH0562IR075A KC633M	Q8
5876896	2CH0562IL125A KC633M	Q8
5876897	2CH0562IX225A KC633M	Q8
5876898	2CH0625IR075A KC633M	Q8
5876899	2CH0625IL125A KC633M	Q8
5876900	2CH0625IX225A KC633M	Q8
5876901	2CH0687IR137A KC633M	Q8
5876902	2CH0750IS100A KC633M	Q8
5876903	2CH0750IR150A KC633M	Q8
5876904	2CH0750IR225A KC633M	Q8
5876905	2CH0750IL300A KC633M	Q8
5876906	2CH0750IX400A KC633M	Q8
5876907	2CH0875IR150A KC633M	Q8
5876908	2CH0875IL225A KC633M	Q8
5876909	2CH1000IS150A KC633M	Q8
5876910	2CH1000IR225A KC633M	Q8
5876911	2CH1000IL300A KC633M	Q8
5876912	2CH1000IX400A KC633M	Q8
5876913	2CH0500IR100B KC633M	Q7
5876914	2CH0500IL200B KC633M	Q7
5876915	2CH0500IX300B KC633M	Q7
5876916	2CH0562IL125B KC633M	Q8
5876917	2CH0562IX225B KC633M	Q8
5876918	2CH0625IL125B KC633M	Q8
5876919	2CH0625IX225B KC633M	Q8
5876920	2CH0687IR137B KC633M	Q8
5876921	2CH0750IR225B KC633M	Q8
5876922	2CH0750IL300B KC633M	Q8
5876923	2CH0750IX400B KC633M	Q8
5876924	2CH0875IR150B KC633M	Q8
5876925	2CH0875IL225B KC633M	Q8
5876926	2CH1000IR225B KC633M	Q8
5876927	2CH1000IL300B KC633M	Q8
5876928	2CH1000IX400B KC633M	Q8
5878707	SPGX070304MD KCPK10	J103
5879813	XNGJ43ANENLD3W KCPM40	S12
5879814	LNPU863ANSLHD2 KCPM40	S95
5879816	LNPU863ANSLHD2 KCPK30	S95
5882266	CNMM866RH KCP30B	B55
5882267	CNMG433RN KCP30B	B53
5882268	CNMG432MN KCP30B	B50
5882269	CNMG432RN KCP30B	B53
5882270	WNMG432MN KCP30B	B159
5882322	CNMG432RP KCP30B	B53
5882323	TNMG332MN KCP30B	B124
5882324	DNMG432MN KCP30B	B81
5882580	DT3IP	W34–35
5882752	MS9000	W17–19, W24–25

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5882759	MS5006	W12, W19
5882760	MS5007	W12–13
5882761	MS5009	W18, W25
5882762	MS5008	W12, W18, W25
5882863	CNMG432MP KCM35B	B51
5882865	CNMG433RP KCM35B	B53
5882866	CNMG432RP KCM35B	B53
5882870	CNMG432UP KCM35B	B54
5882881	TNMG331MP KCM35B	B124
5882884	TNMG332MP KCM35B	B124
5882886	WNMG432RP KCM35B	B161
5882890	WNMG332MP KCM35B	B159
5882891	WNMG432MP KCM35B	B159
5882892	CNMG543RP KCM35B	B53
5882893	CNMG431MP KCM35B	B51
5882899	DNMG443RP KCM35B	B84
5882905	SNMG432MP KCM35B	B102
5882906	WNMG433RP KCM35B	B161
5882924	TCMT3252LF KCK05B	B257
5882925	WNMG432RP KCK05B	B161
5882934	CCMT2152LF KCK05B	B191
5882966	WNMG432UN KCK05B	B162
5882972	CNMG433UN KCK05B	B54
5882973	CNMA434 KCK05B	B47
5882976	TNMG333UN KCK05B	B127
5883000	CNMA431 KCK05B	B47
5883011	CNMG433FN KCK05B	B49
5883013	VNMG332UN KCK05B	B148
5883017	SCMT3252LF KCK05B	B246
5883018	SNMG433UN KCK05B	B106
5883022	CNMG434UN KCK05B	B54
5883025	WNMG431FN KCK05B	B157
5883443	RPPT1204M0SGDX5 KCM40	V106
5883444	RPPT1204M0SGDX8 KCM40	V106
5883445	RPHT1204M0SGDX5 KCM40	V105
5883446	RPHT1204M0SGDX8 KCM40	V105
5883520	CNMG432RP KCP05B	B53
5883573	DNMG442MN KCP05B	B81
5883576	CNMG432MN KCP05B	B50
5883577	DNMG432MN KCP05B	B81
5883581	TNMG332FN KCP05B	B123
5886541	CNMG433RP KCP40B	B53
5886542	CNMG543RP KCP40B	B53
5886544	SNMG643RP KCP40B	B105
5886545	TNMG432RP KCP40B	B127
5887614	SNMG644RP KCPK05	B105
5892306	CNMG432MR KCP30B	B51
5892307	DNMG432RN KCP30B	B83
5892308	SNMG432MN KCP30B	B102
5892411	CNMG433MN KCP30B	B50
5892412	WNMG432RN KCP30B	B161
5892413	CNMG543RN KCP30B	B53
5892414	TNMG543RN KCP30B	B126
5892415	SNMG433RN KCP30B	B105
5892416	TNMG432RN KCP30B	B126
5892417	CNMG643RN KCP30B	B53
5892418	CNMG644RN KCP30B	B53
5892419	TNMG666RN KCP30B	B126
5892420	WNMG433RN KCP30B	B161
5892432	CNMM432MR KCP30B	B54
5892433	CNMG433P KCP30B	B52
5892434	CNMG432P KCP30B	B52
5892435	SNMG644RN KCP30B	B105
5892436	DNMG432MR KCP30B	B82
5892437	WNMG432RP KCP30B	B161
5892438	TNMG544RN KCP30B	B126
5892441	CNMM543MR KCP30B	B54
5892442	SNMG432RN KCP30B	B105
5892443	TNMG433RN KCP30B	B126
5892445	SNMG643RN KCP30B	B105
5892446	WNMG333MN KCP30B	B159
5892447	DNMG433MN KCP30B	B81
5892450	SNMG544RN KCP30B	B105
5892453	CNMG433RP KCP30B	B53
5892558	DNMG443CT KCP05B	B79
5892560	VNMG332MN KCP05B	B146
5892655	CNMG432FW KCP05B	B49
5892659	DNMG332FF KCP05B	B79
5894139	RPPT10T3M0E432X5 X500	V100
5894140	RPPT10T3M0E432X5 SC6525	V100
5894201	RPPT10T3M0E432X5 SP6519	V100
5894202	RPPT10T3M0E432X5 X700	V100
5894258	SDET433PDSR8GB KC725M	T116, T123, U39
5894812	SDET436ENGB KC725M	T116, T123, U39
5894813	SDET436SNGB KC725M	T116, T123, U39
5894815	SDET434SNGB KC725M	T116, T123, U39
5897007	B967A16500 KC7315	G132
5898597	M1D300E1404S100L175	T53
5898598	M1D200E1403S075L157	T53
5903140	M1D150E1403C125L1000	T52
5903579	SNMG543MR KCPK05	B103
5904367	CNMG544MG KCP10B	B57
5904368	DNMG444MG KCP10B	B83
5904369	DNMG443MG KCP10B	B83
5910213	CPMT2152MF KCP10B	B207
5914006	SCW5E	C58
5914007	SCW8E	C58
5914680	NG3094RK KCP10B	C162
5914889	NGD4M400LK KCU25	C165
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
5939453	EVSML200432C	C35
5939454	EVSMR200426C	C34
5939455	EVSMR160426C	C34
5939456	EVSMR160416C	C34
5939457	EVSMR160326C	C34
5939458	EVSMR160316C	C34
5939459	EVSMR120422C	C34
5939460	EVSMR120416C	C34
5939461	EVSMR120322C	C34
5939462	EVSMR120316C	C34
5939463	EVSMR200432C	C34
5939464	EVSML120316C	C35
5939465	EVSML120322C	C35
5939466	EVSML160316C	C35
5939467	EVSML160326C	C35
5939468	EVSML120416C	C35
5939469	EVSML120422C	C35
5939470	EVSML160416C	C35
5939471	EVSML160426C	C35
5939472	EVSML200426C	C35
5940092	TPMR321 KCP25B	B177
5940093	TPMR221 KCP25B	B177
5941012	LNUX301940RRSM KCP10B	E58
5941056	EG0312M03U02GUP KCU25	C17
5941057	EG0312M03U04GUP KCU25	C17
5941058	EG0312M03U02GUN KCU25	C20
5941059	EG0312M03U04GUN KCU25	C20
5941071	EG0412M04U04GUP KCU25	C17
5941072	EG0412M04U04GUN KCU25	C20
5941073	EC030M03N00CF02 KCU25	C22
5941074	EC030M03L06CF02 KCU25	C22
5941075	EC030M03R06CF02 KCU25	C22
5941076	EC040M04N00CF02 KCU25	C22
5941077	EC040M04L06CF02 KCU25	C22
5941078	EC040M04R06CF02 KCU25	C22
5941079	EC030M03N00CM02 KCU25	C24
5941080	EC040M04N00CM02 KCU25	C24
5941081	EC030M03N00CR02 KCU25	C25
5941082	EC040M04N00CR02 KCU25	C25
5941083	EG0412M04U08GUP KCU25	C17
5941084	EG0412M04U08GUN KCU25	C20
5941085	EC030M03L06CM02 KCU25	C24
5941086	EC030M03R06CM02 KCU25	C24
5941087	EC040M04L06CM02 KCU25	C24
5941088	EC040M04R06CM02 KCU25	C24
5941089	EC030M03L06CR02 KCU25	C25
5941090	EC030M03R06CR02 KCU25	C25
5941091	EC040M04L06CR02 KCU25	C25
5941092	EC040M04R06CR02 KCU25	C25
5941093	EG130I03U05GUP KCU25	C18
5941094	EG130I03U1GUP KCU25	C18
5941095	EG130I03U05GUN KCU25	C21
5941096	EG130I03U1GUN KCU25	C21
5941097	EG192I04U1GUP KCU25	C18
5941098	EG192I04U1GUN KCU25	C21
5941099	EG192I04U2GUP KCU25	C18
5941100	EG192I04U2GUN KCU25	C21
5941101	EG0300M03P02GUP KCU25	C17
5941102	EG0300M03P04GUP KCU25	C17
5941103	EG0400M04P04GUP KCU25	C17
5941104	EG0400M04P08GUP KCU25	C17
5941105	EG0300M03P02GUP K313	C17
5941107	EG0300M03P04GUP K313	C17
5941108	EG0400M04P04GUP K313	C17
5941109	EG0400M04P08GUP K313	C17
5941110	EG125I03P05GUP KCU25	C18
5941111	EG125I03P1GUP KCU25	C18
5941112	EG187I04P1GUP KCU25	C18
5941113	EG187I04P2GUP KCU25	C18
5941114	EG125I03P05GUP K313	C18
5941115	EG125I03P1GUP K313	C18
5941116	EG187I04P1GUP K313	C18
5941117	EG187I04P2GUP K313	C18
5941706	EVBSN19G1B14	C58
5941707	EVBSN19G0220	C58
5941708	EVBSN26J1B15	C58
5941709	EVBSN26J0230	C58
5941710	EVBSN26M0230	C58
5941721	EVBSN26J0340	C58
5941722	EVBSN26M0340	C58
5941723	EVBSN26J0440	C58
5941724	EVBSN32M0250	C58
5941725	EVBSN32M0350	C58
5941726	EVBSN32M0450	C58
5945156	T624NC#06-32RH3-DA KSP27	M141
5945157	T624NC#06-32RH5-DA KSP27	M141
5945158	T624NC#08-32RH3-DA KSP27	M141
5945159	T624NC#08-32RH5-DA KSP27	M141
5945160	T624NC#10-24RH4-DA KSP27	M141
5945323	T625NC02500-20RH4-DA KSP27	M142
5945324	T625NC02500-20RH6-DA KSP27	M142
5945325	T625NF02500-28RH4-DA KSP27	M142
5945326	T625NF02500-28RH6-DA KSP27	M142
5945327	T625NC03125-18RH5-DA KSP27	M142
5945328	T625NC03125-18RH7-DA KSP27	M142
5945329	T625NF03125-24RH5-DA KSP27	M142
5945330	T625NF03125-24RH7-DA KSP27	M142
5945351	T624NC#10-24RH6-DA KSP27	M141
5945352	T624NF#10-32RH4-DA KSP27	M141
5945353	T624NF#10-32RH6-DA KSP27	M141
5945354	T624NC02500-20RH4-DA KSP27	M141
5945355	T624NC02500-20RH6-DA KSP27	M141
5945356	T624NF02500-28RH4-DA KSP27	M141
5945357	T624NF02500-28RH6-DA KSP27	M141
5945358	T624NC03125-18RH5-DA KSP27	M141
5945359	T624NC03125-18RH7-DA KSP27	M141
5945360	T624NF03125-24RH5-DA KSP27	M141
5945361	T624NF03125-24RH7-DA KSP27	M141
5945362	T624NC03750-16RH5-DA KSP27	M141
5945363	T624NC03750-16RH7-DA KSP27	M141
5945364	T624NF03750-24RH5-DA KSP27	M141
5945365	T624NF03750-24RH7-DA KSP27	M141
5945366	T624NC05000-13RH5-DA KSP27	M141
5945367	T624NC05000-13RH7-DA KSP27	M141
5945368	T624NF05000-20RH5-DA KSP27	M141
5945369	T624NF05000-20RH7-DA KSP27	M141
5945370	T624NC06250-11RH7-DA KSP27	M141
5945381	T624NC06250-11RH10-DA KSP27	M141
5945382	T624NF06250-18RH7-DA KSP27	M141
5945383	T624NF06250-18RH10-DA KSP27	M141
5945384	T624NC07500-10RH7-DA KSP27	M141
5945385	T624NC07500-10RH10-DA KSP27	M141
5945386	T624NF07500-16RH7-DA KSP27	M141
5945387	T624NF07500-16RH10-DA KSP27	M141
5945388	T624M030X050RD5-DA KSP27	M145
5945389	T624M040X070RD6-DA KSP27	M145
5945390	T624M060X100RD8-DA KSP27	M145
5945401	T624M080X125RD9-DA KSP27	M145
5945402	T624MF100X125RD9-DA KSP27	M145
5945403	T624M100X150RD10-DA KSP27	M145
5945404	T624MF120X125RD9-DA KSP27	M145
5945405	T624MF120X150RD9-DA KSP27	M145
5945406	T624M120X175RD11-DA KSP27	M145
5945407	T624MF140X150RD11-DA KSP27	M145
5945408	T624M140X200RD12-DA KSP27	M145
5945409	T624MF160X150RD11-DA KSP27	M145
5945410	T624M160X200RD12-DA KSP27	M145
5945451	T625NC03750-16RH5-DA KSP27	M142
5945452	T625NC03750-16RH7-DA KSP27	M142
5945453	T625NF03750-24RH5-DA KSP27	M142
5945454	T625NF03750-24RH7-DA KSP27	M142
5945455	T625NC05000-13RH5-DA KSP27	M142
5945456	T625NC05000-13RH7-DA KSP27	M142
5945457	T625NF05000-20RH5-DA KSP27	M142
5945458	T625NF05000-20RH7-DA KSP27	M142
5945459	T625NC06250-11RH7-DA KSP27	M142
5945460	T625NC06250-11RH10-DA KSP27	M142
5945461	T625NF06250-18RH7-DA KSP27	M142
5945462	T625NF06250-18RH10-DA KSP27	M142
5945463	T625NC07500-10RH7-DA KSP27	M142
5945464	T625NC07500-10RH10-DA KSP27	M142
5945465	T625NF07500-16RH7-DA KSP27	M142
5945466	T625NF07500-16RH10-DA KSP27	M142
5945467	T625M060X100RD8-DA KSP27	M146
5945468	T625M080X125RD9-DA KSP27	M146
5945469	T625MF100X125RD9-DA KSP27	M146
5945470	T625M100X150RD10-DA KSP27	M146
5945471	T625MF120X125RD9-DA KSP27	M146
5945472	T625MF120X150RD9-DA KSP27	M146
5945473	T625M120X175RD11-DA KSP27	M146
5945474	T625MF140X150RD11-DA KSP27	M146
5945475	T625M140X200RD12-DA KSP27	M146
5945476	T625MF160X150RD11-DA KSP27	M146
5945477	T625M160X200RD12-DA KSP27	M146
5945600	T627NC02500-20RH4-DA KSP27	M144
5945611	T627NC02500-20RH6-DA KSP27	M144
5945612	T627NF02500-28RH4-DA KSP27	M144
5945613	T627NF02500-28RH6-DA KSP27	M144
5945614	T627NC03125-18RH5-DA KSP27	M144
5945615	T627NC03125-18RH7-DA KSP27	M144
5945616	T627NF03125-24RH5-DA KSP27	M144
5945617	T627NF03125-24RH7-DA KSP27	M144
5945618	T627NC03750-16RH5-DA KSP27	M144
5945619	T627NC03750-16RH7-DA KSP27	M144
5945620	T627NF03750-24RH5-DA KSP27	M144
5945621	T627NF03750-24RH7-DA KSP27	M144
5945622	T627NC05000-13RH5-DA KSP27	M144
5945623	T627NC05000-13RH7-DA KSP27	M144
5945624	T627NF05000-20RH5-DA KSP27	M144
5945625	T627NF05000-20RH7-DA KSP27	M144
5945626	T627NC06250-11RH7-DA KSP27	M144
5945627	T627NC06250-11RH10-DA KSP27	M144
5945628	T627NF06250-18RH7-DA KSP27	M144
5945629	T627NF06250-18RH10-DA KSP27	M144
5945630	T627NC07500-10RH7-DA KSP27	M144
5945631	T627NC07500-10RH10-DA KSP27	M144
5945632	T627NF07500-16RH7-DA KSP27	M144
5945633	T627NF07500-16RH10-DA KSP27	M144
5945634	T627M060X100RD8-DA KSP27	M148
5945635	T627M080X125RD9-DA KSP27	M148
5945636	T627MF100X125RD9-DA KSP27	M148
5945637	T627M100X150RD10-DA KSP27	M148
5945638	T627MF120X125RD9-DA KSP27	M148
5945639	T627MF120X150RD9-DA KSP27	M148
5945640	T627M120X175RD11-DA KSP27	M148
5945641	T627MF140X150RD11-DA KSP27	M148
5945642	T627M140X200RD12-DA KSP27	M148
5945643	T627MF160X150RD11-DA KSP27	M148
5945644	T627M160X200RD12-DA KSP27	M148
5945990	T626NC#02-56RH3-DA KSP27	M143
5946041	T626NC#03-48RH3-DA KSP27	M143
5946042	T626NC#04-40RH3-DA KSP27	M143
5946043	T626NC#04-40RH5-DA KSP27	M143
5946044	T626NC#06-32RH3-DA KSP27	M143
5946045	T626NC#06-32RH5-DA KSP27	M143

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5946046	T626NC#08-32RH3-DA KSP27	M143
5946047	T626NC#08-32RH5-DA KSP27	M143
5946048	T626NC#10-24RH4-DA KSP27	M143
5946050	T626NC#10-24RH6-DA KSP27	M143
5946051	T626NF#10-32RH4-DA KSP27	M143
5946052	T626NF#10-32RH6-DA KSP27	M143
5946053	T626NC02500-20RH4-DA KSP27	M143
5946054	T626NC02500-20RH6-DA KSP27	M143
5946055	T626NF02500-28RH4-DA KSP27	M143
5946056	T626NF02500-28RH6-DA KSP27	M143
5946057	T626NC03125-18RH5-DA KSP27	M143
5946058	T626NC03125-18RH7-DA KSP27	M143
5946059	T626NF03125-24RH5-DA KSP27	M143
5946060	T626NF03125-24RH7-DA KSP27	M143
5946061	T626NC03750-16RH5-DA KSP27	M143
5946062	T626NC03750-16RH7-DA KSP27	M143
5946063	T626NF03750-24RH5-DA KSP27	M143
5946064	T626NF03750-24RH7-DA KSP27	M143
5946065	T626NC05000-13RH5-DA KSP27	M143
5946066	T626NC05000-13RH7-DA KSP27	M143
5946067	T626NF05000-20RH5-DA KSP27	M143
5946068	T626NF05000-20RH7-DA KSP27	M143
5946069	T626NC06250-11RH7-DA KSP27	M143
5946070	T626NC06250-11RH10-DA KSP27	M143
5946071	T626NF06250-18RH7-DA KSP27	M143
5946072	T626NF06250-18RH10-DA KSP27	M143
5946073	T626NC07500-10RH7-DA KSP27	M143
5946074	T626NC07500-10RH10-DA KSP27	M143
5946075	T626NF07500-16RH7-DA KSP27	M143
5946076	T626NF07500-16RH10-DA KSP27	M143
5946077	T626M030X050RD5-DA KSP27	M147
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5967849	NG3189LK KCP10B	C164
5967850	NG3189RK KCP10B	C163
5967872	NG3M120LK KCP10B	C163

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5967873	NG3M120RK KCP10B	C162
5967874	NG3M225LK KCP10B	C164
5967875	NG3M225RK KCP10B	C162
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5968411	KTIP1750FEGM KCPM45	H36
5968412	KTIP1800FEGM KCPM45	H36
5968413	KTIP1850FEGM KCPM45	H36
5968414	KTIP1900FEGM KCPM45	H36
5968416	KTIP07500FEG KCPM45	H36
5968417	KTIP1950FEGM KCPM45	H36
5970222	UJBE0125J6CP KCSM15	P74
5970223	UJBE0125J6BP KCSM15	P74
5970224	UJBE0188J6BP KCSM15	P74
5970225	UJBE0188J6CP KCSM15	P74
5970226	UJBE0250J6CP KCSM15	P74
5970227	UJBE0250J6BP KCSM15	P74
5970228	UJBE0312J6CP KCSM15	P74
5970229	UJBE0312J6BP KCSM15	P74
5970230	UJBE0375J6CP KCSM15	P74
5970231	UJBE0375J6BP KCSM15	P74
5970232	UJBE0438J6CP KCSM15	P74
5970233	UJBE0438J6BP KCSM15	P74
5970234	RPPT1204M0E432X4 X700	V106
5970235	RPPT1204M0E432X4 X500	V106
5970237	RPPT1204M0E432X4 SC6525	V106
5971566	BMD800R6409S250L250HP	V88
5971567	BMD800R8608S250L250HP	V91
5972039	KTIP1394HPM KCP15	H33
5972205	M4KITD100Z02W100SGEKCPM40	T21
5972206	M4KITD125Z03W100SGEKCPM40	T21
5972207	M4KITD150Z04W125SGEKCPM40	T21
5972208	M4KITD150Z05S050SGEKCPM40	T21
5972209	M4KITD200Z05S075SGEKCPM40	T21
5972210	M4KITD200Z06S075SGEKCPM40	T21
5972351	M4KITD250Z06S075SGEKCPM40	T21
5972352	M4KITD300Z07S100SGEKCPM40	T21
5972353	M4KITD400Z08S150SGEKCPM40	T21
5972354	M4KITD100Z02C100EGEKC725M	T21
5972355	M4KITD125Z03C125EGEKC725M	T21
5972356	M4KITD150Z05S050EGEKC725M	T21
5972357	M4KITD200Z05S075EGEKC725M	T21
5972358	M4KITD200Z06S075EGEKC725M	T21
5972359	M4KITD250Z06S075EGEKC725M	T21
5972360	M4KITD300Z07S100EGEKC725M	T21
5972371	M4KITD100Z02W100SGEMKC520M	T21
5972372	M4KITD125Z03W100SGEMKC520M	T21
5972373	M4KITD150Z05S050SGEMKC520M	T21
5972374	M4KITD200Z06S075SGEMKC520M	T21
5972375	M4KITD250Z07S075SGEMKC520M	T21
5972376	M4KITD300Z09S100SGEMKC520M	T21
5972377	M4KITD400Z11S150SGEMKC520M	T21
5975092	LNEU1235R03 4 KCPM40	U19
5975093	LNEU1250R04 KCPM40	U19
5975094	LNEU1250R08 KCPM40	U19
5976169	LNPU543SRGE KCPM40	T19
5976170	LNGU542SRGEM KCPM40	T19
5976671	LNGU543SRGEM KCPM40	T19
5976672	LNGU544SRGEM KCPM40	T19
5976676	MCC0800HP	V88, V91
5976678	SDSW66	V91
5977291	LNUX301960RRP KCP10B	E54
5977292	LNUX301960RRP KCP25B	E54
5977635	EVBSN26J0540	C58
5977636	EVBSN26J0640	C58
5977637	EVBSN32M0560	C58
5977638	EVBSN32M0660	C58
5977639	EVBSN32M0860	C58
5977640	EVBSN52X06120	C58
5977721	EVBSN52X08120	C58
5979010	EVM50R0316MC	C59
5979181	EVM50R0322MC	C59
5979182	EVM50R0416MC	C59
5979183	EVM50R0422MC	C59
5979184	EVM50R0432MC	C59
5979185	EVM50L0316MC	C60
5979186	EVM50L0322MC	C60
5979187	EVM50L0416MC	C60
5979188	EVM50L0422MC	C60
5979189	EVM50L0432MC	C60
5979190	KGMSR2525M50C	C66
5979191	KGMSL2525M50C	C66
5979192	KGMER2525M50C	C68
5979193	KGMEL2525M50C	C68
5979194	KGMSR1650C	C65
5979195	KGMSL1650C	C65
5979196	KGMER1650C	C67
5979197	KGMEL1650C	C67
5979198	EVM50R0426MC	C59
5979199	EVM50L0426MC	C60
5979200	EVM50R0312MC	C59
5979201	EVM50R0412MC	C59
5979202	EVM50L0312MC	C60
5979203	EVM50L0412MC	C60
5979745	KGMSR2525M65C	C66
5979746	KGMSR3232P50C	C66
5979747	KGMSR3232P65C	C66
5979748	KGMSL2525M65C	C66
5979749	KGMSL3232P50C	C66
5979750	KGMSL3232P65C	C66
5979765	KGMER2525M65C	C68
5979766	KGMER3232P50C	C68
5979767	KGMER3232P65C	C68
5979768	KGMEL2525M65C	C68
5979769	KGMEL3232P50C	C68
5979770	KGMEL3232P65C	C68
5979801	KGMSR1665C	C65
5979802	KGMSR2050C	C65
5979803	KGMSR2065C	C65
5979804	KGMSR2450C	C65
5979805	KGMSR2465C	C65
5979806	KGMSL1665C	C65
5979807	KGMSL2050C	C65
5979808	KGMSL2065C	C65
5979809	KGMSL2450C	C65
5979810	KGMSL2465C	C65
5979814	KGMER1665C	C67
5979815	KGMER2050C	C67
5979816	KGMER2065C	C67
5979817	KGMER2450C	C67
5979818	KGMER2465C	C67
5979819	KGMEL1665C	C67
5979820	KGMEL2050C	C67
5979852	WNMG432MG KCP10B	B158
5979853	WNMG432MG KCP25B	B158
5979881	KGMEL2065C	C67
5979882	KGMEL2450C	C67
5979883	KGMEL2465C	C67
5980138	EVSCTR2525M0316C	C40
5980139	EVSCTR1616K0216	C40
5980140	EVSCTR1616K0316C	C40
5980518	A12KEVEMR1F05M	C54
5980519	A12KEVEMR0205M	C54
5980520	A16MEVEMR1F07M	C54
5980621	A16MEVEMR0207M	C54
5980622	A20QEVEMR1F07M	C54
5980623	A20QEVEMR0207M	C54
5980624	A25REVEMR0210M	C54
5980625	A12KEVEML1F05M	C55
5980626	A12KEVEML0205M	C55
5980627	A16MEVEML1F07M	C55
5980628	A16MEVEML0207M	C55
5980629	A20QEVEML1F07M	C55
5980630	A20QEVEML0207M	C55
5980631	A25REVEML0210M	C55
5980635	A08KEVEMR1F05I	C52
5980636	A08KEVEMR0205I	C52
5980637	A10MEVEMR1F07I	C52
5980638	A10MEVEMR0207I	C52
5980639	A12QEVEMR1F07I	C52
5980640	A12QEVEMR0207I	C52
5980671	A16REVEMR0210I	C52
5980672	A08KEVEML1F05I	C53
5980673	A08KEVEML0205I	C53
5980674	A10MEVEML1F07I	C53
5980675	A10MEVEML0207I	C53
5980676	A12QEVEML1F07I	C53
5980677	A12QEVEML0207I	C53
5980678	A16REVEML0210I	C53
5980761	EVSCTR1616K0416C	C40
5980762	EVSCTR2020K0216	C40
5980763	EVSCTR2020K0316C	C40
5980764	EVSCTR2020K0326C	C40
5980765	EVSCTR2020K0416C	C40
5980766	EVSCTR2020K0426C	C40
5980767	EVSCTR2525M0216	C40
5980768	EVSCTR2525M0226	C40
5980769	EVSCTR2525M0326C	C40
5980770	EVSCTR2525M0426C	C40
5980771	EVSCTR2525M0432C	C40
5980772	EVSCTR2525M0526C	C40
5980773	EVSCTR2525M0532C	C40
5980774	EVSCTR3232P0432C	C40
5980775	EVSCTR3232P0540C	C40
5980776	EVSCTL2525M0316C	C41
5980777	EVSCTL1616K0216	C41
5980778	EVSCTL1616K0316C	C41
5980779	EVSCTL1616K0416C	C41
5980780	EVSCTL2020K0216	C41
5980801	EVSCTL2020K0316C	C41
5980802	EVSCTL2020K0326C	C41
5980803	EVSCTL2020K0416C	C41

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5980804	EVSCTL2020K0426C	C41
5980805	EVSCTL2525M0216	C41
5980806	EVSCTL2525M0226	C41
5980807	EVSCTL2525M0326C	C41
5980808	EVSCTL2525M0426C	C41
5980809	EVSCTL2525M0432C	C41
5980810	EVSCTL2525M0526C	C41
5980811	EVSCTL2525M0532C	C41
5980812	EVSCTL3232P0432C	C41
5980813	EVSCTL3232P0540C	C41
5980815	EVSCTR100216	C38
5980816	EVSCTR100316C	C38
5980817	EVSCTR100416C	C38
5980818	EVSCTR120216	C38
5980819	EVSCTR120316C	C38
5980820	EVSCTR120326C	C38
5980911	EVSCTR120416C	C38
5980912	EVSCTR120426C	C38
5980913	EVSCTR160216	C38
5980914	EVSCTR160226	C38
5980915	EVSCTR160316C	C38
5980916	EVSCTR160326C	C38
5980917	EVSCTR160426C	C38
5980918	EVSCTR160432C	C38
5980919	EVSCTR160526C	C38
5980920	EVSCTR160532C	C38
5980932	EVSCTR200432C	C38
5980933	EVSCTR200540C	C38
5980938	EVSCTL100216	C38
5980939	EVSCTL100316C	C39
5980940	EVSCTL100416C	C39
5981011	EVSCTL120216	C39
5981012	EVSCTL120316C	C39
5981013	EVSCTL120326C	C39
5981014	EVSCTL120416C	C39
5981015	EVSCTL120426C	C39
5981016	EVSCTL160216	C39
5981017	EVSCTL160226	C39
5981018	EVSCTL160316C	C39
5981019	EVSCTL160326C	C39
5981020	EVSCTL160426C	C39
5981021	EVSCTL160432C	C39
5981022	EVSCTL160526C	C39
5981023	EVSCTL160532C	C39
5981024	EVSCTL200432C	C39
5981025	EVSCTL200540C	C39
5981500	KSEM1650FEGM KCPM45	H67
5981571	KSEM1700FEGM KCPM45	H67
5981572	KSEM1750FEGM KCPM45	H67
5981573	KSEM1800FEGM KCPM45	H67
5981574	KSEM1850FEGM KCPM45	H67
5981575	KSEM1900FEGM KCPM45	H67
5981576	KSEM0750FEG KCPM45	H67
5981577	KSEM1950FEGM KCPM45	H67
5981578	KSEM2000FEGM KCPM45	H67
5981579	KSEM2050FEGM KCPM45	H67
5981580	KSEM2100FEGM KCPM45	H67
5981581	KSEM2150FEGM KCPM45	H67
5981582	KSEM2200FEGM KCPM45	H67
5981583	KSEM2250FEGM KCPM45	H67
5981584	KSEM2300FEGM KCPM45	H67
5981585	KSEM2350FEGM KCPM45	H67
5981586	KSEM2400FEGM KCPM45	H67
5981587	KSEM2450FEGM KCPM45	H67
5981588	KSEM2500FEGM KCPM45	H67
5981589	KSEM1000FEG KCPM45	H67
5981591	KSEM2550FEGM KCPM45	H67
5981592	KSEM2600FEGM KCPM45	H67
5981593	KSEM2650FEGM KCPM45	H67
5981594	KSEM2700FEGM KCPM45	H67
5981595	KSEM2750FEGM KCPM45	H67
5981596	KSEM2850FEGM KCPM45	H67
5981597	KSEM2900FEGM KCPM45	H67
5981598	KSEM2950FEGM KCPM45	H67
5981599	KSEM3000FEGM KCPM45	H67
5981600	KSEM3100FEGM KCPM45	H67
5981601	KSEM1250FEG KCPM45	H67
5981602	KSEM3200FEGM KCPM45	H67
5981603	KSEM3300FEGM KCPM45	H67
5981604	KSEM3400FEGM KCPM45	H67
5981605	KSEM3500FEGM KCPM45	H67
5981606	KSEM3600FEGM KCPM45	H68
5981607	KSEM3700FEGM KCPM45	H68
5981608	KSEM3800FEGM KCPM45	H68
5981609	KSEM1500FEG KCPM45	H68
5981610	KSEM3900FEGM KCPM45	H68
5982089	VBMT331MP KCP25B	B281
5984676	KSEM2670FEGM KCPM45	H67
5986819	KGIP0300N0189GD KCU45	H101
5987474	B286D03000HPS KN15	G82
5987475	B286D03100HPS KN15	G82
5987476	B286D03175HPS KN15	G82
5987477	B286D03200HPS KN15	G82
5987478	B286D03264HPS KN15	G82
5987479	B286D03300HPS KN15	G82
5987480	B286D03455HPS KN15	G82
5987531	B286D03500HPS KN15	G82
5987532	B286D03571HPS KN15	G82
5987533	B286D03700HPS KN15	G82
5987534	B286D03734HPS KN15	G82
5987535	B286D03900HPS KN15	G82
5987536	B286D03970HPS KN15	G82
5987537	B286D04000HPS KN15	G82
5987538	B286D04039HPS KN15	G82
5987539	B286D04100HPS KN15	G82
5987540	B286D04200HPS KN15	G82
5987551	B286D04400HPS KN15	G82
5987552	B286D04305HPS KN15	G82
5987553	B286D04500HPS KN15	G82
5987554	B286D04600HPS KN15	G82
5987555	B286D04700HPS KN15	G82
5987556	B286D04763HPS KN15	G82
5987557	B286D04800HPS KN15	G82
5987558	B286D04900HPS KN15	G82
5987559	B286D05000HPS KN15	G82
5987560	B286D05100HPS KN15	G82
5987561	B286D05106HPS KN15	G82
5987562	B286D05159HPS KN15	G82
5987563	B286D05200HPS KN15	G82
5987564	B286D05300HPS KN15	G82
5987565	B286D05400HPS KN15	G82
5987566	B286D05410HPS KN15	G82
5987567	B286D05500HPS KN15	G82
5987568	B286D05558HPS KN15	G82
5987569	B286D05600HPS KN15	G83
5987571	B286D05791HPS KN15	G83
5987572	B286D06000HPS KN15	G83
5987573	B286D06200HPS KN15	G83
5987574	B286D06300HPS KN15	G83
5987575	B286D06350HPS KN15	G83
5987576	B286D06400HPS KN15	G83
5987577	B286D06500HPS KN15	G83
5987578	B286D06528HPS KN15	G83
5987579	B286D06600HPS KN15	G83
5987580	B286D06630HPS KN15	G83
5987581	B286D06700HPS KN15	G83
5987582	B286D06746HPS KN15	G83
5987583	B286D06800HPS KN15	G83
5987584	B286D06900HPS KN15	G83
5987585	B286D07000HPS KN15	G83
5987587	B286D07145HPS KN15	G83
5987588	B286D07300HPS KN15	G83
5987589	B286D07400HPS KN15	G83
5987590	B286D07541HPS KN15	G83
5987591	B286D07600HPS KN15	G83
5987592	B286D07700HPS KN15	G83
5987593	B286D07938HPS KN15	G83
5987595	B286D08000HPS KN15	G83
5987596	B286D08334HPS KN15	G83
5987597	B286D08400HPS KN15	G83
5987598	B286D08433HPS KN15	G83
5987599	B286D08500HPS KN15	G83
5987600	B286D08700HPS KN15	G83
5987601	B286D08733HPS KN15	G83
5987602	B286D08800HPS KN15	G83
5987603	B286D08900HPS KN15	G83
5987604	B286D09000HPS KN15	G83
5987605	B286D09100HPS KN15	G83
5987606	B286D09129HPS KN15	G83
5987607	B286D09300HPS KN15	G83
5987608	B286D09400HPS KN15	G83
5987609	B286D09500HPS KN15	G83
5987610	B286D09525HPS KN15	G83
5987611	B286D09900HPS KN15	G83
5987612	B286D09921HPS KN15	G83
5987613	B286D10000HPS KN15	G83
5987614	B286D10100HPS KN15	G83
5987615	B286D10200HPS KN15	G83
5987616	B286D10300HPS KN15	G83
5987617	B286D10320HPS KN15	G83
5987618	B286D10500HPS KN15	G83
5987619	B286D10600HPS KN15	G83
5987620	B286D10716HPS KN15	G84
5987631	B286D10800HPS KN15	G84
5987632	B286D11000HPS KN15	G84
5987633	B286D11100HPS KN15	G84
5987634	B286D11113HPS KN15	G84
5987635	B286D11200HPS KN15	G84
5987636	B286D11300HPS KN15	G84
5987637	B286D11400HPS KN15	G84
5987638	B286D11500HPS KN15	G84
5987639	B286D11509HPS KN15	G84
5987640	B286D11800HPS KN15	G84
5987641	B286D11908HPS KN15	G84
5987642	B286D12000HPS KN15	G84
5987643	B286D12304HPS KN15	G84
5987644	B286D12500HPS KN15	G84
5987645	B286D12600HPS KN15	G84
5987646	B286D12700HPS KN15	G84
5987647	B286D13000HPS KN15	G84
5987648	B286D13096HPS KN15	G84
5987649	B286D13100HPS KN15	G84
5987650	B286D13300HPS KN15	G84
5987651	B286D13400HPS KN15	G84
5987652	B286D13500HPS KN15	G84
5987653	B286D14000HPS KN15	G84
5987654	B286D14200HPS KN15	G84
5987655	B286D14288HPS KN15	G84
5987656	B286D14500HPS KN15	G84
5987657	B286D14684HPS KN15	G84
5987658	B286D15000HPS KN15	G84
5987659	B286D15083HPS KN15	G84
5987660	B286D15100HPS KN15	G84
5987661	B286D15300HPS KN15	G84
5987662	B286D15400HPS KN15	G84
5987663	B286D15875HPS KN15	G84
5987664	B286D16000HPS KN15	G84
5987665	B286D16500HPS KN15	G84
5987666	B286D16670HPS KN15	G84
5987667	B286D16800HPS KN15	G84
5987668	B286D16900HPS KN15	G84
5987669	B286D17000HPS KN15	G84
5987670	B286D17300HPS KN15	G84
5987671	B286D17463HPS KN15	G84
5987672	B286D17500HPS KN15	G84
5987673	B286D17859HPS KN15	G84
5987674	B286D18000HPS KN15	G84
5987675	B286D19000HPS KN15	G84
5987676	B286D19050HPS KN15	G84
5987677	B286D20000HPS KN15	G84
5987680	B284D03100HPS KN15	G82
5987751	B284D03264HPS KN15	G82
5987752	B284D03455HPS KN15	G82
5987753	B284D03700HPS KN15	G82
5987754	B284D03734HPS KN15	G82
5987755	B284D03900HPS KN15	G82
5987756	B284D04039HPS KN15	G82
5987757	B284D04100HPS KN15	G82
5987758	B284D04305HPS KN15	G82
5987759	B284D04400HPS KN15	G82
5987760	B284D04600HPS KN15	G82
5987761	B284D04700HPS KN15	G82
5987762	B284D04900HPS KN15	G82
5987763	B284D05106HPS KN15	G82
5987764	B284D05200HPS KN15	G82
5987765	B284D05300HPS KN15	G82
5987766	B284D05400HPS KN15	G82
5987767	B284D05410HPS KN15	G82
5987768	B284D05500HPS KN15	G82
5987769	B284D05791HPS KN15	G83
5987770	B284D06200HPS KN15	G83
5987771	B284D06300HPS KN15	G83
5987772	B284D06350HPS KN15	G83
5987773	B284D06528HPS KN15	G83
5987774	B284D06600HPS KN15	G83
5987775	B284D06630HPS KN15	G83
5987776	B284D06700HPS KN15	G83
5987777	B284D06900HPS KN15	G83
5987778	B284D07300HPS KN15	G83
5987779	B284D07600HPS KN15	G83
5987780	B284D07700HPS KN15	G83
5987781	B284D08400HPS KN15	G83
5987782	B284D08433HPS KN15	G83
5987783	B284D08700HPS KN15	G83
5987784	B284D08800HPS KN15	G83
5987785	B284D08900HPS KN15	G83
5987786	B284D09100HPS KN15	G83
5987787	B284D09300HPS KN15	G83
5987788	B284D09400HPS KN15	G83
5987789	B284D09900HPS KN15	G83
5987790	B284D10100HPS KN15	G83
5987791	B284D10300HPS KN15	G83
5987792	B284D10600HPS KN15	G83
5987793	B284D10800HPS KN15	G84
5987794	B284D11100HPS KN15	G84
5987795	B284D11200HPS KN15	G84
5987796	B284D11300HPS KN15	G84
5987797	B284D11400HPS KN15	G84
5987798	B284D11500HPS KN15	G84
5987799	B284D11509HPS KN15	G84
5987800	B284D11800HPS KN15	G84
5987801	B284D12304HPS KN15	G84
5987802	B284D12600HPS KN15	G84
5987803	B284D13000HPS KN15	G84
5987804	B284D13096HPS KN15	G84
5987805	B284D13100HPS KN15	G84
5987806	B284D13300HPS KN15	G84
5987807	B284D13400HPS KN15	G84
5987808	B284D13500HPS KN15	G84
5987809	B284D14200HPS KN15	G84
5987810	B284D14500HPS KN15	G84
5987821	B284D14684HPS KN15	G84
5987822	B284D15000HPS KN15	G84
5987823	B284D15083HPS KN15	G84
5987824	B284D15100HPS KN15	G84
5987825	B284D15300HPS KN15	G84
5987826	B284D15400HPS KN15	G84
5987827	B284D16000HPS KN15	G84
5987828	B284D16500HPS KN15	G84
5987829	B284D16670HPS KN15	G84
5987830	B284D16800HPS KN15	G84
5987831	B284D16900HPS KN15	G84
5987832	B284D17000HPS KN15	G84
5987833	B284D17300HPS KN15	G84
5987834	B284D17463HPS KN15	G84
5987835	B284D17859HPS KN15	G84
5987836	B284D17500HPS KN15	G84
5987837	B284D18000HPS KN15	G84
5987838	B284D19000HPS KN15	G84
5988771	EG0200M02P02GUP KCU25	C17
5988772	EG0600M06P04GUP KCU25	C17
5988773	EG0600M06P08GUP KCU25	C17
5988774	EG0500M05P04GUP KCU25	C17
5988775	EG0500M05P08GUP KCU25	C17
5988776	EG0700M06P08GUP KCU25	C17
5988777	EG0800M08P08GUP KCU25	C17
5988778	EG0800M08P12GUP KCU25	C17
5988779	EG1000M10P12GUP KCU25	C17
5988780	ER0300M03P00GUP KCU25	C19
5988781	ER0400M04P00GUP KCU25	C19
5988782	ER0500M05P00GUP KCU25	C19
5988783	ER0600M06P00GUP KCU25	C19
5988785	ER0800M08P00GUP KCU25	C19
5988787	EG094I02P05GUP KCU25	C18
5988788	EG250I06P1GUP KCU25	C18
5988789	EG250I06P2GUP KCU25	C18
5988790	EG312I08P3GUP KCU25	C18
5988811	EG063I1FP05GUP KCU25	C18
5988812	EG375I10P3GUP KCU25	C18
5988813	ER125I03P00GUP KCU25	C20
5988814	ER187I04P00GUP KCU25	C20
5988815	ER250I06P00GUP KCU25	C20
5988816	ER312I08P00GUP KCU25	C20
5988818	EG0200M02P02GUP K313	C17
5988833	ER0300M03P00GUP K313	C19
5988834	EG0600M06P04GUP K313	C17
5988835	EG0600M06P08GUP K313	C17
5988836	EG0500M05P04GUP K313	C17

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
5988837	EG0500M05P08GUP K313	C17
5988838	EG0700M06P08GUP K313	C17
5988839	EG0800M08P08GUP K313	C17
5988840	EG0800M08P12GUP K313	C17
5988851	EG1000M10P12GUP K313	C17
5988858	ER0400M04P00GUP K313	C19
5988859	ER0500M05P00GUP K313	C19
5988860	ER0600M06P00GUP K313	C19
5988861	ER0800M08P00GUP K313	C19
5988903	EG094I02P05GUP K313	C18
5988904	EG063I1FP05GUP K313	C18
5988905	ER125I03P00GUP K313	C20
5988961	EG250I06P1GUP K313	C18
5988962	EG250I06P2GUP K313	C18
5988963	EG312I08P3GUP K313	C18
5988964	EG375I10P3GUP K313	C18
5988965	ER187I04P00GUP K313	C20
5988966	ER250I06P00GUP K313	C20
5988967	ER312I08P00GUP K313	C20
5989962	CNMG432MG KCP25B	B57
5989963	CNMG433MG KCP25B	B57
5989965	CNMG432MG KCP10B	B57
5989966	CNMG433MG KCP10B	B57
5989967	CNMG434MG KCP10B	B57
5990785	B285D03100HPS KN15	G82
5990786	B285D03264HPS KN15	G82
5990787	B285D03455HPS KN15	G82
5990788	B285D03500HPS KN15	G82
5990789	B285D03571HPS KN15	G82
5990790	B285D03700HPS KN15	G82
5990911	B285D03734HPS KN15	G82
5990912	B285D03900HPS KN15	G82
5990913	B285D04039HPS KN15	G82
5990914	B285D04100HPS KN15	G82
5990915	B285D04305HPS KN15	G82
5990916	B285D04400HPS KN15	G82
5990917	B285D04600HPS KN15	G82
5990918	B285D04700HPS KN15	G82
5990919	B285D05106HPS KN15	G82
5990920	B285D05159HPS KN15	G82
5990931	B285D05300HPS KN15	G82
5990932	B285D05400HPS KN15	G82
5990933	B285D05410HPS KN15	G82
5990934	B285D05791HPS KN15	G83
5990935	B285D06200HPS KN15	G83
5990936	B285D06350HPS KN15	G83
5990937	B285D06528HPS KN15	G83
5990938	B285D06630HPS KN15	G83
5990939	B285D06746HPS KN15	G83
5990940	B285D06800HPS KN15	G83
5990941	B285D06900HPS KN15	G83
5990942	B285D07300HPS KN15	G83
5990943	B285D07400HPS KN15	G83
5990944	B285D07541HPS KN15	G83
5990945	B285D07600HPS KN15	G83
5990946	B285D08433HPS KN15	G83
5990947	B285D08700HPS KN15	G83
5990948	B285D08800HPS KN15	G83
5990949	B285D08900HPS KN15	G83
5990950	B285D09100HPS KN15	G83
5990951	B285D09129HPS KN15	G83
5990952	B285D09400HPS KN15	G83
5990953	B285D09900HPS KN15	G83
5990954	B285D09921HPS KN15	G83
5990955	B285D10100HPS KN15	G83
5990956	B285D10200HPS KN15	G83
5990957	B285D10300HPS KN15	G83
5990958	B285D10320HPS KN15	G83
5990959	B285D10600HPS KN15	G83
5990960	B285D10716HPS KN15	G84
5990971	B285D10800HPS KN15	G84
5990972	B285D11100HPS KN15	G84
5990973	B285D11200HPS KN15	G84
5990974	B285D11300HPS KN15	G84
5990975	B285D11400HPS KN15	G84
5990976	B285D11509HPS KN15	G84
5990977	B285D11800HPS KN15	G84
5990978	B285D11908HPS KN15	G84
5990979	B285D12304HPS KN15	G84
5990980	B285D12500HPS KN15	G84
5990981	B285D12600HPS KN15	G84
5990982	B285D12700HPS KN15	G84
5990983	B285D13000HPS KN15	G84
5990984	B285D13096HPS KN15	G84
5990985	B285D13100HPS KN15	G84
5990986	B285D13300HPS KN15	G84
5990987	B285D13400HPS KN15	G84
5990988	B285D13500HPS KN15	G84
5990989	B285D14200HPS KN15	G84
5990990	B285D14288HPS KN15	G84
5990991	B285D14684HPS KN15	G84
5990992	B285D15000HPS KN15	G84
5990993	B285D15083HPS KN15	G84
5990994	B285D15100HPS KN15	G84
5990995	B285D15300HPS KN15	G84
5990996	B285D15400HPS KN15	G84
5990997	B285D15875HPS KN15	G84
5990998	B285D16000HPS KN15	G84
5990999	B285D16500HPS KN15	G84
5991000	B285D16670HPS KN15	G84
5991001	B285D16800HPS KN15	G84
5991002	B285D16900HPS KN15	G84
5991003	B285D17000HPS KN15	G84
5991004	B285D17300HPS KN15	G84
5991005	B285D17463HPS KN15	G84
5991006	B285D17500HPS KN15	G84
5991007	B285D17859HPS KN15	G84
5991008	B285D19000HPS KN15	G84
5991009	B285D19050HPS KN15	G84
5991010	B285D20000HPS KN15	G84
5991410	KSEM2370HPGM KCPM45	H57
5999788	KM40TSKGMER50C	C70, C147
5999789	KM40TSKGMEL50C	C70, C147
5999790	KM40TSKGMSR50C	C69, C146
5999861	KM40TSKGMSL50C	C69, C146
5999862	KM50TSKGMER50C	C70, C147
5999863	KM50TSKGMEL50C	C70, C147
5999864	KM50TSKGMSR50C	C69, C146
5999865	KM50TSKGMSL50C	C69, C146
5999946	KM63TSKGMER50C	C70, C147
5999947	KM63TSKGMEL50C	C70, C147
5999948	KM63TSKGMSR50C	C69, C146
5999949	KM63TSKGMSL50C	C69, C146
5999950	KM63XMZKGMER50CY	C70, C147
5999971	KM63XMZKGMELF50CY	C70, C147
5999972	KM63XMZKGMSR50CY	C69, C146
5999973	KM63XMZKGMSLF50CY	C69, C146
6000012	KM80TSKGMER50C	C70, C147
6000013	KM80TSKGMEL50C	C70, C147
6000014	KM80TSKGMSR50C	C69, C146
6000015	KM80TSKGMSL50C	C69, C146
6000016	KM80ATCKGMER50C	C70, C147
6000017	KM80ATCKGMEL50C	C70, C147
6000018	KM80ATCKGMSR50C	C69, C146
6000019	KM80ATCKGMSL50C	C69, C146
6000026	PSC40KGMER50C	C73, C151
6000027	PSC40KGMEL50C	C73, C151
6000028	PSC40KGMSR50C	C72, C150
6000029	PSC40KGMSL50C	C72, C150
6000030	PSC50KGMER50C	C73, C151
6000151	PSC50KGMEL50C	C73, C151
6000152	PSC50KGMSR50C	C72, C150
6000153	PSC50KGMSL50C	C72, C150
6000159	PSC63KGMER50C	C73, C151
6000160	PSC63KGMEL50C	C73, C151
6000199	CNMU443MN KCP05B	B51
6000211	PSC63KGMSR50C	C72, C150
6000213	PSC63KGMSL50C	C72, C150
6000214	PSC80KGMER50C	C73, C151
6000215	PSC80KGMEL50C	C73, C151
6000216	PSC80KGMSR50C	C72, C150
6000217	PSC80KGMSL50C	C72, C150
6000404	KM4X63KGMER50C	C71, C149
6000405	KM4X63KGMEL50C	C71, C149
6000407	KM4X63KGMSR50C	C71, C148–149
6000408	KM4X63KGMSL50C	C71, C148–149
6000410	KM50TSKGMER65C	C70, C147
6000421	KM50TSKGMEL65C	C70, C147
6000422	KM50TSKGMSR65C	C69, C146
6000424	KM50TSKGMSL65C	C69, C146
6000425	KM63TSKGMER65C	C70, C147
6000430	KM63TSKGMEL65C	C70, C147
6000431	KM63TSKGMSR65C	C69, C146
6000433	KM63TSKGMSL65C	C69, C146
6000434	KM63XMZKGMER65CY	C70, C147
6000436	KM63XMZKGMELF65CY	C70, C147
6000462	PSC63KGMER65C	C73, C151
6000463	PSC63KGMEL65C	C73, C151
6000464	PSC63KGMSR65C	C72, C150
6000465	PSC63KGMSL65C	C72, C150
6000466	PSC80KGMER65C	C73, C151
6000467	PSC80KGMEL65C	C73, C151
6000468	PSC80KGMSR65C	C72, C150
6000469	PSC80KGMSL65C	C72, C150
6001036	ONGX645SNHB KCK15	S34
6001106	ONGX645ENLE KC514M	S33
6001107	ONGX645SNGP KC514M	S33
6001108	ONGX645SNGP KCK15	S33
6001231	LNGU541ERGEJ KC422M	T18
6001232	LNGU542ERGEJ KC422M	T18
6001233	LNPU545SRGE KC725M	T19
6001234	LNPU545SRGE KCPK30	T19
6001235	LNPU545SRGE KCK15	T19
6001236	LNPU545SRGE KCPM40	T19
6001237	LNPU545SRGE KC522M	T19
6001244	ONGX645SNHB KC514M	S34
6001245	ONGX645SNHB KCPK30	S34
6001247	ONGX645SNHB KCK20	S34
6001258	ONGX648SNHB KC514M	S34
6001259	ONGX648SNHB KCK15	S34
6001260	ONGX648SNHB KCK20	S34
6001316	ONGX64ANSNGP KC514M	S33
6001317	ONGX64ANSNGP KCK15	S33
6001321	ONPX642SNGP KCK15	S34
6001322	ONPX645SNHB KCK15	S34
6001323	ONGX642SNHB KC514M	S34
6001324	ONGX642SNHB KCK15	S34
6001979	MILL16E200Z050N08W	S30
6001980	MILL16E250Z060N08W	S30
6002121	MILL16E300Z100N08W	S30
6002122	MILL16E400Z140N08W	S30
6002123	MILL16E500Z180N08W	S30
6002124	MILL16E600Z220N08W	S30
6002125	MILL16E800Z280N08W	S30
6003372	B269A14600HP KCP15	G64
6003373	B269A15200HP KCPK15	G64
6003401	B269A17600HP KCPK15	G64
6003402	B269A18600HP KCPK15	G64
6010729	XDPT090408ERD41 X500	V15
6010730	XDPT090408ERD41 SP6519	V15
6010771	XDPT090408ERD41 SC6525	V15
6010772	XDPT120508ERD41 X500	V22
6010773	XDPT120508ERD41 SP6519	V22
6010774	XDPT120508ERD41 SC6525	V22
6012527	EG0212M02U02GUN KCU10	C20
6012528	EG0251M02U02GUN KCU10	C20
6012529	EG0312M03U02GUN KCU10	C20
6012530	EG0312M03U04GUN KCU10	C20
6012651	EG063I1FU05GUN KCU10	C21
6012652	EG130I03U05GUN KCU10	C21
6012653	EG130I03U1GUN KCU10	C21
6012654	ER0312M03U00GUN KCU10	C21
6012655	ER130I03U00GUN KCU10	C22
6012656	EG0412M04U04GUN KCP10B	C20
6012657	EG0412M04U08GUN KCP10B	C20
6012658	EG192I04U1GUN KCP10B	C21
6012659	EG192I04U2GUN KCP10B	C21
6012660	EG255I06U1GUN KCP10B	C21
6012671	EG255I06U2GUN KCP10B	C21
6012672	EG0812M08U08GUN KCP10B	C20
6012673	EG0812M08U12GUN KCP10B	C20
6012674	EG0612M06U04GUN KCP10B	C20
6012675	EG317I08U3GUN KCP10B	C21
6012676	EG0512M05U04GUN KCP10B	C20
6012677	EG0512M05U08GUN KCP10B	C20
6012678	EG380I10U3GUN KCP10B	C21
6012679	EG1012M10U12GUN KCP10B	C20
6012680	ER0412M04U00GUN KCP10B	C21
6012681	ER192I04U00GUN KCP10B	C22
6012682	ER0512M05U00GUN KCP10B	C21
6012683	ER0612M06U00GUN KCP10B	C21
6012684	ER255I06U00GUN KCP10B	C22
6012685	ER317I08U00GUN KCP10B	C22
6012686	ER0812M08U00GUN KCP10B	C21
6012687	EG0200M02P02GUP KCU10	C17
6012688	EG0300M03P02GUP KCU10	C17
6012689	EG0300M03P04GUP KCU10	C17
6012690	EG0400M04P04GUP KCU10	C17
6012701	EG0400M04P08GUP KCU10	C17
6012702	EG0500M05P04GUP KCU10	C17
6012703	EG0500M05P08GUP KCU10	C17
6012704	EG0600M06P04GUP KCU10	C17
6012705	EG0600M06P08GUP KCU10	C17
6012706	EG063I1FP05GUP KCU10	C18
6012707	EG0700M06P08GUP KCU10	C17
6012708	EG0800M08P08GUP KCU10	C17
6012709	EG0800M08P12GUP KCU10	C17
6012710	EG094I02P05GUP KCU10	C18
6012711	EG1000M10P12GUP KCU10	C17
6012712	EG125I03P05GUP KCU10	C18
6012713	EG125I03P1GUP KCU10	C18
6012714	EG187I04P1GUP KCU10	C18
6012715	EG187I04P2GUP KCU10	C18
6012716	EG250I06P1GUP KCU10	C18
6012717	EG250I06P2GUP KCU10	C18
6012718	EG312I08P3GUP KCU10	C18
6012719	EG375I10P3GUP KCU10	C18
6012720	ER0300M03P00GUP KCU10	C19
6012721	ER0400M04P00GUP KCU10	C19
6012722	ER0500M05P00GUP KCU10	C19
6012723	ER0600M06P00GUP KCU10	C19
6012724	ER0800M08P00GUP KCU10	C19
6012725	ER125I03P00GUP KCU10	C20
6012726	ER187I04P00GUP KCU10	C20
6012727	ER250I06P00GUP KCU10	C20
6012728	ER312I08P00GUP KCU10	C20
6012729	EG0412M04U04GUP KCP10B	C17
6012730	EG0412M04U08GUP KCP10B	C17
6012741	EG192I04U1GUP KCP10B	C18
6012742	EG192I04U2GUP KCP10B	C18
6012743	EG255I06U1GUP KCP10B	C18
6012744	EG255I06U2GUP KCP10B	C18
6012745	EG0812M08U08GUP KCP10B	C17
6012746	EG0812M08U12GUP KCP10B	C17
6012747	EG0612M06U04GUP KCP10B	C17
6012748	EG0612M06U08GUP KCP10B	C17
6012749	EG317I08U3GUP KCP10B	C18
6012750	EG0512M05U04GUP KCP10B	C17
6012751	EG0512M05U08GUP KCP10B	C17
6012752	EG0712M06U08GUP KCP10B	C17
6012753	EG380I10U3GUP KCP10B	C18
6012754	EG1012M10U12GUP KCP10B	C17
6012755	ER0412M04U00GUP KCP10B	C19
6012756	ER192I04U00GUP KCP10B	C19
6012757	ER0512M05U00GUP KCP10B	C19
6012758	ER0612M06U00GUP KCP10B	C19
6012759	ER255I06U00GUP KCP10B	C19
6012760	ER317I08U00GUP KCP10B	C19
6012761	ER0812M08U00GUP KCP10B	C19
6012762	EG0312M03U04GUP KCP25B	C17
6012763	EG130I03U05GUP KCP25B	C18
6012764	EG130I03U1GUP KCP25B	C18
6012765	EG0212M02U02GUP KCP25B	C17
6012766	EG0251M02U02GUP KCP25B	C17
6012767	ER0312M03U00GUP KCP25B	C19
6012768	ER130I03U00GUP KCP25B	C19
6012898	EG0412M04U04GUN KCU10	C20
6012899	EG0412M04U08GUN KCU10	C20
6012900	EG0512M05U04GUN KCU10	C20
6012901	EG0512M05U08GUN KCU10	C20
6012902	EG0612M06U04GUN KCU10	C20
6012903	EG0612M06U08GUN KCU10	C20
6012904	EG0812M08U08GUN KCU10	C20
6012905	EG0812M08U12GUN KCU10	C20
6012906	EG1012M10U12GUN KCU10	C20
6012907	EG192I04U1GUN KCU10	C21
6012908	EG192I04U2GUN KCU10	C21
6012909	EG255I06U1GUN KCU10	C21
6012910	EG255I06U2GUN KCU10	C21
6012911	EG317I08U3GUN KCU10	C21
6012913	EG380I10U3GUN KCU10	C21
6012914	ER0412M04U00GUN KCU10	C21
6012915	ER0512M05U00GUN KCU10	C21
6012916	ER0612M06U00GUN KCU10	C21
6012917	ER0812M08U00GUN KCU10	C21
6012918	ER192I04U00GUN KCU10	C22
6012919	ER255I06U00GUN KCU10	C22
6012920	ER317I08U00GUN KCU10	C22

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
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	C18
6012965	EG192I04U2GUP KCU10	C18
6012966	EG255I06U1GUP KCU10	C18
6012967	EG255I06U2GUP KCU10	C18
6012968	EG317I08U3GUP KCU10	C18
6012969	EG380I10U3GUP KCU10	C18
6012970	ER0412M04U00GUP KCU10	C19
6012971	ER0512M05U00GUP KCU10	C19
6012972	ER0612M06U00GUP KCU10	C19
6012973	ER0812M08U00GUP KCU10	C19
6012974	ER192I04U00GUP KCU10	C19
6012975	ER255I06U00GUP KCU10	C19
6012976	ER317I08U00GUP KCU10	C19
6013031	EG0212M02U02GUP KCU10	C17
6013032	EG0251M02U02GUP KCU10	C17
6013033	EG0312M03U02GUP KCU10	C17
6013034	EG0312M03U04GUP KCU10	C17
6013035	EG130I03U05GUP KCU10	C18
6013036	EG130I03U1GUP KCU10	C18
6013037	ER0312M03U00GUP KCU10	C19
6013038	ER130I03U00GUP KCU10	C19
6013040	EG0312M03U02GUN KCP10B	C20
6013061	EG0312M03U04GUN KCP10B	C20
6013062	EG130I03U05GUN KCP10B	C21
6013063	EG130I03U1GUN KCP10B	C21
6013064	EG0212M02U02GUN KCP10B	C20
6013065	EG0251M02U02GUN KCP10B	C20
6013066	EG063I1FU05GUN KCP10B	C21
6013067	ER0312M03U00GUN KCP10B	C21
6013068	ER130I03U00GUN KCP10B	C22
6013069	EG0312M03U02GUP KCP10B	C17
6013070	EG0312M03U04GUP KCP10B	C17
6013091	EG130I03U05GUP KCP10B	C18
6013092	EG130I03U1GUP KCP10B	C18
6013093	EG0212M02U02GUP KCP10B	C17
6013095	EG0251M02U02GUP KCP10B	C17
6013096	ER0312M03U00GUP KCP10B	C19
6013097	ER130I03U00GUP KCP10B	C19
6013099	EG0312M03U02GUN KCP25B	C20
6013100	EG0312M03U04GUN KCP25B	C20
6013131	EG130I03U05GUN KCP25B	C21
6013132	EG130I03U1GUN KCP25B	C21
6013133	EG0212M02U02GUN KCP25B	C20
6013134	EG0251M02U02GUN KCP25B	C20
6013135	EG063I1FU05GUN KCP25B	C21
6013136	ER0312M03U00GUN KCP25B	C21
6013137	ER130I03U00GUN KCP25B	C22
6017353	EG0312M03U02GUN KCK20B	C20
6017354	EG0312M03U04GUN KCK20B	C20
6017356	EG130I03U05GUN KCK20B	C21
6017357	EG130I03U1GUN KCK20B	C21
6017358	EG0212M02U02GUN KCK20B	C20
6017359	EG0251M02U02GUN KCK20B	C20
6017360	EG063I1FU05GUN KCK20B	C21
6017391	ER0312M03U00GUN KCK20B	C21
6017392	ER130I03U00GUN KCK20B	C22
6017393	EG0412M04U04GUN KCK20B	C20
6017394	EG0412M04U08GUN KCK20B	C20
6017395	EG192I04U1GUN KCK20B	C21
6017396	EG192I04U2GUN KCK20B	C21
6017397	EG255I06U1GUN KCK20B	C21
6017398	EG255I06U2GUN KCK20B	C21
6017399	EG0812M08U08GUN KCK20B	C20
6017400	EG0812M08U12GUN KCK20B	C20
6017481	EG0612M06U04GUN KCK20B	C20
6017482	EG0612M06U08GUN KCK20B	C20
6017483	EG317I08U3GUN KCK20B	C21
6017484	EG0512M05U04GUN KCK20B	C20
6017485	EG0512M05U08GUN KCK20B	C20
6017486	EG380I10U3GUN KCK20B	C21
6017487	EG1012M10U12GUN KCK20B	C20
6017488	ER0412M04U00GUN KCK20B	C21
6017489	ER192I04U00GUN KCK20B	C22
6017490	ER0512M05U00GUN KCK20B	C21
6017491	ER0612M06U00GUN KCK20B	C21
6017492	ER255I06U00GUN KCK20B	C22
6017493	ER317I08U00GUN KCK20B	C22
6017494	ER0812M08U00GUN KCK20B	C21
6017497	EC030M03L06CF02 KCM35B	C22
6017498	EC030M03R06CF02 KCM35B	C22
6017499	EC014M1BN00CF01 KCM35B	C22
6017500	EC020M02N00CF02 KCM35B	C22
6017511	EC014M1BN00CL01 KCM35B	C23
6017512	EC020M02N00CL02 KCM35B	C23
6017513	EC020M02L06CF02 KCM35B	C22
6017514	EC020M02R06CF02 KCM35B	C22
6017515	EC014M1BL06CL01 KCM35B	C23
6017516	EC014M1BR06CL01 KCM35B	C23
6017517	EC020M02L06CL02 KCM35B	C23
6017518	EC020M02R06CL02 KCM35B	C23
6017519	EC030M03L06CL02 KCM35B	C23
6017520	EC030M03R06CL02 KCM35B	C23
6017521	EC014M1BL06CF01 KCM35B	C22
6017522	EC014M1BR06CF01 KCM35B	C22
6017525	EG0412M04U04GUP KCP25B	C17
6017526	EG0412M04U08GUP KCP25B	C17
6017527	EG192I04U1GUP KCP25B	C18
6017528	EG192I04U2GUP KCP25B	C18
6017529	EG255I06U1GUP KCP25B	C18
6017530	EG255I06U2GUP KCP25B	C18
6017541	EG0812M08U08GUP KCP25B	C17
6017542	EG0812M08U12GUP KCP25B	C17
6017543	EG0612M06U04GUP KCP25B	C17
6017544	EG0612M06U08GUP KCP25B	C17
6017545	EG317I08U3GUP KCP25B	C18
6017546	EG0512M05U04GUP KCP25B	C17
6017547	EG0512M05U08GUP KCP25B	C17
6017548	EG0712M06U08GUP KCP25B	C17
6017549	EG380I10U3GUP KCP25B	C18
6017550	EG1012M10U12GUP KCP25B	C17
6017551	ER0412M04U00GUP KCP25B	C19
6017552	ER192I04U00GUP KCP25B	C19
6017553	ER0512M05U00GUP KCP25B	C19
6017555	ER0612M06U00GUP KCP25B	C19
6017556	ER255I06U00GUP KCP25B	C19
6017557	ER317I08U00GUP KCP25B	C19
6017558	ER0812M08U00GUP KCP25B	C19
6017560	EG0412M04U04GUN KCP25B	C20
6017581	EG0412M04U08GUN KCP25B	C20
6017582	EG192I04U1GUN KCP25B	C21
6017583	EG192I04U2GUN KCP25B	C21
6017584	EG255I06U1GUN KCP25B	C21
6017585	EG255I06U2GUN KCP25B	C21
6017587	EG0812M08U08GUN KCP25B	C20
6017588	EG0812M08U12GUN KCP25B	C20
6017589	EG0612M06U08GUN KCP25B	C20
6017590	EG317I08U3GUN KCP25B	C21
6017601	EG0512M05U04GUN KCP25B	C20
6017603	EG0512M05U08GUN KCP25B	C20
6017604	EG380I10U3GUN KCP25B	C21
6017605	EG1012M10U12GUN KCP25B	C20
6017606	ER0412M04U00GUN KCP25B	C21
6017607	ER192I04U00GUN KCP25B	C22
6017608	ER0512M05U00GUN KCP25B	C21
6017609	ER0612M06U00GUN KCP25B	C21
6017610	ER255I06U00GUN KCP25B	C22
6017611	ER317I08U00GUN KCP25B	C22
6017612	ER0812M08U00GUN KCP25B	C21
6017693	KM80TSKGMER65C	C70, C147
6017694	KM80TSKGMEL65C	C70, C147
6017695	KM80TSKGMSR65C	C69, C146
6017696	KM80TSKGMSL65C	C69, C146
6017697	KM80ATCKGMER65C	C70, C147
6017698	KM80ATCKGMEL65C	C70, C147
6017868	WNMG331FW KCP05B	B158
6017935	EC040M04N00CF02 KCM35B	C22
6017936	EC040M04L06CF02 KCM35B	C22
6017937	EC040M04R06CF02 KCM35B	C22
6017938	EC040M04N00CL02 KCM35B	C23
6017939	EC030M03N00CF02 KCM35B	C22
6017940	EC030M03N00CL02 KCM35B	C23
6018001	EC050M05N00CF03 KCM35B	C22
6019339	MILL16E1000Z340N08W	S30
6019340	ONGX64ANENLE KC514M	S33
6019501	LNPU544SRGE KC520M	T19
6019502	LNPU544SRGE KC522M	T19
6019503	LNPU544SRGE KC725M	T19
6019504	LNPU544SRGE KCK15	T19
6019505	LNPU544SRGE KCPK30	T19
6019506	LNPU544SRGE KCPM40	T19
6019507	LNGU545SRGEM KC520M	T19
6019508	LNGU545SRGEM KCK15	T19
6019509	LNGU545SRGEM KCPK30	T19
6019510	LNGU545SRGEM KCPM40	T19
6020741	SDET43PDSR8GB KCSM40	T116, T123, U39
6023085	B053A01000CPG KC7325	G14
6023086	B053A01016CPG KC7325	G14
6023087	B053A01067CPG KC7325	G14
6023088	B053A01100CPG KC7325	G14
6023089	B053A01181CPG KC7325	G14
6023090	B053A01191CPG KC7325	G14
6023121	B053A01200CPG KC7325	G14
6023122	B053A01300CPG KC7325	G14
6023123	B053A01321CPG KC7325	G14
6023124	B053A01397CPG KC7325	G14
6023125	B053A01400CPG KC7325	G14
6025564	C7792VXE16-A2.00Z4R	V26–27
6025565	C7792VXE16-A2.50Z6R	V26–27
6025566	C7792VXE16-A3.00Z7R	V26–27
6025567	C7792VXE16-A4.00Z9R	V26–27
6025568	C7792VXE16-A5.00Z11R	V26–27
6025569	C7792VXE16-6.00Z13R	V26–27
6025581	C7792VXD12-A1.50Z4R	V19–20
6025582	C7792VXD12-A2.00Z6R	V19–20
6025583	C7792VXD12-A2.50Z7R	V19–20
6025584	C7792VXD12-A3.00Z9R	V19–20
6025585	C7792VXD12-A4.00Z11R	V19–20
6025586	C7792VXD12-A5.00Z13R	V19–20
6025587	C7792VXD12-6.00Z15R	V19–20
6025588	C7792VXD12CA1.25Z3R3	V18, V20
6025589	C7792VXD12CA1.50Z4R3	V18, V20
6025590	C7792VXD09CA1.00Z3R2	V11, V13
6025611	C7792VXD09CA1.25Z4R3	V11, V13
6025612	C7792VXD09-A2.00Z7R	V12–13
6025665	DFT070408DS KCU40	J102
6025666	SPPX120408LP KCU40	J104
6025669	DFT030304DS KCU40	J102
6025670	SPPX070304LP KCU40	J104
6025821	DFTX20204DS KCU40	J102
6025822	SPGX050204LP KCU40	J104
6025823	DFT05T308DS KCU40	J102
6025824	SPPX09T308LP KCU40	J104
6025825	DFT05T308D32DS KCU40	H112
6025826	DFT05T308D33DS KCU40	H112
6025827	DFT06T308D36DS KCU40	H112
6025828	DFT06T308D39DS KCU40	H112
6025829	DFT06T308D44DS KCU40	H112
6025830	DFT070408D45DS KCU40	H112
6025891	DFT070408D50DS KCU40	H112
6025892	DFT090508D56DS KCU40	H112
6025893	DFT090508D63DS KCU40	H112
6025894	DFT090508DS KCU40	J102
6025895	DFC040310D28DS KCU40	H114
6025896	DFC05T312D32DS KCU40	H114
6025897	DFC06T312D36DS KCU40	H114
6025898	DFC070416D45DS KCU40	H114
6025899	DFC090520D56DS KCU40	H114
6026363	DFT06T308DS KCU40	J102
6026364	SPGX060304LP KCU40	J104
6026365	TPG432 KCP25B	B177
6026366	SPGF422 KCP25B	B171
6026367	TPGF322 KCP25B	B177
6027457	TPMR322 KCP25B	B177
6030969	EVM50R0212M	C59
6030970	EVM50L0212M	C60
6031031	EVM50R0512MC	C59
6031032	EVM50L0512MC	C60
6031033	EVM50R0516MC	C59
6031034	EVM50L0516MC	C60
6031035	EVM65R0616MC	C59
6031036	EVM65L0616MC	C60
6031037	EVM65R0632MC	C59
6031038	EVM65L0632MC	C60
6031039	EVM65R0816MC	C59
6031040	EVM65L0816MC	C60
6031041	EVM50R1F12M	C59
6031042	EVM50L1F12M	C60
6031130	KTIP0852FEGM KCPM45	H36
6033254	XDPW120515SRD KCPM40	V23
6033255	XDPW120515SRD KCPK30	V23
6033256	XDPW120515SRD KC522M	V23
6033257	XDPW120515SRD KCK15	V23
6033258	XDPW120515SRD KC510M	V23
6034358	LNUX191950RRF KCP10B	E54
6034359	LNUX191950RRF KCP25B	E54
6034360	LNUX191950RRP KCP10B	E54
6034411	LNUX191950RRP KCP25B	E54
6035046	KLSS0714C	S30, S32, V19, V26
6039659	HNGJ43ANSNHD KCPM40	S7, S12, S16
6039660	HNGJ43ANSNHD KCK15	S7, S16
6039811	HNGJ43ANSNHD KC522M	S7, S12, S16
6039812	HNGJ43ANSNHD KCPK30	S7, S16
6039814	SNHJ442SNGD KCPM40	S59
6039815	SNHJ442SNGD KCPK30	S59
6039816	SNHJ442SNGD KCK15	S59
6039817	SNHJ442SNGD KC520M	S59
6039818	SNHJ442SNGD KC522M	S59
6041797	KSEMP7200FDS71B1M	H110, H119
6041798	KSEMP7400FDS71B1M	H110, H119
6041799	KSEMP7600FDS71B1M	H110, H119
6041800	KSEMP7800FDS71B1M	H110, H119
6041881	KSEMP8000FDS80B1M	H110, H120
6041882	KSEMP8200FDS80B1M	H110, H120
6041883	KSEMP8400FDS80B1M	H110, H120
6041884	KSEMP8600FDS80B1M	H110, H120
6041885	KSEMP8800FDS80B1M	H110, H120
6041886	KSEMP9000FDS90B1M	H110, H120
6041887	KSEMP9200FDS90B1M	H110, H120
6041888	KSEMP9400FDS90B1M	H110, H120
6041889	KSEMP9600FDS90B1M	H110, H120
6041890	KSEMP9800FDS90B1M	H110, H120
6041901	KSEMP10000FDS90B1M	H110, H120
6041904	KSEMP7100FDS71A1M	H106, H116, H123
6041906	KSEMP7300FDS71A1M	H106, H116, H123
6041907	KSEMP7500FDS71A1M	H106, H116, H123
6041908	KSEMP7700FDS71A1M	H106, H117, H123
6041909	KSEMP7900FDS71A1M	H106, H117, H123
6041910	KSEMP8100FDS80A1M	H106, H117, H123
6041921	KSEMP8300FDS80A1M	H106, H117, H123
6041922	KSEMP8500FDS80A1M	H106, H117, H123
6041923	KSEMP8700FDS80A1M	H106, H117, H123
6041924	KSEMP8900FDS80A1M	H106, H117, H123
6041925	KSEMP9100FDS90A1M	H106, H117, H123
6041926	KSEMP9300FDS90A1M	H106, H117, H123
6041927	KSEMP9500FDS90A1M	H106, H117, H123
6041928	KSEMP9700FDS90A1M	H106, H117, H123
6041929	KSEMP9900FDS90A1M	H106, H117, H123
6041930	KSEMP10000FDS90A1M	H106, H117, H123
6041931	KSEMP2875FDS71A1	H106, H116, H123
6041932	KSEMP3125FDS80A1	H106, H117, H123
6041933	KSEMP3375FDS80A1	H106, H117, H123
6041934	KSEMP3625FDS90A1	H106, H117, H123
6041935	KSEMP3875FDS90A1	H106, H117, H123
6041937	KSEMP7100FDS71B1M	H110, H119
6041938	KSEMP7300FDS71B1M	H110, H119

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6041939	KSEMP7500FDS71B1M	H110, H119
6041940	KSEMP7700FDS71B1M	H110, H119
6041991	KSEMP7900FDS71B1M	H110, H120
6041992	KSEMP8100FDS80B1M	H110, H120
6041993	KSEMP8300FDS80B1M	H110, H120
6041994	KSEMP8500FDS80B1M	H110, H120
6041995	KSEMP8700FDS80B1M	H110, H120
6041996	KSEMP8900FDS80B1M	H110, H120
6041997	KSEMP9100FDS90B1M	H110, H120
6041998	KSEMP9300FDS90B1M	H110, H120
6041999	KSEMP9500FDS90B1M	H110, H120
6042000	KSEMP9700FDS90B1M	H110, H120
6042001	KSEMP9900FDS90B1M	H110, H120
6042002	KSEMP2875FDS71B1	H110, H119
6042003	KSEMP3125FDS80B1	H110, H120
6042004	KSEMP3375FDS80B1	H110, H120
6042005	KSEMP3625FDS90B1	H110, H120
6042006	KSEMP3875FDS90B1	H110, H120
6042982	KSDR100031E0W4S KD1400	S105
6042983	KSDR100031E0W4S KD1425	S105
6042984	KSDR100031E1W4S KD1400	S105
6042985	KSDR100031E1W4S KD1425	S105
6042986	KSDR100031E3W4S KD1400	S106
6042987	KSDR100031E3W4S KD1425	S106
6042988	KSDR100093E1W4S KD1400	S105
6042989	KSDR100093E1W4S KD1425	S105
6042990	KSDR102S KD1400	S106
6043031	KSDR102S KD1425	S106
6044579	KBDM250SD06	S104
6044580	KBDM300SD08	S104
6044711	KBDM400SD12	S104
6044712	KBDM500SD16	S104
6044713	KBDM600SD18	S104
6044714	KBDM800SD24	S104
6044824	LNGU542SRGEH KCSM40	T20
6048710	KSEM2554HPGM KC7315	H55
6049015	WLJNR32CA19S	E55
6049016	WLJNL32CA19S	E55
6049017	WLJNR32CA30S	E55
6049018	WLJNL32CA30S	E55
6054192	KSCMA90UNBF KD1400	S110
6054193	KSCMA90UNBF KD1420	S110
6054194	KSCMA90QFBF KD1400	S110
6054195	KSCMA90QFBF KD1420	S110
6055137	RMR14000H7SF KCU05	K15
6055138	RMR15000H7SF KCU05	K15
6055139	RMR16000H7SF KCU05	K15
6055140	RMR17000H7SF KCU05	K15
6055148	CNMM644MR 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	K29
6055273	RHR15000KST115H7SF KCU05	K29
6055274	RHR16000KST135H7SF KCU05	K29
6055275	RHR17000KST135H7SF KCU05	K29
6055276	RHR18000KST155H7SF KCU05	K29
6055277	RHR19000KST155H7SF KCU05	K29
6055278	RHR20000KST175H7SF KCU05	K29
6055279	RHR21000KST175H7SF KCU05	K29
6055280	RHR22000KST175H7SF KCU05	K29
6055281	RHR23000KST200H7SF KCU05	K29
6055282	RHR24000KST200H7SF KCU05	K29
6055283	RHR25000KST200H7SF KCU05	K29
6055284	RHR26000KST200H7SF KCU05	K29
6055285	RHR27000KST200H7SF KCU05	K29
6055287	RHR28000KST250H7SF KCU05	K29
6055288	RHR29000KST250H7SF KCU05	K29
6055289	RHR30000KST250H7SF KCU05	K29
6055290	RHR31000KST250H7SF KCU05	K29
6055291	RHR32000KST250H7SF KCU05	K29
6055292	RHR33000KST300H7SF KCU05	K29
6055293	RHR34000KST300H7SF KCU05	K29
6055294	RHR35000KST300H7SF KCU05	K29
6055295	RHR36000KST300H7SF KCU05	K29
6055296	RHR37000KST300H7SF KCU05	K29
6055297	RHR38000KST350H7SF KCU05	K29
6055298	RHR39000KST350H7SF KCU05	K29
6055299	RHR40000KST350H7SF KCU05	K29
6055300	RHR41000KST350H7SF KCU05	K29
6055301	RHR42000KST350H7SF KCU05	K29
6055302	RHR14000KST115H7HF KCU05	K30
6055303	RHR15000KST115H7HF KCU05	K30
6055304	RHR16000KST135H7HF KCU05	K30
6055305	RHR17000KST135H7HF KCU05	K30
6055306	RHR18000KST155H7HF KCU05	K30
6055307	RHR19000KST155H7HF KCU05	K30
6055308	RHR20000KST175H7HF KCU05	K30
6055309	RHR21000KST175H7HF KCU05	K30
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6079273	EVM65L0820B1809990C	C64
6079340	EVM50R0312B0350400C	C63

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6079351	EVSBL1606160600750	C48
6079352	EVSBR1606260600750	C47
6079353	EVSBL1606260600750	C48
6079354	EVSBR1606160751000	C47
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6080474	EVSBL1605160500600C	C47–48
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6086586	4SE0312IX162A KC633M	Q23
6086587	4SE0328IR100A KC633M	Q23
6086588	4SE0343IR100A KC633M	Q23

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6086589	4SE0359IR100A KC633M	Q23
6086590	4SE0375IS062A KC633M	Q23
6086591	4SE0375IR100A KC633M	Q23
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6105091	CNMU433RN KCP10B	B53
6105093	SPU423 KCP25B	B171
6105094	SPU422 KCP25B	B171
6105095	SPU421 KCP25B	B171
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6105102	TPMR222 KCP25B	B177
6105103	TPU322 KCP25B	B178
6105104	TPU433 KCP25B	B178
6108706	SNMG434MG KCP25B	B103
6109122	SDCT4316ENLD2 KCSM40	T115, T122, U38
6109124	SDET4316SNGB KCSM40	T116, T123, U39
6109130	SDET436ENGB KCSM40	T116, T123, U39
6109210	KTIP1595FEGM KCPM45	H36
6109265	SDET436SNGB KCSM40	T116, T123, U39
6111468	OFKT53AFEN4GB KCPM40	S47
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6111470	OFKT64AFSN6HB KCPM40	S52
6111671	SDET433PDER8GB KCPM40	T116, T123, U39
6111672	SDET433PDER8GB2 KCPM40	T115, T122, U39
6111673	SDET435SNGB2 KCPM40	T115, T122, U39
6111674	SDET43PDSR8GB2 KCPM40	T115, T122, U39
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6114095	UJDE1250N6GBJ KCSM15	P63
6114096	UJDE1250N6GBK KCSM15	P63
6114097	UJBE1250N6GB KCSM15	P66
6114098	UJDE1250N6DBB KCSM15	P63
6114099	UJDE1250N6DBC KCSM15	P63
6114100	UJDE1250N6DBD KCSM15	P63
6114121	UJDE1250N6DBE KCSM15	P63
6114122	UJDE1250N6DBH KCSM15	P63
6114123	UJDE1250N6DBF KCSM15	P63
6114124	UJDE1250N6DBJ KCSM15	P63
6114125	UJDE1250N6DBK KCSM15	P63
6114126	UJBE1250N6DB KCSM15	P66
6114127	UJDE1250N6HBB KCSM15	P63
6114128	UJDE1250N6HBC KCSM15	P63
6114129	UJDE1250N6HBD KCSM15	P63
6114132	UJDE1250N6HBE KCSM15	P63
6114133	UJDE1250N6HBH KCSM15	P63
6114134	UJDE1250N6HBF KCSM15	P63
6114135	UJDE1250N6HBJ KCSM15	P63
6114181	UJDE1250N6JBJ KCSM15	P63
6114182	UJDE1250N6JBK KCSM15	P63
6114183	UJBE1250N6JB KCSM15	P66
6114184	UJDE1250N6EBB KCSM15	P63
6114185	UJDE1250N6EBC KCSM15	P63
6114186	UJDE1250N6EBD KCSM15	P63
6114187	UJDE1250N6EBE KCSM15	P63
6114188	UJDE1250N6EBH KCSM15	P63
6114189	UJDE1250N6EBF KCSM15	P63
6114190	UJDE1250N6EBJ KCSM15	P63
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6114232	UJBE1250N6EB KCSM15	P66
6114532	UJDE1500N6XBB KCSM15	P63
6114533	UJDE1500N6XBC KCSM15	P64
6114534	UJDE1500N6XBD KCSM15	P64
6114535	UJDE1500N6XBE KCSM15	P64
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6114538	UJDE1500N6XBJ KCSM15	P64
6114539	UJDE1500N6XBK KCSM15	P64
6114540	UJDE1500N6XBL KCSM15	P64
6114554	UJDE1500N6ABB KCSM15	P64
6114555	UJDE1500N6ABC KCSM15	P64
6114556	UJDE1500N6ABD KCSM15	P64
6114557	UJDE1500N6ABE KCSM15	P64
6114558	UJDE1500N6ABH KCSM15	P64
6114559	UJDE1500N6ABF KCSM15	P64
6114560	UJDE1500N6ABJ KCSM15	P64
6114571	UJDE1500N6ABK KCSM15	P64
6114572	UJDE1500N6ABL KCSM15	P64
6114573	UJBE1500N6AB KCSM15	P67
6114577	UJDE1500N6BBB KCSM15	P64
6114578	UJDE1500N6BBC KCSM15	P64
6114579	UJDE1500N6BBD KCSM15	P64
6114580	UJDE1500N6BBE KCSM15	P64
6114661	UJDE1500N6BBH KCSM15	P64
6114662	UJDE1500N6BBF KCSM15	P64
6114663	UJDE1500N6BBJ KCSM15	P64
6114664	UJDE1500N6BBK KCSM15	P64
6114665	UJDE1500N6BBL KCSM15	P64
6114666	UJBE1500N6BB KCSM15	P67
6114668	UJDE1500N6ZBB KCSM15	P64
6114669	UJDE1500N6ZBC KCSM15	P64
6114670	UJDE1500N6ZBD KCSM15	P64
6114671	UJDE1500N6ZBE KCSM15	P64
6114672	UJDE1500N6ZBH KCSM15	P64
6114673	UJDE1500N6ZBF KCSM15	P64
6114674	UJDE1500N6ZBJ KCSM15	P64
6114675	UJDE1500N6ZBK KCSM15	P64

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6114676	UJDE1500N6ZBL KCSM15	P64
6114677	UJBE1500N6ZB KCSM15	P67
6114678	UJDE1500N6CBB KCSM15	P64
6114679	UJDE1500N6CBC KCSM15	P64
6114680	UJDE1500N6CBD KCSM15	P64
6114721	UJDE1500N6CBE KCSM15	P64
6114722	UJDE1500N6CBH KCSM15	P64
6114723	UJDE1500N6CBF KCSM15	P64
6114724	UJDE1500N6CBJ KCSM15	P64
6114725	UJDE1500N6CBK KCSM15	P64
6114726	UJDE1500N6CBL KCSM15	P64
6114727	UJBE1500N6CB KCSM15	P67
6114729	UJDE1500N6FBB KCSM15	P64
6114730	UJDE1500N6FBC KCSM15	P64
6114751	UJDE1500N6FBD KCSM15	P64
6114752	UJDE1500N6FBE KCSM15	P64
6114753	UJDE1500N6FBH KCSM15	P64
6114754	UJDE1500N6FBF KCSM15	P64
6114755	UJDE1500N6FBJ KCSM15	P64
6114756	UJDE1500N6FBK KCSM15	P64
6114757	UJDE1500N6FBL KCSM15	P65
6114758	UJBE1500N6FB KCSM15	P67
6114760	UJDE1500N6GBB KCSM15	P65
6114771	UJDE1500N6GBC KCSM15	P65
6114772	UJDE1500N6GBD KCSM15	P65
6114773	UJDE1500N6GBE KCSM15	P65
6114774	UJDE1500N6GBH KCSM15	P65
6114775	UJDE1500N6GBF KCSM15	P65
6114776	UJDE1500N6GBJ KCSM15	P65
6114777	UJDE1500N6GBK KCSM15	P65
6114778	UJDE1500N6GBL KCSM15	P65
6114779	UJBE1500N6GB KCSM15	P67
6115641	UJDE1500N6DBB KCSM15	P65
6115642	UJDE1500N6DBC KCSM15	P65
6115643	UJDE1500N6DBD KCSM15	P65
6115644	UJDE1500N6DBE KCSM15	P65
6115645	UJDE1500N6DBH KCSM15	P65
6115646	UJDE1500N6DBF KCSM15	P65
6115647	UJDE1500N6DBJ KCSM15	P65
6115648	UJDE1500N6DBK KCSM15	P65
6115649	UJDE1500N6DBL KCSM15	P65
6115650	UJBE1500N6DB KCSM15	P67
6115651	UJDE1500N6HBB KCSM15	P65
6115652	UJDE1500N6HBC KCSM15	P65
6115653	UJDE1500N6HBD KCSM15	P65
6115654	UJDE1500N6HBE KCSM15	P65
6115655	UJDE1500N6HBH KCSM15	P65
6115656	UJDE1500N6HBF KCSM15	P65
6115657	UJDE1500N6HBJ KCSM15	P65
6115658	UJDE1500N6HBK KCSM15	P65
6115659	UJDE1500N6HBL KCSM15	P65
6115660	UJBE1500N6HB KCSM15	P67
6116297	A32SEVSAR0312M033042	C57
6116298	A32SEVSAL0312M033042	C57
6116299	A40TEVSAR0312M041050	C57
6116300	A40TEVSAL0312M041050	C57
6116521	A25REVSAR0212M026030	C57
6116522	A25REVSAR0312M030035	C57
6116527	A25REVSAL0212M026030	C57
6116528	A25REVSAL0312M030035	C57
6116529	A20SEVSAR0312I033042	C56
6116530	A20SEVSAL0312I033042	C56
6116531	A24TEVSAR0312I041050	C56
6116532	A24TEVSAL0312I041050	C56
6116533	A16REVSAR0212I026030	C56
6116534	A16REVSAR0312I030035	C56
6116539	A16REVSAL0212I026030	C56
6116540	A16REVSAL0312I030035	C56
6116561	EVSBR2020K0312040050C	C49
6116562	EVSBL2020K0312040050C	C50
6116563	EVSBR2020K0312050060C	C49
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6116574	EVSBL2020K0416075100C	C50
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6116577	EVSBR2525M0426075100C	C49
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6116579	EVSBR2525M0426100180C	C49
6116580	EVSBL2525M0426100180C	C50
6116581	EVSBR2525M0426180250C	C49
6116582	EVSBL2525M0426180250C	C50
6116587	EVSBR2525M0416100180C	C49
6116588	EVSBL2525M0416100180C	C50
6116589	EVSBR2525M0416180250C	C49
6116590	EVSBL2525M0416180250C	C50
6116789	EVM50R0312A075100C	C61
6116790	EVM50L0312A075100C	C62
6117023	KSEM3115HPGM KCPM45	H58
6117061	EVM50R0312B075100C	C63
6117062	EVM50L0312B075100C	C64
6117063	EVM50R0312A100180C	C61
6117064	EVM50L0312A100180C	C62
6117065	EVM50R0312B100180C	C63
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6117070	EVM50L0312B180250C	C64
6117071	EVM50R0312A250350C	C61
6117072	EVM50L0312A250350C	C62
6117073	EVM50R0312B250350C	C63
6117074	EVM50L0312B250350C	C64
6117075	EVM50R0312A350999C	C61
6117076	EVM50L0312A350999C	C62
6117077	EVM50R0312B350999C	C63
6117078	EVM50L0312B350999C	C64
6117079	EVM50R0416A100180C	C61
6117080	EVM50L0416A100180C	C62
6117091	EVM50R0416B100180C	C63
6117092	EVM50L0416B100180C	C64
6117093	EVM50R0416A180250C	C61
6117094	EVM50L0416A180250C	C62
6117095	EVM50R0416B180250C	C63
6117096	EVM50L0416B180250C	C64
6117097	EVM50R0416A250350C	C61
6117098	EVM50L0416A250350C	C62
6117099	EVM50R0416B250350C	C63
6117100	EVM50L0416B250350C	C64
6117101	EVM50R0416A350999C	C61
6117102	EVM50L0416A350999C	C62
6117103	EVM50R0416B350999C	C63
6117104	EVM50L0416B350999C	C64
6117117	EVSBR1203120400050C	C46
6117118	EVSBL1203120400050C	C47
6117119	EVSBR1203120500060C	C46
6117120	EVSBL1203120500060C	C47
6117164	EVSBR1605260500060C	C47
6117165	EVSBL1605260500060C	C47–48
6117166	EVSBR1605160600075C	C46
6117167	EVSBL1605160600075C	C47–48
6117168	EVSBR1605260600075C	C47
6117169	EVSBL1605260600075C	C47–48
6117170	EVSBR1605160751100C	C46
6117261	EVSBL1605160751100C	C47–48
6117262	EVSBR1605260751100C	C47
6117263	EVSBL1605260751100C	C47–48
6117264	EVSBR1605161001800C	C46
6117265	EVSBL1605161001800C	C47–48
6117268	EVSBR1605161802500C	C46
6117269	EVSBL1605161802500C	C47–48
6117272	EVSBR1605162503500C	C46
6117273	EVSBL1605162503500C	C47–48
6117276	EVSBR1605163509999C	C47
6117277	EVSBL1605163509999C	C47–48
6117280	EVSBR2005321001800C	C47
6117281	EVSBL2005321001800C	C47–48
6117282	EVSBR2005321802500C	C47
6117283	EVSBL2005321802500C	C47–48
6117284	EVSBR2005322503500C	C47
6117285	EVSBL2005322503500C	C48
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6117287	EVSBL2005323509999C	C48
6117351	EVSBR1203120600075C	C46
6117352	EVSBL1203120600075C	C47
6117353	EVSBR1203120751100C	C46
6117354	EVSBL1203120751100C	C47
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6117356	EVSBL1204160600075C	C47
6117357	EVSBR1204160751100C	C46
6117358	EVSBL1204160751100C	C47
6117359	EVSBR1604260600075C	C46
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6117381	EVSBR1604260751100C	C46
6117382	EVSBL1604260751100C	C47
6117383	EVSBR1604261001800C	C46
6117384	EVSBL1604261001800C	C47–48
6117386	EVSBR1604261802500C	C46
6117387	EVSBL1604261802500C	C47–48
6117402	EVSBR1604161001800C	C46
6117403	EVSBL1604161001800C	C47
6117404	EVSBR1604161802500C	C46
6117405	EVSBL1604161802500C	C47
6117419	CNMU444MN KCP25B	B51
6117573	DNMM443RP KCP10B	B85
6123362	KSEM3450FEGM KCPM45	H67
6123525	KTIP080R12SS10M	H38
6123526	KTIP085R12SS10M	H38
6123527	KTIP090R12SS10M	H38
6123528	KTIP095R12SS10M	H38
6123529	KTIP100R12SS12M	H38
6123530	KTIP105R12SS12M	H38
6123570	WD32FDS28076M	H126
6123571	WD32FDS32082M	H126
6123572	WD32FDS36092M	H126
6123573	WD50FDS40100M	H126
6123575	WD50FDS45112M	H126
6123576	WD50FDS50122M	H126
6123577	WD50FDS56140M	H126
6123578	WD50FDS63154M	H126
6123579	WD50FDS71172M	H126
6123580	WD50FDS80192M	H126
6123581	WD50FDS90212M	H126
6123582	SSF150FDS280299	H128
6123583	SSF150FDS320323	H128
6123584	SSF150FDS360362	H128
6123585	SSF200FDS400394	H128
6123586	SSF200FDS450441	H128
6123587	SSF200FDS500480	H128
6123588	SSF200FDS560551	H128
6123589	SSF200FDS630606	H128
6123590	SSF200FDS710677	H128
6123591	SSF200FDS800756	H128
6123592	SSF200FDS900835	H128
6123601	KTIP110R12SS12M	H38
6123602	KTIP115R12SS12M	H38
6123603	KTIP120R12SS14M	H38
6123604	KTIP125R12SS14M	H38
6123605	KTIP130R12SS14M	H38
6123607	KTIP135R12SS14M	H38
6123608	KTIP140R12SS16M	H38
6123609	KTIP145R12SS16M	H38
6123610	KTIP150R12SS16M	H38
6123611	KTIP160R12SS18M	H38
6123612	KTIP170R12SS18M	H38
6123613	KTIP180R12SS20M	H38
6123614	KTIP190R12SS20M	H38
6123615	KTIP200R12SS25M	H38
6123616	KTIP210R12SS25M	H38
6123617	KTIP220R12SS25M	H38
6123618	KTIP230R12SS25M	H38
6123619	KTIP240R12SS25M	H38
6123620	KTIP250R12SS32M	H38
6123621	KTIP260R12SS32M	H38
6123622	KTIP270R12SS32M	H38
6123704	KSEM321R3WD40M	H74
6123705	KSEM330R3WD40M	H74
6123706	KSEM340R3WD40M	H74
6123707	KSEM350R3WD40M	H74
6123708	KSEM360R3WD40M	H74
6123709	KSEM361R3WD40M	H74
6123710	KSEM370R3WD40M	H74
6123741	KSEM380R3WD40M	H74
6123742	KSEM390R3WD40M	H74
6123743	KSEM400R3WD40M	H74
6123744	KSEM321R5WD40M	H74
6123745	KSEM330R5WD40M	H74
6123746	KSEM340R5WD40M	H74
6123747	KSEM350R5WD40M	H74
6123748	KSEM360R5WD40M	H74
6123749	KSEM361R5WD40M	H74
6123750	KSEM370R5WD40M	H74
6123751	KSEM380R5WD40M	H74
6123752	KSEM390R5WD40M	H74
6123753	KSEM400R5WD40M	H74
6123754	KSEM1281R5SSF150	H83
6123755	KSEM1297R5SSF150	H83
6123756	KSEM1313R5SSF150	H83
6123757	KSEM1328R5SSF150	H83
6123758	KSEM1344R5SSF150	H83
6123759	KSEM1375R5SSF150	H83
6123760	KSEM1406R5SSF150	H83
6123761	KSEM1422R5SSF150	H83
6123762	KSEM1438R5SSF150	H83
6123763	KSEM1469R5SSF150	H83
6123764	KSEM1500R5SSF150	H83
6123765	KSEM1514R5SSF150	H83
6123766	KTIP0313R12SS038	H39
6123767	KTIP0335R12SS038	H39
6123768	KTIP0354R12SS038	H39
6123769	KTIP0945R12SS100	H39
6123770	KTIP0984R12SS100	H39
6123791	KTIP0787R12SS081	H39
6123792	KTIP0394R12SS044	H39
6123793	KTIP0413R12SS044	H39
6123794	KTIP0433R12SS044	H39
6123795	KTIP0453R12SS050	H39
6123796	KTIP0472R12SS050	H39
6123797	KTIP0492R12SS056	H39
6123798	KTIP0512R12SS056	H39
6123799	KTIP0532R12SS056	H39
6123800	KTIP0551R12SS056	H39
6123801	KTIP0571R12SS063	H39
6123802	KTIP0374R12SS044	H39
6123803	KTIP0906R12SS094	H39
6123804	KTIP0591R12SS063	H39
6123805	KTIP0630R12SS069	H39
6123806	KTIP0669R12SS069	H39
6123807	KTIP0709R12SS075	H39
6123808	KTIP0748R12SS075	H39
6123809	KTIP1024R12SS125	H39
6123810	KTIP1063R12SS125	H39
6123811	KTIP0492R12SS050	H39
6123812	KTIP0374R12SS038	H39
6123813	KTIP0827R12SS088	H39
6123814	KTIP0866R12SS088	H39
6124198	EVSBR2525M0526050060C	C50
6124199	EVSBL2525M0526050060C	C50
6124200	EVSBR2525M0516060075C	C49
6124211	EVSBL2525M0516060075C	C50
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6124213	EVSBL2525M0526060075C	C50
6124214	EVSBR2525M0516075100C	C49
6124215	EVSBL2525M0516075100C	C50
6124216	EVSBR2525M0526075100C	C50
6124217	EVSBL2525M0526075100C	C50
6124218	EVSBR2525M0516100180C	C49
6124219	EVSBL2525M0516100180C	C50
6124222	EVSBR2525M0516180250C	C49
6124223	EVSBL2525M0516180250C	C50
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6124227	EVSBL2525M0516250350C	C50
6124230	EVSBR2525M0516350999C	C50
6124232	EVSBL2525M0516350999C	C50
6124235	EVSBR3232P0532100180C	C50
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6124238	EVSBL3232P0532180250C	C51
6124239	EVSBR3232P0532250350C	C50
6124240	EVSBL3232P0532250350C	C51
6124241	EVSBR3232P0532350999C	C50
6124242	EVSBL3232P0532350999C	C51
6124605	EVSBR2525M0616060075C	C50
6124606	EVSBL2525M0616060075C	C51
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6124608	EVSBL2525M0626060075C	C51
6124609	EVSBR2525M0616075100C	C50
6124610	EVSBL2525M0616075100C	C51
6124671	EVSBR2525M0626075100C	C50
6124672	EVSBL2525M0626075100C	C51
6124673	EVSBR2525M0616100180C	C50
6124674	EVSBL2525M0616100180C	C51

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6124677	EVSBR2525M0616180250C	C50
6124678	EVSBL2525M0616180250C	C51
6124681	EVSBR2525M0616250350C	C50
6124682	EVSBL2525M0616250350C	C51
6124685	EVSBR2525M0616350999C	C50
6124686	EVSBL2525M0616350999C	C51
6124689	EVSBR3232P0632100180C	C50
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6124692	EVSBL3232P0632180250C	C51
6124693	EVSBR3232P0632250350C	C50
6124694	EVSBL3232P0632250350C	C51
6124695	EVSBR3232P0632350999C	C50
6124696	EVSBL3232P0632350999C	C51
6125373	B271Z15300HPG KCPK20	G69
6126918	RKDF0375Y4CQA KCSM15	O35
6126919	RKDF0500Y4CQB KCSM15	O35
6126920	RKDF0625Y4CQB KCSM15	O35
6127051	RKDF0750Y6CQB KCSM15	O35
6127052	RKDF1000Y6CQB KCSM15	O35
6127058	FSDE0375Y9CQA KC643M	O43
6127059	FSDE0375Y9CQB KC643M	O43
6127060	FSDE0375Y9CQC KC643M	O43
6127162	RQBB0375Y4CN KCPM15	O36
6127163	RQBB0500Y4CN KCPM15	O36
6127165	RQBB0625Y4CN KCPM15	O36
6127166	RQBB0750Y4CN KCPM15	O36
6127168	RQBB1000Y4CN KCPM15	O36
6127211	FSDE0375Y9CQD KC643M	O43
6127212	FSDE0500Y9CQA KC643M	O43
6127213	FSDE0500Y9CQB KC643M	O43
6127214	FSDE0500Y9CQC KC643M	O43
6127215	FSDE0500Y9CQD KC643M	O43
6127216	FSDE0500Y9CQE KC643M	O43
6127217	FSDE0625Y11CQA KC643M	O43
6127218	FSDE0625Y11CQB KC643M	O43
6127219	FSDE0625Y11CQC KC643M	O43
6127220	FSDE0625Y11CQD KC643M	O43
6127231	FSDE0625Y11CQE KC643M	O43
6127232	FSDE0750Y15CQB KC643M	O43
6127233	FSDE0750Y15CQC KC643M	O43
6127234	FSDE0750Y15CQD KC643M	O43
6127235	FSDE0750Y15CQE KC643M	O43
6127236	FSDE1000Y19CQB KC643M	O43
6127237	FSDE1000Y19CQC KC643M	O43
6127238	FSDE1000Y19CQD KC643M	O43
6127239	FSDE1000Y19CQE KC643M	O43
6127240	FSDE1000Y19CQF KC643M	O43
6127351	XADA0375Y4CU45 KCPM15	O48
6127352	XADA0500Y5CU45 KCPM15	O48
6127353	XADA0625Y6CU45 KCPM15	O48
6127415	RQDB0375Y4CV KCPM15	O34
6127416	RQDB0500Y4CV KCPM15	O34
6127417	RQDB0625Y4CV KCPM15	O34
6127418	RQDB0750Y4CV KCPM15	O34
6127419	RQDB1000Y5CV KCPM15	O34
6127558	FMDF0375Y6CQA KCPM15	O42
6127559	FMDF0500Y6CQB KCPM15	O42
6127560	FMDF0625Y6CQB KCPM15	O42
6127581	FMDF0750Y6CQB KCPM15	O42
6127582	FMDF1000Y6CQB KCPM15	O42
6127709	XRDA0375Y4CUC KCPM15	O49
6127710	XRDA0375Y4CUE KCPM15	O49
6127711	XRDA0500Y5CUB KCPM15	O49
6127712	XRDA0500Y5CUC KCPM15	O49
6127713	XRDA0500Y5CUE KCPM15	O49
6127714	XRDA0625Y6CUC KCPM15	O49
6127715	XRDA0625Y6CUE KCPM15	O49
6127885	EP1004SGE KCPM40	T37
6127886	EP1008SGE KCPM40	T37
6127887	EP1012EHD KCPM40	T36
6127888	EP1016EHD KCPM40	T36
6127889	EP1020EHD KCPM40	T36
6128132	EP1404EHD KCPM40	T57, T68
6128133	EP1408SGD KCPM40	T58, T70
6128134	EP1416EHD KCPM40	T57, T68
6128135	EP1416SGD KCPM40	T58, T70
6128136	EP1424EHD KCPM40	T57, T68
6128137	EC1804E KCPM40	T83
6128138	EC1808E KCPM40	T83
6128139	EC1812E KCPM40	T83
6128780	KTIP1770FEGM KCPM45	H36
6131423	LNGU433SRGEM KCK15	T10
6131424	LNGU433SRGEM KCPK30	T10
6131425	LNGU433SRGEM KC520M	T10
6131426	LNGU433SRGEM KCPM40	T10
6131428	LNPU433SRGE KC522M	T10
6131429	LNPU433SRGE KCPM40	T10
6131430	LNPU433SRGE KC725M	T10
6131502	LNPU432SRGE KC522M	T10
6131503	LNPU432SRGE KCPM40	T10
6131504	LNPU432SRGE KC725M	T10
6131505	LNPU432SRGE KCPK30	T10
6131506	LNPU432SRGE KC520M	T10
6131507	LNPU432SRGE KCK15	T10
6131511	LNPU433SRGE KCPK30	T10
6131512	LNPU433SRGE KC520M	T10
6131513	LNPU433SRGE KCK15	T10
6131514	LNGU431ERGE KC725M	T9
6131515	LNGU431ERGE KC522M	T9
6131516	LNGU431ERGE KCPM40	T9
6131541	LNGU432ERGE KC725M	T9
6131542	LNGU432ERGE KC522M	T9
6131543	LNGU432ERGE KCPM40	T9
6131544	LNGU432ERGE KCSM30	T9
6131556	LNGU432ERLEJ KC422M	T8
6131557	LNPU434SRGE KC522M	T10
6131558	LNPU434SRGE KCPM40	T10
6131559	LNPU434SRGE KC725M	T10
6131560	LNPU434SRGE KCPK30	T10
6131601	LNPU434SRGE KC520M	T10
6131602	LNGU432SRGEM KCK15	T10
6131603	LNGU432SRGEM KCPK30	T10
6131604	LNGU432SRGEM KC520M	T10
6131605	LNGU432SRGEM KC522M	T10
6131606	LNGU432SRGEM KCPM40	T10
6132022	LNGU432SRGE KC522M	T9
6132023	LNGU432SRGE KCPM40	T9
6132024	LNGU432SRGE KC725M	T9
6132025	LNGU432SRGE KCPK30	T9
6132026	LNGU432SRGE KCK15	T9
6132452	KSEM3750SPLM KCMS35	H65
6133656	KSEM2950SPLM KCMS35	H65
6134103	MILL16E300Z080N08W	S30
6134104	MILL16E400Z100N08W	S30
6134105	MILL16E500Z140N08W	S30
6134106	MILL16E600Z160N08W	S30
6134107	MILL16E800Z200N08W	S30
6134108	MILL16E1000Z240N08W	S30
6135413	TWDLTM	O56
6135414	TWTMINSERTDL10	O56
6135415	TWTMINSERTDL12	O56
6135416	TWTMINSERTDL16	O56
6135417	TWTMINSERTDL20	O56
6135418	TWTMINSERTDL25	O56
6135419	TWTMINSERTDL32	O56
6135420	TWTMINSERTDL10W	O56
6135421	TWTMINSERTDL12W	O56
6135422	TWTMEXT	O56
6135423	TWTMBC	O56
6136780	TCMT3253LF KCP10B	B257
6136800	SS038SLDL100225	O54
6136861	SS038DL100375	O55
6136862	SS050SLDL100250	O54
6136863	SS050DL100500	O55
6136864	SS062SLDL100350	O54
6136865	SS062DL100625	O55
6136866	SS075SLDL100450	O54
6136867	SS075DL100750	O55
6136868	SS050SLDL120250	O54
6136869	SS050DL120500	O55
6136870	SS062SLDL120325	O54
6136871	SS062DL120625	O55
6136872	SS075SLDL120425	O54
6136873	SS075DL120750	O55
6136874	SS062SLDL160275	O54
6136875	SS062DL160625	O55
6136876	SS075SLDL160325	O54
6136877	SS075DL160750	O55
6136878	SS100SLDL160450	O54
6136879	SS100DL161000	O55
6136880	SS075SLDL200300	O54
6136881	SS075DL200750	O55
6136882	SS100SLDL200375	O54
6136883	SS100DL201000	O55
6136884	SS100SLDL250350	O54
6136885	SS100DL251000	O55
6136886	SS125SLDL250425	O54
6136887	SS125DL251000	O55
6136888	SS125SLDL320400	O54
6136889	SS125DL321000	O55
6136890	SS150SLDL320550	O54
6136891	SS150DL321000	O55
6136892	SS200SLDL320750	O54
6136893	SS200DL321000	O55
6136895	HSK63ADL10200	O52
6136896	HSK63ADL12225	O52
6136897	HSK63ADL16225	O52
6136898	HSK63ADL20225	O52
6136899	HSK63ADL25250	O52
6136900	HSK63ADL32288	O52
6136931	PSC63DL10200	O52
6136932	PSC63DL12200	O52
6136933	PSC63DL16225	O52
6136934	PSC63DL20225	O52
6136935	PSC63DL25238	O52
6136936	PSC63DL32275	O52
6136937	CV40BDL10162	O53
6136938	CV40BDL12162	O53
6136939	CV40BDL16200	O53
6136940	CV40BDL20200	O53
6136941	CV40BDL25225	O53
6136942	CV40BDL32250	O53
6136943	BT40BDL10200	O53
6136944	BT40BDL12200	O53
6136945	BT40BDL16225	O53
6136946	BT40BDL20225	O53
6136947	BT40BDL25238	O53
6136948	BT40BDL32275	O53
6137128	DNMG332FP KCPK05	B80
6137163	DNMG331FP KCPK05	B80
6139893	M4D075L1103M10L110	T4
6139894	M4D100L1104M12L125	T4
6139895	M4D125L1105M16L175	T4
6139896	M4D100L1103W075L175	T5
6139897	M4D150L1105W125L225	T5
6139898	M4D062L1102C062L600	T6
6139899	M4D075L1103C075L600	T6
6139900	M4D100L1104C100L700	T6
6139921	M4D125L1104C125L800	T6
6139922	M4D150L1106S050L157	T7
6139923	M4D250L1107S100L157	T7
6139924	M4D300L1108S125L175	T7
6139928	M4D062L1102W062L100	T5, T11
6139929	M4D075L1102W075L110	T5, T11
6139930	M4D075L1103W075L110	T5, T11
6140051	M4D100L1103W100L175	T5, T11
6140052	M4D125L1104W125L225	T5, T11
6140053	M4D062L1102C062L400	T6, T11
6140054	M4D075L1103C075L400	T6, T11
6140055	M4D075L1102C075L600	T6
6140056	M4D100L1104C100L450	T6, T11
6140057	M4D100L1103C100L700	T6
6140058	M4D125L1105C125L500	T6, T11
6140059	M4D150L1105S050L157	T7, T11
6140060	M4D200L1105S075L157	T7, T11
6140061	M4D200L1107S075L157	T7, T11
6140062	M4D250L1107S075L157	T7
6140063	M4D300L1108S100L175	T7
6140064	HNEC535ANSN KY3500	S23
6140065	T839M030X050RD3-A KSP39	M91
6140066	T839M035X060RD4-A KSP39	M91
6140067	T839M040X070RD4-A KSP39	M91
6140068	T839M050X080RD4-A KSP39	M91
6140069	T839M060X100RD5-A KSP39	M91
6140070	T839M070X100RD5-A KSP39	M91
6140131	T839MF080X100RD5-A KSP39	M91
6140132	T839M080X125RD5-A KSP39	M91
6140133	T839MF100X125RD5-A KSP39	M91
6140134	T839M100X150RD6-A KSP39	M91
6140135	T839MF120X125RD5-A KSP39	M91
6140136	T839MF120X150RD5-A KSP39	M91
6140137	T839M120X175RD6-A KSP39	M91
6140138	T839MF140X150RD6-A KSP39	M91
6140139	T839M140X200RD7-A KSP39	M91
6140140	T839MF160X150RD6-A KSP39	M91
6140141	T839M160X200RD7-A KSP39	M91
6140142	T839MF180X150RD6-A KSP39	M91
6140594	T838NC#02-56RH2-A KSP39	M79
6140596	T838NC#03-48RH2-A KSP39	M79
6140598	T838NC#04-40RH2-A KSP32	M79
6140600	T838NC#04-40RH2-A KSP39	M79
6140601	T838NC#04-40RH3-A KSP39	M79
6140602	T838NC#04-40RH4-A KSP39	M79
6140603	T838NC#04-40RH5-A KSP39	M79
6140604	T838NF#04-48RH2-A KSP39	M79
6140605	T838NC#05-40RH2-A KSP39	M79
6140606	T838NC#06-32RH2-A KSP39	M79
6140607	T838NC#06-32RH3-A KSP32	M79
6140608	T838NC#06-32RH3-A KSP39	M79
6140609	T838NC#06-32RH4-A KSP39	M79
6140610	T838NC#06-32RH5-A KSP39	M79
6140611	T838NC#06-32RH7-A KSP39	M79
6140612	T838NF#06-40RH2-A KSP39	M79
6140613	T838NF#06-40RH3-A KSP39	M79
6140614	T838NC#08-32RH2-A KSP39	M79
6140615	T838NC#08-32RH3-A KSP32	M79
6140616	T838NC#08-32RH3-A KSP39	M79
6140617	T838NC#08-32RH4-A KSP39	M79
6140618	T838NC#08-32RH5-A KSP39	M79
6140619	T838NC#08-32RH6-A KSP39	M79
6140620	T838NC#08-32RH7-A KSP39	M79
6140621	T838NC#10-24RH2-A KSP39	M79
6140622	T838NC#10-24RH3-A KSP32	M79
6140623	T838NC#10-24RH3-A KSP39	M79
6140624	T838NC#10-24RH4-A KSP39	M79
6140625	T838NC#10-24RH5-A KSP39	M79
6140626	T838NC#10-24RH7-A KSP39	M79
6140627	T838NF#10-32RH2-A KSP39	M79
6140628	T838NF#10-32RH3-A KSP32	M79
6140629	T838NF#10-32RH3-A KSP39	M79
6140630	T838NF#10-32RH4-A KSP39	M80
6140631	T838NF#10-32RH5-A KSP39	M80
6140632	T838NF#10-32RH6-A KSP39	M80
6140633	T838NF#10-32RH7-A KSP39	M80
6140634	T838NC#12-24RH3-A KSP39	M80
6140635	T838NF#12-28RH3-A KSP39	M80
6140636	T838NC02500-20RH2-A KSP39	M80
6140637	T838NC02500-20RH3-A KSP32	M80
6140638	T838NC02500-20RH3-A KSP39	M80
6140639	T838NC02500-20RH5-A KSP39	M80
6140640	T838NC02500-20RH7-A KSP39	M80
6140671	T838NF02500-28RH2-A KSP39	M80
6140672	T838NF02500-28RH3-A KSP32	M80
6140673	T838NF02500-28RH3-A KSP39	M80
6140674	T838NC05000-13RH3-A KSP32	M80
6140675	T838NF02500-28RH4-A KSP39	M80
6140676	T838NC05000-13RH3-A KSP39	M80
6140677	T838NF02500-28RH5-A KSP39	M80
6140678	T838NC05000-13RH5-A KSP39	M80
6140679	T838NF02500-28RH6-A KSP39	M80
6140680	T838NC05000-13RH7-A KSP39	M80
6140681	T838NF02500-28RH7-A KSP39	M80
6140682	T838NF05000-20RH3-A KSP32	M80
6140683	T838NC03125-18RH3-A KSP32	M80
6140684	T838NF05000-20RH3-A KSP39	M80
6140685	T838NC03125-18RH3-A KSP39	M80
6140686	T838NF05000-20RH5-A KSP39	M80
6140687	T838NC03125-18RH5-A KSP39	M80
6140688	T838NF05000-20RH6-A KSP39	M80
6140689	T838NC03125-18RH7-A KSP39	M80
6140690	T838NF05000-20RH7-A KSP39	M80
6140691	T838NF03125-24RH3-A KSP32	M80
6140692	T838NC05625-12RH3-A KSP39	M80
6140693	T838NC05625-12RH3-A KSP32	M80
6140694	T838NF03125-24RH3-A KSP39	M80
6140695	T838NC05625-12RH5-A KSP39	M80
6140696	T838NF03125-24RH5-A KSP39	M80
6140697	T838NF05625-18RH3-A KSP39	M80
6140698	T838NF03125-24RH7-A KSP39	M80
6140699	T838NF05625-18RH5-A KSP39	M80
6140700	T838NC03750-16RH3-A KSP32	M80
6140701	T838NC06250-11RH3-A KSP32	M80
6140702	T838NC03750-16RH3-A KSP39	M80
6140703	T838NC06250-11RH3-A KSP39	M80
6140704	T838NC03750-16RH5-A KSP39	M80
6140705	T838NC06250-11RH5-A KSP39	M80
6140706	T838NC03750-16RH7-A KSP39	M80

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6140707	T838NC06250-11RH7-A KSP39	M80
6140708	T838NF03750-24RH3-A KSP32	M80
6140709	T838NF06250-18RH3-A KSP32	M80
6140710	T838NF03750-24RH3-A KSP39	M80
6140711	T838NF06250-18RH3-A KSP39	M80
6140712	T838NF03750-24RH4-A KSP39	M80
6140713	T838NF06250-18RH5-A KSP39	M80
6140714	T838NF03750-24RH5-A KSP39	M80
6140715	T838NF06250-18RH6-A KSP39	M81
6140716	T838NF03750-24RH6-A KSP39	M80
6140717	T838NF06250-18RH7-A KSP39	M81
6140718	T838NC04375-14RH3-A KSP32	M80
6140719	T838NC07500-10RH3-A KSP32	M81
6140720	T838NC04375-14RH3-A KSP39	M80
6140721	T838NC07500-10RH3-A KSP39	M81
6140722	T838NC04375-14RH5-A KSP39	M80
6140723	T838NC07500-10RH5-A KSP39	M81
6140724	T838NC04375-14RH7-A KSP39	M80
6140725	T838NF07500-16RH3-A KSP32	M81
6140726	T838NF04375-20RH3-A KSP32	M80
6140727	T838NF07500-16RH3-A KSP39	M81
6140728	T838NF04375-20RH3-A KSP39	M80
6140729	T838NF07500-16RH5-A KSP39	M81
6140730	T838NF04375-20RH5-A KSP39	M80
6140731	T838NC08750-9RH4-A KSP39	M81
6140732	T838NF04375-20RH6-A KSP39	M80
6140733	T838NF08750-14RH4-A KSP39	M81
6140734	T838NF04375-20RH7-A KSP39	M80
6140735	T838NC10000-8RH5-A KSP39	M81
6140736	T838NC10000-8RH5-A KSP32	M81
6140737	T838NF1000-12RH4-A KSP39	M81
6140738	T838NC11250-7RH6-A KSP39	M81
6140739	T839NC#04-40RH2-A KSP39	M82
6140740	T839NC#04-40RH3-A KSP39	M82
6140781	T839NC#04-40RH5-A KSP39	M82
6140782	T839NC#05-40RH2-A KSP39	M82
6140783	T839NC#06-32RH2-A KSP39	M82
6140784	T839NC#06-32RH3-A KSP39	M82
6140785	T839NC#06-32RH5-A KSP39	M82
6140786	T839NF#06-40RH2-A KSP39	M82
6140787	T839NF#06-40RH3-A KSP39	M82
6140788	T839NC#08-32RH2-A KSP39	M82
6140789	T839NC#08-32RH3-A KSP39	M82
6140790	T839NC#08-32RH5-A KSP39	M82
6140791	T839NC#10-24RH3-A KSP39	M82
6140792	T839NC#10-24RH5-A KSP39	M82
6140793	T839NF#10-32RH3-A KSP39	M82
6140794	T839NF#10-32RH5-A KSP39	M82
6140795	T839NC02500-20RH3-A KSP39	M82
6140796	T839NC02500-20RH5-A KSP39	M82
6140797	T839NF02500-28RH3-A KSP39	M82
6140798	T839NF02500-28RH5-A KSP39	M82
6140799	T839NC03125-18RH3-A KSP39	M82
6140800	T839NC03125-18RH5-A KSP39	M82
6140801	T839NF03125-24RH3-A KSP39	M82
6140802	T839NF03125-24RH5-A KSP39	M82
6140803	T839NC03750-16RH3-A KSP39	M82
6140804	T839NC03750-16RH5-A KSP39	M82
6140805	T838M030X050RD3-A KSP32	M90
6140806	T839NF03750-24RH3-A KSP39	M82
6140807	T838M030X050RD3-A KSP39	M90
6140808	T839NF03750-24RH4-A KSP39	M82
6140809	T838M035X060RD4-A KSP39	M90
6140810	T839NF03750-24RH5-A KSP39	M83
6140811	T838M040X070RD4-A KSP32	M90
6140812	T839NC04375-14RH3-A KSP39	M83
6140813	T838M040X070RD4-A KSP39	M90
6140814	T839NC04375-14RH5-A KSP39	M83
6140815	T838M050X080RD4-A KSP32	M90
6140816	T839NF04375-20RH3-A KSP39	M83
6140817	T838M050X080RD4-A KSP39	M90
6140818	T839NF04375-20RH5-A KSP39	M83
6140819	T838M060X100RD5-A KSP32	M90
6140820	T839NC05000-13RH3-A KSP39	M83
6140821	T838M060X100RD5-A KSP39	M90
6140822	T839NC05000-13RH5-A KSP39	M83
6140823	T838M070X100RD5-A KSP39	M90
6140824	T839NF05000-20RH3-A KSP39	M83
6140825	T838MF080X100RD5-A KSP39	M90
6140826	T839NC05625-12RH3-A KSP39	M83
6140827	T838M080X125RD5-A KSP32	M90
6140828	T839NC05625-12RH5-A KSP39	M83
6140829	T838M080X125RD5-A KSP39	M90
6140830	T839NF05625-18RH3-A KSP39	M83
6140841	T838MF100X125RD5-A KSP39	M90
6140842	T839NC06250-11RH3-A KSP39	M83
6140843	T838M100X150RD6-A KSP39	M90
6140844	T839NC06250-11RH5-A KSP39	M83
6140845	T838M100X150RD6-A KSP32	M90
6140846	T839NF06250-18RH3-A KSP39	M83
6140847	T838MF120X125RD5-A KSP39	M90
6140848	T839NF06250-18RH5-A KSP39	M83
6140849	T838MF120X150RD5-A KSP39	M90
6140850	T839NC07500-10RH3-A KSP39	M83
6140851	T838M120X175RD6-A KSP32	M90
6140852	T839NF07500-16RH3-A KSP39	M83
6140853	T838M120X175RD6-A KSP39	M90
6140854	T838MF140X150RD6-A KSP39	M90
6140855	T838M140X200RD7-A KSP39	M90
6140856	T838MF160X150RD6-A KSP39	M90
6140857	T838M160X200RD7-A KSP39	M90
6140858	T838MF180X150RD6-A KSP39	M90
6140859	T838M180X250RD7-A KSP39	M90
6143903	3SE0031IR007A KC633M	Q16
6143904	3SE0047IR011A KC633M	Q16
6143905	3SE0062IR019A KC633M	Q16
6143906	3SE0078IR011A KC633M	Q16
6143907	3SE0094IR037A KC633M	Q16
6143908	3SE0109IR037A KC633M	Q16
6143909	3SE0125IR025A KC633M	Q16
6143910	3SE0125IL050A KC633M	Q16
6143941	3SE0125IX062A KC633M	Q16
6143943	3SE0156IR056A KC633M	Q16
6143944	3SE0188IS031A KC633M	Q16
6143945	3SE0188IR056A KC633M	Q16
6143946	3SE0188IL062A KC633M	Q16
6143947	3SE0188IX100A KC633M	Q16
6143949	3SE0219IR062A KC633M	Q16
6143950	3SE0219IL075A KC633M	Q16
6143951	3SE0250IS050A KC633M	Q16
6143952	3SE0250IR075A KC633M	Q16
6143953	3SE0250IL100A KC633M	Q16
6143954	3SE0250IX150A KC633M	Q16
6143955	3SE0281IR075A KC633M	Q16
6143956	3SE0281IL081A KC633M	Q16
6143957	3SE0312IR050A KC633M	Q16
6143958	3SE0312IL081A KC633M	Q16
6143962	3SE0375IS050A KC633M	Q16
6143963	3SE0375IR088A KC633M	Q16
6143964	3SE0375IL100A KC633M	Q16
6143965	3SE0375IX112A KC633M	Q16
6143967	3SE0437IR062A KC633M	Q16
6143968	3SE0437IL088A KC633M	Q16
6143969	3SE0437IX100A KC633M	Q16
6143970	3SE0500IR100A KC633M	Q16
6143971	3SE0500IL200A KC633M	Q17
6143973	3SE0563IR112A KC633M	Q17
6143974	3SE0625IR075A KC633M	Q17
6143975	3SE0625IL125A KC633M	Q17
6143976	3SE0750IR100A KC633M	Q17
6143977	3SE0750IL150A KC633M	Q17
6143978	3SE0750IX225A KC633M	Q17
6143979	3SE1000IR150A KC633M	Q17
6143980	3SE1000IX225A KC633M	Q17
6145034	3SE0563IR112B KC633M	Q17
6145035	3SE0625IR075B KC633M	Q17
6145036	3SE0625IL125B KC633M	Q17
6145038	3SE0750IL150B KC633M	Q17
6145039	3SE0750IX225B KC633M	Q17
6145041	3SE1000IX225B KC633M	Q17
6145374	1-16NPTF-JIC	C83
6145375	1-8NPTF-JIC	C83
6145376	G18-JIC	C83
6145377	M10-JIC	C83
6145378	M8-JIC	C83
6145379	JICM-JICF-ELB	C83
6145380	COOL-HOSE-200	C83
6145381	COOL-HOSE-300	C83
6145382	M6-JIC	C83
6145383	JICM-JICM-STR	C83
6145386	G14-G18-RED	C83
6151112	ABDF0375Y2CU K600	O28
6151113	ABDF0500Y2CU K600	O28
6151114	ABDF0625Y2CU K600	O28
6151115	ABDF0750Y2CU K600	O28
6151491	VDIB1M302040C	C75
6151492	VDIB1M402544C	C75
6151493	VDIB2M302040C	C75
6151494	VDIB2M402544C	C75
6151495	VDIB3M302040C	C76
6151497	VDIB3M402544C	C76
6151498	VDIB4M302040C	C76
6151499	VDIB4M402544C	C76
6151500	VDIB5M302040C	C77
6151511	VDIB5M402544C	C77
6151512	VDIB6M302040C	C77
6151513	VDIB6M402544C	C77
6151514	VDIC1M302070C	C78
6151515	VDIC1M402585C	C78
6151516	VDIC2M302070C	C78
6151517	VDIC2M402585C	C78
6151518	VDIC3M302070C	C79
6151519	VDIC3M402585C	C79
6151520	VDIC4M302070C	C79
6151521	VDIC4M402585C	C79
6151522	CNMG4305LF KCP25B	B50
6151523	CNMG431LF KCP25B	B50
6151524	CNMG432LF KCP25B	B50
6151527	CNMG643MG KCP25B	B57
6151528	CNMM432MR KCP25B	B54
6151529	CNMM543MR KCP25B	B54
6151530	CNMM544MR KCP25B	B54
6151562	DNMP332K KCP25B	B86
6151565	VNMG332LF KCP25B	B145
6151567	RCMH64K KCP10B	B239
6152251	D315CFA	S31
6152252	D355CFA	S31
6152253	D400CFA	S31
6152254	D500CFA	S31
6153948	ABDE0375Y3CQA K600	O29
6153949	ABDE0375Y3CQB K600	O29
6153950	ABDE0375Y3CQC K600	O29
6153951	ABDE0375Y3CQD K600	O29
6153952	ABDE0500Y3CQA K600	O29
6153953	ABDE0500Y3CQB K600	O29
6153954	ABDE0500Y3CQC K600	O29
6153955	ABDE0500Y3CQD K600	O29
6153956	ABDE0500Y3CQE K600	O29
6153957	ABDE0625Y3CQA K600	O29
6153958	ABDE0625Y3CQB K600	O29
6153959	ABDE0625Y3CQC K600	O29
6153960	ABDE0625Y3CQD K600	O29
6153961	ABDE0625Y3CQE K600	O29
6153963	ABDE0750Y3CQB K600	O29
6153964	ABDE0750Y3CQC K600	O29
6153965	ABDE0750Y3CQD K600	O29
6153966	ABDE0750Y3CQE K600	O29
6153967	ABDE1000Y3CQB K600	O29
6153968	ABDE1000Y3CQC K600	O29
6153969	ABDE1000Y3CQD K600	O29
6153970	ABDE1000Y3CQE K600	O29
6153971	ABDE1000Y3CQF K600	O29
6159069	MILL16E200Z040N08SC	S32
6159070	MILL16E250Z040N08SC	S32
6159072	MILL16E300Z050N08SC	S32
6159074	MILL16E400Z060N08SC	S32
6159076	MILL16E500Z080N08SC	S32
6159078	MILL16E600Z100N08SC	S32
6159080	MILL16E800Z100N08SC	S32
6159082	MILL16E1000Z120N08SC	S32
6160117	5720VZ16HA050Z4R75	T99
6160743	C7792VXE16-A1.5/4.00Z7R	V26
6160744	C7792VXE16-A1.5/4.00Z9R	V26
6162808	EP1816EHD KCPM40	T84
6162809	EP1832EHD KCPM40	T84
6162869	KSEM1830SPLM KCMS35	H64
6162870	KSEM0797SPL KCMS35	H64
6163121	KSEM2250SPLM KCMS35	H64
6163122	KSEM2350SPLM KCMS35	H64
6163123	KSEM2450SPLM KCMS35	H64
6163124	KSEM2525SPLM KCMS35	H64
6163125	KSEM2530SPLM KCMS35	H64
6163126	KSEM2550SPLM KCMS35	H64
6163127	KSEM2630SPLM KCMS35	H64
6163128	KSEM2650SPLM KCMS35	H64
6163129	KSEM1047SPL KCMS35	H64
6163130	KSEM2750SPLM KCMS35	H64
6163131	KSEM2800SPLM KCMS35	H64
6163132	KSEM2850SPLM KCMS35	H64
6163133	KSEM2900SPLM KCMS35	H65
6163134	KSEM3050SPLM KCMS35	H65
6163135	KSEM3100SPLM KCMS35	H65
6163136	KSEM3150SPLM KCMS35	H65
6163137	KSEM3250SPLM KCMS35	H65
6163138	KSEM3350SPLM KCMS35	H65
6163139	KSEM3400SPLM KCMS35	H65
6163141	KSEM3450SPLM KCMS35	H65
6163142	KSEM3500SPLM KCMS35	H65
6163143	KSEM3550SPLM KCMS35	H65
6163144	KSEM3600SPLM KCMS35	H65
6163145	KSEM3650SPLM KCMS35	H65
6163146	KSEM3700SPLM KCMS35	H65
6163147	KSEM3800SPLM KCMS35	H65
6163148	KSEM3850SPLM KCMS35	H65
6163149	KSEM3900SPLM KCMS35	H65
6163150	KSEM3950SPLM KCMS35	H65
6163300	KTIP03594FEG KCPM45	H36
6163381	KTIP1010FEGM KCPM45	H36
6163382	KTIP1170FEGM KCPM45	H36
6163383	KSEM0781FEG KCPM45	H67
6163384	KSEM2580FEGM KCPM45	H67
6163385	KSEM1016FEG KCPM45	H67
6163386	KSEM1031FEG KCPM45	H67
6163387	KSEM3050FEGM KCPM45	H67
6163388	KSEM3150FEGM KCPM45	H67
6163389	KSEM3250FEGM KCPM45	H67
6163390	KSEM3350FEGM KCPM45	H67
6163411	KSEM3550FEGM KCPM45	H67
6163412	KSEM3650FEGM KCPM45	H68
6163413	KSEM3750FEGM KCPM45	H68
6163414	KSEM3850FEGM KCPM45	H68
6163415	KSEM3950FEGM KCPM45	H68
6163504	KSEM0929HPG KCPM45	H57
6163505	KSEM1965HPGM KCPM45	H57
6165350	RNGJ10T3M0ELDJ KCSM40	V48
6165392	RNGJ1204M0SGDJ KCSM40	V55
6165393	RNPJ1605M0SGD KCSM40	V59
6165397	LNGU432SRGE KCSM40	T9
6165400	LNGU542SRGE KCSM40	T19
6165421	LNGU543SRGE KCSM40	T19
6165422	LNGU542ERGE KCSM40	T18
6165423	LNGU543ERGE KCSM40	T18
6165759	HNPJ43ANSNGD KCSM40	S7, S13
6165760	HNPJ43ANSNHD KCSM40	S7, S13, S16
6165861	HNPJ438ANSNHD KCSM40	S7, S13, S16
6165863	XNGJ43ANENLD3W KCSM40	S12
6165864	HNGJ43ANSNHD KCSM40	S7, S12, S16
6167534	FSDE0375J9BCA KC643M	P98
6167535	FSDE0375J9BCB KC643M	P98
6167536	FSDE0500J9BCA KC643M	P98
6167537	FSDE0500J9BCB KC643M	P98
6167538	FSDE0500J9BCC KC643M	P98
6167539	FSDE0625JBBCB KC643M	P98
6167540	FSDE0750JFBCA KC643M	P98
6167551	FSDE0750JFBCB KC643M	P98
6167552	FSDE0750JFBCC KC643M	P98
6167553	FSDE0750JFBCE KC643M	P98
6167554	FSDE1000JJBCA KC643M	P98
6167555	FSDE1000JJBCB KC643M	P98
6167556	FSDE1000JJBCC KC643M	P98
6167557	FSDE1000JJBCE KC643M	P98
6168013	SDCT43PDER8LD2 KCSM40	T115, T122, U38
6168014	SDCT433PDER8LD2 KCSM40	T115, T122
6168015	SDET433PDER8GB KCSM40	T116, T123, U39
6168016	SDCT434ENLD2 KCSM40	T115, T122, U38
6168017	SDCT438ENLD2 KCSM40	T115, T122
6168018	SDET43PDER8GB2 KCSM40	T115, T122, U39
6168019	SDET4316ENGB KCSM40	T116, T123, U39
6168020	SDET4312SNGB KCSM40	T116, T123, U39
6168101	SDET4312ENGB KCSM40	T116, T123, U39

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6168102	SDET438SNGB KCSM40	T116, T123, U39
6168103	SDET438ENGB KCSM40	T116, T123, U39
6168104	SDET434SNGB KCSM40	T116, T123, U39
6168105	SDET434ENGB KCSM40	T116, T123, U39
6168106	SDET433PDSR8GB KCSM40	T116, T123, U39
6171518	EC1408EGD KCSM40	T57, T68
6171519	EC1412EGD KCSM40	T57, T68
6171520	EC1416EGD KCSM40	T57, T68
6171591	EC1431EGD KCSM40	T57, T68
6172122	EP1408EHD KCSM40	T57, T68
6172123	EP1412EHD KCSM40	T57, T68
6172124	EP1416EHD KCSM40	T57, T68
6172125	EP1420EHD KCSM40	T57, T68
6172126	EP1424EHD KCSM40	T57, T68
6172127	EP1431EHD KCSM40	T57, T68
6172128	EP1440EHD KCSM40	T57, T68
6172129	EP1408SGD KCSM40	T58, T70
6172130	EP1412SGD KCSM40	T58, T70
6172191	EP1416SGD KCSM40	T58, T70
6172192	EP1408SGE KCSM40	T58, T69
6172193	EP1412SGE KCSM40	T58, T69
6172194	EP1416SGE KCSM40	T58, T69
6172195	EP1431SGE KCSM40	T58, T69
6172348	EP1808S KCSM40	T85
6172349	EP1812S KCSM40	T85
6172350	EP1816S KCSM40	T85
6172391	EP1832S KCSM40	T85
6172392	EP1848S KCSM40	T85
6172393	EP1864S KCSM40	T85
6172394	EP1808SGE KCSM40	T84
6172395	EP1812SGE KCSM40	T84
6172396	EP1816SGE KCSM40	T84
6172397	EP1832SGE KCSM40	T84
6172398	EP1808E KCSM40	T83
6172399	EP1816E KCSM40	T83
6172400	EP1832E KCSM40	T83
6172411	EP1848E KCSM40	T83
6172412	EP1864E KCSM40	T83
6172413	EP1808EHD KCSM40	T84
6172414	EP1812EHD KCSM40	T84
6172415	EP1816EHD KCSM40	T84
6172416	EP1832EHD KCSM40	T84
6172417	EP1840EHD KCSM40	T84
6172418	EP1848EHD KCSM40	T84
6172513	B967A03000 KC7315	G130
6172514	B967A03100 KC7315	G130
6172515	B967A03200 KC7315	G130
6172516	B967A03300 KC7315	G130
6172517	B967A03500 KC7315	G130
6172518	B967A03800 KC7315	G130
6172519	B967A04000 KC7315	G130
6172520	B967A04200 KC7315	G130
6172531	B967A04300 KC7315	G130
6172532	B967A04500 KC7315	G130
6172533	B967A04800 KC7315	G130
6172534	B967A05100 KC7315	G130
6172535	B967A05200 KC7315	G130
6172536	B967A05500 KC7315	G130
6172537	B967A05800 KC7315	G130
6172538	B967A06100 KC7315	G130
6172539	B967A06600 KC7315	G131
6172540	B967A06800 KC7315	G131
6172541	B967A07800 KC7315	G131
6172542	B967A08100 KC7315	G131
6172543	B967A08600 KC7315	G131
6172544	B967A08800 KC7315	G131
6172655	T839M030X050R6H-D1 KSP39	M97
6172656	T839M030X050R6H-D1 KSU31	M97
6172657	T839M040X070R6H-D1 KSP39	M97
6172658	T839M040X070R6H-D1 KSU31	M97
6172659	T839M050X080R6H-D1 KSP39	M97
6172660	T839M050X080R6H-D1 KSU31	M97
6172681	T839M060X100R6H-D1 KSP39	M97
6172682	T839M060X100R6H-D1 KSU31	M97
6172683	T839M080X125R6H-D1 KSP39	M97
6172684	T839M080X125R6H-D1 KSU31	M97
6172685	T839M100X150R6H-D1 KSP39	M97
6172686	T839M100X150R6H-D1 KSU31	M97
6172687	T839M120X175R6H-D6 KSP39	M97
6172688	T839M120X175R6H-D6 KSU31	M97
6172689	T839M140X200R6H-D6 KSP39	M97
6172690	T839M140X200R6H-D6 KSU31	M97
6172701	T839M160X200R6H-D6 KSP39	M97
6172702	T839M160X200R6H-D6 KSU31	M97
6172703	T839M180X250R6H-D6 KSP39	M97
6172704	T839M180X250R6H-D6 KSU31	M97
6172705	T839M200X250R6H-D6 KSP39	M97
6172706	T839M200X250R6H-D6 KSU31	M97
6172875	T838NC05625-12R2B-D6 KSP39	M85
6172876	T838NC05625-12R2B-D6 KSU31	M85
6172877	T838NF05625-18R2B-D4 KSP39	M85
6172878	T838NF05625-18R2B-D4 KSU31	M85
6172879	T838NC06250-11R2B-D6 KSP39	M85
6172880	T838NC06250-11R2B-D6 KSU31	M85
6172967	T838M020X040R6H-D1 KSP39	M95
6172968	T838M020X040R6H-D1 KSU31	M95
6172969	T838M030X050R6H-D1 KSP39	M95
6172970	T838M030X050R6H-D1 KSU31	M95
6173001	T838M040X070R6H-D1 KSP39	M95
6173002	T838M040X070R6H-D1 KSU31	M95
6173003	T838M050X080R6H-D1 KSP39	M95
6173004	T838M050X080R6H-D1 KSU31	M95
6173005	T838M050X080R6H-D6 KSP39	M95
6173006	T838M050X080R6H-D6 KSU31	M95
6173007	T838MF060X075R6H-D4 KSP39	M95
6173008	T838MF060X075R6H-D4 KSU31	M95
6173009	T838M060X100R6H-D1 KSP39	M95
6173010	T838M060X100R6H-D1 KSU31	M95
6173011	T838M060X100R6H-D6 KSP39	M95
6173012	T838M060X100R6H-D6 KSU31	M95
6173013	T838MF080X075R6H-D4 KSP39	M95
6173014	T838MF080X075R6H-D4 KSU31	M95
6173015	T838MF080X100R6H-D4 KSP39	M95
6173016	T838MF080X100R6H-D4 KSU31	M95
6173017	T838M080X125R6H-D1 KSP39	M95
6173018	T838M080X125R6H-D1 KSU31	M95
6173019	T838M080X125R6H-D6 KSP39	M95
6173020	T838M080X125R6H-D6 KSU31	M95
6173021	T838MF100X075R6H-D4 KSP39	M95
6173022	T838MF100X075R6H-D4 KSU31	M95
6173023	T838MF100X100R6H-D4 KSP39	M95
6173024	T838MF100X100R6H-D4 KSU31	M95
6173025	T838MF100X125R6H-D4 KSP39	M95
6173026	T838MF100X125R6H-D4 KSU31	M95
6173027	T838M100X150R6H-D1 KSP39	M95
6173028	T838M100X150R6H-D1 KSU31	M95
6173029	T838M100X150R6H-D6 KSP39	M95
6173030	T838M100X150R6H-D6 KSU31	M95
6173051	T838MF120X100R6H-D4 KSP39	M95
6173052	T838MF120X100R6H-D4 KSU31	M95
6173053	T838MF120X125R6H-D4 KSP39	M95
6173054	T838MF120X125R6H-D4 KSU31	M95
6173055	T838MF120X150R6H-D4 KSP39	M95
6173056	T838MF120X150R6H-D4 KSU31	M95
6173057	T838M120X175R6H-D6 KSP39	M95
6173058	T838M120X175R6H-D6 KSU31	M95
6173059	T838MF140X100R6H-D4 KSP39	M95
6173060	T838MF140X100R6H-D4 KSU31	M95
6173061	T838MF140X125R6H-D4 KSP39	M95
6173062	T838MF140X125R6H-D4 KSU31	M95
6173063	T838MF140X150R6H-D4 KSP39	M95
6173064	T838MF140X150R6H-D4 KSU31	M95
6173065	T838M140X200R6H-D6 KSP39	M95
6173066	T838M140X200R6H-D6 KSU31	M95
6173068	T838MF160X150R6H-D4 KSP39	M95
6173069	T838MF160X150R6H-D4 KSU31	M95
6173070	T838M160X200R6H-D6 KSP39	M95
6173071	T838NF06250-18R2B-D4 KSP39	M85
6173072	T838NF06250-18R2B-D4 KSU31	M85
6173073	T838NC07500-10R2B-D6 KSP39	M85
6173074	T838NC07500-10R2B-D6 KSU31	M85
6173075	T838NF07500-16R2B-D4 KSP39	M85
6173076	T838NF07500-16R2B-D4 KSU31	M85
6173077	T838NC08750-9R2B-D6 KSP39	M86
6173078	T838NC08750-9R2B-D6 KSU31	M86
6173079	T838NF08750-14R2B-D4 KSP39	M86
6173080	T838NF08750-14R2B-D4 KSU31	M86
6173081	T838NC10000-8R2B-D6 KSP39	M86
6173082	T838NC10000-8R2B-D6 KSU31	M86
6173083	T838NF10000-12R2B-D4 KSP39	M86
6173084	T838NF10000-12R2B-D4 KSU31	M86
6173085	T838NC11250-7R2B-D6 KSP39	M86
6173086	T838NC11250-7R2B-D6 KSU31	M86
6173087	T838NF11250-12R2B-D4 KSP39	M86
6173088	T838NF11250-12R2B-D4 KSU31	M86
6173089	T838NC12500-7R2B-D6 KSP39	M86
6173090	T838NC12500-7R2B-D6 KSU31	M86
6173091	T838NF12500-12R2B-D4 KSP39	M86
6173092	T838NF12500-12R2B-D4 KSU31	M86
6173093	T838NC13750-6R2B-D6 KSP39	M86
6173094	T838NC13750-6R2B-D6 KSU31	M86
6173095	T838NF13750-12R2B-D4 KSP39	M86
6173096	T838NF13750-12R2B-D4 KSU31	M86
6173097	T838NC15000-6R2B-D6 KSP39	M86
6173098	T838NC15000-6R2B-D6 KSU31	M86
6173099	T838NF15000-12R2B-D4 KSP39	M86
6173100	T838NF15000-12R2B-D4 KSU31	M86
6173101	T838NC17500-5R2B-D6 KSP39	M86
6173102	T838NC17500-5R2B-D6 KSU31	M86
6173103	T838NC20000-4,5R2B-D6 KSP39	M86
6173104	T838NC20000-4,5R2B-D6 KSU31	M86
6173111	T838M160X200R6H-D6 KSU31	M95
6173112	T838MF180X150R6H-D4 KSP39	M95
6173113	T838MF180X150R6H-D4 KSU31	M95
6173114	T838MF180X200R6H-D4 KSP39	M96
6173115	T838MF180X200R6H-D4 KSU31	M96
6173116	T838M180X250R6H-D6 KSP39	M96
6173117	T838M180X250R6H-D6 KSU31	M96
6173118	T838MF200X150R6H-D4 KSP39	M96
6173119	T838MF200X150R6H-D4 KSU31	M96
6173120	T838MF200X200R6H-D4 KSP39	M96
6173131	T838MF200X200R6H-D4 KSU31	M96
6173132	T838M200X250R6H-D6 KSP39	M96
6173133	T838M200X250R6H-D6 KSU31	M96
6173134	T838MF220X150R6H-D4 KSP39	M96
6173135	T838MF220X150R6H-D4 KSU31	M96
6173136	T838MF220X200R6H-D4 KSP39	M96
6173137	T838MF220X200R6H-D4 KSU31	M96
6173138	T838M220X250R6H-D6 KSP39	M96
6173139	T838M220X250R6H-D6 KSU31	M96
6173140	T838MF240X150R6H-D4 KSP39	M96
6173141	T838MF240X150R6H-D4 KSU31	M96
6173142	T838MF240X200R6H-D4 KSP39	M96
6173143	T838MF240X200R6H-D4 KSU31	M96
6173144	T838M240X300R6H-D6 KSP39	M96
6173145	T838M240X300R6H-D6 KSU31	M96
6173146	T838MF270X150R6H-D4 KSP39	M96
6173147	T838MF270X150R6H-D4 KSU31	M96
6173148	T838MF270X300R6H-D6 KSP39	M96
6173149	T838M270X300R6H-D6 KSU31	M96
6173150	T838MF300X150R6H-D4 KSP39	M96
6173151	T838MF300X150R6H-D4 KSU31	M96
6173152	T838MF300X200R6H-D4 KSP39	M96
6173153	T838MF300X200R6H-D4 KSU31	M96
6173154	T838M300X350R6H-D6 KSP39	M96
6173155	T838M300X350R6H-D6 KSU31	M96
6173156	T838M330X350R6H-D6 KSP39	M96
6173157	T838M330X350R6H-D6 KSU31	M96
6173158	T838M360X400R6H-D6 KSP39	M96
6173159	T838M360X400R6H-D6 KSU31	M96
6173160	T838M390X400R6H-D6 KSP39	M96
6173171	T838M390X400R6H-D6 KSU31	M96
6173172	T838M420X450R6H-D6 KSP39	M96
6173173	T838M420X450R6H-D6 KSU31	M96
6173174	T838M450X450R6H-D6 KSP39	M96
6173175	T838M450X450R6H-D6 KSU31	M96
6173176	T838M480X500R6H-D6 KSP39	M96
6173177	T838M480X500R6H-D6 KSU31	M96
6173178	T838M520X500R6H-D6 KSP39	M96
6173179	T838M520X500R6H-D6 KSU31	M96
6173240	T838NC#06-32R2B-D1 KSP39	M85
6173261	T838NC#06-32R2B-D1 KSU31	M85
6173262	T838NF#06-40R2B-D1 KSP39	M85
6173263	T838NF#06-40R2B-D1 KSU31	M85
6173264	T838NC#08-32R2B-D1 KSP39	M85
6173265	T838NC#08-32R2B-D1 KSU31	M85
6173266	T838NF#08-36R2B-D1 KSP39	M85
6173267	T838NF#08-36R2B-D1 KSU31	M85
6173268	T838NC#10-24R2B-D1 KSP39	M85
6173269	T838NC#10-24R2B-D1 KSU31	M85
6173270	T838NF#10-32R2B-D1 KSP39	M85
6173271	T838NF#10-32R2B-D1 KSU31	M85
6173272	T838NC#12-24R2B-D1 KSP39	M85
6173273	T838NC#12-24R2B-D1 KSU31	M85
6173274	T838NF#12-28R2B-D1 KSP39	M85
6173275	T838NF#12-28R2B-D1 KSU31	M85
6173276	T838NC02500-20R2B-D1 KSP39	M85
6173277	T838NC02500-20R2B-D1 KSU31	M85
6173278	T838NC02500-20R2B-D6 KSP39	M85
6173279	T838NC02500-20R2B-D6 KSU31	M85
6173280	T838NF02500-28R2B-D1 KSP39	M85
6173281	T838NF02500-28R2B-D1 KSU31	M85
6173282	T838NF02500-28R2B-D4 KSP39	M85
6173283	T838NF02500-28R2B-D4 KSU31	M85
6173284	T838NC03125-18R2B-D1 KSP39	M85
6173285	T838NC03125-18R2B-D1 KSU31	M85
6173286	T838NC03125-18R2B-D6 KSP39	M85
6173287	T838NC03125-18R2B-D6 KSU31	M85
6173288	T838NF03125-24R2B-D4 KSP39	M85
6173289	T838NF03125-24R2B-D4 KSU31	M85
6173290	T838NC03750-16R2B-D1 KSP39	M85
6173301	T838NC03750-16R2B-D1 KSU31	M85
6173302	T838NC03750-16R2B-D6 KSP39	M85
6173303	T838NC03750-16R2B-D6 KSU31	M85
6173304	T838NF03750-24R2B-D4 KSP39	M85
6173305	T838NF03750-24R2B-D4 KSU31	M85
6173306	T838NC04375-14R2B-D6 KSP39	M85
6173307	T838NC04375-14R2B-D6 KSU31	M85
6173308	T838NF04375-20R2B-D4 KSP39	M85
6173309	T838NF04375-20R2B-D4 KSU31	M85
6173310	T838NC05000-13R2B-D6 KSP39	M85
6173311	T838NC05000-13R2B-D6 KSU31	M85
6173312	T838NF05000-20R2B-D4 KSP39	M85
6173313	T838NF05000-20R2B-D4 KSU31	M85
6173786	LNPU763PNSRHD2 KCSM40	S99, S101
6175756	EP1008EHD KCSM40	T36
6175757	EP1012EHD KCSM40	T36
6175758	EP1016EHD KCSM40	T36
6175759	EP1020EHD KCSM40	T36
6175760	EP1024EHD KCSM40	T36
6176091	EP1031EHD KCSM40	T36
6176092	EP1008SGE KCSM40	T37
6176093	EP1012SGE KCSM40	T37
6176094	EP1016SGE KCSM40	T37
6176095	EP1031SGE KCSM40	T37
6176096	EC1008ELD KCSM40	T36
6176097	EC1012ELD KCSM40	T36
6176098	EC1016ELD KCSM40	T36
6176099	EC1024ELD KCSM40	T36
6176100	EC1031ELD KCSM40	T36
6177823	SNHJ442SNGD KCSM40	S59
6177924	OFKT53AFEN6LB KCSM40	S47
6177925	OFKT53AFEN4GB KCSM40	S47
6177926	OFKT53AFSN4HB KCSM40	S47
6177927	OFPT53AFSN4HB KCSM40	S48
6177928	OFKT64AFEN6LB KCSM40	S51
6177929	OFKT64AFEN6GB KCSM40	S52
6177930	OFKT64AFSN6HB KCSM40	S52
6178011	OFPT64AFSN6HB KCSM40	S52
6178103	HNGJ535ANENLD KCSM40	S18, S21
6178104	HNGJ535ANSNGD KCSM40	S18, S22
6178105	HNGJ535ANSNHD KCSM40	S19, S22
6178106	HNGJ53511ANSNHD KCSM40	S19, S22
6178107	XNGJ535ANSNGD3W KCSM40	S21
6178108	HNPJ535ANSNHD KCSM40	S19, S23
6178109	HNPJ53511ANSNHD KCSM40	S19, S23
6178110	HNPJ75ANSNHD KCSM40	S26
6178121	LNPU863ANSRHD2 KCSM40	S95
6178232	DFT030304GD KC7140	J101
6178233	DFT05T308GD KC7140	J101
6178234	DFT06T308GD KC7140	J101
6178235	DFT070408GD KC7140	J101
6178236	DFT090508GD KC7140	J101
6178237	SDHT120412EN422 KCSM40	T132
6178238	SDHT120412EN423 KCSM40	T132
6178239	SDMT120412EN41 KCSM40	T133
6178240	SDMW120412TN KCSM40	T133
6178251	SDHT09T308EN422 KCSM40	T129
6178252	SDHT09T308EN423 KCSM40	T129
6178253	SDMT09T308EN41 KCSM40	T130
6178254	SDMW09T308TN KCSM40	T130
6179398	EVSCTR081B16	C38
6179399	EVSCTR081F16	C38

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6179400	EVSCTR080216	C38
6179709	EVSCFL1010K1B10	C45
6179710	EVSCFL1010K1F10	C45
6179721	EVSCTR080316C	C38
6179722	EVSCTL081B16	C38
6179723	EVSCTL081F16	C38
6179724	EVSCTL080216	C38
6179725	EVSCTL080316C	C39
6179726	EVSCFL061B10	C43
6179727	EVSCFL061F10	C43
6179728	EVSCFL060210	C43
6179729	EVSCFL081B10	C43
6179730	EVSCFL081B13	C43
6179731	EVSCFL081F10	C43
6179732	EVSCFL081F13	C43
6179733	EVSCFL080210	C43
6179734	EVSCFL080216	C43
6179735	EVSCFL080310C	C43
6179736	EVSCFL080316C	C43
6179737	EVSCFL101B16	C43
6179738	EVSCFL101F16	C43
6179739	EVSCFL100216	C43
6179740	EVSCFL100316C	C43
6179751	EVSCFL121B16	C43
6179752	EVSCFL121F16	C43
6179753	EVSCFL120216	C43
6179754	EVSCFL120316C	C43
6179755	EVSCTR1212K0316C	C40
6179756	EVSCTL1212K0316C	C41
6179757	EVSCTR1212K1B16	C40
6179758	EVSCTR1212K1F16	C40
6179759	EVSCTR1212K0216	C40
6179760	EVSCTL1212K1B16	C41
6179761	EVSCTL1212K1F16	C41
6179762	EVSCTL1212K0216	C41
6179763	EVSCFR1010K1B10	C44
6179764	EVSCFR1010K1F10	C44
6179765	EVSCFR1010K0210	C44
6179766	EVSCFR1212K1B10	C44
6179767	EVSCFR1212K1B13	C44
6179768	EVSCFR1212K1F10	C44
6179769	EVSCFR1212K1F13	C44
6179770	EVSCFR1212K0210	C44
6179771	EVSCFR1212K0216	C44
6179772	EVSCFR1212K0310C	C44
6179773	EVSCFR1212K0316C	C44
6179774	EVSCFR1616K1B16	C44
6179775	EVSCFR1616K1F16	C44
6179776	EVSCFR1616K0216	C44
6179777	EVSCFR1616K0316C	C44
6179778	EVSCFR2020K1B16	C44
6179779	EVSCFR2020K1F16	C44
6179780	EVSCFR2020K0216	C44
6179781	EVSCFR2020K0316C	C44
6179921	EVSCFL1010K0210	C45
6179922	EVSCFL1212K1B10	C45
6179923	EVSCFL1212K1B13	C45
6179924	EVSCFL1212K1F10	C45
6179925	EVSCFL1212K1F13	C45
6179926	EVSCFL1212K0210	C45
6179927	EVSCFL1212K0216	C45
6179928	EVSCFL1212K0310C	C45
6179929	EVSCFL1212K0316C	C45
6179930	EVSCFL1616K1B16	C45
6179931	EVSCFL1616K1F16	C45
6179932	EVSCFL1616K0216	C45
6179933	EVSCFL1616K0316C	C45
6179934	EVSCFL2020K1B16	C45
6179935	EVSCFL2020K1F16	C45
6179936	EVSCFL2020K0216	C45
6179937	EVSCFL2020K0316C	C45
6180116	EVSCFR061B10	C42
6180117	EVSCFR061F10	C42
6180118	EVSCFR060210	C42
6180119	EVSCFR081B10	C42
6180120	EVSCFR081B13	C42
6180121	EVSCFR081F10	C42
6180124	EVSCFR081F13	C42
6180125	EVSCFR080210	C42
6180126	EVSCFR080216	C42
6180127	EVSCFR080310C	C42
6180128	EVSCFR080316C	C42
6180129	EVSCFR101B16	C42
6180130	EVSCFR101F16	C42
6180141	EVSCFR100216	C42
6180142	EVSCFR100316C	C42
6180143	EVSCFR121B16	C42
6180144	EVSCFR121F16	C42
6180146	EVSCFR120216	C42
6180147	EVSCFR120316C	C42
6180436	DNMG333CT KCP10B	B79
6181213	LNUX191940S-WT5 KCP25B	E59
6181214	NPR13M05F KCP25B	E36
6181215	SNMX190640S-WT5 KCP25B	E59
6181216	NPR5M05 KCP25B	E36
6181217	NPR13M05N KCP25B	E35
6181311	CNMM190740RRP KCP10B	E59
6181316	RCMX2507M076 KCP25B	E59
6183779	RIQB6C4500S KBHK10	K59
6183780	RIQB7C4500S KBHK10	K59
6183831	RIQ07C4500S KBHK10	K59
6183832	RIQ08C4500S KBHK10	K59
6183833	RIQ09C4500S KBHK10	K59
6183834	RIQB6C4500S KBHK15	K59
6183836	RIQB7C4500S KBHK15	K59
6183837	RIQ07C4500S KBHK15	K59
6183838	RIQ08C4500S KBHK15	K59
6183839	RIQ09C4500S KBHK15	K59
6185769	XPPT060308ERD41 KCSM40	V7
6185770	XEPT160512ERD41 KCSM40	V28
6185921	XDPT090408ERD41 KCSM40	V15
6185922	XDPT090412ERD411 KCSM40	V15
6187383	SDPT43PDER8GB2 KCSM40	T116, T123, U39
6187384	SDPT43PDSR8GB2 KCSM40	T116, T123, U39
6187511	XPPW060310SRD KCPM40	V7
6187512	XPPW060310SRD KCPK30	V7
6187513	XPPW060310SRD KC522M	V7
6187514	XPPW060310SRD KC510M	V7
6187535	XDPW090412SRD KCPM40	V15
6187536	XDPW090412SRD KCPK30	V15
6187537	XDPW090412SRD KCK15	V15
6187538	XDPW090412SRD KC522M	V15
6187539	XDPW090412SRD KC510M	V15
6187714	XEPW160520SRD KCPM40	V28
6187715	XEPW160520SRD KCPK30	V28
6187716	XEPW160520SRD KCK15	V28
6187717	XEPW160520SRD KC522M	V28
6187806	XDPT120508ERD41 KCSM40	V22
6187808	XDPT120512ERD411 KCSM40	V22
6191237	KSDR100031E0W0S KD1400	S105
6191238	KSDR100031E0W0S KD1425	S105
6191358	RCGT64ELF KCSM40	V89
6191359	RCGT64SHF KCSM40	V89
6191360	RCGT86ELF KCSM40	V92
6191511	RCGT86SHF KCSM40	V92
6191557	XEPT160516ERD41 KCPM40	V28
6191558	XEPT160516ERD41 KCPK30	V28
6191559	XEPT160516ERD41 KC522M	V28
6191642	XDPT090412SRGP KCPM40	V16
6191643	XDPT090412SRGP KCPK30	V16
6191644	XDPT090412SRGP KC725M	V16
6191645	XDPT090412SRGP KC522M	V16
6197561	DTQ50140	S30
6200729	LNGU434SRGEM KCK15	T10
6200730	LNGU434SRGEM KCPK30	T10
6201021	LNGU434SRGEM KC520M	T10
6201022	LNGU434SRGEM KCPM40	T10
6201279	LNGU431SRGE KC522M	T9
6201280	LNGU431SRGE KCPM40	T9
6201291	LNGU431SRGE KCSM40	T9
6201292	LNGU431ERLEJ KC422M	T8
6201351	LNGU433ERGE KCSM40	T9
6201352	LNGU433ERGE KC522M	T9
6201353	LNGU433ERGE KCPM40	T9
6201354	LNGU432ERGE KCSM40	T9
6201903	M4D100L1104C075L450	T6
6201904	M4D125L1105C100L500	T6
6202190	MILL16E1200Z420N08WSC	S31
6202291	MILL16E1400Z480N08WSC	S31
6202292	MILL16E1600Z560N08WSC	S31
6202293	MILL16E2000Z700N08WSC	S31
6202335	K1200Z328RF60HN09WSC	S82
6202340	ONPX642SNGP KCK20	S34
6202371	ONPX645SNHB KCK20	S34
6205876	BTQSW3L90	S30
6214774	M4-11KITD062Z2W062SGEKCPM40	T11
6214775	M4-11KITD062Z2C062SGEKCPM40	T11
6214776	M4-11KITD075Z2W075SGEKCPM40	T11
6214777	M4-11KITD075Z3W075SGEKCPM40	T11
6214778	M4-11KITD075Z3C075SGEKCPM40	T11
6214779	M4-11KITD100Z3W100SGEKCPM40	T11
6214780	M4-11KITD100Z4C100SGEKCPM40	T11
6214801	M4-11KITD125Z4W125SGEKCPM40	T11
6214802	M4-11KITD125Z5C125SGEKCPM40	T11
6214803	M4-11KITD150Z5S050SGEKCPM40	T11
6214804	M4-11KITD200Z5S075SGEKCPM40	T11
6214805	M4-11KITD200Z7S075SGEKCPM40	T11
6214806	M4-11KITD062Z2W062SGEKC725M	T11
6214807	M4-11KITD062Z2C062SGEKC725M	T11
6214808	M4-11KITD075Z3W075SGEKC725M	T11
6214809	M4-11KITD075Z3C075SGEKC725M	T11
6214810	M4-11KITD100Z3W100SGEKC725M	T11
6214821	M4-11KITD100Z4C100SGEKC725M	T11
6214822	M4-11KITD125Z4W125SGEKC725M	T11
6214823	M4-11KITD125Z5C125SGEKC725M	T11
6214824	M4-11KITD150Z5S050SGEKC725M	T11
6214825	M4-11KITD200Z5S075SGEKC725M	T11
6214826	M4-11KITD200Z7S075SGEKC725M	T11
6226803	LNUX191940RRSM KCP25B	E58
6228171	NG2031L KCK20B	C170
6228172	NG2031R KCK20B	C170
6228173	NG2041L KCK20B	C170
6228174	NG2041R KCK20B	C170
6228175	NG2047R KCK20B	C170
6228176	NG2062L KCK20B	C170
6228177	NG2062R KCK20B	C170
6228178	NG2094L KCK20B	C170
6228179	NG2094R KCK20B	C170
6228180	NG2125L KCK20B	C170
6228181	NG3047L KCK20B	C170
6228182	NG3047R KCK20B	C170
6228183	NG3062L KCK20B	C170
6228184	NG3062R KCK20B	C170
6228185	NG3072R KCK20B	C170
6228186	NG3078R KCK20B	C170
6228187	NG3088R KCK20B	C170
6228188	NG3094L KCK20B	C170
6228189	NG3094R KCK20B	C170
6228190	NG3097R KCK20B	C170
6228191	NG3105R KCK20B	C170
6228192	NG3125L KCK20B	C171
6228193	NG3125R KCK20B	C170
6228194	NG3156R KCK20B	C170
6228195	NG3189L KCK20B	C171
6228196	NG3189R KCK20B	C170
6228197	NG4125R KCK20B	C170
6228198	NG4189L KCK20B	C171
6228199	NG4189R KCK20B	C170
6228200	NG4250L KCK20B	C171
6228201	NG4250R KCK20B	C170
6231686	EG094I02U05GUN KCU10	C21
6231687	EG125I03U05GUN KCU10	C21
6231688	EG125I03U1GUN KCU10	C21
6231689	EG187I04U1GUN KCU10	C21
6231690	EG187I04U2GUN KCU10	C21
6231851	EG250I06U1GUN KCU10	C21
6231852	EG250I06U2GUN KCU10	C21
6231853	EG312I08U3GUN KCU10	C21
6231854	EG375I10U3GUN KCU10	C21
6231855	EG094I02U05GUN KCU25	C21
6231856	EG125I03U05GUN KCU25	C21
6231857	EG125I03U1GUN KCU25	C21
6231858	EG187I04U1GUN KCU25	C21
6231859	EG187I04U2GUN KCU25	C21
6231860	EG250I06U1GUN KCU25	C21
6231861	EG250I06U2GUN KCU25	C21
6231862	EG312I08U3GUN KCU25	C21
6231863	EG375I10U3GUN KCU25	C21
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6295951	DNGA441S0415MT KBH10	B334
6295952	DNGA442S0415MT KBH10	B334

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6295953	DNGA443S0415MT KBH10	B334
6295954	DNGA442S0525MT KBH10	B334
6295955	DNGA443S0525MT KBH10	B334
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6350579	B212A06630SGL KCMS15	G31
6350580	B212A06800SGL KCMS15	G31
6350591	B212A07000SGL KCMS15	G31
6350592	B212A07500SGL KCMS15	G31
6350593	B212A07800SGL KCMS15	G31
6350594	B212A08000SGL KCMS15	G31

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6350595	B212A08400SGL KCMS15	G31
6350596	B212A08500SGL KCMS15	G31
6350597	B212A08800SGL KCMS15	G32
6350598	B212A09000SGL KCMS15	G32
6350599	B212A09500SGL KCMS15	G32
6350600	B212A10000SGL KCMS15	G32
6350601	B212A10200SGL KCMS15	G32
6350602	B212A10500SGL KCMS15	G32
6350603	B212A11000SGL KCMS15	G32
6350604	B212A11800SGL KCMS15	G32
6350605	B212A12000SGL KCMS15	G32
6350606	B212A12500SGL KCMS15	G32
6350607	B212A13000SGL KCMS15	G32
6350608	B212A13500SGL KCMS15	G32
6350609	B212A14000SGL KCMS15	G32
6351164	B271Z02500SGL KCMS20	G68
6351166	B271Z03000SGL KCMS20	G68
6351168	B271Z03175SGL KCMS20	G68
6351170	B271Z03500SGL KCMS20	G68
6351172	B271Z03970SGL KCMS20	G68
6351174	B271Z04000SGL KCMS20	G68
6351176	B271Z04500SGL KCMS20	G68
6351178	B271Z04763SGL KCMS20	G68
6351179	B273Z02500SGL KCMS20	G72
6351191	B271Z04800SGL KCMS20	G68
6351192	B273Z03000SGL KCMS20	G72
6351194	B271Z05000SGL KCMS20	G68
6351195	B273Z03175SGL KCMS20	G72
6351197	B271Z05500SGL KCMS20	G68
6351198	B273Z03500SGL KCMS20	G72
6351200	B271Z05558SGL KCMS20	G68
6351201	B273Z04000SGL KCMS20	G72
6351203	B271Z06000SGL KCMS20	G68
6351204	B273Z04500SGL KCMS20	G72
6351206	B271Z06350SGL KCMS20	G68
6351207	B273Z05000SGL KCMS20	G72
6351209	B271Z06500SGL KCMS20	G69
6351210	B273Z05500SGL KCMS20	G72
6351212	B271Z06746SGL KCMS20	G69
6351213	B273Z06000SGL KCMS20	G72
6351215	B271Z07000SGL KCMS20	G69
6351216	B273Z06500SGL KCMS20	G72
6351218	B271Z07145SGL KCMS20	G69
6351219	B273Z07000SGL KCMS20	G72
6351221	B271Z07500SGL KCMS20	G69
6351222	B273Z08000SGL KCMS20	G72
6351224	B271Z07938SGL KCMS20	G69
6351225	B273Z08500SGL KCMS20	G72
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6351228	B273Z09000SGL KCMS20	G72
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6351233	B271Z08733SGL KCMS20	G69
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6351236	B271Z09000SGL KCMS20	G69
6351237	B273Z12000SGL KCMS20	G72
6351239	B271Z09525SGL KCMS20	G69
6351240	B273Z13000SGL KCMS20	G72
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6351243	B273Z13500SGL KCMS20	G72
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6351246	B273Z14000SGL KCMS20	G72
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6351252	B273Z16000SGL KCMS20	G72
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6351258	B274Z03000SGL KCMS20	G73
6351260	B271Z12000SGL KCMS20	G69
6351261	B274Z03175SGL KCMS20	G73
6351263	B271Z12700SGL KCMS20	G69
6351264	B274Z03500SGL KCMS20	G73
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6351284	B272Z03175SGL KCMS20	G70
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6351307	B274Z06500SGL KCMS20	G73
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6351464	B275Z11000SGL KCMS20	G75
6353749	TNMG544RP KCU10	B127
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6358124	B210A03175SGL KCMS15	G30
6358125	B210A03200SGL KCMS15	G30
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6358146	B210A04366SGL KCMS15	G30
6358147	B210A04500SGL KCMS15	G30
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6358150	B210A04900SGL KCMS15	G31
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6358152	B210A05100SGL KCMS15	G31
6358153	B210A05106SGL KCMS15	G31
6358154	B210A05159SGL KCMS15	G31
6358155	B210A05200SGL KCMS15	G31
6358156	B210A05300SGL KCMS15	G31
6358157	B210A05400SGL KCMS15	G31
6358158	B210A05500SGL KCMS15	G31
6358159	B210A05616SGL KCMS15	G31
6358160	B210A05800SGL KCMS15	G31
6358161	B210A05954SGL KCMS15	G31
6358162	B210A06000SGL KCMS15	G31
6358163	B210A06100SGL KCMS15	G31
6358164	B210A06200SGL KCMS15	G31
6358165	B210A06300SGL KCMS15	G31
6358166	B210A06350SGL KCMS15	G31
6358167	B210A06400SGL KCMS15	G31
6358168	B210A06500SGL KCMS15	G31
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6358182	B210A08400SGL KCMS15	G31
6358183	B210A08433SGL KCMS15	G31
6358184	B210A08500SGL KCMS15	G31
6358185	B210A08600SGL KCMS15	G31
6358186	B210A08700SGL KCMS15	G32
6358187	B210A08800SGL KCMS15	G32
6358188	B210A09000SGL KCMS15	G32
6358189	B210A09093SGL KCMS15	G32
6358190	B210A09500SGL KCMS15	G32
6358191	B210A09700SGL KCMS15	G32
6358192	B210A09800SGL KCMS15	G32
6358193	B210A09921SGL KCMS15	G32
6358194	B210A10000SGL KCMS15	G32
6358195	B210A10200SGL KCMS15	G32
6358196	B210A10400SGL KCMS15	G32
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6358198	B210A10716SGL KCMS15	G32
6358199	B210A10800SGL KCMS15	G32
6358200	B210A11000SGL KCMS15	G32
6358201	B210A11200SGL KCMS15	G32
6358202	B210A11500SGL KCMS15	G32
6358203	B210A11509SGL KCMS15	G32
6358204	B210A12000SGL KCMS15	G32
6358205	B210A12200SGL KCMS15	G32
6358206	B210A12304SGL KCMS15	G32
6358207	B210A12500SGL KCMS15	G32
6358208	B210A12700SGL KCMS15	G32
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6358210	B210A13000SGL KCMS15	G32
6358211	B210A13495SGL KCMS15	G32
6358212	B210A13500SGL KCMS15	G32
6358213	B210A14000SGL KCMS15	G32
6358214	B210A14100SGL KCMS15	G32
6358215	B210A14200SGL KCMS15	G33
6358216	B210A14500SGL KCMS15	G33
6358217	B210A15000SGL KCMS15	G33
6358218	B210A15500SGL KCMS15	G33
6358219	B210A15875SGL KCMS15	G33
6358220	B210A16000SGL KCMS15	G33
6358221	B210A16129SGL KCMS15	G33
6358222	B210A16500SGL KCMS15	G33
6358223	B210A16670SGL KCMS15	G33
6358224	B210A17000SGL KCMS15	G33
6358225	B210A17500SGL KCMS15	G33
6358226	B210A18000SGL KCMS15	G33
6358227	B210A18500SGL KCMS15	G33
6358228	B210A19050SGL KCMS15	G33
6358229	B210A19500SGL KCMS15	G33
6358230	B210A20000SGL KCMS15	G33
6358241	B210Z02500SGL KCMS15	G30
6358971	B941Z02500 KCH10	G124
6358972	B941A03000 KCH10	G124
6358973	B941A03300 KCH10	G124
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6358995	B941A10400 KCH10	G124
6358996	B941A10500 KCH10	G124
6358997	B941A11100 KCH10	G124
6358998	B941A12000 KCH10	G124
6358999	B941A14000 KCH10	G124
6359000	B951A03000 KCH10	G125
6359011	B951A03175 KCH10	G125
6359012	B951A03454 KCH10	G125
6359013	B951A03500 KCH10	G125
6359014	B951A03800 KCH10	G125
6359015	B951A04000 KCH10	G125
6359016	B951A04100 KCH10	G125
6359017	B951A04200 KCH10	G125
6359018	B951A04300 KCH10	G125
6359019	B951A04500 KCH10	G125
6359020	B951A04800 KCH10	G125
6359021	B951A04900 KCH10	G125
6359022	B951A05000 KCH10	G125
6359023	B951A05500 KCH10	G125
6359024	B951A05800 KCH10	G125

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6359025	B951A06000 KCH10	G125
6359026	B951A06350 KCH10	G125
6359027	B951A06500 KCH10	G125
6359028	B951A06800 KCH10	G125
6359029	B951A07000 KCH10	G125
6359030	B951A08000 KCH10	G125
6359031	B951A08500 KCH10	G125
6359032	B951A09000 KCH10	G125
6359033	B951A09500 KCH10	G125
6359034	B951A09800 KCH10	G125
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6359051	B951A16000 KCH10	G126
6370147	KTFST16000HPCM KC7410	H13
6370148	KTFST06340HPC KC7410	H13
6370149	KTFST16100HPCM KC7410	H13
6370150	KTFST16200HPCM KC7410	H13
6370351	KTFST06406HPC KC7410	H13
6370352	KTFST16300HPCM KC7410	H13
6370353	KTFST16500HPCM KC7410	H13
6370354	KTFST16550HPCM KC7410	H13
6370355	KTFST16600HPCM KC7410	H13
6370356	KTFST06563HPC KC7410	H13
6370357	KTFST17000HPCM KC7410	H13
6370358	KTFST06719HPC KC7410	H13
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6370362	KTFST06875HPC KC7410	H13
6370363	KTFST17500HPCM KC7410	H13
6370364	KTFST17550HPCM KC7410	H13
6370365	KTFST17600HPCM KC7410	H13
6370366	KTFST17700HPCM KC7410	H13
6370367	KTFST17800HPCM KC7410	H13
6370368	KTFST18000HPCM KC7410	H13
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6370370	KTFST07188HPC KC7410	H13
6370381	KTFST18500HPCM KC7410	H13
6370382	KTFST18600HPCM KC7410	H13
6370383	KTFST18700HPCM KC7410	H13
6370384	KTFST19000HPCM KC7410	H13
6370385	KTFST07500HPC KC7410	H13
6370386	KTFST07590HPC KC7410	H13
6370387	KTFST07656HPC KC7410	H13
6370388	KTFST19500HPCM KC7410	H13
6370389	KTFST19800HPCM KC7410	H13
6370390	KTFST20000HPCM KC7410	H13
6370401	KTFST07969HPC KC7410	H13
6370402	KTFST20300HPCM KC7410	H13
6370403	KTFST20500HPCM KC7410	H13
6370404	KTFST08125HPC KC7410	H13
6370405	KTFST21000HPCM KC7410	H13
6370406	KTFST08438HPC KC7410	H13
6370407	KTFST21500HPCM KC7410	H13
6370408	KTFST22000HPCM KC7410	H13
6370409	KTFST08750HPC KC7410	H13
6370410	KTFST22440HPCM KC7410	H13
6370411	KTFST22500HPCM KC7410	H13
6370412	KTFST23000HPCM KC7410	H13
6370413	KTFST09219HPC KC7410	H13
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6370417	KTFST24500HPCM KC7410	H13
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6370419	KTFST25000HPCM KC7410	H13
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6370421	KTFST10000HPC KC7410	H13
6370422	KTFST25500HPCM KC7410	H13
6370423	KTFST10110HPC KC7410	H13
6370424	KTFST10160HPC KC7410	H13
6370425	KTFST26000HPCM KC7410	H13
6370700	KTFST06000HPCM KC7410	H12
6370871	KTFST06200HPCM KC7410	H12
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6370875	KTFST02656HPC KC7410	H12
6370876	KTFST06700HPCM KC7410	H12
6370877	KTFST06800HPCM KC7410	H12
6370878	KTFST07000HPCM KC7410	H12
6370879	KTFST02813HPC KC7410	H12
6370880	KTFST07300HPCM KC7410	H12
6370881	KTFST07500HPCM KC7410	H12
6370882	KTFST07600HPCM KC7410	H12
6370883	KTFST07800HPCM KC7410	H12
6370884	KTFST03125HPC KC7410	H12
6370885	KTFST08000HPCM KC7410	H12
6370886	KTFST08100HPCM KC7410	H12
6370887	KTFST03230HPC KC7410	H12
6370888	KTFST08500HPCM KC7410	H12
6370889	KTFST08600HPCM KC7410	H12
6370890	KTFST08700HPCM KC7410	H12
6370891	KTFST03438HPC KC7410	H12
6370892	KTFST09000HPCM KC7410	H12
6370893	KTFST09100HPCM KC7410	H12
6370894	KTFST09500HPCM KC7410	H12
6370895	KTFST03750HPC KC7410	H12
6370896	KTFST09600HPCM KC7410	H12
6370897	KTFST09700HPCM KC7410	H12
6370898	KTFST09800HPCM KC7410	H12
6370899	KTFST03906HPC KC7410	H12
6370900	KTFST10000HPCM KC7410	H12
6370901	KTFST03946HPC KC7410	H12
6370902	KTFST10200HPCM KC7410	H12
6370903	KTFST10300HPCM KC7410	H12
6370904	KTFST04063HPC KC7410	H12
6370905	KTFST10500HPCM KC7410	H12
6370906	KTFST16000HPLM KCMS15	H16
6370907	KTFST06340HPL KCMS15	H16
6370908	KTFST10600HPCM KC7410	H12
6370909	KTFST16100HPLM KCMS15	H16
6370910	KTFST10700HPCM KC7410	H12
6370911	KTFST16150HPLM KCMS15	H16
6370912	KTFST04219HPC KC7410	H12
6370913	KTFST06406HPL KCMS15	H16
6370914	KTFST10800HPCM KC7410	H12
6370915	KTFST11000HPCM KC7410	H12
6370916	KTFST16500HPLM KCMS15	H16
6370917	KTFST11100HPCM KC7410	H12
6370918	KTFST06563HPL KCMS15	H16
6370919	KTFST04375HPC KC7410	H12
6370920	KTFST17000HPLM KCMS15	H16
6370921	KTFST11400HPCM KC7410	H12
6370922	KTFST06875HPL KCMS15	H16
6370923	KTFST11500HPCM KC7410	H12
6370924	KTFST17480HPLM KCMS15	H16
6370925	KTFST11800HPCM KC7410	H12
6370926	KTFST17500HPLM KCMS15	H16
6370927	KTFST17700HPLM KCMS15	H16
6370928	KTFST04688HPC KC7410	H12
6370929	KTFST18000HPLM KCMS15	H16
6370930	KTFST12000HPCM KC7410	H12
6370931	KTFST07188HPL KCMS15	H16
6370932	KTFST04844HPC KC7410	H12
6370933	KTFST18500HPLM KCMS15	H16
6370934	KTFST12500HPCM KC7410	H12
6370935	KTFST07344HPL KCMS15	H16
6370936	KTFST05000HPC KC7410	H12
6370937	KTFST19000HPLM KCMS15	H16
6370938	KTFST13000HPCM KC7410	H12
6370939	KTFST07500HPL KCMS15	H16
6370940	KTFST05156HPC KC7410	H12
6370941	KTFST19200HPLM KCMS15	H16
6370942	KTFST07570HPL KCMS15	H16
6370943	KTFST13200HPCM KC7410	H12
6370944	KTFST07580HPL KCMS15	H16
6370945	KTFST13300HPCM KC7410	H12
6370946	KTFST05312HPC KC7410	H12
6370947	KTFST07590HPL KCMS15	H16
6370948	KTFST13500HPCM KC7410	H12
6370949	KTFST07620HPL KCMS15	H16
6370950	KTFST13600HPCM KC7410	H12
6370951	KTFST07656HPL KCMS15	H16
6370952	KTFST13800HPCM KC7410	H12
6370953	KTFST19460HPLM KCMS15	H16
6370954	KTFST05469HPC KC7410	H12
6370955	KTFST19500HPLM KCMS15	H16
6370956	KTFST06000HPLM KCMS15	H15
6370957	KTFST07813HPL KCMS15	H16
6370958	KTFST14000HPCM KC7410	H12
6370959	KTFST19850HPLM KCMS15	H16
6370960	KTFST14100HPCM KC7410	H12
6370971	KTFST02500HPL KCMS15	H15
6370972	KTFST20000HPLM KCMS15	H16
6370973	KTFST05625HPC KC7410	H12
6370974	KTFST06500HPLM KCMS15	H15
6370975	KTFST20500HPLM KCMS15	H16
6370976	KTFST14500HPCM KC7410	H12
6370977	KTFST02610HPL KCMS15	H15
6370978	KTFST08125HPL KCMS15	H16
6370979	KTFST14600HPCM KC7410	H12
6370980	KTFST06800HPLM KCMS15	H15
6370981	KTFST21000HPLM KCMS15	H16
6370982	KTFST21150HPLM KCMS15	H16
6370983	KTFST07000HPLM KCMS15	H15
6370984	KTFST05781HPC KC7410	H12
6370985	KTFST21500HPLM KCMS15	H16
6370986	KTFST07500HPLM KCMS15	H15
6370987	KTFST07800HPLM KCMS15	H15
6370988	KTFST22000HPLM KCMS15	H16
6370989	KTFST14800HPCM KC7410	H12
6370990	KTFST03125HPL KCMS15	H15
6370991	KTFST08750HPL KCMS15	H16
6370992	KTFST08000HPLM KCMS15	H15
6370993	KTFST22500HPLM KCMS15	H16
6370994	KTFST08100HPLM KCMS15	H15
6370995	KTFST15000HPCM KC7410	H12
6370996	KTFST23000HPLM KCMS15	H16
6370997	KTFST03230HPL KCMS15	H15
6370998	KTFST05938HPC KC7410	H12
6370999	KTFST23500HPLM KCMS15	H16
6371000	KTFST03281HPL KCMS15	H15
6371001	KTFST15100HPCM KC7410	H12
6371002	KTFST09375HPL KCMS15	H16
6371003	KTFST08400HPLM KCMS15	H15
6371004	KTFST15200HPCM KC7410	H12
6371005	KTFST24000HPLM KCMS15	H16
6371006	KTFST08500HPLM KCMS15	H15
6371007	KTFST15300HPCM KC7410	H12
6371008	KTFST24500HPLM KCMS15	H16
6371009	KTFST08600HPLM KCMS15	H15
6371010	KTFST15500HPCM KC7410	H13
6371011	KTFST25000HPLM KCMS15	H16
6371012	KTFST08700HPLM KCMS15	H15
6371013	KTFST15600HPCM KC7410	H13
6371014	KTFST10000HPL KCMS15	H16
6371015	KTFST08800HPLM KCMS15	H15
6371016	KTFST15800HPCM KC7410	H13
6371017	KTFST25500HPLM KCMS15	H16
6371018	KTFST08900HPLM KCMS15	H15
6371019	KTFST06250HPC KC7410	H13
6371020	KTFST25600HPLM KCMS15	H16
6371031	KTFST09000HPLM KCMS15	H15
6371032	KTFST25650HPLM KCMS15	H16
6371033	KTFST09100HPLM KCMS15	H15
6371034	KTFST10110HPL KCMS15	H16
6371035	KTFST09200HPLM KCMS15	H15
6371036	KTFST10160HPL KCMS15	H16
6371037	KTFST09400HPLM KCMS15	H15
6371038	KTFST26000HPLM KCMS15	H16
6371039	KTFST09500HPLM KCMS15	H15
6371040	KTFST03763HPL KCMS15	H15
6371041	KTFST09600HPLM KCMS15	H15
6371042	KTFST09700HPLM KCMS15	H15
6371043	KTFST09800HPLM KCMS15	H15
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6371053	KTFST10700HPLM KCMS15	H15
6371054	KTFST10800HPLM KCMS15	H15
6371055	KTFST10900HPLM KCMS15	H15
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6371060	KTFST11400HPLM KCMS15	H15
6371061	KTFST11500HPLM KCMS15	H15
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6371063	KTFST11800HPLM KCMS15	H15
6371064	KTFST04688HPL KCMS15	H15
6371065	KTFST12000HPLM KCMS15	H15
6371066	KTFST12200HPLM KCMS15	H15
6371067	KTFST04844HPL KCMS15	H15
6371068	KTFST12500HPLM KCMS15	H15
6371069	KTFST05000HPL KCMS15	H15
6371070	KTFST12800HPLM KCMS15	H15
6371071	KTFST12900HPLM KCMS15	H15
6371072	KTFST13000HPLM KCMS15	H15
6371073	KTFST05156HPL KCMS15	H15
6371074	KTFST13200HPLM KCMS15	H15
6371075	KTFST05312HPL KCMS15	H15
6371076	KTFST13500HPLM KCMS15	H15
6371077	KTFST13800HPLM KCMS15	H15
6371078	KTFST05469HPL KCMS15	H15
6371079	KTFST05471HPL KCMS15	H15
6371080	KTFST14000HPLM KCMS15	H15
6371081	KTFST14100HPLM KCMS15	H15
6371082	KTFST14200HPLM KCMS15	H15
6371083	KTFST05625HPL KCMS15	H15
6371084	KTFST14300HPLM KCMS15	H15
6371085	KTFST14400HPLM KCMS15	H15
6371086	KTFST14500HPLM KCMS15	H15
6371087	KTFST05781HPL KCMS15	H15
6371088	KTFST14800HPLM KCMS15	H16
6371089	KTFST15000HPLM KCMS15	H16
6371090	KTFST15100HPLM KCMS15	H16
6371111	KTFST15200HPLM KCMS15	H16
6371112	KTFST15500HPLM KCMS15	H16
6371113	KTFST06250HPL KCMS15	H16
6371340	KTFS100R03SS12M	H18
6371961	KTFS105R03SS12M	H18
6371962	KTFS110R03SS12M	H18
6371963	KTFS115R03SS12M	H18
6371964	KTFS120R03SS14M	H18
6371965	KTFS125R03SS14M	H18
6371966	KTFS130R03SS14M	H18
6371967	KTFS135R03SS14M	H18
6371968	KTFS140R03SS16M	H18
6371969	KTFS145R03SS16M	H18
6371970	KTFS150R03SS16M	H18
6371971	KTFS160R03SS16M	H18
6371972	KTFS170R03SS20M	H18
6371973	KTFS100R05SS12M	H18
6371974	KTFS105R05SS12M	H18
6371975	KTFS110R05SS12M	H18
6371976	KTFS115R05SS12M	H18
6371977	KTFS120R05SS14M	H18
6371978	KTFS125R05SS14M	H18
6371979	KTFS130R05SS14M	H18
6371980	KTFS135R05SS14M	H18
6371981	KTFS140R05SS16M	H18
6371982	KTFS145R05SS16M	H18
6371983	KTFS150R05SS16M	H18
6371984	KTFS160R05SS16M	H18
6371985	KTFS170R05SS20M	H18
6371986	KTFS100R08SS12M	H18
6371987	KTFS105R08SS12M	H18
6371988	KTFS110R08SS12M	H18
6371989	KTFS115R08SS12M	H18
6371990	KTFS120R08SS14M	H18
6371991	KTFS125R08SS14M	H18
6371992	KTFS130R08SS14M	H18
6371993	KTFS135R08SS14M	H18
6371994	KTFS140R08SS16M	H18
6371995	KTFS145R08SS16M	H18
6371996	KTFS150R08SS16M	H18
6371997	KTFS160R08SS16M	H18

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6371999	KTFS170R08SS20M	H18
6372000	KTFS0394R03SS044	H20
6372011	KTFS0414R03SS044	H20
6372012	KTFS0434R03SS044	H20
6372013	KTFS0453R03SS050	H20
6372014	KTFS0473R03SS050	H20
6372015	KTFS0493R03SS050	H20
6372016	KTFS0512R03SS056	H20
6372017	KTFS0532R03SS056	H20
6372018	KTFS0552R03SS056	H20
6372019	KTFS0571R03SS063	H20
6372020	KTFS0591R03SS063	H20
6372021	KTFS0630R03SS063	H20
6372022	KTFS0670R03SS075	H20
6372023	KTFS0394R05SS044	H20
6372024	KTFS0414R05SS044	H20
6372025	KTFS0434R05SS044	H20
6372026	KTFS0453R05SS050	H20
6372027	KTFS0473R05SS050	H20
6372028	KTFS0493R05SS050	H20
6372029	KTFS0512R05SS056	H20
6372030	KTFS0532R05SS056	H20
6372051	KTFS0552R05SS056	H20
6372052	KTFS0571R05SS063	H20
6372053	KTFS0591R05SS063	H20
6372054	KTFS0630R05SS063	H20
6372055	KTFS0670R05SS075	H20
6372056	KTFS0394R08SS044	H20
6372057	KTFS0414R08SS044	H20
6372058	KTFS0434R08SS044	H20
6372059	KTFS0453R08SS050	H20
6372060	KTFS0473R08SS050	H20
6372062	KTFS0493R08SS050	H20
6372063	KTFS0512R08SS056	H20
6372064	KTFS0532R08SS056	H20
6372065	KTFS0552R08SS056	H20
6372066	KTFS0571R08SS063	H20
6372067	KTFS0591R08SS063	H20
6372068	KTFS0630R08SS063	H20
6372069	KTFS0670R08SS075	H20
6372514	KTFS100R03SCF16M	H19
6372515	KTFS105R03SCF16M	H19
6372516	KTFS110R03SCF16M	H19
6372517	KTFS115R03SCF16M	H19
6372518	KTFS120R03SCF16M	H19
6372519	KTFS125R03SCF16M	H19
6372520	KTFS130R03SCF16M	H19
6372591	KTFS135R03SCF16M	H19
6372592	KTFS140R03SCF16M	H19
6372593	KTFS145R03SCF16M	H19
6372594	KTFS150R03SCF20M	H19
6372595	KTFS160R03SCF20M	H19
6372596	KTFS170R03SCF20M	H19
6372597	KTFS100R05SCF16M	H19
6372598	KTFS105R05SCF16M	H19
6372599	KTFS110R05SCF16M	H19
6372600	KTFS115R05SCF16M	H19
6372601	KTFS120R05SCF16M	H19
6372602	KTFS125R05SCF16M	H19
6372603	KTFS130R05SCF16M	H19
6372604	KTFS135R05SCF16M	H19
6372605	KTFS140R05SCF16M	H19
6372606	KTFS145R05SCF16M	H19
6372607	KTFS150R05SCF20M	H19
6372608	KTFS160R05SCF20M	H19
6372609	KTFS170R05SCF20M	H19
6372610	KTFS100R08SCF16M	H19
6372611	KTFS105R08SCF16M	H19
6372612	KTFS110R08SCF16M	H19
6372613	KTFS115R08SCF16M	H19
6372614	KTFS120R08SCF16M	H19
6372615	KTFS125R08SCF16M	H19
6372616	KTFS130R08SCF16M	H19
6372617	KTFS135R08SCF16M	H19
6372618	KTFS140R08SCF16M	H19
6372619	KTFS145R08SCF16M	H19
6372620	KTFS150R08SCF20M	H19
6372621	KTFS160R08SCF20M	H19
6372622	KTFS170R08SCF20M	H19
6388420	KTFSS16000HPGM KCP15A	H9
6388531	KTFSS06310HPG KCP15A	H9
6388532	KTFSS16080HPGM KCP15A	H9
6388533	KTFSS06340HPG KCP15A	H9
6388534	KTFSS16100HPGM KCP15A	H9
6388535	KTFSS16200HPGM KCP15A	H9
6388536	KTFSS06406HPG 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	KTFSS06563HPG KCP15A	H9
6388545	KTFSS06300HPGM KCP15A	H8
6388546	KTFSS16700HPGM KCP15A	H9
6388547	KTFSS02500HPG 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	KTFSS06719HPG KCP15A	H9
6388555	KTFSS06600HPGM KCP15A	H8
6388556	KTFSS17100HPGM KCP15A	H9
6388557	KTFSS02610HPG KCP15A	H8
6388558	KTFSS17200HPGM KCP15A	H9
6388559	KTFSS06700HPGM KCP15A	H8
6388560	KTFSS17300HPGM KCP15A	H9
6388561	KTFSS02656HPG KCP15A	H8
6388562	KTFSS17400HPGM KCP15A	H9
6388563	KTFSS06800HPGM KCP15A	H8
6388564	KTFSS06875HPG KCP15A	H9
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6388566	KTFSS17480HPGM KCP15A	H9
6388567	KTFSS02720HPG KCP15A	H8
6388568	KTFSS17500HPGM KCP15A	H9
6388569	KTFSS07000HPGM KCP15A	H8
6388570	KTFSS17600HPGM KCP15A	H9
6388571	KTFSS07100HPGM KCP15A	H8
6388572	KTFSS17700HPGM KCP15A	H9
6388573	KTFSS02813HPG KCP15A	H8
6388574	KTFSS17800HPGM KCP15A	H9
6388575	KTFSS07031HPG KCP15A	H9
6388576	KTFSS07200HPGM KCP15A	H8
6388577	KTFSS17900HPGM KCP15A	H9
6388578	KTFSS02900HPG KCP15A	H8
6388579	KTFSS18000HPGM KCP15A	H9
6388580	KTFSS07400HPGM KCP15A	H8
6388581	KTFSS18100HPGM KCP15A	H9
6388582	KTFSS07500HPGM KCP15A	H8
6388583	KTFSS18200HPGM KCP15A	H9
6388584	KTFSS02969HPG KCP15A	H8
6388585	KTFSS07188HPG 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	KTFSS03125HPG KCP15A	H8
6388595	KTFSS07344HPG KCP15A	H9
6388596	KTFSS08000HPGM KCP15A	H8
6388597	KTFSS18700HPGM KCP15A	H9
6388598	KTFSS08100HPGM KCP15A	H8
6388599	KTFSS03214HPG KCP15A	H8
6388600	KTFSS18800HPGM KCP15A	H9
6388601	KTFSS18900HPGM KCP15A	H9
6388602	KTFSS03230HPG KCP15A	H8
6388603	KTFSS19000HPGM KCP15A	H9
6388604	KTFSS08300HPGM KCP15A	H8
6388605	KTFSS07500HPG KCP15A	H9
6388606	KTFSS03281HPG KCP15A	H8
6388607	KTFSS19100HPGM KCP15A	H9
6388608	KTFSS08400HPGM KCP15A	H8
6388609	KTFSS19200HPGM KCP15A	H9
6388610	KTFSS03320HPG KCP15A	H8
6388611	KTFSS08500HPGM KCP15A	H8
6388612	KTFSS07570HPG KCP15A	H9
6388613	KTFSS08600HPGM KCP15A	H8
6388614	KTFSS07580HPG KCP15A	H9
6388615	KTFSS03390HPG KCP15A	H8
6388616	KTFSS07590HPG KCP15A	H9
6388617	KTFSS08700HPGM KCP15A	H8
6388618	KTFSS19300HPGM KCP15A	H9
6388619	KTFSS07620HPG KCP15A	H9
6388620	KTFSS03438HPG KCP15A	H8
6388621	KTFSS19400HPGM KCP15A	H10
6388622	KTFSS08800HPGM KCP15A	H8
6388623	KTFSS07656HPG KCP15A	H10
6388624	KTFSS03480HPG KCP15A	H8
6388625	KTFSS19460HPGM KCP15A	H10
6388626	KTFSS08900HPGM KCP15A	H8
6388627	KTFSS19500HPGM KCP15A	H10
6388628	KTFSS09000HPGM KCP15A	H8
6388629	KTFSS19600HPGM KCP15A	H10
6388630	KTFSS03580HPG KCP15A	H8
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6388642	KTFSS09100HPGM KCP15A	H8
6388643	KTFSS19800HPGM KCP15A	H10
6388644	KTFSS03594HPG KCP15A	H8
6388645	KTFSS07813HPG KCP15A	H10
6388646	KTFSS09200HPGM KCP15A	H8
6388647	KTFSS19900HPGM KCP15A	H10
6388648	KTFSS09300HPGM KCP15A	H8
6388649	KTFSS20000HPGM KCP15A	H10
6388650	KTFSS03680HPG KCP15A	H8
6388651	KTFSS20100HPGM KCP15A	H10
6388652	KTFSS09400HPGM KCP15A	H8
6388653	KTFSS20200HPGM KCP15A	H10
6388654	KTFSS09500HPGM KCP15A	H8
6388655	KTFSS07969HPG KCP15A	H10
6388656	KTFSS03750HPG KCP15A	H8
6388657	KTFSS20300HPGM KCP15A	H10
6388658	KTFSS03763HPG KCP15A	H8
6388659	KTFSS20500HPGM KCP15A	H10
6388660	KTFSS09600HPGM KCP15A	H8
6388661	KTFSS20600HPGM KCP15A	H10
6388662	KTFSS09700HPGM KCP15A	H8
6388663	KTFSS08125HPG KCP15A	H10
6388664	KTFSS09800HPGM KCP15A	H8
6388665	KTFSS20700HPGM KCP15A	H10
6388666	KTFSS09900HPGM KCP15A	H8
6388667	KTFSS20800HPGM KCP15A	H10
6388668	KTFSS03906HPG KCP15A	H8
6388669	KTFSS20900HPGM KCP15A	H10
6388670	KTFSS10000HPGM KCP15A	H8
6388671	KTFSS20990HPGM KCP15A	H10
6388672	KTFSS03946HPG KCP15A	H8
6388673	KTFSS21000HPGM KCP15A	H10
6388674	KTFSS03970HPG KCP15A	H8
6388675	KTFSS21100HPGM KCP15A	H10
6388676	KTFSS10100HPGM KCP15A	H8
6388677	KTFSS21200HPGM KCP15A	H10
6388678	KTFSS10200HPGM KCP15A	H8
6388679	KTFSS21300HPGM KCP15A	H10
6388680	KTFSS04040HPG KCP15A	H8
6388681	KTFSS21400HPGM KCP15A	H10
6388682	KTFSS10300HPGM KCP15A	H8
6388683	KTFSS08438HPG KCP15A	H10
6388684	KTFSS04063HPG KCP15A	H8
6388685	KTFSS21500HPGM KCP15A	H10
6388686	KTFSS10400HPGM KCP15A	H8
6388687	KTFSS21700HPGM KCP15A	H10
6388688	KTFSS04130HPG KCP15A	H8
6388689	KTFSS21800HPGM KCP15A	H10
6388690	KTFSS10500HPGM KCP15A	H8
6388691	KTFSS08594HPG KCP15A	H10
6388692	KTFSS10600HPGM KCP15A	H8
6388693	KTFSS21900HPGM KCP15A	H10
6388694	KTFSS10700HPGM KCP15A	H8
6388695	KTFSS22000HPGM KCP15A	H10
6388696	KTFSS04219HPG KCP15A	H8
6388697	KTFSS22100HPGM KCP15A	H10
6388698	KTFSS10800HPGM KCP15A	H8
6388699	KTFSS22200HPGM KCP15A	H10
6388700	KTFSS10900HPGM KCP15A	H8
6388701	KTFSS08750HPG KCP15A	H10
6388702	KTFSS11000HPGM KCP15A	H8
6388703	KTFSS22400HPGM KCP15A	H10
6388704	KTFSS11100HPGM KCP15A	H8
6388705	KTFSS22500HPGM KCP15A	H10
6388706	KTFSS04375HPG 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	KTFSS04531HPG 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	KTFSS09219HPG KCP15A	H10
6388726	KTFSS04688HPG 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	KTFSS04844HPG KCP15A	H9
6388735	KTFSS09375HPG KCP15A	H10
6388736	KTFSS12400HPGM KCP15A	H9
6388737	KTFSS23900HPGM KCP15A	H10
6388738	KTFSS04911HPG KCP15A	H9
6388739	KTFSS24000HPGM KCP15A	H10
6388740	KTFSS12500HPGM KCP15A	H9
6388741	KTFSS24100HPGM KCP15A	H10
6388742	KTFSS12600HPGM KCP15A	H9
6388743	KTFSS24200HPGM KCP15A	H10
6388744	KTFSS05000HPG 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	KTFSS05156HPG KCP15A	H9
6388754	KTFSS09688HPG 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	KTFSS05312HPG 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	KTFSS10000HPG KCP15A	H10
6388773	KTFSS13800HPGM KCP15A	H9
6388774	KTFSS25500HPGM KCP15A	H10
6388775	KTFSS05469HPG KCP15A	H9
6388776	KTFSS25540HPGM KCP15A	H10
6388777	KTFSS05471HPG KCP15A	H9
6388778	KTFSS25600HPGM KCP15A	H10
6388779	KTFSS13940HPGM KCP15A	H9
6388780	KTFSS10110HPG KCP15A	H10
6388781	KTFSS14000HPGM KCP15A	H9
6388782	KTFSS25700HPGM KCP15A	H10
6388783	KTFSS25800HPGM KCP15A	H10
6388784	KTFSS14100HPGM KCP15A	H9
6388785	KTFSS10160HPG KCP15A	H10
6388786	KTFSS14200HPGM KCP15A	H9
6388787	KTFSS05625HPG KCP15A	H9
6388788	KTFSS25900HPGM KCP15A	H10
6388789	KTFSS14300HPGM KCP15A	H9

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Order No.	Catalog No.	Page(s)
6388790	KTFSS26000HPGM KCP15A	H10
6388791	KTFSS14400HPGM KCP15A	H9
6388792	KTFSS14500HPGM KCP15A	H9
6388793	KTFSS14600HPGM KCP15A	H9
6388794	KTFSS05774HPG KCP15A	H9
6388795	KTFSS05781HPG KCP15A	H9
6388796	KTFSS14700HPGM KCP15A	H9
6388798	KTFSS14800HPGM KCP15A	H9
6388799	KTFSS14900HPGM KCP15A	H9
6388800	KTFSS15000HPGM KCP15A	H9
6388821	KTFSS05938HPG KCP15A	H9
6388822	KTFSS15100HPGM KCP15A	H9
6388823	KTFSS15200HPGM KCP15A	H9
6388824	KTFSS15300HPGM KCP15A	H9
6388825	KTFSS15380HPGM KCP15A	H9
6388826	KTFSS15400HPGM KCP15A	H9
6388828	KTFSS06094HPG KCP15A	H9
6388829	KTFSS15500HPGM KCP15A	H9
6388830	KTFSS15600HPGM KCP15A	H9
6388831	KTFSS15700HPGM KCP15A	H9
6388832	KTFSS15800HPGM KCP15A	H9
6388833	KTFSS06250HPG KCP15A	H9
6388834	KTFSS15900HPGM KCP15A	H9
6389147	KTFS180R03SS20M	H18
6389148	KTFS190R03SS20M	H18
6389149	KTFS180R05SS20M	H18
6389150	KTFS190R05SS20M	H18
6389271	KTFS180R08SS20M	H18
6389272	KTFS190R08SS20M	H18
6389273	KTFS0709R03SS075	H20
6389274	KTFS0749R03SS075	H20
6389275	KTFS0709R05SS075	H20
6389276	KTFS0749R05SS075	H20
6389277	KTFS0709R08SS075	H20
6389278	KTFS0749R08SS075	H20
6389279	KTFS180R03SCF25M	H19
6389280	KTFS190R03SCF25M	H19
6389281	KTFS200R03SCF25M	H19
6389282	KTFS210R03SCF25M	H19
6389283	KTFS220R03SCF25M	H19
6389284	KTFS230R03SCF25M	H19
6389285	KTFS240R03SCF25M	H19
6389286	KTFS250R03SCF25M	H19
6389287	KTFS180R05SCF25M	H19
6389288	KTFS190R05SCF25M	H19
6389289	KTFS200R05SCF25M	H19
6389290	KTFS210R05SCF25M	H19
6389311	KTFS220R05SCF25M	H19
6389312	KTFS230R05SCF25M	H19
6389313	KTFS240R05SCF25M	H19
6389314	KTFS250R05SCF25M	H19
6389315	KTFS180R08SCF25M	H19
6389316	KTFS190R08SCF25M	H19
6389317	KTFS200R08SCF25M	H19
6389318	KTFS210R08SCF25M	H19
6389319	KTFS220R08SCF25M	H19
6389320	KTFS230R08SCF25M	H19
6389331	KTFS240R08SCF25M	H19
6389332	KTFS250R08SCF25M	H19
6389333	KTFS0788R03SCF100	H20
6389334	KTFS0827R03SCF100	H20
6389335	KTFS0867R03SCF100	H20
6389336	KTFS0906R03SCF100	H20
6389337	KTFS0945R03SCF100	H20
6389338	KTFS0985R03SCF100	H20
6389339	KTFS0788R05SCF100	H20
6389340	KTFS0827R05SCF100	H20
6389341	KTFS0867R05SCF100	H20
6389342	KTFS0906R05SCF100	H20
6389343	KTFS0945R05SCF100	H20
6389344	KTFS0985R05SCF100	H20
6389345	KTFS0788R08SCF100	H20
6389346	KTFS0827R08SCF100	H20
6389347	KTFS0867R08SCF100	H20
6389348	KTFS0906R08SCF100	H20
6389349	KTFS0945R08SCF100	H20
6389350	KTFS0985R08SCF100	H20
6389361	KTFS060R03SS08M	H18
6389362	KTFS063R03SS08M	H18
6389363	KTFS066R03SS08M	H18
6389364	KTFS070R03SS08M	H18
6389365	KTFS075R03SS08M	H18
6389366	KTFS080R03SS10M	H18
6389367	KTFS085R03SS10M	H18
6389368	KTFS090R03SS10M	H18
6389369	KTFS095R03SS10M	H18
6389370	KTFS060R05SS08M	H18
6389381	KTFS063R05SS08M	H18
6389382	KTFS066R05SS08M	H18
6389383	KTFS070R05SS08M	H18
6389384	KTFS075R05SS08M	H18
6389385	KTFS080R05SS10M	H18
6389386	KTFS085R05SS10M	H18
6389387	KTFS090R05SS10M	H18
6389388	KTFS095R05SS10M	H18
6389389	KTFS060R08SS08M	H18
6389390	KTFS063R08SS08M	H18
6389391	KTFS066R08SS08M	H18
6389392	KTFS070R08SS08M	H18
6389393	KTFS075R08SS08M	H18
6389394	KTFS080R08SS10M	H18
6389395	KTFS085R08SS10M	H18
6389396	KTFS090R08SS10M	H18
6389397	KTFS095R08SS10M	H18
6389398	KTFS0237R03SS031	H20
6389399	KTFS0249R03SS031	H20
6389400	KTFS0260R03SS031	H20
6389401	KTFS0276R03SS031	H20
6389402	KTFS0296R03SS031	H20
6389403	KTFS0315R03SS038	H20
6389404	KTFS0335R03SS038	H20
6389405	KTFS0355R03SS038	H20
6389406	KTFS0375R03SS038	H20
6389407	KTFS0237R05SS031	H20
6389408	KTFS0249R05SS031	H20
6389409	KTFS0260R05SS031	H20
6389410	KTFS0276R05SS031	H20
6389421	KTFS0296R05SS031	H20
6389422	KTFS0315R05SS038	H20
6389423	KTFS0335R05SS038	H20
6389424	KTFS0355R05SS038	H20
6389425	KTFS0375R05SS038	H20
6389426	KTFS0237R08SS031	H20
6389427	KTFS0249R08SS031	H20
6389428	KTFS0260R08SS031	H20
6389429	KTFS0276R08SS031	H20
6389430	KTFS0296R08SS031	H20
6389431	KTFS0315R08SS038	H20
6389432	KTFS0335R08SS038	H20
6389433	KTFS0355R08SS038	H20
6389434	KTFS0375R08SS038	H20
6389436	KTFS080R03SCF12M	H19
6389437	KTFS085R03SCF12M	H19
6389438	KTFS090R03SCF12M	H19
6389439	KTFS095R03SCF12M	H19
6389440	KTFS080R05SCF12M	H19
6389441	KTFS085R05SCF12M	H19
6389442	KTFS090R05SCF12M	H19
6389443	KTFS095R05SCF12M	H19
6389444	KTFS080R08SCF12M	H19
6389445	KTFS085R08SCF12M	H19
6389446	KTFS090R08SCF12M	H19
6389447	KTFS095R08SCF12M	H19
6389448	KTFS100R01SS12M	H18
6389449	KTFS105R01SS12M	H18
6389450	KTFS110R01SS12M	H18
6389471	KTFS115R01SS12M	H18
6389472	KTFS120R01SS14M	H18
6389473	KTFS125R01SS14M	H18
6389474	KTFS130R01SS14M	H18
6389475	KTFS135R01SS14M	H18
6389476	KTFS140R01SS16M	H18
6389477	KTFS145R01SS16M	H18
6389478	KTFS150R01SS16M	H18
6389479	KTFS160R01SS16M	H18
6389480	KTFS170R01SS20M	H18
6389481	KTFS100R12SF16M	H18
6389482	KTFS105R12SF16M	H18
6389483	KTFS110R12SF16M	H18
6389484	KTFS115R12SF16M	H18
6389485	KTFS120R12SF16M	H18
6389486	KTFS125R12SF16M	H18
6389487	KTFS130R12SF16M	H18
6389488	KTFS135R12SF16M	H18
6389489	KTFS140R12SF16M	H18
6389490	KTFS145R12SF16M	H18
6389501	KTFS150R12SF20M	H18
6389502	KTFS160R12SF20M	H18
6389503	KTFS170R12SF20M	H18
6389504	KTFS200R01SCF25M	H19
6389505	KTFS210R01SCF25M	H19
6389506	KTFS220R01SCF25M	H19
6389507	KTFS230R01SCF25M	H19
6389508	KTFS240R01SCF25M	H19
6389509	KTFS250R01SCF25M	H19
6389510	KTFS200R12SCF25M	H19
6389561	KTFS210R12SCF25M	H19
6389562	KTFS220R12SCF25M	H19
6389563	KTFS230R12SCF25M	H19
6389564	KTFS240R12SCF25M	H19
6389565	KTFS250R12SCF25M	H19
6389566	KTFS180R01SS20M	H18
6389567	KTFS190R01SS20M	H18
6389568	KTFS180R12SF25M	H18
6389569	KTFS190R12SF25M	H18
6389570	KTFS060R01SS08M	H18
6389571	KTFS063R01SS08M	H18
6389572	KTFS066R01SS08M	H18
6389573	KTFS070R01SS08M	H18
6389574	KTFS075R01SS08M	H18
6389575	KTFS080R01SS10M	H18
6389576	KTFS085R01SS10M	H18
6389577	KTFS090R01SS10M	H18
6389578	KTFS095R01SS10M	H18
6389579	KTFS060R12SF12M	H18
6389580	KTFS063R12SF12M	H18
6389581	KTFS066R12SF12M	H18
6389582	KTFS070R12SF12M	H18
6389583	KTFS075R12SF12M	H18
6389584	KTFS080R12SF12M	H18
6389585	KTFS085R12SF12M	H18
6389586	KTFS090R12SF12M	H18
6389587	KTFS095R12SF12M	H18
6397378	SNXF43ZNENLD KCPK30	S89
6397379	SNXF43ZNSNHE KCPK30	S89
6397380	SNXF433SNGP KCPK30	S89
6397611	SNXF433SNHE KCPK30	S89
6397612	SNXF433ENLD KCPK30	S89
6397613	SNXF43ZNSNGP KCPK30	S89
6397614	SNXF43ZNENLD KCK20	S89
6397615	SNXF43ZNSNHE KCK20	S89
6397616	SNXF433SNGP KCK20	S89
6397617	SNXF433SNHE KCK20	S89
6397618	SNXF433ENLD KCK20	S89
6397619	SNXF43ZNSNGP KCK20	S89
6401814	A4M50L0314MC	C137
6401815	A4M50R0314MC	C137
6401816	A4M50L0414MC	C137
6401817	A4M50R0414MC	C137
6401818	A4M50L0519MC	C137
6401819	A4M50R0519MC	C137
6401820	A4M65L0522MC	C137
6401831	A4M65R0522MC	C137
6401832	A4M65L0620MC	C137
6401833	A4M65L0626MC	C137
6401834	A4M65R0620MC	C137
6401835	A4M65R0626MC	C137
6401836	A4M65L0820MC	C137
6401837	A4M65L0826MC	C137
6401838	A4M65R0820MC	C137
6401839	A4M65R0826MC	C137
6401840	A4M65L1020MC	C137
6401851	A4M65L1026MC	C137
6401852	A4M65R1020MC	C137
6401853	A4M65R1026MC	C137
6401854	EVSMR2020K0216C	C36
6401855	EVSMR2525M0216C	C36
6401856	EVSMR2525M0226C	C36
6401857	EVSMR2020K0222C	C36
6401858	EVSMR160226C	C34
6401859	EVSMR160216C	C34
6401860	EVSMR120222C	C34
6401881	EVSML2525M0216C	C37
6406706	ONGX645ENLE KCK15	S33
6406707	ONGX645ENLE KCK20	S33
6406708	ONGX64ANENLE KCK15	S33
6406709	ONGX64ANENLE KCK20	S33
6406710	ONGX645SNGP KCK20	S33
6406851	ONGX645SNGP KCPK30	S33
6406852	ONGX64ANSNGP KCK20	S33
6406853	ONPX642SNGP KCPK30	S34
6406854	ONPX645SNHB KCPK30	S34
6408092	XADA0375Y4CU60 KCPM15	048
6408093	XADA0500Y5CU60 KCPM15	048
6408094	XADA0625Y6CU60 KCPM15	048
6432549	COOL-HOSE-200-FLEX	C83
6432550	COOL-HOSE-300-FLEX	C83

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
#1/2-20X1-1/4 LHCSA S	V19, V26
#1/2-20X1-1/4SHCSA S	T98, T128, T131, V19, V26, V103
#1/4-28X3/4SHCSA S	T98, V12, V98, V103
#3/4-16X1-3/4SHCSA S	V19, V26
#3/8-24X1SHCSA S	T98, V12, V19, V98, V103
#5/8-18X1-1/2SHCSA S	T131, V19, V26
1-16NPTF-JIC	C83
1-8NPTF-JIC	C83
1.10820R310	E15
1.10825L310	E15
1.10825R310	E15
1.10825R700	E15
1.17125L330	E16
1.18016L110	E16
1.18016R110	E16
1.18020L110	E16
1.18020R110	E16
1.18020R310	E16
1.18025L310	E16
1.18025L315	E16
1.18025L330	E17
1.18025R110	E16
1.18025R310	E16
1.18025R310Z	E20, E22
1.18025R315	E16
1.18032L315	E16
1.18032R315	E16
1.38020R021	E17
1.38025L021	E17
1.38025R021	E17
1.38025R021Z	E20, E22
1.77120L100	E18
1.77120R100	E18
1.77125R300	E18
1.77125R300Z	E21, E23
1.77132R400	E18
1.77225R301	E19
1.77725R301	E18
1.78012R103	E19
1.78016R100	E19
1.78020R100	E19
1.78025L100	E19
1.78025L300	E19
1.78025L300Z	E21, E23
1.78025R100	E19
1.78025R300	E19
1.78025R300Z	E21, E23
1.78032L400Z	E21, E23
1.78032R400	E19
100B04RP90BG15CUM	S121
100B06RP90BG15C2WUPM	S122
100B08RP70SP12C2WUFP	S64
100B08RP90BG15C2WUPM	S122
100B08RP90SP12C2WUFP	S67
100B12RP70SP12C3WUFP	S64
100B12RP90SP12C3WUFP	S67
100G10RP90SP10	U25
10X1R015B20STN11T	W42
112.244	E16
112.403	E15–16
112.404	E15–17, E20, E22
112.505	E16
114.111	E17
114.114	E17, E20, E22
114.305	E55, E61
118.204	E18–19
118.314	E18–19
11X1R012B12STN11N	W40
11X1R020B20STN11N	W40
121.612	E15–16, E18, S64, S67
121.616	E15–17, E19–20, E22, E55, E61, S70
121.808	K48–50
121.812	E17, K48–50
121.816	E17–23
121.825	E19, E21, E23
12147629800	K116–117
12148006000	T24
12148044900	S30–31, S77, S82, S88
12148068700	K116–117
125.625	K48–50
125.820	J84–85
125.830	J84–85
125B05RP90BG15CUM	S121
125B08RP70SP15C2WUFP	S70
125B08RP90BG15C2WUPM	S122
125B10RP70SP12C2WUFP	S64
125B10RP90SP12C2WUFP	S67
125B15RP90SP12C3WUFP	S67
125H11RP90SP10	U25
12748308500	S82
12748358200	S77, S82, S88
12748500200	S83
12748500400	S83
12748500500	S83
12748503400	S83
12748600900	S77, S82, S88
12748601000	S30–31
128.508	H87
128.510	H87
128.610	J75
129.612	J84–85
129.616	J84–85
12MHC030M	G79
12MHC040M	G79
12MHC050M	G79
12MHC060M	G79
12MHC070M	G79
12MHC080M	G79
12MHC090M	G79
12MHC100M	G79
132.151	E16
132.156	E16
15X1R020B16STN16C	W42
15X1R022B16STN16T	W42
160B06RP90BG15CUM	S121
160B10RP70SP15C2WUFP	S70
160B10RP90BG15C2WUPM	S122
160B12RP70SP12C3WUFP	S64
160B12RP90SP12C3WUFP	S67
160B18RP70SP12C3WUFP	S64
170.000	K76
170.002	K51
170.003	E15–20, E22, E55, E61, I14, K51, S64, S67, S70, S121–123
170.004	E17–23, J90, K48–51
170.005	I14, J91, K48–50
170.006	J90–91, K48–50
170.008	J90–92
170.023	J10–15, J25, J27, J29, J31, J33, J35, J37, J39
170.024	I25–27, J25, J27, J29, J31, J33, J35, J37, J39, J49–50, J52–53, J114
170.025	I14–15, I25–27, J25, J27, J29, J31, J33, J35, J37, J39, J49–50, J52–53, J114, S4–5, S8–10, S14, S17, S20, V44–47, V51–54, V62
170.026	J49, J52–53, V58
170.027	J10–15
170.028	I14–15, J10–15, J25, J27, J29, J31, J33, J35, J37, J39, J114
170.135	K51
170.136	K51
170.270	H72, H81, H85–86, H88
170.271	H84, H88
170.272	H72, H81, H85–86, H88
170.273	H88
170.274	H72, H81, H85–86, H88
170.275	H88
170.276	H72, H81, H85–86, H88
170.277	H88
170.281	H84, H88
170.282	H84, H88
170.283	H84, H88
170.284	H84, H88
170.285	H88
170.286	H88
170.287	H88
170.288	H88
170.289	H72, H81, H86, H88
170.290	H88
170.291	H88
170.294	H72, H81, H88
170.295	H88
170.296	H88
170.306	H38–41
170.307	H38–41
170.308	H38–41
170.309	H38–41
170.314	H38–41
170.345	H122
170.346	H122
170.347	H122–123
170.348	H123
170.350	H122
170.352	H122
170.353	H122
170.355	H122–123
170.356	H122–123
170.365	H123
170.370	J25, J27, J33, J35
17X1R022B16STN16N	W40
190.076	I27
190.116	J75
190.195	I27
190.371	I27
190.458	J75
191.282	K76
191.375	J49, J52
191.405	B72, B115–119, B175–176, B186, B217, B220, B236–237, B254–255, B276–279, B395–397
191.406	B72–74, B94, B115–119, B140–142, B174, B186–187, B198, B245, B249–251, B276–279, B394, B397–398, C196, D41
191.407	B72–74, B94–95, B115–117, B119, B140–142, B186, B198, B249, B397
191.698	H122, J25, J27, J29, J31, J33, J35, J37, J39, J49–50, J52–53, J84–85
191.725	I14–15, V155–156
191.726	H122–123, J49, J52–53
191.727	J87–90
191.728	J87, J89–92
191.729	J91–92
191.848	J49–50, J52–53, J84–85, V44–47
191.916	C42–45, H122–123, J25, J27, J29, J31, J33, J35, J37, J39, J85, J114
191.924	H122, J25, J27, J29, J31, J33, J35, J37, J39, J49–50, J52–53, J84–85, J114, V156
192.057	I27
192.111	J84–85
192.112	J84–85
192.126	J92
192.156	J87–90
192.157	J87–91
192.158	J92
192.416	J10–15, J75
192.419	J87–90
192.420	J87–90
192.421	J87–91
192.422	J87–90
192.423	J87–91
192.424	J87, J89–92
192.425	J87, J89–92
192.426	J91–92
192.432	H122, I14–15, J10–15, J25, J27, J29, J31, J33, J35, J37, J39, J75, J84–85, J114
192.433	J25, J27, J29, J31, J33, J35, J37, J39
192.530	U13
192.592	J75, J84
192.593	J84–85
192.718	I14–15
192.720	I14–15
192.730	J92
192.731	J92
192.759	J92
192.888	I14–15
192.889	I14–15
192.902	J75, J84–85
192.903	J84–85
192.932	V58
193.113	I27
193.114	I27
193.115	I27
193.116	I27
193.281	J10–15, J25, J27, J33, J35
193.297	C130–131
193.300	S64, S70
193.326	S123
193.371	J87–89
193.372	J87–89
193.389	V121–122
193.390	V121–123, V132
193.391	V121–123, V132–133
193.392	V121, V123, V132
193.393	V121–123, V132–133
193.394	V121–123
193.395	V122–123
193.397	J75
193.407	C130
193.409	S50, V155–156
193.433	S44–45
193.450	J85
193.451	J85
193.462	S109
193.465	S109
193.491	J25, J27, J29, J31, J33, J35, J37, J39
193.492	S4–5, S8–10, S14, S17, S20, S56, S58, V51–54, V62
193.523	H126–129
193.524	H126–129
193.525	H126–129
193.526	H126–129
193.531	S24
193.537	H126–129
193.545	H126–129
199.123	H87
19X1R023B20STN16T	W42
200C16RP70SP12C4WUFP	S64
20MHC030M	G79
20MHC040M	G79
20MHC050M	G79
20MHC060M	G79
20MHC070M	G79
20MHC080M	G79
20MHC090M	G79
20MHC100M	G79
20MHC110M	G79
20MHC120M	G79
20MHC130M	G79
20MHC140M	G79
20MHC150M	G79
20MHC160M	G79
20X1R043B20STN16N	W40
22X1R025B25STN16L	W41
250C20RP70SP12C4WUFP	S64
25MHC030M	G79
25MHC040M	G79
25MHC050M	G79
25MHC060M	G79
25MHC070M	G79
25MHC080M	G79
25MHC090M	G79
25MHC100M	G79
25MHC120M	G79
25MHC140M	G79
25MHC160M	G79
25X1R040B25STN27C	W42
26X2R043B25STN16D	W43
2BN0031IR007A KC633M	Q9
2BN0047IR018A KC633M	Q9
2BN0063IR018A KC633M	Q9
2BN0094IL037A KC633M	Q9
2BN0094IR018A KC633M	Q9
2BN0109IR037A KC633M	Q9
2BN0125IL075A KC633M	Q9
2BN0125IR050A KC633M	Q9
2BN0125IS025A KC633M	Q9
2BN0125IX075A KC633M	Q9
2BN0156IL056A KC633M	Q9
2BN0156IR031A KC633M	Q9
2BN0187IL075A KC633M	Q9
2BN0187IR062A KC633M	Q9

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
2BN0187IS031A KC633M	Q9
2BN0187IX100A KC633M	Q9
2BN0219IR062A KC633M	Q9
2BN0250IL150A KC633M	Q9
2BN0250IR075A KC633M	Q9
2BN0250IR112A KC633M	Q9
2BN0250IS050A KC633M	Q9
2BN0250IX150A KC633M	Q9
2BN0312IL112A KC633M	Q9
2BN0312IR081A KC633M	Q9
2BN0312IX150A KC633M	Q9
2BN0375IL112A KC633M	Q9
2BN0375IR087A KC633M	Q9
2BN0375IS062A KC633M	Q9
2BN0375IX300A KC633M	Q9
2BN0406IR100A KC633M	Q9
2BN0437IR100A KC633M	Q9
2BN0500IL200A KC633M	Q10
2BN0500IR100A KC633M	Q10
2BN0500IS062A KC633M	Q9
2BN0500IX150A KC633M	Q10
2BN0500IX300A KC633M	Q10
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2BN0750IL200A KC633M	Q10
2BN0750IR150A KC633M	Q10
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2BN1000IL300A KC633M	Q10
2BN1000IR150A KC633M	Q10
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2CH0125IR025A KC633M	Q6
2CH0125IX075A KC633M	Q6
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2CH0156IL056A KC633M	Q6
2CH0156IR031A KC633M	Q6
2CH0171IR062A KC633M	Q6
2CH0187IL075A KC633M	Q6
2CH0187IR062A KC633M	Q6
2CH0187IX112A KC633M	Q6
2CH0218IL062A KC633M	Q7
2CH0218IR043A KC633M	Q6
2CH0250IL112A KC633M	Q7
2CH0250IR075A KC633M	Q7
2CH0250IS050A KC633M	Q7
2CH0250IX150A KC633M	Q7
2CH0281IR075A KC633M	Q7
2CH0312IL112A KC633M	Q7
2CH0312IR081A KC633M	Q7
2CH0312IS050A KC633M	Q7
2CH0312IX162A KC633M	Q7
2CH0343IR100A KC633M	Q7
2CH0375IL112A KC633M	Q7
2CH0375IR100A KC633M	Q7
2CH0375IS062A KC633M	Q7
2CH0375IX175A KC633M	Q7
2CH0406IR100A KC633M	Q7
2CH0437IL100A KC633M	Q7
2CH0437IR062A KC633M	Q7
2CH0437IX200A KC633M	Q7
2CH0468IR100A KC633M	Q7
2CH0500IL200A KC633M	Q7
2CH0500IL200B KC633M	Q7
2CH0500IR100A KC633M	Q7
2CH0500IR100B KC633M	Q7
2CH0500IS062A KC633M	Q7
2CH0500IX300A KC633M	Q7
2CH0500IX300B KC633M	Q7
2CH0562IL125A KC633M	Q8
2CH0562IL125B KC633M	Q8
2CH0562IR075A KC633M	Q8
2CH0562IX225A KC633M	Q8
2CH0562IX225B KC633M	Q8
2CH0625IL125A KC633M	Q8
2CH0625IL125B KC633M	Q8
2CH0625IR075A KC633M	Q8
2CH0625IX225A KC633M	Q8
2CH0625IX225B KC633M	Q8
2CH0687IR137A KC633M	Q8
2CH0687IR137B KC633M	Q8
2CH0750IL300A KC633M	Q8
2CH0750IL300B KC633M	Q8
2CH0750IR150A KC633M	Q8
2CH0750IR225A KC633M	Q8
2CH0750IR225B KC633M	Q8
2CH0750IS100A KC633M	Q8
2CH0750IX400A KC633M	Q8
2CH0750IX400B KC633M	Q8
2CH0875IL225A KC633M	Q8
2CH0875IL225B KC633M	Q8
2CH0875IR150A KC633M	Q8
2CH0875IR150B KC633M	Q8
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2CH1000IL300B KC633M	Q8
2CH1000IR225A KC633M	Q8
2CH1000IR225B KC633M	Q8
2CH1000IS150A KC633M	Q8
2CH1000IX400A KC633M	Q8
2CH1000IX400B KC633M	Q8
2SE0016IR003A KC633M	Q6
2SE0031IR007A KC633M	Q6
2SE0062IL018A KC633M	Q6
2SE0062IR012A KC633M	Q6
2SE0062IX050A KC633M	Q6
2SE0078IR018A KC633M	Q6
2SE0093IL037A KC633M	Q6
2SE0093IR018A KC633M	Q6
2SE0093IX062A KC633M	Q6
2SE0109IR037A KC633M	Q6
2SE0125IL050A KC633M	Q6
2SE0125IR025A KC633M	Q6
2SE0125IX075A KC633M	Q6
2SE0140IR056A KC633M	Q6
2SE0156IL056A KC633M	Q6
2SE0156IR031A KC633M	Q6
2SE0171IR062A KC633M	Q6
2SE0187IL075A KC633M	Q6
2SE0187IR062A KC633M	Q6
2SE0187IX112A KC633M	Q6
2SE0218IL062A KC633M	Q7
2SE0218IR043A KC633M	Q6
2SE0250IL112A KC633M	Q7
2SE0250IR075A KC633M	Q7
2SE0250IS050A KC633M	Q7
2SE0250IX150A KC633M	Q7
2SE0281IR075A KC633M	Q7
2SE0312IL112A KC633M	Q7
2SE0312IR081A KC633M	Q7
2SE0312IS050A KC633M	Q7
2SE0312IX162A KC633M	Q7
2SE0343IR100A KC633M	Q7
2SE0375IL112A KC633M	Q7
2SE0375IR100A KC633M	Q7
2SE0375IS062A KC633M	Q7
2SE0375IX175A KC633M	Q7
2SE0406IR100A KC633M	Q7
2SE0437IL100A KC633M	Q7
2SE0437IR062A KC633M	Q7
2SE0437IX200A KC633M	Q7
2SE0468IR100A KC633M	Q7
2SE0500IL200A KC633M	Q7
2SE0500IL200B KC633M	Q7
2SE0500IR100A KC633M	Q7
2SE0500IR100B KC633M	Q7
2SE0500IS062A KC633M	Q7
2SE0500IX300A KC633M	Q7
2SE0500IX300B KC633M	Q7
2SE0562IL125A KC633M	Q8
2SE0562IL125B KC633M	Q8
2SE0562IR075A KC633M	Q8
2SE0562IX225A KC633M	Q8
2SE0562IX225B KC633M	Q8
2SE0625IL125A KC633M	Q8
2SE0625IL125B KC633M	Q8
2SE0625IR075A KC633M	Q8
2SE0625IX225A KC633M	Q8
2SE0625IX225B KC633M	Q8
2SE0687IR137A KC633M	Q8
2SE0687IR137B KC633M	Q8
2SE0750IL300A KC633M	Q8
2SE0750IL300B KC633M	Q8
2SE0750IR150A KC633M	Q8
2SE0750IR225A KC633M	Q8
2SE0750IR225B KC633M	Q8
2SE0750IS100A KC633M	Q8
2SE0750IX400A KC633M	Q8
2SE0750IX400B KC633M	Q8
2SE0875IL225A KC633M	Q8
2SE0875IL225B KC633M	Q8
2SE0875IR150A KC633M	Q8
2SE0875IR150B KC633M	Q8
2SE1000IL300A KC633M	Q8
2SE1000IL300B KC633M	Q8
2SE1000IR225A KC633M	Q8
2SE1000IR225B KC633M	Q8
2SE1000IS150A KC633M	Q8
2SE1000IX400A KC633M	Q8
2SE1000IX400B KC633M	Q8
3.37042R320	I14
3.37042R820	I14
3.37051R320	I14
3.37051R820	I14
3.37052R320	I14
3.37052R820	I14
3.37060R720	I26
3.37061R320	I14
3.37061R820	I14
3.37062R320	I14
3.37062R820	I14
3.37071R320	I14
3.37071R820	I14
3.37080R720	I26
3.37081R320	I14
3.37081R820	I14
3.37091R320	I14
3.37091R820	I14
3.37092R320	I14
3.37092R820	I14
3.37100R720	I26
3.37101R332	I14
3.37101R832	I14
3.37111R332	I14
3.37111R832	I14
3.37120R732	I26
3.37121R332	I14
3.37121R832	I14
3.37131R332	I14
3.37131R832	I14
3.37140R732	I26
3.37141R332	I14
3.37141R832	I14
3.37151R332	I14
3.37151R832	I14
3.37160R732	I26
3.37161R332	I14
3.37161R832	I14
3.37171R332	I14
3.37171R832	I14
3.37180R732	I26
3.37181R332	I14
3.37181R832	I14
3.37526R006	I27
3.37528R008	I27
3.37530R010	I27
3.37532R012	I27
3.37534R014	I27
3.37538R016	I27
3.37540R018	I27
3.37542R020	I27
3.41020R900 KMF	I17
3.41020R900STF CS5	I17
3.41020R901 CS5	I16
3.41020R901 KC7315	I16
3.41020R902 CS5	I16
3.41020R902 KC7315	I16
3.41020R903 CS5	I16
3.41020R903 KC7315	I16
3.41020R904 KC7315	I17
3.41220R900 KMF	I17
3.41220R900SF KMF	I17
3.41220R900STF CS5	I17
3.41220R901 CS5	I16
3.41220R901 KC7315	I16
3.41220R902 CS5	I16
3.41220R902 KC7315	I16
3.41220R903 CS5	I16
3.41220R903 KC7315	I16
3.41220R904 KC7315	I17
3.42805R001 CS5	I30
3.42805R001 KC7215	I30
3.42805R001 KMF	I30
3.42805R021 KC7015	I30
3.42805R021 KC7315	I30
3.42805R081 KC7215	I30
3.42807R001 CS5	I30
3.42807R001 KC7215	I30
3.42807R001 KMF	I30
3.42807R021 KC7015	I30
3.42807R021 KC7315	I30
3.42807R081 KC7215	I30
3.76045R028V	J82–83
3.76050R028V	J82–83
3.76055R032V	J82–83
3.76058R032V	J82–83
3.76063R032V	J82–83
3.76063R040V	J82–83
3.76068R040V	J82–83
3.76073R040V	J82–83
3.76078R040V	J82–83
3.76078R048V	J82–83
3.76084R048V	J82–83
3.76090R048V	J82–83
3.76096R048V	J82–83
3.76096R058V	J82–83
3.76102R058V	J82–83
3.76108R058V	J82–83
3.76115R070V	J82–83
3.76122R070V	J82–83
3.76130R070V	J82–83
3.76140R080V	J82–83
3.76150R080V	J82–83
3.76158R080V	J82–83
3.76162R080V	J82–83
3.76180R110	J82–83
3.76195R110	J82–83
3.76213R125	J82–83
3.76230R160	J82–83
3.76260R160	J82–83
3.77000R023V	J84
3.77000R024V	J84
3.77000R025V	J84
3.77000R026V	J84
3.77000R027V	J84
3.77000R028V	J84
3.77000R029V	J84
3.77000R030V	J84
3.77000R031V	J84
3.77000R038V	J84
3.77000R039V	J84
3.77000R048V	J84
3.77000R049V	J84
3.77000R050V	J84
3.77000R051V	J84
3.77000R052V	J84
3.77000R053V	J84
3.77000R073V	J84
3.77000R074V	J84
3.77000R075V	J84
3.77000R076V	J84
3.77000R077V	J84
3.77000R078V	J84
3.77000R079V	J84
3.77000R080V	J84
3.77000R081V	J84
3.77000R082V	J84
3.77000R083V	J84
3.77000R084V	J84
3.77000R085V	J84
3.77000R086V	J84
3.77000R087V	J84
3.77000R088V	J84
3.77000R224V	J85
3.77000R227V	J85
3.77000R228V	J85
3.77000R229V	J85
3.77000R230V	J85

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
3.77000R231V	J85
3.77000R239V	J85
3.77000R248V	J85
3.77000R249V	J85
3.77000R250V	J85
3.77000R251V	J85
3.77000R252V	J85
3.77000R253V	J85
3.77000R274V	J85
3.77000R276V	J85
3.77000R278V	J85
3.77000R280V	J85
3.77000R282V	J85
3.77000R284V	J85
3.77000R286V	J85
3.77000R288V	J85
302.009	J90
302.010	J90
302.011	J90
302.014	J92
30X1R052B25STN27N	W40
30X1R092B25STN27L	W41
32MHC060M	G79
32MHC070M	G79
32MHC080M	G79
32MHC090M	G79
32MHC100M	G79
32MHC110M	G79
32MHC120M	G79
32MHC130M	G79
32MHC140M	G79
32MHC150M	G79
32MHC160M	G79
35X1R055B32STNB38N	W41
360.510	I25–26
360.511	I25–26
360.513	I25–26
360.516	I25
360.550	I25–27
360.551	H87, I25–27
360.630	I26, I29
360.631	I26, I29
360.632	I26, I29
360.633	I26, I29
360.634	I26
360.635	I26, I29
360.636	I26, I29
360.637	I26, I29
360.650	I25, I29
360.651	I25, I29
360.652	I25, I29
360.653	I25, I29
360.654	I25, I29
360.655	I25, I29
360.660	H87
360.661	H87
360.663	H87
360.664	H87
360.665	H87
360.666	H87
360.667	H87
360.668	H87
360.669	H87
360.670	H87
364.010	H72–73, H75, H77, H79, H81–82, H84–86, H122
364.011	H72–75, H77–79, H81–82, H84–86, H122
364.012	H72, H74–76, H78–86, H122–123
364.013	H72, H74, H76, H78, H80–81, H83–86, H123
364.015	H72, H74, H81, H83, H85–86, H123
364.016	H72–73, H75, H81–82, H85–86, H122
364.017	H72–73, H75, H81–82, H85–86
37X1R058B32STN27N	W40
37X1R098B32STN27L	W41
3SE0031IR007A KC633M	Q16
3SE0047IR011A KC633M	Q16
3SE0062IR019A KC633M	Q16
3SE0078IR011A KC633M	Q16
3SE0094IR037A KC633M	Q16
3SE0109IR037A KC633M	Q16
3SE0125IL050A KC633M	Q16
3SE0125IR025A KC633M	Q16
3SE0125IX062A KC633M	Q16
3SE0156IR056A KC633M	Q16
3SE0188IL062A KC633M	Q16
3SE0188IR056A KC633M	Q16
3SE0188IS031A KC633M	Q16
3SE0188IX100A KC633M	Q16
3SE0219IL075A KC633M	Q16
3SE0219IR062A KC633M	Q16
3SE0250IL100A KC633M	Q16
3SE0250IR075A KC633M	Q16
3SE0250IS050A KC633M	Q16
3SE0250IX150A KC633M	Q16
3SE0281IL081A KC633M	Q16
3SE0281IR075A KC633M	Q16
3SE0312IL081A KC633M	Q16
3SE0312IR050A KC633M	Q16
3SE0375IL100A KC633M	Q16
3SE0375IR088A KC633M	Q16
3SE0375IS050A KC633M	Q16
3SE0375IX112A KC633M	Q16
3SE0437IL088A KC633M	Q16
3SE0437IR062A KC633M	Q16
3SE0437IX100A KC633M	Q16
3SE0500IL200A KC633M	Q17
3SE0500IR100A KC633M	Q16
3SE0563IR112A KC633M	Q17
3SE0563IR112B KC633M	Q17
3SE0625IL125A KC633M	Q17
3SE0625IL125B KC633M	Q17
3SE0625IR075A KC633M	Q17
3SE0625IR075B KC633M	Q17
3SE0750IL150A KC633M	Q17
3SE0750IL150B KC633M	Q17
3SE0750IR100A KC633M	Q17
3SE0750IX225A KC633M	Q17
3SE0750IX225B KC633M	Q17
3SE1000IR150A KC633M	Q17
3SE1000IX225A KC633M	Q17
3SE1000IX225B KC633M	Q17
40A02RP90BG15CUPM	S122
410.081	E15, S64, S67
410.083	S121–123
410.084	E18–19, E21, E23, S70
410.091	E18–19, E21, E23
4111492VRS	B168, B386
4111573VRS	B168, B386
4111593VRS	B168, B386
4111603VRS	B168, B386
4111654VRS	B168, B386
4111664VRS	B168, B386
4111674VRS	B168, B386
420.060	S121–123
420.101 SCREW	S121–123
420.121	S121–123
420.161	S121–122
420.162	S32
420.201	S17, S20, S24, S32, S45, S50, S121–122, T17
420.241	S17, S20, S24, S32, S50, S121–122, T17
42X2R045B32STN27D	W43
460.716	J92
46X1R100B40STNB38L	W41
470.232	S32
470.240	S17, S20, S24, S45, S50, S121–122
470.241	S17, S20, S24, S32, S50, S121–122
470.242	S20, S24, S32
470.243	S20, S24, S32
479.100	S64, S67, S70
4BN0031IR008A KC633M	Q26
4BN0047IR012A KC633M	Q26
4BN0062IR019A KC633M	Q26
4BN0078IR019A KC633M	Q26
4BN0094IL037A KC633M	Q26
4BN0094IR019A KC633M	Q26
4BN0109IR037A KC633M	Q26
4BN0125IL075A KC633M	Q26
4BN0125IR050A KC633M	Q26
4BN0125IS025A KC633M	Q26
4BN0125IX075A KC633M	Q26
4BN0141IR056A KC633M	Q26
4BN0156IR056A KC633M	Q26
4BN0172IR062A KC633M	Q26
4BN0187IL062A KC633M	Q26
4BN0187IR031A KC633M	Q26
4BN0187IX100A KC633M	Q26
4BN0203IR062A KC633M	Q26
4BN0219IR062A KC633M	Q26
4BN0234IR075A KC633M	Q26
4BN0250IL150A KC633M	Q26
4BN0250IR075A KC633M	Q26
4BN0250IR112A KC633M	Q26
4BN0250IS050A KC633M	Q26
4BN0250IX150A KC633M	Q26
4BN0281IR075A KC633M	Q26
4BN0312IL112A KC633M	Q26
4BN0312IR081A KC633M	Q26
4BN0312IS050A KC633M	Q26
4BN0312IX162A KC633M	Q26
4BN0344IR100A KC633M	Q26
4BN0375IL112A KC633M	Q27
4BN0375IR100A KC633M	Q27
4BN0375IS100A KC633M	Q26
4BN0375IX150A KC633M	Q27
4BN0437IR100A KC633M	Q27
4BN0500IL200A KC633M	Q27
4BN0500IR100A KC633M	Q27
4BN0500IR200A KC633M	Q27
4BN0500IS100A KC633M	Q27
4BN0500IX150A KC633M	Q27
4BN0500IX300A KC633M	Q27
4BN0562IR125A KC633M	Q27
4BN0625IL225A KC633M	Q27
4BN0625IR125A KC633M	Q27
4BN0750IL300A KC633M	Q27
4BN0750IR150A KC633M	Q27
4BN0875IR150A KC633M	Q27
4BN1000IL225A KC633M	Q27
4BN1000IR150A KC633M	Q27
4CH0125IL075A KC633M	Q22
4CH0125IR050A KC633M	Q22
4CH0125IS025A KC633M	Q22
4CH0125IX100A KC633M	Q22
4CH0140IR056A KC633M	Q22
4CH0156IR056A KC633M	Q22
4CH0187IL075A KC633M	Q22
4CH0187IR062A KC633M	Q22
4CH0187IS075A KC633M	Q22
4CH0187IX112A KC633M	Q22
4CH0203IR062A KC633M	Q22
4CH0218IL062A KC633M	Q22
4CH0218IR043A KC633M	Q22
4CH0234IR075A KC633M	Q23
4CH0250IL112A KC633M	Q23
4CH0250IR075A KC633M	Q23
4CH0250IS050A KC633M	Q23
4CH0250IX150A KC633M	Q23
4CH0265IR075A KC633M	Q23
4CH0281IR075A KC633M	Q23
4CH0296IR081A KC633M	Q23
4CH0312IL112A KC633M	Q23
4CH0312IR081A KC633M	Q23
4CH0312IS050A KC633M	Q23
4CH0312IX162A KC633M	Q23
4CH0328IR100A KC633M	Q23
4CH0343IR100A KC633M	Q23
4CH0359IR100A KC633M	Q23
4CH0375IL112A KC633M	Q23
4CH0375IR100A KC633M	Q23
4CH0375IS062A KC633M	Q23
4CH0375IX175A KC633M	Q23
4CH0390IR100A KC633M	Q23
4CH0406IR100A KC633M	Q23
4CH0421IR100A KC633M	Q23
4CH0437IL200A KC633M	Q23
4CH0437IR100A KC633M	Q23
4CH0437IS100A KC633M	Q23
4CH0437IX300A KC633M	Q23
4CH0453IR100A KC633M	Q24
4CH0468IR100A KC633M	Q24
4CH0484IR100A KC633M	Q24
4CH0500IL200A KC633M	Q24
4CH0500IL200B KC633M	Q24
4CH0500IR100A KC633M	Q24
4CH0500IR100B KC633M	Q24
4CH0500IS062A KC633M	Q24
4CH0500IX300A KC633M	Q24
4CH0562IL125A KC633M	Q24
4CH0562IL125B KC633M	Q24
4CH0562IR075A KC633M	Q24
4CH0562IX225A KC633M	Q24
4CH0625IL225A KC633M	Q24
4CH0625IL225B KC633M	Q24
4CH0625IR125A KC633M	Q24
4CH0625IR125B KC633M	Q24
4CH0625IS075A KC633M	Q24
4CH0625IX400A KC633M	Q24
4CH0687IR137A KC633M	Q24
4CH0750IL300A KC633M	Q24
4CH0750IL300B KC633M	Q24
4CH0750IR150A KC633M	Q24
4CH0750IR150B KC633M	Q24
4CH0750IR225A KC633M	Q24
4CH0750IR225B KC633M	Q24
4CH0750IX400A KC633M	Q24
4CH0875IL225A KC633M	Q25
4CH0875IL225B KC633M	Q25
4CH0875IR150A KC633M	Q25
4CH0875IR150B KC633M	Q25
4CH1000IL300A KC633M	Q25
4CH1000IL300B KC633M	Q25
4CH1000IR225A KC633M	Q25
4CH1000IR225B KC633M	Q25
4CH1000IS150A KC633M	Q25
4CH1000IX400A KC633M	Q25
4SE0015IR003A KC633M	Q22
4SE0031IR008A KC633M	Q22
4SE0062IR010A KC633M	Q22
4SE0078IR018A KC633M	Q22
4SE0093IL062A KC633M	Q22
4SE0093IR037A KC633M	Q22
4SE0109IR037A KC633M	Q22
4SE0125IL075A KC633M	Q22
4SE0125IR050A KC633M	Q22
4SE0125IS025A KC633M	Q22
4SE0125IX100A KC633M	Q22
4SE0140IR056A KC633M	Q22
4SE0156IR056A KC633M	Q22
4SE0187IL075A KC633M	Q22
4SE0187IR062A KC633M	Q22
4SE0187IS075A KC633M	Q22
4SE0187IX112A KC633M	Q22
4SE0203IR062A KC633M	Q22
4SE0218IL062A KC633M	Q23
4SE0218IR043A KC633M	Q22
4SE0234IR075A KC633M	Q23
4SE0250IL112A KC633M	Q23
4SE0250IR075A KC633M	Q23
4SE0250IS050A KC633M	Q23
4SE0250IX150A KC633M	Q23
4SE0265IR075A KC633M	Q23
4SE0281IR075A KC633M	Q23
4SE0296IR081A KC633M	Q23
4SE0312IL112A KC633M	Q23
4SE0312IR081A KC633M	Q23
4SE0312IS050A KC633M	Q23
4SE0312IX162A KC633M	Q23
4SE0328IR100A KC633M	Q23
4SE0343IR100A KC633M	Q23
4SE0359IR100A KC633M	Q23
4SE0375IL112A KC633M	Q23
4SE0375IR100A KC633M	Q23
4SE0375IS062A KC633M	Q23
4SE0375IX175A KC633M	Q23
4SE0390IR100A KC633M	Q23
4SE0406IR100A KC633M	Q23
4SE0421IR100A KC633M	Q23
4SE0437IL200A KC633M	Q23
4SE0437IR100A KC633M	Q23
4SE0437IS100A KC633M	Q23
4SE0437IX300A KC633M	Q24
4SE0453IR100A KC633M	Q24
4SE0468IR100A KC633M	Q24
4SE0484IR100A KC633M	Q24

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
4SE0500IL200A KC633M	Q24
4SE0500IL200B KC633M	Q24
4SE0500IR100A KC633M	Q24
4SE0500IR100B KC633M	Q24
4SE0500IS062A KC633M	Q24
4SE0500IX300A KC633M	Q24
4SE0562IL125A KC633M	Q24
4SE0562IL125B KC633M	Q24
4SE0562IR075A KC633M	Q24
4SE0562IX225A KC633M	Q24
4SE0625IL225A KC633M	Q24
4SE0625IL225B KC633M	Q24
4SE0625IR125A KC633M	Q24
4SE0625IR125B KC633M	Q24
4SE0625IS075A KC633M	Q24
4SE0625IX400A KC633M	Q24
4SE0687IR137A KC633M	Q24
4SE0750IL300A KC633M	Q24
4SE0750IL300B KC633M	Q24
4SE0750IR150A KC633M	Q24
4SE0750IR150B KC633M	Q24
4SE0750IR225A KC633M	Q24
4SE0750IR225B KC633M	Q24
4SE0750IS100A KC633M	Q24
4SE0750IX400A KC633M	Q24
4SE0875IL225A KC633M	Q25
4SE0875IL225B KC633M	Q25
4SE0875IR150A KC633M	Q25
4SE0875IR150B KC633M	Q25
4SE1000IL300A KC633M	Q25
4SE1000IL300B KC633M	Q25
4SE1000IR225A KC633M	Q25
4SE1000IR225B KC633M	Q25
4SE1000IS150A KC633M	Q25
4SE1000IX400A KC633M	Q25
5.34032-025115	J88
5.34032-025200	J88
5.34032-028115	J88
5.34032-028200	J88
5.34032-032125	J88
5.34050-025300	J88
5.34050-025450	J88
5.34050-028300	J88
5.34050-028450	J88
5.34050-032200	J88
5.34050-032500	J88
5.34050-040148	J88
5.34050-040300	J88
5.34050-040450	J88
5.34050-040600	J88
5.34050-048168	J88
5.34050-048300	J88
5.34050-048450	J88
5.34050-048600	J88
5.34050-058186	J88
5.34050-058300	J88
5.34050-058450	J88
5.34050-058600	J88
5.34050032350	J88
5.34125R025150	J87
5.34128R028150	J87
5.34132R032100	J87
5.34132R032200	J87
5.34140R040200	J87
5.34148R048200	J87
5.34158R058300	J87
5.34170R070186	J87
5.34170R070300	J87
5.34170R070500	J87
5.34180R080204	J87
5.34180R080300	J87
5.34180R080500	J87
5.34240R032100	J87
5.34248R040100	J87
5.34258R048100	J87
5.34270R058100	J87
5.34280R028080	J87
5.34280R032080	J87
5.34280R040080	J87
5.34280R048080	J87
5.34280R058080	J87
5.34280R070150	J87
5.34350-090100	J92
5.36050-154050	J91
5.36050154040	J91
50A03RP90BG15CUM	S121
50A03RP90BG15CUPM	S122
50A04RP70SP12CUFP	S64
50A04RP90SP12CUFP	S67
50A05RP70SP12CUFP	S64
50A05RP90SP12CUFP	S67
50HC030M	G79
50HC040M	G79
50HC050M	G79
50HC060M	G79
50HC080M	G79
50HC100M	G79
551.326	B383–384, B391
551.343	B391
552.210	B384
552.221	B383, B391
552.230	B391
552.232	B383–384
554.260	B383–384, B391
5720VZ16HA025Z2R75	T99
5720VZ16HA032Z3R75	T99
5720VZ16HA040Z4R75	T99
5720VZ16HA050Z4R75	T99
63A03RP90BG15CUM	S121
63A04RP90BG15C1WUPM	S122
63A04RP90BG15C4WUHPM	S123
63A05RP90SP12CUFP	S67
63A07RP70SP12CUFP	S64
75HC030M	G79
75HC040M	G79
75HC050M	G79
75HC060M	G79
75HC080M	G79
75HC100M	G79
75HC120M	G79
75HC140M	G79
75HC160M	G79
80A03RP90BG15CUM	S121
80A05RP90BG15C1WUPM	S122
80A05RP90BG15C5WUHPM	S123
80A06RP70SP12C1WUFP	S64
80A06RP90BG15C2WUPM	S122
80A06RP90SP12C1WUFP	S67
80A08RP70SP12C2WUFP	S64
80A08RP90SP12C2WUFP	S67
840.142.200	K122–124
840.142.250	K122–124
840.142.320	K122–123
840.142.420	K122–123
840.142.550	K122–123
840.142.720	K122–123
840.142.940	K122–123
841.142.200	K122–124
841.142.250	K122–124
841.142.320	K122–123
841.142.420	K122–123
841.142.550	K122–123
841.142.720	K122–123
841.142.940	K122–123
841.342.200	K122–124
841.342.420	K122–123
843.006.000	K124–126, K140
843.009.000	K124–126, K140
843.012.000	K124–126
844.012.000	K124–126
844.016.000	K124–126
845.012.000	K124–126
845.016.000	K124–126
846.012.000	K124–126
846.016.000	K124–126
847.012.000	K124–126
847.016.000	K124–126
848.200.005	K125
848.200.407	K124–126
848.250.005	K125
848.250.409	K124–126
848.320.005	K125
848.320.413	K124–126
848.420.005	K125
848.420.614	K124–126
848.550.005	K125
848.550.620	K124–126
848.720.000	K124–126
848.720.005	K125
848.940.640	K124, K126
880.252.200	K137–139
880.252.250	K137–139
880.252.320	K137–139
880.252.420	K137–138
880.252.550	K137–138
881.252.200	K137–139
881.252.250	K137–139
881.252.320	K137–139
881.252.420	K137–138
881.252.550	K137–138
881.252.720	K137–138
881.252.940	K137–138
886038045	K136
9X1R012B12STN10M	W40
9X1R017B20STN10M	W40
A0306GSCLDL12	B203
A0306GSCLDR12	B203
A0306SWLPL15	B291
A0306SWLPR15	B291
A03GSTLDR128	B265
A03XSC7DL12	B204
A03XSC7DR12	B204
A03XSCFDR12	B200
A03XSCLDL12	B201
A03XSCLDR12	B201
A03XSCLDR12A	B201
A0406HSCLDL12	B203
A0406HSCLDR12	B203
A0406SWLPR15	B291
A0406XSCFDR12125	B201
A0406XSCLDR12075	B203
A0406XSCLDR12125	B203
A0408XSCFDR12075	B201
A04FSCFDR12	B200
A04FSCLDL12	B201
A04FSCLDR12	B201
A04HSTFDR128	B264
A04HSTLDR128	B265
A04HSWUPR15	B291
A0506KSCLPR18	B215
A0506KSWLPR15	B291
A0506STFPR18	B273
A05HSTLDR128	B265
A05HSWUPR15	B291
A05KSTFPR18	B271
A06MCTLPR2	B185, B390
A06MSCFCR2	B196
A06MSCFPL2	B212
A06MSCFPR2	B212
A06MSCLCL2	B197
A06MSCLCR2	B197
A06MSCLPL2	B213
A06MSCLPR2	B213
A06MSDUCL2	B230
A06MSDUCR2	B230
A06MSDUPL2	B234
A06MSDUPR2	B234
A06MSTFCR2	B261
A06MSTFPL2	B271
A06MSTFPR2	B271
A06MSTLCL2	B262
A06MSTLCR2	B262
A06MSTLPL2	B274
A06MSTLPR2	B274
A06MSWLCR2	B287
A06MSWLPR2	B289
A06NER1	C190, D36
A06RCTFPR2	B183, B389
A08KEVEML0205I	C53
A08KEVEML1F05I	C53
A08KEVEMR0205I	C52
A08KEVEMR1F05I	C52
A08NEL2	C191, D35
A08NER1	C190, D36
A08NER2	C191, D35
A08NKQCL05	E46
A08NKQCR05	E46
A08RCTFPL2	B183, B389
A08RCTFPR2	B183, B389
A08RCTLNR2	B388
A08RCTLPL2	B185, B390
A08RCTLPR2	B185, B390
A08RSCFCR2	B196
A08RSCFPL2	B212
A08RSCFPR2	B212
A08RSCLCL2	B197
A08RSCLCR2	B197
A08RSCLPL2	B213
A08RSCLPR2	B213
A08RSDUCL2	B230
A08RSDUCR2	B230
A08RSDUPL2	B234
A08RSDUPR2	B234
A08RSDXCL2	B230
A08RSDXCR2	B230
A08RSDXPL2	B235
A08RSDXPR2	B235
A08RSTFCL2	B261
A08RSTFCR2	B261
A08RSTFPL2	B271
A08RSTFPR2	B271
A08RSTLCL2	B262
A08RSTLCR2	B262
A08RSTLPL2	B274
A08RSTLPR2	B274
A08RSVMBR2E	B284
A08RSWLCR2	B287
A08RSWLPL2	B289
A08RSWLPR2	B289
A08SCLPR2D	B217
A10CTFPL2	B183, B389
A10CTLNL2	B388
A10KNNT0R1	C190
A10MEVEML0207I	C53
A10MEVEML0307I	C53
A10MEVEML1F07I	C53
A10MEVEMR0207I	C52
A10MEVEMR0307I	C52
A10MEVEMR1F07I	C52
A10NER1	C190, D36
A10NKLCR05	E44
A10RA4SAL2S12N017021	C134
A10RA4SAR2S12N017021	C134
A10SCLPR2D	B217
A10SCTFPR2	B183, B389
A10SCTLNR2	B388
A10SCTLPL2	B185, B390
A10SNEL2	C191, D35
A10SNER2	C191, D35
A10SNKLCL05	E44
A10SSCFCL2	B196
A10SSCFCR2	B196
A10SSCFPL2	B212
A10SSCFPR2	B212
A10SSCLCL2	B197
A10SSCLCL3	B197
A10SSCLCR2	B197
A10SSCLCR3	B197
A10SSCLPL2	B213
A10SSCLPL3	B213
A10SSCLPL3AP5	B216
A10SSCLPR2	B213
A10SSCLPR3	B213
A10SSCLPR3AP5	B216
A10SSDUCL2	B230
A10SSDUCR2	B230
A10SSDUPL2	B234
A10SSDUPR2	B234
A10SSDXPL2	B235
A10SSDXPR2	B235
A10SSTFCR2	B261
A10SSTFPR2	B271
A10SSTLCL2	B262
A10SSTLCR2	B262
A10SSTLPL2	B274
A10SSTLPR2	B274
A10SSVMBR2E	B284
A10SSVQBL2	B284

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
A10SSVQBR2	B284
A10SSWLCR3	B287
A10SSWLPL3	B289
A10SSWLPR3	B289
A12KEVEML0205M	C55
A12KEVEML1F05M	C55
A12KEVEMR0205M	C54
A12KEVEMR1F05M	C54
A12MNNTOL2	C192
A12MNNTOR1	C190
A12MNNTOR2	C192
A12NEL2	C191, D35
A12NKXCR05	E46
A12QEVEML0207I	C53
A12QEVEML0307I	C53
A12QEVEML1F07I	C53
A12QEVEMR0207I	C52
A12QEVEMR0307I	C52
A12QEVEMR1F07I	C52
A12RA4EML0307N	C132
A12RA4EML0407N	C132
A12RA4EMR0207N	C132
A12RA4EMR0307N	C132
A12RA4EMR0407N	C132
A12RA4SAR2S12N021026	C134
A12SCLPR3D	B217
A12SCTFPL3	B183, B389
A12SCTFPR3	B183, B389
A12SCTLPL3	B185, B390
A12SCTLPR3	B185, B390
A12SNER2	C191, D35
A12SNKLCL05	E44
A12SNKLCR05	E44
A12SNKQCL05	E46
A12SNKQCR05	E46
A12SSCFCL3	B196
A12SSCFCR3	B196
A12SSCFPL3	B212
A12SSCFPR3	B212
A12SSCLCL3	B197
A12SSCLCR3	B197
A12SSCLPL3	B213
A12SSCLPL3AP5	B216
A12SSCLPR3	B213
A12SSCLPR3AP5	B216
A12SSDUCL3	B230
A12SSDUCR3	B230
A12SSDUPL3	B234
A12SSDUPR3	B234
A12SSDXCR3	B230
A12SSDXPR3	B235
A12SSTFCL3	B261
A12SSTFCR3	B261
A12SSTFPL3	B271
A12SSTFPR3	B271
A12SSTLCL3	B262
A12SSTLCR3	B262
A12SSTLPL3	B274
A12SSTLPR3	B274
A12SSVMBR3E	B284
A12SSVQBL2	B284
A12SSVQBR2	B284
A12SSVUBL2	B285
A12SSVUBR2	B285
A12SSWLPL3	B289
A12SSWLPR3	B289
A16CCLPR4	B165, B389
A16CRGNL3	B388
A16CRGNR3	B388
A16CTLPL3	B185, B390
A16CTLPR3	B185, B390
A16MCFNR4	B69
A16MCLNL3	B71
A16MCLNR3	B71
A16MCLNR4D	B69
A16MEVEML0207M	C55
A16MEVEML0307M	C55
A16MEVEML1F07M	C55
A16MEVEMR0207M	C54
A16MEVEMR0307M	C54
A16MEVEMR1F07M	C54
A16MNNTOL2	C192
A16MNNTOR2	C192
A16MTFNL3	B139
A16MTFNR3	B139
A16NEL3	C191, D35
A16NER3	C191, D35
A16NKLCR05	E44
A16NKQCL05	E46
A16NKQCR05	E46
A16NKXCR05	E46
A16RA4EML0310N	C132
A16RA4EML0410N	C132
A16RA4EMR0210N	C132
A16RA4EMR0310N	C132
A16RA4EMR0410N	C132
A16RA4SAL2S12M017021	C134
A16RA4SAL3S14N026036	C134
A16RA4SAR2S12M017021	C134
A16RA4SAR2S12N026036	C134
A16RA4SAR3S14N026036	C134
A16REVEML0210I	C53
A16REVEML0310I	C53
A16REVEML0410I	C53
A16REVEMR0210I	C52
A16REVEMR0310I	C52
A16REVEMR0410I	C52
A16REVSAL0212I026030	C56
A16REVSAL0312I030035	C56
A16REVSAR0212I026030	C56
A16REVSAR0312I030035	C56
A16SCFPR3	B212
A16SCLPL3	B213
A16SCLPL3AP5	B216
A16SCLPR3AP5	B216
A16STFCL3	B261
A16STFCR3	B261
A16STFPR3	B271
A16STLCL3	B262
A16STLCR3	B262
A16STLPR3	B274
A16SWLPR3	B289
A16TCTFPR3	B183, B389
A16TDCFNR4KC3	B67
A16TDCLNL4KC3	B68
A16TDCLNR3KC2	B68
A16TDCLNR4KC3	B68
A16TDDUNL3KC3	B92
A16TDDUNR3KC3	B92
A16TDTFNR3KC3	B138
A16TMCFNL4	B69
A16TMCLNL4	B71
A16TMCLNR4	B71
A16TMDUNL3	B93
A16TMDUNR3	B93
A16TNEL2	C191, D35
A16TNER2	C191, D35
A16TNKLCL05	E44
A16TNSL3	C194
A16TNSR3	C194
A16TSCFCR3	B196
A16TSCLCL3	B197
A16TSCLCR3	B197
A16TSCLPR3	B213
A16TSDUCL3	B230
A16TSDUCR3	B230
A16TSDUPL3	B234
A16TSDUPR3	B234
A16TSDXCL3	B230
A16TSDXCR3	B230
A16TSDXPL3	B235
A16TSDXPR3	B235
A16TSVMBR3E	B284
A16TSVQBL3	B284
A16TSVQBR3	B284
A16TSVUBL3	B285
A16TSVUBR3	B285
A20MCFNR4	B69
A20MCKNL4	B70
A20MCKNR4	B70
A20MCLNR4D	B69
A20MDPNL4	B92
A20MDPNR4	B92
A20MDQNL4	B93
A20MSKNR4	B114
A20MTUNR3D	B139
A20NEL3	C191, D35
A20NER3	C191, D35
A20NKLCR05	E44
A20NVJCR3	E47
A20NVLCR3	E47
A20QEVEML0207M	C55
A20QEVEML0307M	C55
A20QEVEML1F07M	C55
A20QEVEMR0207M	C54
A20QEVEMR0307M	C54
A20QEVEMR1F07M	C54
A20QNNTOL2	C192
A20QNNTOR2	C192
A20RA4EML0207M	C133
A20RA4EML0307M	C133
A20RA4EML0407M	C133
A20RA4EMR0207M	C133
A20RA4EMR0307M	C133
A20RA4EMR0407M	C133
A20RA4SAL2S12M021026	C134
A20RA4SAR2S12M021026	C134
A20RA4SAR3S14M021026	C134
A20SA4EMR0312N	C132
A20SA4EMR0412N	C132
A20SA4EMR0516N	C132
A20SA4EMR0616N	C132
A20SEVEML0312I	C53
A20SEVEML0412I	C53
A20SEVEMR0312I	C52
A20SEVEMR0412I	C52
A20SEVSAL0312I033042	C56
A20SEVSAR0312I033042	C56
A20UCTFPR3	B183, B389
A20UDCLNL4KC3	B68
A20UDCLNR4KC3	B68
A20UDDPNR4KC3	B91
A20UDDQNL4KC3	B91
A20UDDQNR4KC3	B91
A20UDDUNR3KC3	B92
A20UDDUNR4KC3	B92
A20UDSKNL3KC2	B113
A20UDVUNR3KC3	B154
A20UMCLNL4	B71
A20UMCLNR4	B71
A20UMDQNR4	B93
A20UMDUNL4	B93
A20UMDUNR4	B93
A20UMTFNR3	B139
A20UMVUNL3	B154
A20UMVUNR3	B154
A20UNSR3	C194
A24CCLNL4MX5	B391
A24CCLNR4MX5	B391
A24CCLPR4	B165, B389
A24CTFPL4	B183, B389
A24CTFPR3	B183, B389
A24CTFPR4	B183, B389
A24MCFNL4	B69
A24MCFNR4	B69
A24MCKNL4	B70
A24MCLNL5	B71
A24MCLNR4D	B69
A24MCLNR5	B71
A24MDPNL4	B92
A24MDPNR4	B92
A24MDQNL4	B93
A24NEL3	C191, D35
A24NER3	C191, D35
A24NKLCR05	E44
A24NVLCR3	E47
A24TA4EML0516N	C132
A24TA4EML0616N	C132
A24TA4EMR0416N	C132
A24TA4EMR0516N	C132
A24TA4EMR0616N	C132
A24TEVSAL0312I041050	C56
A24TEVSAR0312I041050	C56
A24UDCFNR4KC3	B67
A24UDCLNL4KC3	B68
A24UDCLNR4KC3	B68
A24UDCLNR5KC4	B68
A24UDDPNL4KC3	B91
A24UDDPNR4KC3	B91
A24UDDQNL4KC3	B91
A24UDDQNR4KC3	B91
A24UDDUNR4KC3	B92
A24UDVUNL3KC3	B154
A24UDVUNR3KC3	B154
A24UMCKNR4	B70
A24UMCLNL4	B71
A24UMCLNR4	B71
A24UMDQNR4	B93
A24UMDUNL4	B93
A24UMDUNR4	B93
A24UMTFNR3	B139
A24UMTFNR4	B139
A24UMVUNL3	B154
A24UMVUNR3	B154
A24UNSL3	C194
A24UNSR3	C194
A25RA4EML0210M	C133
A25RA4EML0310M	C133
A25RA4EML0410M	C133
A25RA4EMR0210M	C133
A25RA4EMR0310M	C133
A25RA4EMR0410M	C133
A25RA4SAL2S12M026036	C134
A25RA4SAL3S14M026036	C134
A25RA4SAR2S12M026036	C134
A25RA4SAR3S14M026036	C134
A25REVEML0210M	C55
A25REVEML0310M	C55
A25REVEML0410M	C55
A25REVEMR0210M	C54
A25REVEMR0310M	C54
A25REVEMR0410M	C54
A25REVSAL0212M026030	C57
A25REVSAL0312M030035	C57
A25REVSAR0212M026030	C57
A25REVSAR0312M030035	C57
A25RNNTOL2	C192
A25RNNTOL3	C192
A25RNNTOR2	C192
A25RNNTOR3	C192
A2732SVSPRW4	B285
A28MDUNL4	B93
A28MDUNR4	B93
A28MTFNR3	B139
A28MTFNR4	B139
A28NEL3	C191, D35
A28NEL4	C191, D35
A28NER3	C191, D35
A28NER4	C191, D35
A28UDCLNL4KC3	B68
A28UDCLNR4KC3	B68
A28UMCLNL4	B71
A28UMCLNR4	B71
A2906XSCLDR1205	B203
A2906XSCLDR121	B203
A2908XSCLDR121	B203
A3206XSCLDR1205	B203
A3206XSCLDR121	B203
A3208XSCLDR121	B203
A32CCLNL4MX5	B391
A32CCLNR4MX5	B391
A32CRGNR4MN5	B391
A32CTFPR4	B183, B389
A32MCKNR4	B70
A32MCLNL5	B71
A32MCLNR4D	B69
A32MCLNR5	B71
A32MCLNR5D	B69
A32MTFNR4	B139
A32MVUNL4	B154
A32MVUNR4	B154
A32NEL3	C191, D35
A32NEL4	C191, D35
A32NEL5	C191, D35
A32NEL6	C191, D35
A32NER3	C191, D35
A32NER4	C191, D35
A32NER6	C191, D35

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
A32NVLCR3	E47
A32SA4EML0312M	C133
A32SA4EML0412M	C133
A32SA4EML0516M	C133
A32SA4EMR0312M	C133
A32SA4EMR0412M	C133
A32SA4EMR0516M	C133
A32SEVEML0312M	C55
A32SEVEML0412M	C55
A32SEVEMR0312M	C54
A32SEVEMR0412M	C54
A32SEVSAL0312M033042	C57
A32SEVSAR0312M033042	C57
A32SNNTOL3	C192
A32SNNTOR3	C192
A32TA4EMR0616N	C132
A32VDCKNL4KC3	B67
A32VDCKNL5KC4	B67
A32VDCLNL4KC3	B68
A32VDCLNL6KC4	B68
A32VDCLNR4KC3	B68
A32VDCLNR5KC4	B68
A32VDDUNR4KC3	B92
A32VMCLNL4	B71
A32VMCLNL6	B71
A32VMCLNR4	B71
A32VMCLNR6	B71
A32VMDUNL4	B93
A32VMDUNR4	B93
A32VNSL3	C194
A32VNSR3	C194
A40MCLNL4	B71
A40MSKNR6	B114
A40MVUNL4	B154
A40MVUNR4	B154
A40NEL3	C191, D35
A40NER3	C191, D35
A40NER4	C191, D35
A40TA4EML0416M	C133
A40TA4EML0516M	C133
A40TA4EML0616M	C133
A40TA4EMR0416M	C133
A40TA4EMR0516M	C133
A40TA4EMR0616M	C133
A40TEVSAL0312M041050	C57
A40TEVSAR0312M041050	C57
A40TNNTOL3	C192
A40TNNTOL4	C192
A40TNNTOR3	C192
A40TNNTOR4	C192
A40VDCLNL4KC3	B68
A40VDCLNL6KC4	B68
A40VDCLNR4KC3	B68
A40VDCLNR6KC4	B68
A40VMCLNL5	B71
A40VMCLNR4	B71
A40VMCLNR5	B71
A40VMCLNR6	B71
A40VNSR3	C194
A4BHCL26K0317R	C135–136
A4BHCL32K0217L	C135–136
A4BHCL32K0317L	C135–136
A4BHCL32K0317R	C135–136
A4BHCR26K0317L	C135–136
A4BHCR32K0217R	C135–136
A4C0155L06CF01 KC5025	C113
A4C0155N00CF01 KC5025	C112
A4C0155N00CF01 KCU25	C112
A4C0155R06CF01 KC5025	C113
A4C0155R10CF01 KCU25	C113
A4C0155R16CF01 KC5025	C113
A4C0205L06CF02 KCU25	C113
A4C0205L10CF02 KC5025	C113
A4C0205N00CF02 KC5025	C112
A4C0205N00CF02 KCU25	C112
A4C0205R06CF02 KC5025	C113
A4C0205R06CF02 KCU25	C113
A4C0205R10CF02 KCU25	C113
A4C0255N00CF02 KC5025	C112
A4C0255N00CF02 KCU25	C112
A4C0255R06CF02 KC5025	C113
A4C0305L06CF02 KC5025	C113
A4C0305L06CF02 KCU25	C113
A4C0305L10CF02 KCU25	C113
A4C0305N00CF02 KC5025	C112
A4C0305N00CF02 KCU25	C112
A4C0305R06CF02 KC5025	C113
A4C0305R06CF02 KCU25	C113
A4C0305R10CF02 KC5025	C113
A4C0305R10CF02 KCU25	C113
A4C0405L06CF02 KCU25	C113
A4C0405L10CF02 KCU25	C113
A4C0405N00CF02 KC5025	C112
A4C0405N00CF02 KCU25	C112
A4C0405R06CF02 KCU25	C113
A4C0405R10CF02 KC5025	C113
A4C0405R10CF02 KCU25	C113
A4ENN120305	C130
A4ENN120407	C130
A4ENN160305	C130
A4ENN160407	C130
A4ENN160509	C130
A4ENN160611	C130
A4ENN160811	C130
A4ENN200611	C130
A4ENN2020K0305	C131
A4ENN2020K0407	C131
A4ENN2020K0611	C131
A4ENN2525M0305	C131
A4ENN2525M0407	C131
A4ENN2525M0509	C131
A4ENN2525M0611	C131
A4ENN3232P0611	C131
A4G0200M02P02GMP KC5010	C105
A4G0200M02P02GMP KC5025	C105
A4G0200M02P02GMP KCU10	C105
A4G0200M02P02GMP KCU25	C105
A4G0200M02P02GUP KCU10	C103
A4G0200M02P02GUP KCU25	C103
A4G0200M2SP02GUP KCU10	C108
A4G0200M2SP02GUP KCU25	C108
A4G0205M02U02GMN KC5010	C106
A4G0205M02U02GMN KC5025	C106
A4G0205M02U02GMN KCP10	C106
A4G0205M02U02GMN KCU10	C106
A4G0205M02U02GMN KCU25	C106
A4G0205M02U02GMP KC5010	C105
A4G0205M02U02GMP KC5025	C105
A4G0205M02U02GMP KCU25	C105
A4G0205M02U02GUP KCP10	C102
A4G0205M02U02GUP KCP25	C102
A4G0205M02U02GUP KCU10	C102
A4G0205M02U02GUP KCU25	C102
A4G0205M2SU02GMN KCU10	C109
A4G0205M2SU02GMN KCU25	C109
A4G0205M2SU02GUP KCU10	C109
A4G0205M2SU02GUP KCU25	C109
A4G0250M2BP02GMP KC5010	C105
A4G0250M2BP02GMP KCU10	C105
A4G0255M2BU02GMN KC5025	C106
A4G0255M2BU02GMP KC5025	C105
A4G0255M2BU02GMP KCU25	C105
A4G0300M03P02GMP K313	C105
A4G0300M03P02GMP KC5010	C105
A4G0300M03P02GMP KC5025	C105
A4G0300M03P02GMP KCU10	C105
A4G0300M03P02GMP KCU25	C105
A4G0300M03P02GUP KCU10	C103
A4G0300M03P02GUP KCU25	C103
A4G0300M03P04E KD1405	B370, C110
A4G0300M03P04EST KB1630	C111
A4G0300M03P04GMP K313	C105
A4G0300M03P04GMP KC5010	C105
A4G0300M03P04GMP KC5025	C105
A4G0300M03P04GMP KCU10	C105
A4G0300M03P04GMP KCU25	C105
A4G0300M03P04GUP KCU10	C103
A4G0300M03P04GUP KCU25	C103
A4G0300M03P04S02025ST KB1630	C111
A4G0300M03P04S02025ST KB5625	C111
A4G0300M03P04T01025 KY3500	B321, C110
A4G0300M3SP02GUP KCU10	C108
A4G0300M3SP02GUP KCU25	C108
A4G0300M3SP04GUP KCU10	C108
A4G0300M3SP04GUP KCU25	C108
A4G0305M03U02B KC5025	C108
A4G0305M03U02B KCK20	C108
A4G0305M03U02B KCU25	C108
A4G0305M03U02GMN KC5010	C106
A4G0305M03U02GMN KC5025	C106
A4G0305M03U02GMN KCP10	C106
A4G0305M03U02GMN KCP25	C106
A4G0305M03U02GMN KCU10	C106
A4G0305M03U02GMN KCU25	C106
A4G0305M03U02GMP KC5010	C105
A4G0305M03U02GMP KC5025	C105
A4G0305M03U02GMP KCU10	C105
A4G0305M03U02GMP KCU25	C105
A4G0305M03U02GMP KT315	C105
A4G0305M03U02GUP KCP10	C102
A4G0305M03U02GUP KCP25	C102
A4G0305M03U02GUP KCU10	C102
A4G0305M03U02GUP KCU25	C102
A4G0305M03U04GMN KC5010	C106
A4G0305M03U04GMN KC5025	C106
A4G0305M03U04GMN KCP10	C106
A4G0305M03U04GMN KCP25	C106
A4G0305M03U04GMN KCU10	C106
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A4G0305M03U04GMP KC5025	C105
A4G0305M03U04GMP KCU10	C105
A4G0305M03U04GMP KCU25	C105
A4G0305M03U04GMP KT315	C105
A4G0305M03U04GUP KCP10	C102
A4G0305M03U04GUP KCP25	C102
A4G0305M03U04GUP KCU10	C102
A4G0305M03U04GUP KCU25	C102
A4G0305M3SU02GMN KCU25	C109
A4G0305M3SU02GUP KCU10	C109
A4G0305M3SU02GUP KCU25	C109
A4G0305M3SU04GMN KCU10	C109
A4G0305M3SU04GMN KCU25	C109
A4G0305M3SU04GUP KCU10	C109
A4G0305M3SU04GUP KCU25	C109
A4G0400M04P02GMP K313	C105
A4G0400M04P02GMP KC5010	C105
A4G0400M04P02GMP KC5025	C105
A4G0400M04P02GMP KCU10	C105
A4G0400M04P02GMP KCU25	C105
A4G0400M04P02GUP KCU10	C103
A4G0400M04P02GUP KCU25	C103
A4G0400M04P04E KD1405	B370, C110
A4G0400M04P04GMP K313	C105
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For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
A4G0600M06P08EST KB1630	C111
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For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
A4R0405M04U00GUP KCU25	C102
A4R0500M05P00E KD1405	B370, C111
A4R0500M05P00EST KB1630	B355, C112
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A4R0800M08P00T01025 KY3500	B321, C110
A4R0805M08U00GMN KC5010	C107
A4R0805M08U00GMN KC5025	C107
A4R0805M08U00GMN KCP10	C107
A4R0805M08U00GMN KCP25	C107
A4R0805M08U00GMN KCU10	C107
A4R0805M08U00GMN KCU25	C107
A4R0805M08U00GUP KCU25	C102
A4R1000M10P00GUP KCU10	C104
A4R1000M10P00GUP KCU25	C104
A4R1005M10U00GMN KCP25	C107
A4R1005M10U00GMN KCU10	C107
A4R1005M10U00GMN KCU25	C107
A4R1005M10U00GUP KCU10	C104
A4R1005M10U00GUP KCU25	C104
A4R125I03P00GMN KC5010	C107
A4R125I03P00GMN KC5025	C107
A4R125I03P00GMN KCU10	C107
A4R125I03P00GMN KCU25	C107
A4R125I03P00GUP KCU10	C104
A4R125I03P00GUP KCU25	C104
A4R187I04P00GMN KC5010	C107
A4R187I04P00GMN KC5025	C107
A4R187I04P00GMN KCU10	C107
A4R187I04P00GMN KCU25	C107
A4R187I04P00GUP KCU25	C104
A4R250I06P00GMN KC5010	C107
A4R250I06P00GMN KC5025	C107
A4R250I06P00GMN KCU10	C107
A4R250I06P00GMN KCU25	C107
A4R250I06P00GUP KCU10	C104
A4R250I06P00GUP KCU25	C104
A4R250I06P00T0425 KY3500	B321, C110
A4R312I08P00GMN KCU10	C107
A4R312I08P00GUP KCU10	C104
A4R375I10P00GMN KC5025	C107
A4SBL122S12016020	C129
A4SBL2020K2S12016020	C129
A4SBL2020K2S12025036	C129
A4SBL2020K3S14020025	C129
A4SBL2020K4S14025035	C129
A4SBL2525M5S19038058	C129
A4SBR122S12016020	C129
A4SBR122S12020025	C129
A4SBR123S14020025	C129
A4SBR123S14025036	C129
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A4SBR2020K2S12016020	C129
A4SBR2020K2S12020025	C129
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A4SBR2525M5S19028038	C129
A4SBR2525M5S19038058	C129
A4SCL080113	C127
A4SCL080214	C127
A4SCL080314	C127
A4SCL100113	C127
A4SCL100217	C127
A4SCL100317	C127
A4SCL120113	C127
A4SCL1212K0113	C128
A4SCL1212K0214	C128
A4SCL1616K0113	C128
A4SCL1616K0217	C128
A4SCL1616K0317	C128
A4SCL2020K0113	C128
A4SCR060113	C127
A4SCR080113	C127
A4SCR080214	C127
A4SCR080314	C127
A4SCR100113	C127
A4SCR100217	C127
A4SCR100317	C127
A4SCR1010K0113	C128
A4SCR120113	C127
A4SCR1212K0113	C128
A4SCR1212K0214	C128
A4SCR1212K0314	C128
A4SCR1616K0113	C128
A4SCR1616K0217	C128
A4SCR1616K0317	C128
A4SCR2020K0113	C128
A4SML100214	C123
A4SML100314	C123
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A4SML120314	C123
A4SML120414	C123
A4SML120519	C123
A4SML120620	C123
A4SML160217	C123
A4SML160317	C123
A4SML160417	C123
A4SML160520	C123
A4SML160620	C123
A4SML160624	C123
A4SML160824	C123
A4SML1616K0214	C125
A4SML1616K0314	C125
A4SML200417	C123
A4SML200522	C123
A4SML200626	C123
A4SML201026	C123
A4SML2016K0317	C125
A4SML2020K0208	C126
A4SML2020K0214	C125
A4SML2020K0217	C125
A4SML2020K0308	C126
A4SML2020K0314	C125
A4SML2020K0317	C125
A4SML2020K0408	C126
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A4SML2020K0620	C125
A4SML240626	C123
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A4SML2525M0217	C125
A4SML2525M0317	C125
A4SML2525M0417	C125
A4SML2525M0510	C126
A4SML2525M0520	C125
A4SML2525M0610	C126
A4SML2525M0620	C125
A4SML2525M0820	C125
A4SML3225P0417	C125
A4SML3225P0522	C125
A4SML3225P0626	C125
A4SML3225P0826	C125
A4SML3225P1026	C125
A4SMR100214	C122
A4SMR100314	C122
A4SMR100414	C122
A4SMR120214	C122
A4SMR120217	C122
A4SMR120308	C126
A4SMR120314	C122
A4SMR120414	C122
A4SMR120519	C122
A4SMR120620	C122
A4SMR160217	C122
A4SMR160317	C122
A4SMR160417	C122
A4SMR160510	C126
A4SMR160520	C122
A4SMR160620	C122
A4SMR160624	C122
A4SMR160820	C122
A4SMR160824	C122
A4SMR1616K0214	C124
A4SMR1616K0314	C124
A4SMR200417	C122
A4SMR200522	C122
A4SMR200626	C122
A4SMR200826	C122
A4SMR201026	C122
A4SMR2016K0317	C124
A4SMR2016K0417	C124
A4SMR2020K0208	C126
A4SMR2020K0214	C124
A4SMR2020K0217	C124
A4SMR2020K0308	C126
A4SMR2020K0314	C124
A4SMR2020K0317	C124
A4SMR2020K0408	C126
A4SMR2020K0414	C124
A4SMR2020K0417	C124
A4SMR2020K0519	C124
A4SMR2020K0620	C124
A4SMR240626	C122
A4SMR240826	C122
A4SMR2525M0214	C124
A4SMR2525M0217	C124
A4SMR2525M0317	C124
A4SMR2525M0417	C124
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A4SMR2525M0520	C124
A4SMR2525M0610	C126
A4SMR2525M0620	C124
A4SMR2525M0820	C124
A4SMR3225P0417	C124
A4SMR3225P0522	C124
A4SMR3225P0626	C124
A4SMR3225P0826	C124
A4SMR3225P1026	C124
A50UNNTOR4	C192
A5505VX05SA.625R1.00	V111
A5505VX06SA.750R1.377	V111
A5505VX08SA1.00R1.575	V111
A5505VX10SA1.25R1.968	V111
A5720VZ16SA1.00Z2R2	T96
A5720VZ16SA1.25Z02R2	T96
A5720VZ16SA1.25Z3R2	T96
A7713VR10SA1.25Z4R1.7	V97–98
A7713VR12SA1.00Z2R1.4	V102–103
A7713VR12SA1.25Z3R1.7	V102–103
A7713VR12SA1.50Z4R1.7	V102
A7713VR12SA1.50Z5R1.7	V102–103
A7792VXD09SA1.0Z2R1.4 S	V9, V13
A7792VXD09SA1.25Z3R2 S	V9, V13
A7792VXD12SA1.25Z2R2 S	V17, V20
A7792VXD12SA1.5Z3R1.7 S	V17, V20
A7792VXP06SA.625Z2R1 S	V4, V6
A7792VXP06SA.75Z2R1.4 S	V4, V6
A7792VXP06SA.75Z3R1.4	V4, V6
A7792VXP06SA1.0Z3R1.4 S	V4, V6
A7792VXP06SA1.0Z4R1.4 S	V4, V6
A7792VXP06SA1.25Z5R2 S	V4, V6
AADE0125J3D K600	P128
AADE0125J3E K600	P128
AADE0188J3C K600	P128
AADE0188J3D K600	P128
AADE0188J3E K600	P128
AADE0250J3A K600	P128
AADE0250J3ARB K600	P128
AADE0250J3B K600	P128
AADE0250J3BRA K600	P128
AADE0250J3BRB K600	P128
AADE0250J3C K600	P128
AADE0250J3CRA K600	P128
AADE0250J3CRB K600	P128
AADE0250J3D K600	P128
AADE0250J3E K600	P128
AADE0250J3F K600	P128
AADE0250J3FRA K600	P128
AADE0250J3G K600	P128
AADE0312J3A K600	P128
AADE0312J3B K600	P128
AADE0312J3D K600	P128
AADE0312J3DRB K600	P128
AADE0375J3A K600	P128
AADE0375J3B K600	P129
AADE0375J3BRB K600	P128
AADE0375J3BRC K600	P128
AADE0375J3C K600	P129
AADE0375J3CRB K600	P129
AADE0375J3CRC K600	P129
AADE0375J3D K600	P129
AADE0375J3DRA K600	P129
AADE0375J3DRB K600	P129
AADE0375J3E K600	P129
AADE0375J3ERA K600	P129
AADE0375J3ERB K600	P129
AADE0375J3ERC K600	P129
AADE0375J3F K600	P128
AADE0375J3G K600	P128
AADE0375J3H K600	P129
AADE0375J3J K600	P129
AADE0375J3KRB K600	P129
AADE0375J3KRC K600	P129
AADE0438J3A K600	P129
AADE0500J3A K600	P129
AADE0500J3ARB K600	P129
AADE0500J3ARC K600	P129
AADE0500J3B K600	P129
AADE0500J3BRA K600	P129
AADE0500J3BRB K600	P129
AADE0500J3BRC K600	P129
AADE0500J3BRE K600	P129
AADE0500J3C K600	P129
AADE0500J3CRA K600	P129
AADE0500J3CRB K600	P129
AADE0500J3CRC K600	P129
AADE0500J3D K600	P129
AADE0500J3DRB K600	P129
AADE0500J3DRC K600	P129
AADE0500J3F K600	P129
AADE0500J3FRA K600	P129
AADE0500J3FRB K600	P129
AADE0500J3FRC K600	P129
AADE0500J3G K600	P129
AADE0500J3GRB K600	P129
AADE0500J3GRC K600	P129
AADE0500J3GRD K600	P129
AADE0500J3H K600	P129
AADE0500J3K K600	P129
AADE0500J3KRB K600	P129
AADE0500J3KRC K600	P129
AADE0500J3L K600	P129
AADE0500J3LRB K600	P129
AADE0500J3LRC K600	P129
AADE0625J3A K600	P129
AADE0625J3B K600	P130
AADE0625J3D K600	P130
AADE0625J3DRA K600	P129
AADE0625J3DRE K600	P130
AADE0625J3E K600	P130
AADE0625J3F K600	P130
AADE0625J3FRE K600	P130

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
AADE0625J3G K600	P130
AADE0625J3H K600	P130
AADE0625J3HRC K600	P130
AADE0750J3A K600	P130
AADE0750J3ARB K600	P130
AADE0750J3ARC K600	P130
AADE0750J3B K600	P130
AADE0750J3BRB K600	P130
AADE0750J3BRC K600	P130
AADE0750J3BRE K600	P130
AADE0750J3C K600	P130
AADE0750J3CRA K600	P130
AADE0750J3CRB K600	P130
AADE0750J3CRC K600	P130
AADE0750J3CRE K600	P130
AADE0750J3D K600	P130
AADE0750J3DRB K600	P130
AADE0750J3DRC K600	P130
AADE0750J3F K600	P130
AADE0750J3G K600	P130
AADE0750J3GRA K600	P130
AADE0750J3GRB K600	P130
AADE0750J3GRD K600	P130
AADE0750J3GRE K600	P130
AADE0750J3H K600	P130
AADE0750J3HRB K600	P130
AADE0750J3HRD K600	P130
AADE0750J3K K600	P130
AADE1000J3A K600	P130
AADE1000J3ARB K600	P130
AADE1000J3B K600	P130
AADE1000J3BRC K600	P130
AADE1000J3C K600	P130
AADE1000J3CRB K600	P130
AADE1000J3CRC K600	P130
AADE1000J3D K600	P130
AADE1000J3E K600	P130
AADE1000J3ERA K600	P130
AADE1000J3ERB K600	P130
AADE1000J3ERE K600	P130
AADE1000J3GRB K600	P130
AADE1000J3H K600	P130
AADE1000J3HRA K600	P130
AADE1000J3I K600	P130
AADE1000J3K K600	P130
AADE125J3F K600	P128
AADE125J3G K600	P128
AADE188J3F K600	P128
AADE250J3B K600	P128
AADE250J3H K600	P128
AADE375J3I K600	P129
AADE438J3A K600	P129
AADE500J3H K600	P129
AADE625J3I K600	P129
AADE750J3J K600	P130
AADE750J3K K600	P130
AADF0125J2A K600	P126
AADF0125J2B K600	P126
AADF0188J2A K600	P126
AADF0188J2B K600	P126
AADF0188J2D K600	P126
AADF0250J2A K600	P126
AADF0250J2B K600	P126
AADF0250J2BRA K600	P126
AADF0250J2BRB K600	P126
AADF0250J2C K600	P126
AADF0250J2E K600	P126
AADF0250J2F K600	P126
AADF0250J2FRB K600	P126
AADF0250J2G K600	P126
AADF0375J2B K600	P126
AADF0375J2C K600	P126
AADF0375J2CRB K600	P126
AADF0375J2CRC K600	P126
AADF0375J2D K600	P126
AADF0375J2DRA K600	P126
AADF0375J2DRB K600	P126
AADF0375J2E K600	P126
AADF0500J2A K600	P126
AADF0500J2B K600	P127
AADF0500J2BRA K600	P127
AADF0500J2BRB K600	P127
AADF0500J2C K600	P127
AADF0500J2CRA K600	P127
AADF0500J2CRB K600	P127
AADF0500J2CRC K600	P127
AADF0500J2D K600	P127
AADF0500J2E K600	P126
AADF0500J2F K600	P127
AADF0500J2FRB K600	P126
AADF0500J2G K600	P127
AADF0500J2GRA K600	P127
AADF0500J2GRB K600	P127
AADF0500J2GRC K600	P127
AADF0625J2BRB K600	P127
AADF0625J2FRB K600	P127
AADF0625J2GRB K600	P127
AADF0750J2B K600	P127
AADF0750J2BRB K600	P127
AADF0750J2C K600	P127
AADF0750J2CRA K600	P127
AADF0750J2CRB K600	P127
AADF0750J2F K600	P127
AADF0750J2GRA K600	P127
AADF1000J2A K600	P127
AADF1000J2BRB K600	P127
AADF1000J2C K600	P127
AADF1000J2D K600	P127
AADF250J2I K600	P126
AADF375J2G K600	P126
AADF375J2H K600	P126
AADF500J2B K600	P127
AADF500J2F K600	P127
ABDE0188J3ARA K600	P117
ABDE0188J3AS K600	P117
ABDE0250J3AQ K600	P120
ABDE0250J3AQB K600	P120
ABDE0250J3ARB K600	P117
ABDE0250J3AS K600	P117
ABDE0250J3BQ K600	P120
ABDE0250J3BQB K600	P120
ABDE0250J3CQ K600	P120
ABDE0250J3CQB K600	P120
ABDE0312J3AQB K600	P120
ABDE0312J3ARB K600	P117
ABDE0312J3AS K600	P117
ABDE0375J3AQ K600	P120
ABDE0375J3AQB K600	P120
ABDE0375J3ARB K600	P117
ABDE0375J3AS K600	P117
ABDE0375J3BQ K600	P120
ABDE0375J3BQB K600	P120
ABDE0375Y3CQA K600	029
ABDE0375Y3CQB K600	029
ABDE0375Y3CQC K600	029
ABDE0375Y3CQD K600	029
ABDE0500J3AQ K600	P120
ABDE0500J3AQB K600	P120
ABDE0500J3AQE K600	P120
ABDE0500J3ARB K600	P117
ABDE0500J3ARC K600	P117
ABDE0500J3ARE K600	P117
ABDE0500J3AS K600	P117
ABDE0500J3BQ K600	P120
ABDE0500J3BQB K600	P120
ABDE0500J3BQC K600	P120
ABDE0500J3BQD K600	P120
ABDE0500J3BQE K600	P120
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ABDE0500J3CQB K600	P120
ABDE0500J3CQC K600	P120
ABDE0500J3CQD K600	P120
ABDE0500J3CQE K600	P120
ABDE0500Y3CQA K600	029
ABDE0500Y3CQB K600	029
ABDE0500Y3CQC K600	029
ABDE0500Y3CQD K600	029
ABDE0500Y3CQE K600	029
ABDE0625J3AQ K600	P120
ABDE0625J3AQB K600	P120
ABDE0625J3AS K600	P117
ABDE0625J3BQ K600	P120
ABDE0625J3BQB K600	P120
ABDE0625J3BQE K600	P120
ABDE0625J3BRB K600	P117
ABDE0625J3BS K600	P117
ABDE0625Y3CQA K600	029
ABDE0625Y3CQB K600	029
ABDE0625Y3CQC K600	029
ABDE0625Y3CQD K600	029
ABDE0625Y3CQE K600	029
ABDE0750J3AQ K600	P120
ABDE0750J3AQB K600	P120
ABDE0750J3AQE K600	P120
ABDE0750J3ARB K600	P117
ABDE0750J3ARC K600	P117
ABDE0750J3ARE K600	P117
ABDE0750J3AS K600	P117
ABDE0750J3BQ K600	P121
ABDE0750J3BQB K600	P121
ABDE0750J3BQC K600	P121
ABDE0750J3BQD K600	P121
ABDE0750J3BQE K600	P121
ABDE0750J3BRB K600	P117
ABDE0750J3BRC K600	P117
ABDE0750J3BRE K600	P117
ABDE0750J3BS K600	P117
ABDE0750J3CQ K600	P121
ABDE0750J3CQB K600	P121
ABDE0750Y3CQB K600	029
ABDE0750Y3CQC K600	029
ABDE0750Y3CQD K600	029
ABDE0750Y3CQE K600	029
ABDE1000J3AQ K600	P121
ABDE1000J3AQB K600	P121
ABDE1000J3AQE K600	P121
ABDE1000J3ARB K600	P117
ABDE1000J3ARC K600	P117
ABDE1000J3ARE K600	P117
ABDE1000J3AS K600	P117
ABDE1000J3BQ K600	P121
ABDE1000J3BQB K600	P121
ABDE1000J3BQE K600	P121
ABDE1000J3BRB K600	P117
ABDE1000J3BRC K600	P117
ABDE1000J3BRE K600	P117
ABDE1000J3BS K600	P117
ABDE1000J3CQ K600	P121
ABDE1000J3CQB K600	P121
ABDE1000Y3CQB K600	029
ABDE1000Y3CQC K600	029
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ABDE1000Y3CQE K600	029
ABDE1000Y3CQF K600	029
ABDF0188J2ARA K600	P116
ABDF0188J2AS K600	P116
ABDF0250J2AQB K600	P118
ABDF0250J2ARA K600	P116
ABDF0250J2ARB K600	P116
ABDF0250J2AS K600	P116
ABDF0250J2BQ K600	P118
ABDF0250J2BQB K600	P118
ABDF0250J2CQ K600	P118
ABDF0250J2CQB K600	P118
ABDF0312J2AQB K600	P118
ABDF0312J2ARA K600	P116
ABDF0312J2ARB K600	P116
ABDF0312J2AS K600	P116
ABDF0375J2AQ K600	P118
ABDF0375J2AQB K600	P118
ABDF0375J2ARB K600	P116
ABDF0375J2AS K600	P116
ABDF0375J2BQ K600	P118
ABDF0375J2BQB K600	P118
ABDF0375Y2CU K600	028
ABDF0500J2AQ K600	P118
ABDF0500J2AQB K600	P118
ABDF0500J2AQE K600	P118
ABDF0500J2ARB K600	P116
ABDF0500J2ARC K600	P116
ABDF0500J2ARE K600	P116
ABDF0500J2AS K600	P116
ABDF0500J2BQ K600	P118
ABDF0500J2BQB K600	P118
ABDF0500J2BQC K600	P118
ABDF0500J2BQD K600	P118
ABDF0500J2BQE K600	P118
ABDF0500J2CQ K600	P118
ABDF0500J2CQB K600	P118
ABDF0500J2CQC K600	P118
ABDF0500J2CQD K600	P118
ABDF0500J2CQE K600	P118
ABDF0500Y2CU K600	028
ABDF0625J2AQ K600	P118
ABDF0625J2AS K600	P116
ABDF0625J2BQ K600	P118
ABDF0625J2BQB K600	P118
ABDF0625J2BQE K600	P118
ABDF0625J2BRB K600	P116
ABDF0625J2BRC K600	P116
ABDF0625J2BRE K600	P116
ABDF0625J2BS K600	P116
ABDF0625Y2CU K600	028
ABDF0750J2AQ K600	P118
ABDF0750J2AQB K600	P118
ABDF0750J2AQE K600	P118
ABDF0750J2ARB K600	P116
ABDF0750J2ARC K600	P116
ABDF0750J2ARE K600	P116
ABDF0750J2AS K600	P116
ABDF0750J2BQ K600	P119
ABDF0750J2BQB K600	P118
ABDF0750J2BQC K600	P118
ABDF0750J2BQD K600	P119
ABDF0750J2BQE K600	P119
ABDF0750J2BRB K600	P116
ABDF0750J2BRC K600	P116
ABDF0750J2BS K600	P116
ABDF0750J2CQ K600	P119
ABDF0750J2CQB K600	P119
ABDF0750Y2CU K600	028
ABDF1000J2AQ K600	P119
ABDF1000J2AQB K600	P119
ABDF1000J2AQE K600	P119
ABDF1000J2ARB K600	P116
ABDF1000J2ARC K600	P116
ABDF1000J2ARE K600	P116
ABDF1000J2AS K600	P116
ABDF1000J2BQ K600	P119
ABDF1000J2BQB K600	P119
ABDF1000J2BQE K600	P119
ABDF1000J2BRB K600	P116
ABDF1000J2BRC K600	P116
ABDF1000J2BS K600	P116
ABDF1000J2CQ K600	P119
ABDF1000J2CQB K600	P119
AFB09075SCFCR06	K134
AFB13085SCFCR06	K134
AFB17100SCFCR06	K134
AFB21110SCFCR09	K134
AFB24115SCFCR09	K134
AFB27115SCFCR09	K134
AFB31115SCFCR09	K134
AFB34115SCFCR09	K134
AFB38115SCFPR09	K134
AFB42115SCFPR09	K134
AFB47115SCFPR09	K134
AFM29115	K135
AFM29SCFPR06	K136
AFM47115	K135
AFM47SCFPR09	K136
ASPM07001802	T63–64
B041A01000CPG KC7325	G8
B041A01016CPG KC7325	G8
B041A01041CPG KC7325	G8
B041A01067CPG KC7325	G8
B041A01092CPG KC7325	G8
B041A01100CPG KC7325	G8
B041A01181CPG KC7325	G8
B041A01191CPG KC7325	G8
B041A01200CPG KC7325	G8
B041A01300CPG KC7325	G8
B041A01321CPG KC7325	G8
B041A01397CPG KC7325	G8
B041A01400CPG KC7325	G8
B041A01500CPG KC7325	G8
B041A01600CPG KC7325	G8
B041A01700CPG KC7325	G8

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B041A01800CPG KC7325	G8
B041A01900CPG KC7325	G8
B041A01984CPG KC7325	G8
B041A02000CPG KC7325	G8
B041A02100CPG KC7325	G8
B041A02200CPG KC7325	G8
B041A02300CPG KC7325	G8
B041A02383CPG KC7325	G8
B041A02400CPG KC7325	G8
B041A02439CPG KC7325	G8
B041A02489CPG KC7325	G8
B041A02500CPG KC7325	G8
B041A02578CPG KC7325	G8
B041A02600CPG KC7325	G8
B041A02642CPG KC7325	G8
B041A02700CPG KC7325	G8
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B042A03970CPG KC7325	G9
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B042A04090CPG KC7325	G9
B042A04100CPG KC7325	G9
B042A04200CPG KC7325	G9
B042A04217CPG KC7325	G9
B042A04300CPG KC7325	G9
B042A04366CPG KC7325	G9
B042A04400CPG KC7325	G9
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B042A04600CPG KC7325	G9
B042A04623CPG KC7325	G9
B042A04700CPG KC7325	G9
B042A04763CPG KC7325	G9
B042A04800CPG KC7325	G9
B042A04852CPG KC7325	G9
B042A04900CPG KC7325	G9
B042A05000CPG KC7325	G9
B042A05100CPG KC7325	G9
B042A05106CPG KC7325	G9
B042A05159CPG KC7325	G9
B042A05200CPG KC7325	G9

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B042A05300CPG KC7325	G9
B042A05400CPG KC7325	G9
B042A05410CPG KC7325	G9
B042A05500CPG KC7325	G9
B042A05558CPG KC7325	G9
B042A05600CPG KC7325	G10
B042A05616CPG KC7325	G10
B042A05700CPG KC7325	G10
B042A05800CPG KC7325	G10
B042A05900CPG KC7325	G10
B042A05954CPG KC7325	G10
B042A06000CPG KC7325	G10
B042A06100CPG KC7325	G10
B042A06200CPG KC7325	G10
B042A06300CPG KC7325	G10
B042A06350CPG KC7325	G10
B042A06400CPG KC7325	G10
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B042A06528CPG KC7325	G10
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B042A11400CPG KC7325	G11
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B042A11600CPG KC7325	G11
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B051A05300CPG KC7325	G15
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B051A05558CPG KC7325	G15
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B051A05700CPG KC7325	G15
B051A05800CPG KC7325	G15
B051A05900CPG KC7325	G15
B051A05954CPG KC7325	G15
B051A06000CPG KC7325	G16
B051A06100CPG KC7325	G16
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B051A06400CPG KC7325	G16
B051A06500CPG KC7325	G16
B051A06528CPG KC7325	G16
B051A06600CPG KC7325	G16
B051A06630CPG KC7325	G16
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B051A06746CPG KC7325	G16
B051A06800CPG KC7325	G16
B051A06900CPG KC7325	G16
B051A07000CPG KC7325	G16
B051A07100CPG KC7325	G16
B051A07145CPG KC7325	G16
B051A07200CPG KC7325	G16
B051A07300CPG KC7325	G16
B051A07400CPG KC7325	G16
B051A07500CPG KC7325	G16
B051A07541CPG KC7325	G16
B051A07600CPG KC7325	G16
B051A07700CPG KC7325	G16
B051A07800CPG KC7325	G16
B051A07900CPG KC7325	G16
B051A07938CPG KC7325	G16
B051A08000CPG KC7325	G16
B051A08100CPG KC7325	G16
B051A08200CPG KC7325	G16
B051A08300CPG KC7325	G16
B051A08334CPG KC7325	G16
B051A08400CPG KC7325	G16
B051A08433CPG KC7325	G16
B051A08500CPG KC7325	G16
B051A08600CPG KC7325	G16
B051A08700CPG KC7325	G16
B051A08733CPG KC7325	G16
B051A08800CPG KC7325	G16
B051A08900CPG KC7325	G16
B051A09000CPG KC7325	G16
B051A09100CPG KC7325	G16
B051A09129CPG KC7325	G16
B051A09200CPG KC7325	G16
B051A09300CPG KC7325	G16
B051A09347CPG KC7325	G16
B051A09400CPG KC7325	G16
B051A09500CPG KC7325	G16
B051A09525CPG KC7325	G16
B051A09600CPG KC7325	G16
B051A09700CPG KC7325	G16
B051A09800CPG KC7325	G16
B051A09900CPG KC7325	G17
B051A09921CPG KC7325	G17
B051A10000CPG KC7325	G17
B051A10100CPG KC7325	G17
B051A10200CPG KC7325	G17
B051A10300CPG KC7325	G17
B051A10320CPG KC7325	G17
B051A10400CPG KC7325	G17
B051A10500CPG KC7325	G17
B051A10600CPG KC7325	G17
B051A10700CPG KC7325	G17
B051A10716CPG KC7325	G17
B051A10800CPG KC7325	G17

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B051A10900CPG KC7325	G17
B051A11000CPG KC7325	G17
B051A11100CPG KC7325	G17
B051A11113CPG KC7325	G17
B051A11200CPG KC7325	G17
B051A11300CPG KC7325	G17
B051A11400CPG KC7325	G17
B051A11500CPG KC7325	G17
B051A11509CPG KC7325	G17
B051A11600CPG KC7325	G17
B051A11700CPG KC7325	G17
B051A11800CPG KC7325	G17
B051A11900CPG KC7325	G17
B051A11908CPG KC7325	G17
B051A12000CPG KC7325	G17
B051A12100CPG KC7325	G17
B051A12200CPG KC7325	G17
B051A12300CPG KC7325	G17
B051A12304CPG KC7325	G17
B051A12400CPG KC7325	G17
B051A12500CPG KC7325	G17
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B051A12700CPG KC7325	G17
B051A12800CPG KC7325	G17
B051A12900CPG KC7325	G17
B051A13000CPG KC7325	G17
B051A13096CPG KC7325	G17
B051A13100CPG KC7325	G17
B051A13200CPG KC7325	G17
B051A13300CPG KC7325	G17
B051A13400CPG KC7325	G17
B051A13500CPG KC7325	G17
B051A13600CPG KC7325	G17
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B051A13891CPG KC7325	G17
B051A13900CPG KC7325	G17
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B051A14288CPG KC7325	G18
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B051A14684CPG KC7325	G18
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B052A14000CPG KC7325	G17
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B052A14288CPG KC7325	G18
B052A14300CPG KC7325	G18
B052A14400CPG KC7325	G18
B052A14500CPG KC7325	G18
B052A14600CPG KC7325	G18
B052A14684CPG KC7325	G18
B052A14700CPG KC7325	G18
B052A14800CPG KC7325	G18
B052A14900CPG KC7325	G18
B052A15000CPG KC7325	G18
B052A15083CPG KC7325	G18
B052A15100CPG KC7325	G18
B052A15200CPG KC7325	G18
B052A15300CPG KC7325	G18
B052A15400CPG KC7325	G18
B052A15479CPG KC7325	G18
B052A15500CPG KC7325	G18
B052A15600CPG KC7325	G18
B052A15700CPG KC7325	G18
B052A15800CPG KC7325	G18
B052A15875CPG KC7325	G18
B052A15900CPG KC7325	G18
B052A16000CPG KC7325	G18
B052A16100CPG KC7325	G18
B052A16200CPG KC7325	G18
B052A16271CPG KC7325	G18
B052A16300CPG KC7325	G18
B052A16400CPG KC7325	G18
B052A16500CPG KC7325	G18
B052A16600CPG KC7325	G18
B052A16670CPG KC7325	G18
B052A16700CPG KC7325	G18
B052A16800CPG KC7325	G18
B052A16900CPG KC7325	G18
B052A17000CPG KC7325	G18
B052A17100CPG KC7325	G18

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B052A17200CPG KC7325	G18
B052A17300CPG KC7325	G18
B052A17400CPG KC7325	G18
B052A17463CPG KC7325	G18
B052A17500CPG KC7325	G18
B052A17600CPG KC7325	G18
B052A17700CPG KC7325	G18
B052A17800CPG KC7325	G18
B052A17859CPG KC7325	G18
B052A17900CPG KC7325	G18
B052A18000CPG KC7325	G18
B052A18100CPG KC7325	G18
B052A18200CPG KC7325	G18
B052A18258CPG KC7325	G18
B052A18300CPG KC7325	G18
B052A18400CPG KC7325	G19
B052A18500CPG KC7325	G19
B052A18600CPG KC7325	G19
B052A18654CPG KC7325	G19
B052A18700CPG KC7325	G19
B052A18800CPG KC7325	G19
B052A18900CPG KC7325	G19
B052A19000CPG KC7325	G19
B052A19050CPG KC7325	G19
B052A19100CPG KC7325	G19
B052A19200CPG KC7325	G19
B052A19300CPG KC7325	G19
B052A19400CPG KC7325	G19
B052A19500CPG KC7325	G19
B052A19600CPG KC7325	G19
B052A19700CPG KC7325	G19
B052A19800CPG KC7325	G19
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B105A05700 K10	G24
B105A05800 K10	G24
B105A06000 K10	G24
B105A06100 K10	G24

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B105A06200 K10	G24
B105A06300 K10	G24
B105A06350 K10	G24
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B212A03000SGL KCMS15	G30
B212A03175SGL KCMS15	G30
B212A03200SGL KCMS15	G30
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B212A03300SGL KCMS15	G30
B212A03455SGL KCMS15	G30
B212A03500SGL KCMS15	G30
B212A03571SGL KCMS15	G30

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B212A03658SGL KCMS15	G30
B212A03700SGL KCMS15	G30
B212A03800SGL KCMS15	G30
B212A04000SGL KCMS15	G30
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B224A03400HP KCPK15	G44
B224A03455HP KCPK15	G44
B224A03500HP KCPK15	G44
B224A03600HP KCPK15	G44
B224A03658HP KCPK15	G44
B224A03700HP KCPK15	G44

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B224A03734HP KCPK15	G44
B224A03800HP KCPK15	G44
B224A03900HP KCPK15	G44
B224A03970HP KCPK15	G44
B224A04000HP KCPK15	G44
B224A04039HP KCPK15	G44
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B225A16670HP KCPK15	G47
B225A17000HP KCPK15	G48
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B225A19050HP KCPK15	G48
B225A19200HP KCPK15	G48
B225A19250HP KCPK15	G48
B225A19300HP KCPK15	G48
B225A19500HP KCPK15	G48
B225A20000HP KCPK15	G48
B225A20500HP KCPK15	G48
B225A21000HP KCPK15	G48
B24CTFPR4	B184, B390
B254A03000YPC KCK10	G52
B254A03048YPC KCK10	G52
B254A03200YPC KCK10	G52
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B254A05558YPC KCK10	G53
B254A05791YPC KCK10	G53
B254A05800YPC KCK10	G53
B254A06000YPC KCK10	G53

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B254A06100YPC KCK10	G53
B254A06200YPC KCK10	G53
B254A06500YPC KCK10	G53
B254A06528YPC KCK10	G53
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B256A09100YPC KCK10	G54
B256A09300YPC KCK10	G54
B256A09347YPC KCK10	G54
B256A09500 KC7315	G58
B256A09500YPC KCK10	G54
B256A09600YPC KCK10	G54
B256A09700YPC KCK10	G54

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B256A09800YPC KCK10	G54
B256A10000 KC7315	G58
B256A10000YPC KCK10	G54
B256A10200 KC7315	G58
B256A10200YPC KCK10	G54
B256A10300YPC KCK10	G54
B256A10400YPC KCK10	G54
B256A10500 KC7315	G58
B256A10500YPC KCK10	G54
B256A10700YPC KCK10	G54
B256A10800YPC KCK10	G54
B256A11000 KC7315	G58
B256A11000YPC KCK10	G54
B256A11200YPC KCK10	G54
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B256A12400YPC KCK10	G55
B256A12500 KC7315	G58
B256A12500YPC KCK10	G55
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B256A13000YPC KCK10	G55
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B256A13500YPC KCK10	G55
B256A13700YPC KCK10	G55
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For page references A–E, please see Volume I • Turning Tools Catalog.

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B274Z07000HPG KCPK20	G73
B274Z07000HPS KN25	G73
B274Z07000SGL KCMS20	G73

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B274Z07145SGL KCMS20	G73
B274Z07500SGL KCMS20	G73
B274Z07700HPG KCPK20	G74
B274Z07938HPG KCPK20	G74
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B285D06700HPS KN15	G83
B285D06746HPS KN15	G83
B285D06800HPS KN15	G83
B285D06900HPS KN15	G83

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B285D07000HPS KN15	G83
B285D07145HPS KN15	G83
B285D07300HPS KN15	G83
B285D07400HPS KN15	G83
B285D07541HPS KN15	G83
B285D07600HPS KN15	G83
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For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
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B551A04763DAL KN15	G104
B551A06350DAL KN15	G104

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B551A07938DAL KN15	G104
B551A09525DAL KN15	G104
B551A11113DAL KN15	G104
B551A12700DAL KN15	G104
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B966A03000 KC7315	G130
B966A03100 KC7315	G130

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B966A03200 KC7315	G130
B966A03300 KC7315	G130
B966A03400 KC7315	G130
B966A03500 KC7315	G130
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B976A15875 KC7315	G138
B976A16000 KC7315	G138
B976A16200 KC7315	G138
B976A16500 KC7315	G138

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B976A16670 KC7315	G138
B976A16800 KC7315	G138
B976A17000 KC7315	G138
B976A17100 KC7315	G138
B976A17463 KC7315	G138
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B978A15875 KC7315	G141
B978A16000 KC7315	G141
B978A16078 KC7315	G141
B978A16200 KC7315	G141

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
B978A16500 KC7315	G141
B978A17000 KC7315	G141
B978A17463 KC7315	G141
B978A17500 KC7315	G141
B978A18000 KC7315	G141
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BGHX15L5PCERGGT KD1415	S124
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BGHX15L5PCFRGG KC510M	S124
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BGHX15L5PCTRGG KC510M	S124
BGHX15L5PCTRHET KD1410	S125
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BMD125R1203M16L150	V68
BMD125R1203W125L200	V68
BMD150R1203C125L800	V69
BMD150R1204M16L150	V68
BMD150R1204S050L158	V70
BMD150R1204W150L200	V68
BMD150R1602C125L800	V76
BMD150R1603M16	V75
BMD150R1603W125L200	V75
BMD200R1203S075L200	V70
BMD200R1205S075L200	V70
BMD200R1603S075L200	V77
BMD200R1604S075L200	V77
BMD200R6403W150L200	V87
BMD250R1207S100L200	V70
BMD250R1605S100L200	V77
BMD250R6404S075L200	V88
BMD300R1206S100L200	V70
BMD300R1208S100L200	V70
BMD300R1605S100L200	V77
BMD300R1607S100L200	V77
BMD300R6405S100L200	V88
BMD300R8603S075L200	V91
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BMD400R1608S125L200	V77
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BMD400R6406S125L200	V88
BMD400R8605S125L250	V91
BMD500R6406S150L250	V88
BMD500R6408S150L250	V88
BMD500R8606S150L250	V91
BMD600R1610S150L250	V77
BMD600R6407S150L250	V88
BMD600R6408S150L250	V88
BMD600R8607S150L250	V91
BMD800R6409S250L250	V88
BMD800R6409S250L250HP	V88
BMD800R8608S250L250	V91
BMD800R8608S250L250HP	V91
BP46	B170, B385
BP68	B170, B385
BP812	B170, B385
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BT40BDL12200	053
BT40BDL16225	053
BT40BDL20225	053
BT40BDL25238	053
BT40BDL32275	053
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BT40BKR50050M	K91
BT40BSIF80063M	K48
BT40FBHM1691	K133
BT40FBHMKIT164M	K127, K131
BT50BHTS22075M	J91
BT50BHTS32080M	J91
BT50BHTS40080M	J91
BT50BHTS50080M	J91
BT50BKR32040M	K91
BT50BKR50040M	K91
BT50BKR63060M	K91
BT50BKR80060M	K91
BT50BSIF100068M	K49
BT50BSIF70063M	K49
BT50BT13088	K142
BTQSW3L90	S30
BTQT25	S94, S98, S100
C11816W KWH	B407
C11820W KWH	B407
C11932W KWH	B409
C11940W KWH	B409
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C2FIX180610LMN KCP25	E8
C2FIX180610LMN KCP40	E8
C2FIX180610LMN KCU10	E8
C5230VS09-A2.0Z04R3.1	T128
C5230VS09-A2.0Z4R2.0	T128
C5230VS09CA2.0Z04R4.0	T127
C5230VS12-A2.5Z4R2.24	T131
C5230VS12-A2.5Z4R3.70	T131
C5230VS12-A3.0Z5R2.56	T131
C5230VS12-A3.0Z5R4.33	T131
C5505VX05CA.62R1.6	V114
C5505VX05CA.75/.62R1	V114
C5505VX06CA.75R1.7	V114
C5505VX06CA1/.75R1.5	V114
C5505VX06WA.750R2.00	V113
C5505VX08CA1.00R2.2	V114
C5505VX08WA1.00R2.37	V112
C5505VX10CA1.25R2.2	V114
C5505VX10WA1.25R3.00	V112
C5505VX10WA1.25R4.00	V112
C5505VX12WA1.50R4.00	V112
C5505VX12WA1.50R6.00	V112
C5505VX16WA2.00R4.00	V112
C5505VX16WA2.00R6.00 S	V112
C5720VZ16-A1.50Z03R	T98
C5720VZ16-A2.00Z03R	T98
C5720VZ16-A2.00Z04R	T98
C5720VZ16-A2.50Z04R	T98
C5720VZ16-A2.50Z05R	T98
C5720VZ16-A3.00Z04R	T98
C5720VZ16-A3.00Z05R	T98
C5720VZ16CA1.0Z02R2.7	T97
C5720VZ16CA1.25Z2R3.0	T97
C5720VZ16CA1.25Z3R3.0	T97
C6420 KWH	B408
C6420W KWH	B408
C6424W KWH	B408
C6428W KWH	B408
C6432W KWH	B408
C6440W KWH	B408
C7713VR10-A1.50Z05R	V98
C7713VR10-A2.00Z7R	V98
C7713VR10-A2.50Z8R	V98
C7713VR10CA1.00Z3R2.0	V97–98
C7713VR10CA1.25Z4R2.7	V97–98
C7713VR12-A1.50Z4R	V103
C7713VR12-A1.50Z5R	V103
C7713VR12-A2.00Z4R	V103
C7713VR12-A2.00Z5R	V103
C7713VR12-A2.00Z6R	V103
C7713VR12-A2.50Z6R	V103
C7713VR12-A2.50Z7R	V103
C7713VR12-A3.00Z8R	V103
C7713VR12CA1.00Z2R2.0	V102–103
C7713VR12CA1.25Z3R2.7	V102–103
C7792VXD09-A1.50Z4R	V12–13
C7792VXD09-A1.50Z5R	V12–13
C7792VXD09-A2.00Z5R	V12–13
C7792VXD09-A2.00Z6R	V12–13
C7792VXD09-A2.00Z7R	V12–13
C7792VXD09CA1.00Z2R2	V11, V13
C7792VXD09CA1.00Z3R2	V11, V13
C7792VXD09CA1.25Z3R3	V11, V13
C7792VXD09CA1.25Z4R3	V11, V13
C7792VXD09WA1.00Z2R	V10, V13
C7792VXD09WA1.25Z3R	V10, V13
C7792VXD12-6.00Z12R	V19–20
C7792VXD12-6.00Z15R	V19–20
C7792VXD12-6.30Z8R	V19–20
C7792VXD12-A1.50Z4R	V19–20
C7792VXD12-A2.00Z3R	V19–20
C7792VXD12-A2.00Z4R	V19–20
C7792VXD12-A2.00Z5R	V19–20
C7792VXD12-A2.00Z6R	V19–20
C7792VXD12-A2.50Z4R	V19–20
C7792VXD12-A2.50Z5R	V19–20
C7792VXD12-A2.50Z7R	V19–20
C7792VXD12-A3.00Z5R	V19–20
C7792VXD12-A3.00Z8R	V19–20
C7792VXD12-A3.00Z9R	V19–20
C7792VXD12-A4.00Z11R	V19–20
C7792VXD12-A4.00Z6R S	V19–20
C7792VXD12-A4.00Z9R	V19–20
C7792VXD12-A5.00Z11R	V19–20
C7792VXD12-A5.00Z13R	V19–20
C7792VXD12-A5.00Z8R	V19–20
C7792VXD12CA1.2/1.5Z3	V18, V20
C7792VXD12CA1.25Z2R3	V18, V20
C7792VXD12CA1.25Z3R3	V18, V20
C7792VXD12CA1.50Z4R3	V18, V20
C7792VXE16-6.00Z12R	V26–27
C7792VXE16-6.00Z13R	V26–27
C7792VXE16-A1.5/4.00Z7R	V26
C7792VXE16-A1.5/4.00Z9R	V26
C7792VXE16-A2.00Z4R	V26–27
C7792VXE16-A2.50Z5R	V26–27
C7792VXE16-A2.50Z6R	V26–27
C7792VXE16-A3.00Z6R	V26–27
C7792VXE16-A3.00Z7R	V26–27
C7792VXE16-A4.00Z8R	V26–27
C7792VXE16-A4.00Z9R	V26–27
C7792VXE16-A5.00Z10R	V26–27
C7792VXE16-A5.00Z11R	V26–27
C7792VXE16CA1.50Z2R4	V25
C7792VXE16CA2.00Z3R4	V25, V27
C7792VXP06CA.62Z2R5.5	V5–6
C7792VXP06CA.75Z3R6.1	V5–6
C7792VXP06CA1.0Z4R6.1	V5–6
C7792VXP06CA1.25Z5R8	V5–6
C8FIX120503LMP KCP10	E13
C8FIX120503LMP KCP25	E13
C8FIX120503LMP KCU10	E13
C8FIX120503RMP KCP25	E13
C8FIX120503RMP KCU10	E13
C8FIX120503RMP KCU25	E13
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	E13
C8FIX150603RMP KCP10	E13
C8FIX150603RMP KCP25	E13
C8FIX150603RMP KCP40	E13
C8FIX150603RMP KCU10	E13
C8FIX150603RMP KCU25	E13
C8FIX150605LRN KCP25	E12
C8FIX150605LRN KCP40	E12
C8FIX150605LRN KCU25	E12
C8FIX150605RRN KCP10	E12
C8FIX150605RRN KCP25	E12
C8FIX150605RRN KCP40	E12
C8FIX150605RRN KCU10	E12
C8FIX150605RRN KCU25	E12
C8FIX150608LRN KCP25	E12
C8FIX150608LRN KCU25	E12
C8FIX150608LRP KCU25	E12
C8FIX150608RRN KCP10	E12
C8FIX150608RRN KCP25	E12
C8FIX150608RRN KCP40	E12
C8FIX150608RRN KCU25	E12
C8FIX150612LRN KCP25	E12
C8FIX150612LRP KCP25	E12
C8FIX150612RRN KCP25	E12
C8FIX180805RMP KCP25	E13
C8FIX180808RRN KCP25	E12
C8FIX180808RRN KCP40	E12
C8FIX180812LRN KCP25	E12
C8FIX180812RRN KCP25	E12
C8FIX180812RRN KCP40	E12
C8FIX180812RRN KCU25	E12
CBDB0250JXAS KCN05	P138
CBDB0250JXBS KCN05	P138
CBDB0375JXAS KCN05	P138
CBDB0375JXBS KCN05	P138
CBDB0500JXAS KCN05	P138
CBDB0500JXBS KCN05	P138
CBTF150R2WD20N2M	J114
CBTF160R2WD20N2M	J114
CBTF170R2WD20N2M	J114
CBTF180R2WD20N2M	J114
CBTF180R2WD20N3M	J114
CBTF200R2WD20N2M	J114
CBTF200R2WD20N3M	J114
CBTF210R2WD20N2M	J114
CBTF210R2WD20N3M	J114
CBTF220R2WD20N2M	J114
CBTF220R2WD20N3M	J114
CBTF230R2WD20N2M	J114
CBTF230R2WD20N3M	J114
CBTF240R2WD20N2M	J114
CBTF240R2WD20N3M	J114
CBTF250R2WD20N2M	J114
CBTF250R2WD20N3M	J114
CBTF260R2WD20N2M	J114
CBTF270R2WD20N3M	J114
CBTF280R2WD20N3M	J114
CBTF300R2WD20N3M	J114
CBTF320R2WD20N3M	J114
CBTF330R2WD20N3M	J114
CBTF340R2WD32N3M	J114
CBTF350R2WD32N3M	J114
CBTF360R2WD32N3M	J114
CBTF380R2WD32N3M	J114
CBTF400R2WD32N3M	J114
CBTF420R2WD32N3M	J114
CBTF460R2WD32N3M	J114
CC09	B200–204
CC11	B200–203
CCGM3251S0525MTCB1 KBH20	B328
CCGM3252S0525MTCB1 KBH20	B328
CCGT21505HP K313	B189
CCGT21505HP KC5025	B189
CCGT21505HP KC5410	B189
CCGT21505HP KCU10	B189
CCGT21505HP KCU25	B189
CCGT21505LF KC5010	B189
CCGT21505LF KC5025	B189
CCGT21505LF KCU10	B189
CCGT2150LF KC5010	B189
CCGT2150LF KC5025	B189

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
CCGT2150LF KCU10	B189
CCGT2151HP K313	B189
CCGT2151HP KC5010	B189
CCGT2151HP KC5025	B189
CCGT2151HP KC5410	B189
CCGT2151HP KCU10	B189
CCGT2151HP KCU25	B189
CCGT2151LF KC5010	B189
CCGT2151LF KC5025	B189
CCGT2151LF KCU10	B189
CCGT2152HP KC5010	B189
CCGT2152HP KC5410	B189
CCGT2152HP KCU25	B189
CCGT2152LF KC5010	B189
CCGT2152LF KCU10	B189
CCGT215X0LF KC5025	B189
CCGT32505HP K313	B189
CCGT32505HP KC5010	B189
CCGT32505HP KC5025	B189
CCGT32505HP KC5410	B189
CCGT32505HP KCU10	B189
CCGT32505HP KCU25	B189
CCGT32505LF KC5010	B189
CCGT32505LF KC5025	B189
CCGT32505LF KCU10	B189
CCGT3250LF KC5010	B189
CCGT3250LF KC5025	B189
CCGT3250LF KCU10	B189
CCGT3251HP K313	B189
CCGT3251HP KC5010	B189
CCGT3251HP KC5025	B189
CCGT3251HP KC5410	B189
CCGT3251HP KCU10	B189
CCGT3251HP KCU25	B189
CCGT3251LF KC5010	B189
CCGT3251LF KC5025	B189
CCGT3251LF KC5410	B189
CCGT3251LF KCU10	B189
CCGT3252HP KC5010	B189
CCGT3252HP KC5025	B189
CCGT3252HP KC5410	B189
CCGT3252HP KCU10	B189
CCGT3252HP KCU25	B189
CCGT3252LF K313	B189
CCGT3252LF KC5010	B189
CCGT3252LF KC5025	B189
CCGT3252LF KCU10	B189
CCGT325X0LF KC5025	B189
CCGT4305HP KC5010	B189
CCGT4305HP KCU10	B189
CCGT4305HP KCU25	B189
CCGT431HP K313	B189
CCGT431HP KC5010	B189
CCGT431HP KC5025	B189
CCGT431HP KC5410	B189
CCGT431HP KCU10	B189
CCGT432HP K313	B189
CCGT432HP KC5010	B189
CCGT432HP KC5410	B189
CCGT432HP KCU10	B189
CCGT432HP KCU25	B189
CCGW21505S0415C KB5630	B311, B328
CCGW21505S0415MT KBH10	B328
CCGW21505S0525MT KBH20	B328
CCGW2151FST KD1400	B362
CCGW2151FST KD1425	B362
CCGW2151S0415C KB5630	B311, B328
CCGW2151S0415MT KBH10	B328
CCGW2151S0525MT KBH20	B328
CCGW32505S0415MT KBH10	B328
CCGW32505S0525MT KBH20	B328
CCGW3251FST KD1400	B362
CCGW3251FST KD1425	B362
CCGW3251S0415FWMT KBH20	B328
CCGW3251S0415MT KB5630	B311, B328
CCGW3251S0415MT KBH10	B328
CCGW3251S0415MT KBH20	B328
CCGW3251S0525MT KBH10	B328
CCGW3251S0525MT KBH20	B328
CCGW3252EC KB1345	B311
CCGW3252FST KD1400	B362
CCGW3252FST KD1425	B362
CCGW3252S0415FWMT KBH10	B328
CCGW3252S0415FWMT KBH20	B328
CCGW3252S0415MT KB5630	B311, B328
CCGW3252S0415MT KBH10	B328
CCGW3252S0415MT KBH20	B328
CCGW3252S0525MT KBH10	B328
CCGW3252S0525MT KBH20	B328
CCGW432S0415MT KBH20	B328
CCLNL164	B372
CCLNL164DMX5	B383
CCLNL204DMX5	B383
CCLNLP163D	B372
CCLNR164	B372
CCLNR164DMX5	B383
CCLNR204DMX5	B383
CCLNRP163D	B372
CCLPL124B	B165, B376
CCLPL164C	B165, B376
CCLPR084V	B165, B376
CCLPR124B	B165, B376
CCLPR164C	B165, B376
CCMT21505FP KCM25	B190
CCMT21505FP KCM25B	B190
CCMT21505FP KCP10	B190
CCMT21505FP KCP25	B190
CCMT21505FP KCU10	B190
CCMT21505FP KCU25	B190
CCMT21505FW KC5010	B190
CCMT21505FW KT315	B190
CCMT21505LF KC5010	B191
CCMT21505LF KC5025	B191
CCMT21505LF KT315	B191
CCMT215111 KT315	B190
CCMT2151FP KCM15	B190
CCMT2151FP KCM15B	B190
CCMT2151FP KCM25	B190
CCMT2151FP KCM25B	B190
CCMT2151FP KCP05	B190
CCMT2151FP KCP10	B190
CCMT2151FP KCP10B	B190
CCMT2151FP KCP25	B190
CCMT2151FP KCP25B	B190
CCMT2151FP KCU10	B190
CCMT2151FP KCU25	B190
CCMT2151FP KTP10	B190
CCMT2151FW KC5010	B190
CCMT2151FW KCK20B	B190
CCMT2151FW KCP25	B190
CCMT2151FW KCU10	B190
CCMT2151FW KT315	B190
CCMT2151LF K313	B191
CCMT2151LF KC5010	B191
CCMT2151LF KC5025	B191
CCMT2151LF KCK05	B191
CCMT2151LF KCK15	B191
CCMT2151LF KCK15B	B191
CCMT2151LF KCK20	B191
CCMT2151LF KCK20B	B191
CCMT2151LF KCM15	B191
CCMT2151LF KCM15B	B191
CCMT2151LF KCM25	B191
CCMT2151LF KCM25B	B191
CCMT2151LF KCM35	B191
CCMT2151LF KCP10	B191
CCMT2151LF KCP10B	B191
CCMT2151LF KCP25	B191
CCMT2151LF KCP25B	B191
CCMT2151LF KCP30	B191
CCMT2151LF KT315	B191
CCMT2151MF KCK15	B191
CCMT2151MF KCK20	B191
CCMT2151MF KCM15B	B191
CCMT2151MF KCM25	B191
CCMT2151MF KCM25B	B191
CCMT2151MF KCM35	B191
CCMT2151MF KCP10	B191
CCMT2151MF KCP10B	B191
CCMT2151MF KCP25	B191
CCMT2151MF KCP25B	B191
CCMT2151MF KCP30	B191
CCMT2151MP KCM15	B191
CCMT2151MP KCM15B	B191
CCMT2151MP KCM25	B191
CCMT2151MP KCM25B	B191
CCMT2151MP KCP10	B191
CCMT2151MP KCP25	B191
CCMT2151MP KCU10	B191
CCMT2151UF KC5010	B192
CCMT2151UF KCP05	B192
CCMT2151UF KCP10	B192
CCMT2151UF KCP25	B192
CCMT2151UF KCP25B	B192
CCMT2152FP KCM25	B190
CCMT2152FP KCM25B	B190
CCMT2152FP KCP25	B190
CCMT2152FP KCP25B	B190
CCMT2152FP KCU10	B190
CCMT2152FP KCU25	B190
CCMT2152FP KTP10	B190
CCMT2152FW KC5010	B190
CCMT2152FW KCK20	B190
CCMT2152FW KCP25	B190
CCMT2152FW KT315	B190
CCMT2152LF KC5010	B191
CCMT2152LF KC5025	B191
CCMT2152LF KCK05	B191
CCMT2152LF KCK05B	B191
CCMT2152LF KCK15	B191
CCMT2152LF KCK15B	B191
CCMT2152LF KCK20B	B191
CCMT2152LF KCM15B	B191
CCMT2152LF KCM25	B191
CCMT2152LF KCP05	B191
CCMT2152LF KCP10	B191
CCMT2152LF KCP25	B191
CCMT2152LF KCP25B	B191
CCMT2152LF KCP30	B191
CCMT2152LF KT315	B191
CCMT32505FP KCM25	B190
CCMT32505FP KCM25B	B190
CCMT32505FP KCP25	B190
CCMT32505FP KCP25B	B190
CCMT32505FP KCU10	B190
CCMT32505FP KCU25	B190
CCMT32505FP KTP10	B190
CCMT32505LF K313	B191
CCMT32505LF KC5010	B191
CCMT32505LF KC5025	B191
CCMT32505LF KT315	B191
CCMT32505UF KC5010	B192
CCMT32505UF KCP05	B192
CCMT32505UF KCP10	B192
CCMT325111 KT315	B190
CCMT3251FP KCM15	B190
CCMT3251FP KCM15B	B190
CCMT3251FP KCM25	B190
CCMT3251FP KCM25B	B190
CCMT3251FP KCP05	B190
CCMT3251FP KCP10B	B190
CCMT3251FP KCP25	B190
CCMT3251FP KCP25B	B190
CCMT3251FP KCU10	B190
CCMT3251FP KCU25	B190
CCMT3251FP KTP10	B190
CCMT3251FW KC5010	B190
CCMT3251FW KCP25	B190
CCMT3251FW KCU10	B190
CCMT3251FW KT315	B190
CCMT3251LF K313	B191
CCMT3251LF KC5010	B191
CCMT3251LF KC5025	B191
CCMT3251LF KCK05	B191
CCMT3251LF KCK15	B191
CCMT3251LF KCK15B	B191
CCMT3251LF KCK20	B191
CCMT3251LF KCM15B	B191
CCMT3251LF KCM25	B191
CCMT3251LF KCM25B	B191
CCMT3251LF KCM35	B191
CCMT3251LF KCP10	B191
CCMT3251LF KCP10B	B191
CCMT3251LF KCP25	B191
CCMT3251LF KCP25B	B191
CCMT3251LF KCP30	B191
CCMT3251LF KT315	B191
CCMT3251MF KCK15	B191
CCMT3251MF KCK15B	B191
CCMT3251MF KCK20	B191
CCMT3251MF KCK20B	B191
CCMT3251MF KCM15B	B191
CCMT3251MF KCM25	B191
CCMT3251MF KCM25B	B191
CCMT3251MF KCP10B	B191
CCMT3251MF KCP25	B191
CCMT3251MF KCP25B	B191
CCMT3251MF KCP30	B191
CCMT3251MP KCK20B	B191
CCMT3251MP KCM15B	B191
CCMT3251MP KCM25	B191
CCMT3251MP KCM25B	B191
CCMT3251MP KCP10	B191
CCMT3251MP KCP25	B191
CCMT3251MP KCU10	B191
CCMT3251MW KC5010	B192
CCMT3251MW KCM15B	B192
CCMT3251MW KCU10	B192
CCMT3251MW KT315	B192
CCMT3251UF KC5010	B192
CCMT3251UF KCP10	B192
CCMT3251UF KCP25	B192
CCMT325211 KT315	B190
CCMT3252FP KCM15B	B190
CCMT3252FP KCM25	B190
CCMT3252FP KCM25B	B190
CCMT3252FP KCP10	B190
CCMT3252FP KCP10B	B190
CCMT3252FP KCP25	B190
CCMT3252FP KCP25B	B190
CCMT3252FP KCU10	B190
CCMT3252FP KCU25	B190
CCMT3252FP KTP10	B190
CCMT3252FW KC5010	B190
CCMT3252FW KCK20	B190
CCMT3252FW KCM15B	B190
CCMT3252FW KCP25	B190
CCMT3252FW KCU10	B190
CCMT3252FW KT315	B190
CCMT3252LF K313	B191
CCMT3252LF KC5010	B191
CCMT3252LF KCK05	B191
CCMT3252LF KCK15	B191
CCMT3252LF KCK15B	B191
CCMT3252LF KCK20	B191
CCMT3252LF KCK20B	B191
CCMT3252LF KCM15B	B191
CCMT3252LF KCM25	B191
CCMT3252LF KCM25B	B191
CCMT3252LF KCM35	B191
CCMT3252LF KCP05	B191
CCMT3252LF KCP10	B191
CCMT3252LF KCP10B	B191
CCMT3252LF KCP25	B191
CCMT3252LF KCP25B	B191
CCMT3252LF KCP30	B191
CCMT3252LF KT315	B191
CCMT3252MF KC5025	B191
CCMT3252MF KCK15	B191
CCMT3252MF KCK15B	B191
CCMT3252MF KCK20	B191
CCMT3252MF KCK20B	B191
CCMT3252MF KCM15B	B191
CCMT3252MF KCM25	B191
CCMT3252MF KCM25B	B191
CCMT3252MF KCM35	B191
CCMT3252MF KCP10B	B191
CCMT3252MF KCP25	B191
CCMT3252MF KCP25B	B191
CCMT3252MF KCP30	B191
CCMT3252MP KCK20	B191
CCMT3252MP KCK20B	B191
CCMT3252MP KCM15B	B191
CCMT3252MP KCM25	B191
CCMT3252MP KCM25B	B191
CCMT3252MP KCP10	B191
CCMT3252MP KCP25	B191
CCMT3252MP KCU10	B191

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
CCMT3252MW KC5010	B192
CCMT3252MW KCK20	B192
CCMT3252MW KCK20B	B192
CCMT3252MW KCM15B	B192
CCMT3252MW KCP25	B192
CCMT3252MW KCU10	B192
CCMT3252MW KT315	B192
CCMT3252UF KC5010	B192
CCMT3252UF KCP10B	B192
CCMT3253MF KCK15	B191
CCMT3253MF KCK20	B191
CCMT3253MF KCK20B	B191
CCMT3253MF KCM25B	B191
CCMT3253MF KCP10	B191
CCMT3253MF KCP25	B191
CCMT3253MF KCP25B	B191
CCMT3253MP KCM25	B191
CCMT3253MP KCP25	B191
CCMT3253MP KCU10	B191
CCMT431FP KCM25B	B190
CCMT431FP KCP10B	B190
CCMT431FP KCP25B	B190
CCMT431FP KCU10	B190
CCMT431FP KCU25	B190
CCMT431LF KC5010	B191
CCMT431LF KC5025	B191
CCMT431LF KCK15B	B191
CCMT431LF KCK20	B191
CCMT431LF KCP10	B191
CCMT431LF KCP25	B191
CCMT431LF KCP25B	B191
CCMT431LF KCP30	B191
CCMT431MW KC5010	B192
CCMT431MW KCP25	B192
CCMT432FP KCM25	B190
CCMT432FP KCP25B	B190
CCMT432FP KCU10	B190
CCMT432LF KC5010	B191
CCMT432LF KC5025	B191
CCMT432LF KCK15	B191
CCMT432LF KCK20	B191
CCMT432LF KCK20B	B191
CCMT432LF KCM25B	B191
CCMT432LF KCM35	B191
CCMT432LF KCP10	B191
CCMT432LF KCP10B	B191
CCMT432LF KCP25	B191
CCMT432LF KCP25B	B191
CCMT432MF KCK15	B191
CCMT432MF KCK15B	B191
CCMT432MF KCK20	B191
CCMT432MF KCK20B	B191
CCMT432MF KCM15B	B191
CCMT432MF KCM25	B191
CCMT432MF KCM25B	B191
CCMT432MF KCM35	B191
CCMT432MF KCP10	B191
CCMT432MF KCP10B	B191
CCMT432MF KCP25	B191
CCMT432MF KCP25B	B191
CCMT432MF KCP30	B191
CCMT432MP KCK20	B191
CCMT432MP KCK20B	B191
CCMT432MP KCM25B	B191
CCMT432MP KCP10	B191
CCMT432MP KCP25	B191
CCMT432MP KCU10	B191
CCMT432MW KC5010	B192
CCMT432MW KCK20B	B192
CCMT432MW KCP25	B192
CCMT433FP KCP10	B190
CCMT433LF KCK20B	B191
CCMT433LF KCM25	B191
CCMT433LF KCP10	B191
CCMT433LF KCP25B	B191
CCMT433MF KC5025	B191
CCMT433MF KCK15	B191
CCMT433MF KCK20	B191
CCMT433MF KCP25	B191
CCMT433MF KCP25B	B191
CCMT433MP KCK20	B191
CCMT433MP KCM25	B191
CCMT433MP KCM25B	B191
CCMT433MP KCP25	B191
CCMW2151 KCK20B	B192
CCMW3252 KCK20	B192
CCMW3252 KCK20B	B192
CCMW432 KCK20	B192
CCMW432 KCK20B	B192
CCMW433 KCK20	B192
CCMW433 KCK20B	B192
CCNC0250J3AH KCN05	P136
CCNC0250J3BH KCN05	P136
CCNC0375J4AH KCN05	P136
CCNC0375J4BH KCN05	P136
CCNC0500J4AH KCN05	P136
CCNC0500J4BH KCN05	P136
CCRNRP163D	B373
CDDC0250J6AH KCN05	P137
CDDC0250J6BH KCN05	P137
CDDC0375J6AH KCN05	P137
CDDC0375J6BH KCN05	P137
CDDC0500J6AH KCN05	P137
CDDC0500J6BH KCN05	P137
CDHB120601 KC5010	B199
CDHB120601 KC5025	B199
CDHB120601 KCU25	B199
CDHB120605 K313	B199
CDHB120605 KC5010	B199
CDHB120605 KC5025	B199
CDHB120605 KCU10	B199
CDHB120605 KCU25	B199
CDHB120605 KT315	B199
CDHB120605FST KD1400	B362
CDHB120605FST KD1425	B362
CDHB12061 KC5010	B199
CDHB12061 KC5025	B199
CDHB12061 KCU10	B199
CDHB12061 KCU25	B199
CDHB12061 KT315	B199
CDHB1206X0 KCU10	B199
CDHB1206X0FST KD1400	B362
CDHH120605L KC5010	B199
CDHH120605L KC5025	B199
CDHH120605L KCU10	B199
CDHH120605L KCU25	B199
CDHH120605L KT315	B199
CDHH120605R KC5010	B199
CDHH120605R KC5025	B199
CDHH120605R KCU10	B199
CDHH120605R KT315	B199
CDHH12061L KC5010	B199
CDHH12061L KC5025	B199
CDHH12061L KCU10	B199
CDHH12061L KCU25	B199
CDHH12061R KC5010	B199
CDHH12061R KCU10	B199
CFB10082	K135
CFB12096	K135
CFB14110	K135
CFB16120	K135
CFB18140	K135
CFM0402R00RHP KCU40	H43
CFM0402R30RHP KCU40	H43
CFM0402R45RHP KCU40	H43
CK10	B172–173, B179, B181–184, B188, B374–382, B389–390, B393
CK12	B61–65, B69, B71, B75–76, B89–90, B93, B96, B98, B111–112, B114, B120, B133–134, B137, B165, B373, B376
CK13	B165, B180, B376, B379–380
CK19	B132, B135–136, B179, B181–185, B378, B381–382, B389–390, B392
CK20	B60–64, B69–71, B75–76, B89–90, B163, B165, B183–185, B372–374, B389–390, B392
CK21	B61, B66, B69, B98–99, B120, B371–372
CK22	B92, B96, B155, B165, B389
CK23	B89–90, B180, B379–380
CK24	B63–64, B98, B111–112
CK27	B183–185, B388–390, B392
CK28	B374
CK29	B172, B376
CK43	B152–155
CK6	B63, B71, B98, B111, B113, B132–137, B163, B373
CK7	B69, B76, B89–90, B93, B96, B133, B139, B143, B165, B172, B183–185, B376, B389–390, B392
CK7LP	B170, B388, B392–393
CK9	B62, B65, B98, B111–114, B132–139, B143, B172–173, B179, B181–184, B374–382, B389–390
CKM34	B72–74, B94–95, B115–119, B140–142, B174–176, B186–187, B394–398
CKM35	B74, B115, B140–142, B186, B397
CKM36	B72, B94–95, B115–119
CKM37	B74, B115–117, B119
CKM41	B74, B94
CM-72	C193, D31–33, D36, D39
CM105	E45
CM106	E44–45
CM109	C190, D36–37
CM111	E46
CM112	E46
CM113	E43, E47, E49
CM114	E43
CM116	E40, E48
CM117	E40
CM118	E48–49
CM119	E49
CM120	C184, C187, C191, D26, D28, D32, D35
CM121	C184, C187, C191, C195, D26, D28, D32, D35, D38
CM144	C184, D28
CM145	C195, D38
CM146	C191–193, D35–37, D39–40
CM147	C191–193, D35–37, D39–40
CM180	E42
CM181	E42
CM182	C185, D25
CM183	C185, D25
CM184LP	C185, D25
CM185LP	C185, D25
CM209R ASSY	B58–60, B67–68, B87
CM210R ASSY	B58–60, B68, B98, B109–110
CM214	B168–169, B386–387
CM215R ASSY	B150–151, B154
CM216	B168–169, B386–387
CM219	B168–169, B386–387
CM234R ASSY	B58–60, B67–68, B87–88, B91–92, B98, B109–110, B113, B131, B154, B163
CM234RLP ASSY	B67–68, B92, B138
CM235R ASSY	B150–151
CM66	E41, E45
CM68	E41–42, E44–46
CM71	E41, E44–45
CM72LP	C182–184, C186–189, C191–192, C194–196, D26–30, D35, D38, D41
CM73	C193, D31–33, D36, D39
CM73LP	C182–184, C186–189, C191–192, C194–195, D26–30, D35, D37–38
CM74	C182–183, C185–188, C191–193, C196, D25–27, D29–31, D33, D35–36, D39, D41
CM75	C182–183, C185, C187–188, C191–193, C196, D25–27, D30–31, D33, D35–37, D39, D41
CM79	E41, E44–46
CM80	C182, C187, C191, D26–27, D32, D35
CM81	C182, C187, D26–27, D32
CNG431T0820 KY1615	B329
CNG432T0820 KY1615	B329
CNG432T0820 KY3500	B316
CNG433T0820 KY1615	B329
CNG433T0820 KY3500	B316
CNG434T0420 KYS25	B350
CNG434T0820 KY3500	B316
CNG452T0820 KY1615	B329
CNG453T0420 KYS25	B350
CNG453T0420 KYS30	B350
CNG453T0820 KY1615	B329
CNG453T0820 KY3500	B316
CNG454T0420 KYS30	B350
CNG454T0820 KY1615	B329
CNG454T0820 KYK10	B316
CNG554T0820 KY1615	B329
CNG554T2015 KY1615	B329
CNGA431E KD1405	B362
CNGA431FST KD1400	B362
CNGA431FST KD1425	B362
CNGA431S0415FWMT KBH10	B330
CNGA431S0415FWMT KBH20	B330
CNGA431S0415MT KBH10	B330
CNGA431S0415MT KBH20	B330
CNGA431S0425FWMT KB5630	B310, B330
CNGA431S0425MT KB5630	B310, B330
CNGA431S0525MT KBH20	B330
CNGA431S0735MT KBH20	B330
CNGA431T0820 KY1615	B329
CNGA432E KD1405	B362
CNGA432E KYS25	B350
CNGA432E KYS30	B350
CNGA432FST KD1400	B362
CNGA432FST KD1425	B362
CNGA432S0415FWMT KBH10	B330
CNGA432S0415FWMT KBH20	B330
CNGA432S0415MT KBH10	B330
CNGA432S0415MT KBH20	B330
CNGA432S0420MT KB1345	B310
CNGA432S0425FWMT KB5630	B310, B330
CNGA432S0425MT KB5630	B310, B330
CNGA432S0525FWMT KBH10	B330
CNGA432S0525MT KBH10	B330
CNGA432S0525MT KBH20	B330
CNGA432S0735MT KBH10	B330
CNGA432S0735MT KBH20	B330
CNGA432S0820MT KB1345	B310
CNGA432T0220 KY1615	B329
CNGA432T0420 KYS25	B350
CNGA432T0420 KYS30	B350
CNGA432T0420FW KY3500	B313
CNGA432T0420FW KYK25	B313
CNGA432T0820 KY1615	B313, B329
CNGA432T0820 KY3500	B313
CNGA432T0820 KYK10	B313
CNGA432T0820 KYK25	B313
CNGA433S0415FWMT KBH20	B330
CNGA433S0415MT KBH10	B330
CNGA433S0415MT KBH20	B330
CNGA433S0420MT KB5630	B310, B330
CNGA433S0425MT KB5630	B310, B330
CNGA433S0525FWMT KBH10	B330
CNGA433S0525MT KBH10	B330
CNGA433S0525MT KBH20	B330
CNGA433S0735MT KBH10	B330
CNGA433S0735MT KBH20	B330
CNGA433T0420 KYS25	B350
CNGA433T0420 KYS30	B350
CNGA433T0420FW KY3500	B313
CNGA433T0420FW KYK10	B313
CNGA433T0420FW KYK25	B313
CNGA433T0820 KY1615	B313, B329
CNGA433T0820 KY3500	B313
CNGA433T0820 KYK10	B313
CNGA433T0820 KYK25	B313
CNGA433T0820FW KYK10	B313
CNGA434T0420FW KY3500	B313
CNGA434T0820 KY1615	B313, B329
CNGA434T0820 KY3500	B313
CNGA434T0820 KYK10	B313
CNGA434T0820 KYK25	B313
CNGA543T0820 KY1615	B313, B329
CNGA543T0820 KY3500	B313
CNGA543T0820 KYK25	B313
CNGA544T0820 KY3500	B313
CNGA643T0820 KY1615	B313, B329
CNGA643T0820 KY3500	B313
CNGA644T0820 KY1615	B313, B329
CNGA644T0820 KY3500	B313
CNGA644T0820 KYK25	B313
CNGF432 KB1340	B307
CNGG4305FS KC5010	B46
CNGG4305FS KCU10	B46
CNGG4305FS KCU25	B46
CNGG4305LF KC5010	B46
CNGG4305LF KCU10	B46

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
CNGG430FS KC5010	B46
CNGG430FS KCU10	B46
CNGG430LF KC5010	B46
CNGG430LF KCU10	B46
CNGG431FS KC5010	B46
CNGG431FS KC5025	B46
CNGG431FS KCU10	B46
CNGG431FS KCU25	B46
CNGG431LF KC5010	B46
CNGG431LF KCU10	B46
CNGG432FS KC5010	B46
CNGG432FS KC5025	B46
CNGG432FS KCU10	B46
CNGG432FS KCU25	B46
CNGG432LF KC5010	B46
CNGG432LF KCU10	B46
CNGG433LF KC5010	B46
CNGG433LF KCU10	B46
CNGM431S0525MTCB1 KBH20	B330
CNGM432S0525MTCB1 KBH20	B330
CNGM433S0525MTCB1 KBH20	B330
CNGN332T0820 KBK45	B304
CNGN333S0820 KBK45	B304
CNGN432T0820 KBK45	B304
CNGN433S0820 KBK45	B304
CNGN434S0820 KBK45	B304
CNGP430 KC5010	B46
CNGP430 KC5410	B46
CNGP430 KCU10	B46
CNGP4305 KC5010	B46
CNGP4305 KC5410	B46
CNGP4305 KCU10	B46
CNGP431 K313	B46
CNGP431 K68	B46
CNGP431 KC5010	B46
CNGP431 KC5410	B46
CNGP431 KCU10	B46
CNGP432 K313	B46
CNGP432 K68	B46
CNGP432 KC5010	B46
CNGP432 KC5410	B46
CNGP432 KCU10	B46
CNGP432K KC5010	B47
CNGP433 K313	B46
CNGP433 KC5010	B46
CNGP433 KC5410	B46
CNGP433 KCU10	B46
CNGP434 KC5010	B46
CNGP543K K313	B47
CNGX432T0820 KBK45	B307
CNGX433S0415 KB1340	B307
CNGX433S0415FW KB1340	B307
CNGX433S0820 KBK45	B307
CNGX434S0820 KB1340	B307
CNGX434S0820 KBK45	B307
CNGX452T0420 KYS25	B350
CNGX452T0420 KYS30	B350
CNGX452T0420FW KY3500	B316
CNGX452T0820 KY1615	B331
CNGX453T0420 KYS25	B350
CNGX453T0420 KYS30	B350
CNGX453T0420FW KY3500	B316
CNGX453T0820 KY1615	B331
CNGX454E KYS30	B350
CNGX454T0420FW KY3500	B316
CNM432S0820 KB1340	B304
CNM433S0820 KB1340	B304
CNMA431 KCK05B	B47
CNMA431 KCK15	B47
CNMA431 KCK15B	B47
CNMA431 KCK20	B47
CNMA431 KCK20B	B47
CNMA432 K68	B47
CNMA432 KCK05	B47
CNMA432 KCK15	B47
CNMA432 KCK15B	B47
CNMA432 KCK20	B47
CNMA432 KCK20B	B47
CNMA432S0820 KB1340	B309
CNMA433 KCK05	B47
CNMA433 KCK15	B47
CNMA433 KCK15B	B47
CNMA433 KCK20	B47
CNMA433 KCK20B	B47
CNMA433S0820 KB1340	B309
CNMA434 KCK05	B47
CNMA434 KCK05B	B47
CNMA434 KCK15	B47
CNMA434 KCK15B	B47
CNMA434 KCK20	B47
CNMA542 KCK15	B47
CNMA542 KCK20	B47
CNMA543 KCK15	B47
CNMA543 KCK15B	B47
CNMA543 KCK20	B47
CNMA543 KCK20B	B47
CNMA544 KCK15	B47
CNMA544 KCK20B	B47
CNMA643 KCK05	B47
CNMA643 KCK15	B47
CNMA643 KCK15B	B47
CNMA643 KCK20	B47
CNMA644 KCK15B	B47
CNMA644 KCK20	B47
CNMA644 KCK20B	B47
CNMG321FF KC5010	B48
CNMG321FN KCP10	B49
CNMG321FN KT315	B49
CNMG321MN KCP10	B50
CNMG321MN KCP25B	B50
CNMG321MN KCP30	B50
CNMG322FF KC5010	B48
CNMG322FN KCK05	B49
CNMG322FN KCP10	B49
CNMG322FN KCP10B	B49
CNMG322MN KCP10	B50
CNMG322MN KCP10B	B50
CNMG322MN KCP25	B50
CNMG322MN KCP25B	B50
CNMG322MN KCP30	B50
CNMG322MP KC5010	B51
CNMG322MP KCM15B	B51
CNMG322MP KCM25	B51
CNMG322MP KCU10	B51
CNMG323MN KCP25	B50
CNMG4305FN KC5010	B49
CNMG4305FN KCU10	B49
CNMG4305FN KT315	B49
CNMG4305LF KCP25B	B50
CNMG4305MS KC5010	B52
CNMG4305MS KC5025	B52
CNMG4305MS KCU10	B52
CNMG4305MS KCU25	B52
CNMG430MS KC5010	B52
CNMG430MS KC5025	B52
CNMG430MS KCU10	B52
CNMG430MS KCU25	B52
CNMG431 K68	B47
CNMG431FF KC5010	B48
CNMG431FF KCM15B	B48
CNMG431FF KCP05	B48
CNMG431FF KCP10	B48
CNMG431FF KCP10B	B48
CNMG431FF KCU10	B48
CNMG431FF KT315	B48
CNMG431FN KCK05	B49
CNMG431FN KCK15B	B49
CNMG431FN KCP05	B49
CNMG431FN KCP10	B49
CNMG431FN KCP10B	B49
CNMG431FN KCP25	B49
CNMG431FN KCP25B	B49
CNMG431FN KT315	B49
CNMG431FP KC5010	B49
CNMG431FP KCM15	B49
CNMG431FP KCP10	B49
CNMG431FP KCP25B	B49
CNMG431FP KCU10	B49
CNMG431FP KT315	B49
CNMG431FW KC5010	B49
CNMG431FW KCP05	B49
CNMG431FW KCP10	B49
CNMG431FW KCP10B	B49
CNMG431FW KCU10	B49
CNMG431FW KT315	B49
CNMG431LF KCP25B	B50
CNMG431MN KCP10	B50
CNMG431MN KCP10B	B50
CNMG431MN KCP25	B50
CNMG431MN KCP25B	B50
CNMG431MN KCP30	B50
CNMG431MN KCP40B	B50
CNMG431MP KC5010	B51
CNMG431MP KCM15	B51
CNMG431MP KCM15B	B51
CNMG431MP KCM25	B51
CNMG431MP KCM25B	B51
CNMG431MP KCM35	B51
CNMG431MP KCM35B	B51
CNMG431MP KCU10	B51
CNMG431MR KCM15B	B51
CNMG431MS K313	B52
CNMG431MS KC5010	B52
CNMG431MS KC5025	B52
CNMG431MS KCU10	B52
CNMG431MS KCU25	B52
CNMG431P KC5010	B52
CNMG431P KCU10	B52
CNMG431RP KC5010	B53
CNMG431RP KC5025	B53
CNMG431RP KCM25	B53
CNMG431RP KCM25B	B53
CNMG431RP KCP10	B53
CNMG431RP KCP25	B53
CNMG431RP KCP25B	B53
CNMG431RP KCU10	B53
CNMG431RP KCU25	B53
CNMG431UN KCK05	B54
CNMG431UN KCK15	B54
CNMG431UN KCK15B	B54
CNMG431UN KCK20	B54
CNMG431UN KCK20B	B54
CNMG431UP KC5010	B54
CNMG431UP KCM15B	B54
CNMG431UP KCM25	B54
CNMG431UP KCM25B	B54
CNMG432 K313	B47
CNMG432 K68	B47
CNMG432 KC5010	B47
CNMG43233 KT315	B48
CNMG432CT KC5010	B48
CNMG432CT KCP05	B48
CNMG432CT KCP10B	B48
CNMG432CT KCP25	B48
CNMG432CT KCP25B	B48
CNMG432CT KCU10	B48
CNMG432FF KC5010	B48
CNMG432FF KCM15B	B48
CNMG432FF KCP05	B48
CNMG432FF KCP10	B48
CNMG432FF KCP10B	B48
CNMG432FF KCU10	B48
CNMG432FF KT315	B48
CNMG432FN KCK05	B49
CNMG432FN KCK15B	B49
CNMG432FN KCP05	B49
CNMG432FN KCP10	B49
CNMG432FN KCP10B	B49
CNMG432FN KCP25	B49
CNMG432FN KCP25B	B49
CNMG432FN KT315	B49
CNMG432FP KC5010	B49
CNMG432FP KCM15	B49
CNMG432FP KCM15B	B49
CNMG432FP KCP10B	B49
CNMG432FP KCP25	B49
CNMG432FP KCP25B	B49
CNMG432FP KCU10	B49
CNMG432FP KT315	B49
CNMG432FW KC5010	B49
CNMG432FW KCK15B	B49
CNMG432FW KCM15B	B49
CNMG432FW KCP05	B49
CNMG432FW KCP05B	B49
CNMG432FW KCP10	B49
CNMG432FW KCP10B	B49
CNMG432FW KCU10	B49
CNMG432FW KT315	B49
CNMG432LF KCP25B	B50
CNMG432MG KC5010	B57
CNMG432MG KCP10B	B57
CNMG432MG KCP25B	B57
CNMG432MN KCP05	B50
CNMG432MN KCP05B	B50
CNMG432MN KCP10	B50
CNMG432MN KCP10B	B50
CNMG432MN KCP25	B50
CNMG432MN KCP25B	B50
CNMG432MN KCP30	B50
CNMG432MN KCP30B	B50
CNMG432MN KCP40	B50
CNMG432MN KCP40B	B50
CNMG432MN KCPK05	B50
CNMG432MP KC5010	B51
CNMG432MP KC5025	B51
CNMG432MP KCM15	B51
CNMG432MP KCM15B	B51
CNMG432MP KCM25	B51
CNMG432MP KCM25B	B51
CNMG432MP KCM35	B51
CNMG432MP KCM35B	B51
CNMG432MP KCP10	B51
CNMG432MP KCP25	B51
CNMG432MP KCP25B	B51
CNMG432MP KCU10	B51
CNMG432MP KCU25	B51
CNMG432MR KCK15B	B51
CNMG432MR KCM15	B51
CNMG432MR KCM15B	B51
CNMG432MR KCM25	B51
CNMG432MR KCM25B	B51
CNMG432MR KCM35	B51
CNMG432MR KCP10B	B51
CNMG432MR KCP25B	B51
CNMG432MR KCP30B	B51
CNMG432MR KCP40	B51
CNMG432MR KCPK05	B51
CNMG432MR KCU10	B51
CNMG432MS K313	B52
CNMG432MS KC5010	B52
CNMG432MS KC5025	B52
CNMG432MS KCU10	B52
CNMG432MS KCU25	B52
CNMG432MW KCK15B	B52
CNMG432MW KCM25B	B52
CNMG432MW KCP05	B52
CNMG432MW KCP10	B52
CNMG432MW KCP10B	B52
CNMG432MW KCP25	B52
CNMG432MW KCP25B	B52
CNMG432P K313	B52
CNMG432P KC5010	B52
CNMG432P KCM15B	B52
CNMG432P KCP30B	B52
CNMG432P KCU10	B52
CNMG432RN KCK15B	B53
CNMG432RN KCP05	B53
CNMG432RN KCP10	B53
CNMG432RN KCP10B	B53
CNMG432RN KCP25	B53
CNMG432RN KCP25B	B53
CNMG432RN KCP30	B53
CNMG432RN KCP30B	B53
CNMG432RN KCP40	B53
CNMG432RN KCP40B	B53
CNMG432RP KC5010	B53
CNMG432RP KC5025	B53
CNMG432RP KCK05	B53
CNMG432RP KCK15	B53
CNMG432RP KCK15B	B53
CNMG432RP KCK20	B53
CNMG432RP KCK20B	B53
CNMG432RP KCM15	B53
CNMG432RP KCM15B	B53
CNMG432RP KCM25	B53
CNMG432RP KCM25B	B53
CNMG432RP KCM35	B53
CNMG432RP KCM35B	B53

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
CNMG432RP KCP05	B53
CNMG432RP KCP05B	B53
CNMG432RP KCP10	B53
CNMG432RP KCP10B	B53
CNMG432RP KCP25	B53
CNMG432RP KCP25B	B53
CNMG432RP KCP30	B53
CNMG432RP KCP30B	B53
CNMG432RP KCP40	B53
CNMG432RP KCPK05	B53
CNMG432RP KCU10	B53
CNMG432RP KCU25	B53
CNMG432UN KCK05	B54
CNMG432UN KCK15	B54
CNMG432UN KCK15B	B54
CNMG432UN KCK20	B54
CNMG432UN KCK20B	B54
CNMG432UP KC5010	B54
CNMG432UP KCM15	B54
CNMG432UP KCM15B	B54
CNMG432UP KCM25	B54
CNMG432UP KCM25B	B54
CNMG432UP KCM35	B54
CNMG432UP KCM35B	B54
CNMG432UP KCU10	B54
CNMG433 K68	B47
CNMG433CT KCP10B	B48
CNMG433CT KCP25	B48
CNMG433CT KCP25B	B48
CNMG433FM KCP10B	B50
CNMG433FM KCP25B	B50
CNMG433FN KCK05B	B49
CNMG433FN KCP10B	B49
CNMG433FN KCP25	B49
CNMG433FN KCP25B	B49
CNMG433FN KT315	B49
CNMG433FP KCM15	B49
CNMG433FP KCU10	B49
CNMG433FW KC5010	B49
CNMG433FW KCP05	B49
CNMG433FW KCP10	B49
CNMG433FW KCP10B	B49
CNMG433FW KCU10	B49
CNMG433FW KT315	B49
CNMG433MG KCP10B	B57
CNMG433MG KCP25B	B57
CNMG433MN KCP05	B50
CNMG433MN KCP10	B50
CNMG433MN KCP10B	B50
CNMG433MN KCP25	B50
CNMG433MN KCP25B	B50
CNMG433MN KCP30B	B50
CNMG433MN KCP40	B50
CNMG433MN KCP40B	B50
CNMG433MP KC5010	B51
CNMG433MP KCM15	B51
CNMG433MP KCM15B	B51
CNMG433MP KCM25	B51
CNMG433MP KCM25B	B51
CNMG433MP KCM35	B51
CNMG433MP KCP10	B51
CNMG433MP KCP25	B51
CNMG433MP KCU10	B51
CNMG433MP KCU25	B51
CNMG433MR KCK15B	B51
CNMG433MR KCM15	B51
CNMG433MR KCM15B	B51
CNMG433MR KCM25	B51
CNMG433MR KCM25B	B51
CNMG433MR KCM35	B51
CNMG433MR KCP10B	B51
CNMG433MR KCP25B	B51
CNMG433MR KCPK05	B51
CNMG433MR KCU10	B51
CNMG433MS K313	B52
CNMG433MS KC5010	B52
CNMG433MS KC5025	B52
CNMG433MS KCU10	B52
CNMG433MS KCU25	B52
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CNMG433MW KCP05	B52
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CNMG433MW KCP10B	B52
CNMG433MW KCP25	B52
CNMG433MW KCP25B	B52
CNMG433P KC5010	B52
CNMG433P KCP30B	B52
CNMG433RN KCP10	B53
CNMG433RN KCP10B	B53
CNMG433RN KCP25	B53
CNMG433RN KCP25B	B53
CNMG433RN KCP30	B53
CNMG433RN KCP30B	B53
CNMG433RN KCP40	B53
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CNMG433RN KCPK05	B53
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CNMG433RP KCM35	B53
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CNMG433RP KCP30B	B53
CNMG433RP KCP40	B53
CNMG433RP KCP40B	B53
CNMG433RP KCPK05	B53
CNMG433RP KCU10	B53
CNMG433RP KCU25	B53
CNMG433UN KCK05	B54
CNMG433UN KCK05B	B54
CNMG433UN KCK15	B54
CNMG433UN KCK15B	B54
CNMG433UN KCK20	B54
CNMG433UN KCK20B	B54
CNMG433UP KC5010	B54
CNMG433UP KCM15	B54
CNMG433UP KCM25	B54
CNMG433UP KCM25B	B54
CNMG433UP KCU10	B54
CNMG434CT KCP10	B48
CNMG434FN KCP10	B49
CNMG434FN KCP25	B49
CNMG434MG KCP10B	B57
CNMG434MN KCP10	B50
CNMG434MN KCP10B	B50
CNMG434MN KCP25	B50
CNMG434MN KCP25B	B50
CNMG434MP KC5010	B51
CNMG434MP KCM15B	B51
CNMG434MR KCP10B	B51
CNMG434MS KC5010	B52
CNMG434MS KC5025	B52
CNMG434MS KCU10	B52
CNMG434MS KCU25	B52
CNMG434RN KCP10	B53
CNMG434RN KCP10B	B53
CNMG434RN KCP25	B53
CNMG434RN KCP25B	B53
CNMG434RN KCP40	B53
CNMG434RN KCP40B	B53
CNMG434RP KC5010	B53
CNMG434RP KCK20B	B53
CNMG434RP KCM25	B53
CNMG434RP KCM25B	B53
CNMG434RP KCM35	B53
CNMG434RP KCP10	B53
CNMG434RP KCP10B	B53
CNMG434RP KCP25	B53
CNMG434RP KCP25B	B53
CNMG434RP KCU10	B53
CNMG434RP KCU25	B53
CNMG434UN KCK05B	B54
CNMG434UN KCK15B	B54
CNMG434UN KCK20	B54
CNMG434UN KCK20B	B54
CNMG542MN KCP10	B50
CNMG542MN KCP10B	B50
CNMG542MN KCP25	B50
CNMG542MN KCP25B	B50
CNMG542MN KCP30	B50
CNMG542MP KC5010	B51
CNMG542MP KCM15B	B51
CNMG542MP KCM25	B51
CNMG542MP KCM35	B51
CNMG542MP KCU10	B51
CNMG542MR KCP25B	B51
CNMG542MS KC5010	B52
CNMG542MS KC5025	B52
CNMG542MS KCU10	B52
CNMG542MS KCU25	B52
CNMG542RN KCP10B	B53
CNMG542RN KCP25	B53
CNMG542RN KCP25B	B53
CNMG542RN KCP30	B53
CNMG542RP KC5025	B53
CNMG542RP KCK20	B53
CNMG542RP KCP10	B53
CNMG542RP KCP25	B53
CNMG542RP KCP25B	B53
CNMG542RP KCU10	B53
CNMG542RP KCU25	B53
CNMG542UN KCK15	B54
CNMG542UN KCK15B	B54
CNMG542UN KCK20	B54
CNMG542UN KCK20B	B54
CNMG542UP KCM25	B54
CNMG542UP KCM35	B54
CNMG543MN KCP10	B50
CNMG543MN KCP10B	B50
CNMG543MN KCP25	B50
CNMG543MN KCP25B	B50
CNMG543MN KCP30	B50
CNMG543MP KC5010	B51
CNMG543MP KCM15	B51
CNMG543MP KCM15B	B51
CNMG543MP KCM25	B51
CNMG543MP KCM25B	B51
CNMG543MP KCU10	B51
CNMG543MP KCU25	B51
CNMG543MR KCM25B	B51
CNMG543MR KCP10B	B51
CNMG543MR KCP25B	B51
CNMG543MR KCP40	B51
CNMG543MS K313	B52
CNMG543MS KC5010	B52
CNMG543MS KC5025	B52
CNMG543MS KCU10	B52
CNMG543MS KCU25	B52
CNMG543RN KCP10	B53
CNMG543RN KCP10B	B53
CNMG543RN KCP25	B53
CNMG543RN KCP25B	B53
CNMG543RN KCP30	B53
CNMG543RN KCP30B	B53
CNMG543RN KCP40	B53
CNMG543RN KCP40B	B53
CNMG543RN KCPK05	B53
CNMG543RP KC5010	B53
CNMG543RP KC5025	B53
CNMG543RP KCK05	B53
CNMG543RP KCK15	B53
CNMG543RP KCK20	B53
CNMG543RP KCK20B	B53
CNMG543RP KCM15B	B53
CNMG543RP KCM25	B53
CNMG543RP KCM25B	B53
CNMG543RP KCM35	B53
CNMG543RP KCM35B	B53
CNMG543RP KCP10	B53
CNMG543RP KCP10B	B53
CNMG543RP KCP25	B53
CNMG543RP KCP25B	B53
CNMG543RP KCP30	B53
CNMG543RP KCP40	B53
CNMG543RP KCP40B	B53
CNMG543RP KCP05	B53
CNMG543RP KCP10	B53
CNMG543RP KCU10	B53
CNMG543RP KCU25	B53
CNMG543UN KCK15	B54
CNMG543UN KCK15B	B54
CNMG543UN KCK20	B54
CNMG543UN KCK20B	B54
CNMG543UP KCM25	B54
CNMG543UP KCM25B	B54
CNMG543UP KCM35	B54
CNMG543UP KCU10	B54
CNMG544MG KCP10B	B57
CNMG544MN KCP10	B50
CNMG544MN KCP10B	B50
CNMG544MN KCP25	B50
CNMG544MP KC5010	B51
CNMG544MP KCM25B	B51
CNMG544MR KCM25B	B51
CNMG544MR KCP10B	B51
CNMG544MR KCP25B	B51
CNMG544RN KCP10	B53
CNMG544RN KCP10B	B53
CNMG544RN KCP25	B53
CNMG544RN KCP25B	B53
CNMG544RN KCP40B	B53
CNMG544RN KCPK05	B53
CNMG544RP KC5025	B53
CNMG544RP KCK20	B53
CNMG544RP KCM25	B53
CNMG544RP KCM25B	B53
CNMG544RP KCP10	B53
CNMG544RP KCP10B	B53
CNMG544RP KCP25	B53
CNMG544RP KCP25B	B53
CNMG544RP KCPK05	B53
CNMG544RP KCU25	B53
CNMG544UN KCK15	B54
CNMG544UN KCK15B	B54
CNMG544UN KCK20	B54
CNMG544UN KCK20B	B54
CNMG642MN KCP10	B50
CNMG642MN KCP25	B50
CNMG642MN KCP25B	B50
CNMG642MN KCP30	B50
CNMG642MP KC5010	B51
CNMG642MP KCM15B	B51
CNMG642MP KCM25	B51
CNMG642MP KCM25B	B51
CNMG642MS KC5010	B52
CNMG642MS KC5025	B52
CNMG642MS KCU10	B52
CNMG642MS KCU25	B52
CNMG642RN KCP10B	B53
CNMG642RN KCP25	B53
CNMG642RN KCP25B	B53
CNMG642RN KCP40	B53
CNMG642UN KCK15	B54
CNMG642UN KCK20	B54
CNMG643 K68	B47
CNMG643 KCP25	B47
CNMG643 KCU10	B47
CNMG643MG KCP25B	B57
CNMG643MN KCP10	B50
CNMG643MN KCP25	B50
CNMG643MN KCP25B	B50
CNMG643MN KCP30	B50
CNMG643MP KC5010	B51
CNMG643MP KCM15	B51
CNMG643MP KCM25	B51
CNMG643MP KCM25B	B51
CNMG643MP KCU25	B51
CNMG643MR KCM25	B51
CNMG643MR KCM25B	B51
CNMG643MR KCP25B	B51
CNMG643MS KC5010	B52
CNMG643MS KC5025	B52
CNMG643MS KCU10	B52
CNMG643MS KCU25	B52
CNMG643P KCU10	B52
CNMG643RN KCP10	B53
CNMG643RN KCP10B	B53

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
CNMG643RN KCP25	B53
CNMG643RN KCP25B	B53
CNMG643RN KCP30	B53
CNMG643RN KCP30B	B53
CNMG643RN KCP40	B53
CNMG643RN KCP40B	B53
CNMG643RP KC5010	B53
CNMG643RP KC5025	B53
CNMG643RP KCK15	B53
CNMG643RP KCM25	B53
CNMG643RP KCM25B	B53
CNMG643RP KCM35	B53
CNMG643RP KCP10B	B53
CNMG643RP KCP25	B53
CNMG643RP KCP25B	B53
CNMG643RP KCP30	B53
CNMG643RP KCP40B	B53
CNMG643RP KCU10	B53
CNMG643RP KCU25	B53
CNMG643UN KCK15	B54
CNMG643UN KCK15B	B54
CNMG643UN KCK20	B54
CNMG643UP KCM25	B54
CNMG643UP KCM25B	B54
CNMG643UP KCM35	B54
CNMG644 KCP25	B47
CNMG644MN KCP10B	B50
CNMG644MN KCP25	B50
CNMG644MN KCP25B	B50
CNMG644MN KCP30	B50
CNMG644MP KC5010	B51
CNMG644MP KCM25	B51
CNMG644MP KCU10	B51
CNMG644MR KCP25B	B51
CNMG644MS KCU10	B52
CNMG644MS KCU25	B52
CNMG644RN KCP10B	B53
CNMG644RN KCP25	B53
CNMG644RN KCP25B	B53
CNMG644RN KCP30	B53
CNMG644RN KCP30B	B53
CNMG644RN KCP40	B53
CNMG644RN KCP40B	B53
CNMG644RN KCPK05	B53
CNMG644RP KCM25	B53
CNMG644RP KCM25B	B53
CNMG644RP KCM35	B53
CNMG644RP KCP10	B53
CNMG644RP KCP25B	B53
CNMG644RP KCP30	B53
CNMG644RP KCPK05	B53
CNMG644RP KCU10	B53
CNMG644RP KCU25	B53
CNMG644UN KCK05	B54
CNMG644UN KCK15	B54
CNMG644UN KCK20	B54
CNMG644UP KCM25	B54
CNMG646MN KCP25B	B50
CNMG646RN KCP25	B53
CNMG646RN KCP25B	B53
CNMG646RN KCP30	B53
CNMG866 KCP25	B47
CNMM190740RRP KCP10B	E59
CNMM432MR KCP25B	B54
CNMM432MR KCP30B	B54
CNMM432RM KCP10	B55
CNMM432RM KCP25	B55
CNMM432RM KCP25B	B55
CNMM432RM KCP30	B55
CNMM432RP KCM25	B56
CNMM432RP KCM25B	B56
CNMM432RP KCP05	B56
CNMM432RP KCP10	B56
CNMM432RP KCP25B	B56
CNMM432RP KCP40	B56
CNMM433RM KCP10	B55
CNMM433RM KCP10B	B55
CNMM433RM KCP25	B55
CNMM433RM KCP25B	B55
CNMM433RP KCP10B	B56
CNMM433RP KCP25	B56
CNMM433RP KCP25B	B56
CNMM433RP KCP30	B56
CNMM434RP KCP25	B56
CNMM434RP KCP25B	B56
CNMM542RP KCP25B	B56
CNMM543MR KCP25B	B54
CNMM543MR KCP30B	B54
CNMM543RM KCP10	B55
CNMM543RM KCP10B	B55
CNMM543RM KCP25	B55
CNMM543RM KCP25B	B55
CNMM543RP KCM25B	B56
CNMM543RP KCP10	B56
CNMM543RP KCP10B	B56
CNMM543RP KCP25	B56
CNMM543RP KCP40	B56
CNMM544MR KCP25B	B54
CNMM544RM KCP10	B55
CNMM544RM KCP10B	B55
CNMM544RM KCP25	B55
CNMM544RM KCP25B	B55
CNMM544RM KCP30	B55
CNMM544RP KCM25	B56
CNMM544RP KCP10	B56
CNMM544RP KCP10B	B56
CNMM544RP KCP25	B56
CNMM544RP KCP25B	B56
CNMM544RP KCPK05	B56
CNMM546RM KCP10	B55
CNMM546RM KCP25B	B55
CNMM546RP KCP10B	B56
CNMM643RH KCP25	B55
CNMM643RH KCP40	B55
CNMM643RM KCP10	B55
CNMM643RM KCP25	B55
CNMM643RM KCP25B	B55
CNMM643RM KCP40	B55
CNMM643RP KCM25B	B56
CNMM643RP KCP25	B56
CNMM643RP KCP25B	B56
CNMM644MR KCP25B	B54
CNMM644RH KCP10B	B55
CNMM644RH KCP25B	B55
CNMM644RH KCP30	B55
CNMM644RH KCP40B	B55
CNMM644RM KCP10	B55
CNMM644RM KCP10B	B55
CNMM644RM KCP25	B55
CNMM644RM KCP25B	B55
CNMM644RM KCP30	B55
CNMM644RP KCM25B	B56
CNMM644RP KCP10	B56
CNMM644RP KCP10B	B56
CNMM644RP KCP25	B56
CNMM644RP KCP25B	B56
CNMM646RH KCP10	B55
CNMM646RH KCP10B	B55
CNMM646RH KCP25	B55
CNMM646RH KCP25B	B55
CNMM646RH KCP30	B55
CNMM646RH KCP40B	B55
CNMM646RM KCP25	B55
CNMM646RM KCP25B	B55
CNMM646RM KCP30	B55
CNMM646RP KCM25B	B56
CNMM646RP KCP25	B56
CNMM646RW KCP10B	B56
CNMM646RW KCP25B	B56
CNMM866RH KCP10	B55
CNMM866RH KCP25	B55
CNMM866RH KCP25B	B55
CNMM866RH KCP30	B55
CNMM866RH KCP30B	B55
CNMM866RH KCP40	B55
CNMM866RM KCP10	B55
CNMM866RM KCP25	B55
CNMM866RM KCP25B	B55
CNMM866RM KCP40	B55
CNMM866RP KCP25	B56
CNMM866RW KCP25B	B56
CNMP431 K313	B56
CNMP431 K68	B56
CNMP431 KC5410	B56
CNMP431K KCP10B	B57
CNMP431K KCP25	B57
CNMP431K KCP25B	B57
CNMP432 K313	B56
CNMP432 K68	B56
CNMP432 KC5410	B56
CNMP432 KCP25B	B56
CNMP432K KCP10	B57
CNMP432K KCP10B	B57
CNMP432K KCP25	B57
CNMP432K KCP25B	B57
CNMP433 K68	B56
CNMP542 KCP25B	B56
CNMP643 K313	B56
CNMS431FST KD1400	B363
CNMS432 K68	B57
CNMS432 KC5410	B57
CNMS432E KD1405	B363
CNMS432FST KD1400	B363
CNMS432FST KD1425	B363
CNMS542 KC5410	B57
CNMS642 K68	B57
CNMS642 KC5410	B57
CNMS643 K68	B57
CNMU433RN KCP10B	B53
CNMU443MN KCP05B	B51
CNMU443MN KCP10	B51
CNMU444MN KCP25B	B51
CNMX452T0820 KY3500	B316
CNMX453T0820 KY3500	B316
CNMX454T0820 KY3500	B316
COOL-HOSE-200	C83
COOL-HOSE-200-FLEX	C83
COOL-HOSE-300	C83
COOL-HOSE-300-FLEX	C83
CPG421 K313	B164
CPG421 K68	B164
CPG421F KD1425	B363
CPG422 K313	B164
CPG422 K68	B164
CPG422F KD1425	B363
CPGM21505 K68	B205
CPGM2151 K313	B205
CPGM2151 K68	B205
CPGM2151 KC5010	B205
CPGM3250 KC5010	B205
CPGM3250 KC5025	B205
CPGM3250 KCU10	B205
CPGM3250 KT315	B205
CPGM32505 K68	B205
CPGM32505 KC5010	B205
CPGM32505 KC5025	B205
CPGM32505 KCU10	B205
CPGM32505 KCU25	B205
CPGM3251 K313	B205
CPGM3251 K68	B205
CPGM3251 KC5010	B205
CPGM3251 KC5025	B205
CPGM3251 KCM15B	B205
CPGM3251 KCP10B	B205
CPGM3251 KCP25B	B205
CPGM3251 KCU10	B205
CPGM3251 KCU25	B205
CPGM3251 KT315	B205
CPGM3252 K313	B205
CPGM3252 K68	B205
CPGM3252 KC5010	B205
CPGM3252 KC5025	B205
CPGM3252 KCP10B	B205
CPGM3252 KCP25B	B205
CPGM3252 KCU10	B205
CPGM3252 KCU25	B205
CPGT21505HP KC5010	B205
CPGT21505HP KC5025	B205
CPGT21505HP KC5410	B205
CPGT21505HP KCU10	B205
CPGT21505HP KCU25	B205
CPGT21505LF KC5010	B206
CPGT21505LF KC5025	B206
CPGT21505LF KCU10	B206
CPGT2150LF KC5010	B206
CPGT2150LF KC5025	B206
CPGT2150LF KCU10	B206
CPGT2150LF KC5410	B206
CPGT2150LF KCU10	B206
CPGT2151HP KC5010	B205
CPGT2151HP KC5025	B205
CPGT2151HP KC5410	B205
CPGT2151HP KCU10	B205
CPGT2151HP KCU25	B205
CPGT2151LF KC5010	B206
CPGT2151LF KC5025	B206
CPGT2151LF KC5410	B206
CPGT2151LF KCU10	B206
CPGT2152HP KC5010	B205
CPGT2152HP KC5410	B205
CPGT2152HP KCU25	B205
CPGT2152LF KC5010	B206
CPGT2152LF KC5025	B206
CPGT2152LF KCU10	B206
CPGT32505HP K313	B205
CPGT32505HP KC5010	B205
CPGT32505HP KC5025	B205
CPGT32505HP KC5410	B205
CPGT32505HP KCU10	B205
CPGT32505LF KC5010	B206
CPGT32505LF KC5025	B206
CPGT32505LF KCU10	B206
CPGT3251HP K313	B205
CPGT3251HP KC5010	B205
CPGT3251HP KC5025	B205
CPGT3251HP KC5410	B205
CPGT3251HP KCU10	B205
CPGT3251HP KCU25	B205
CPGT3251LF KC5010	B206
CPGT3251LF KC5025	B206
CPGT3251LF KC5410	B206
CPGT3251LF KCU10	B206
CPGT3252HP KC5010	B205
CPGT3252HP KC5410	B205
CPGT3252HP KCU10	B205
CPGT3252HP KCU25	B205
CPGT3252LF KC5010	B206
CPGT3252LF KC5025	B206
CPGT3252LF KCU10	B206
CPGW21505FST KD1400	B364
CPGW21505FST KD1425	B364
CPGW2151E KD1405	B363
CPGW2151FST KD1400	B364
CPGW2151FST KD1425	B364
CPGW2151FWST KD1400	B364
CPGW2151FWST KD1425	B364
CPGW2152FST KD1400	B364
CPGW2152FST KD1425	B364
CPGW3251E KD1405	B363
CPGW3251FST KD1400	B364
CPGW3251FST KD1425	B364
CPGW3251S0415MT KB5630	B331
CPGW3252FST KD1400	B364
CPGW3252FST KD1425	B364
CPGW3252FWST KD1400	B364
CPGW3252FWST KD1425	B364
CPGW3252S0415MT KB5630	B331
CPGW432FWST KD1400	B364
CPGW432FWST KD1425	B364
CPMT181505FP KCU10	B206
CPMT181505FP KCU25	B206
CPMT181505LF KC5010	B207
CPMT18151FP KCP25	B206
CPMT18151FP KCU10	B206
CPMT18151FP KCU25	B206
CPMT18151LF KC5010	B207
CPMT18151LF KC5025	B207
CPMT18151LF KT315	B207
CPMT21505FP KCM25	B206
CPMT21505FP KCP10	B206
CPMT21505FP KCP25	B206
CPMT21505FP KCU10	B206
CPMT21505FP KCU25	B206
CPMT21505FP KTP10	B206
CPMT21505FW KC5010	B206
CPMT21505FW KT315	B206
CPMT21505LF KC5010	B207
CPMT21505LF KC5025	B207
CPMT2151FP KCK20	B206

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
CPMT2151FP KCM25	B206
CPMT2151FP KCP10	B206
CPMT2151FP KCP25	B206
CPMT2151FP KCP25B	B206
CPMT2151FP KCU10	B206
CPMT2151FP KCU25	B206
CPMT2151FP KTP10	B206
CPMT2151FW KC5010	B206
CPMT2151FW KCK20	B206
CPMT2151FW KCU10	B206
CPMT2151FW KT315	B206
CPMT2151LF K313	B207
CPMT2151LF K68	B207
CPMT2151LF KC5010	B207
CPMT2151LF KC5025	B207
CPMT2151LF KCK05	B207
CPMT2151LF KCK15	B207
CPMT2151LF KCK15B	B207
CPMT2151LF KCK20	B207
CPMT2151LF KCM15	B207
CPMT2151LF KCM25	B207
CPMT2151LF KCP10	B207
CPMT2151LF KCP10B	B207
CPMT2151LF KCP25	B207
CPMT2151LF KCP25B	B207
CPMT2151LF KT315	B207
CPMT2151UF KC5010	B208
CPMT2151UF KCP10B	B208
CPMT2151UF KCP25	B208
CPMT2151UF KCP25B	B208
CPMT2152FP KCP25	B206
CPMT2152FP KTP10	B206
CPMT2152FW KC5010	B206
CPMT2152FW KCK20	B206
CPMT2152FW KCP25	B206
CPMT2152FW KCU10	B206
CPMT2152FW KT315	B206
CPMT2152LF K313	B207
CPMT2152LF KC5010	B207
CPMT2152LF KC5025	B207
CPMT2152LF KCK05	B207
CPMT2152LF KCK15	B207
CPMT2152LF KCM25	B207
CPMT2152LF KCP10	B207
CPMT2152LF KCP25	B207
CPMT2152LF KCP25B	B207
CPMT2152LF KCP30	B207
CPMT2152LF KT315	B207
CPMT2152MF KCK15	B207
CPMT2152MF KCK20	B207
CPMT2152MF KCK20B	B207
CPMT2152MF KCM15B	B207
CPMT2152MF KCM25B	B207
CPMT2152MF KCP10B	B207
CPMT2152MF KCP25B	B207
CPMT2152MP KCP25B	B207
CPMT2152MP KCU10	B207
CPMT32505FP KCM25	B206
CPMT32505FP KCU10	B206
CPMT32505LF KC5010	B207
CPMT32505LF KT315	B207
CPMT3251FP KCM15	B206
CPMT3251FP KCM25	B206
CPMT3251FP KCP10	B206
CPMT3251FP KCP25B	B206
CPMT3251FP KCU10	B206
CPMT3251FP KCU25	B206
CPMT3251FW KC5010	B206
CPMT3251FW KCK20B	B206
CPMT3251FW KCP25	B206
CPMT3251FW KT315	B206
CPMT3251LF KC5010	B207
CPMT3251LF KC5025	B207
CPMT3251LF KCK05	B207
CPMT3251LF KCK15B	B207
CPMT3251LF KCK20	B207
CPMT3251LF KCK20B	B207
CPMT3251LF KCM15	B207
CPMT3251LF KCM15B	B207
CPMT3251LF KCM25	B207
CPMT3251LF KCM25B	B207
CPMT3251LF KCP05	B207
CPMT3251LF KCP10	B207
CPMT3251LF KCP10B	B207
CPMT3251LF KCP25	B207
CPMT3251LF KCP25B	B207
CPMT3251LF KCP30	B207
CPMT3251LF KT315	B207
CPMT3251MW KCU10	B208
CPMT3251UF KC5010	B208
CPMT3251UF KCP25	B208
CPMT3251UF KCP25B	B208
CPMT3252FP KCM25	B206
CPMT3252FP KCP10	B206
CPMT3252FP KCP25B	B206
CPMT3252FP KCU10	B206
CPMT3252FP KCU25	B206
CPMT3252FP KTP10	B206
CPMT3252FW KC5010	B206
CPMT3252FW KCK20	B206
CPMT3252FW KCP25	B206
CPMT3252FW KCU10	B206
CPMT3252FW KT315	B206
CPMT3252LF K68	B207
CPMT3252LF KC5010	B207
CPMT3252LF KC5025	B207
CPMT3252LF KCK05	B207
CPMT3252LF KCK15	B207
CPMT3252LF KCK15B	B207
CPMT3252LF KCK20	B207
CPMT3252LF KCK20B	B207
CPMT3252LF KCM15	B207
CPMT3252LF KCM25	B207
CPMT3252LF KCP10	B207
CPMT3252LF KCP10B	B207
CPMT3252LF KCP25	B207
CPMT3252LF KCP25B	B207
CPMT3252LF KCP30	B207
CPMT3252LF KT315	B207
CPMT3252MF KCK15	B207
CPMT3252MF KCK15B	B207
CPMT3252MF KCK20	B207
CPMT3252MF KCK20B	B207
CPMT3252MF KCM15	B207
CPMT3252MF KCM15B	B207
CPMT3252MF KCM25	B207
CPMT3252MF KCM25B	B207
CPMT3252MF KCM35	B207
CPMT3252MF KCP10	B207
CPMT3252MF KCP10B	B207
CPMT3252MF KCP25	B207
CPMT3252MF KCP25B	B207
CPMT3252MP KCK20	B207
CPMT3252MP KCM25	B207
CPMT3252MP KCM25B	B207
CPMT3252MP KCP10	B207
CPMT3252MP KCP25	B207
CPMT3252MP KCP25B	B207
CPMT3252MP KCU10	B207
CPMT3252MW KC5010	B208
CPMT3252MW KCK20	B208
CPMT3252MW KCK20B	B208
CPMT3252MW KCP25	B208
CPMT3253MF KCM25B	B207
CPMT3253MF KCP25	B207
CRDPN162DV	B168, B386
CRDPN163DV	B168, B386
CRDPN164DV	B168, B386
CRDPN203DV	B168, B386
CRDPN204DV	B168, B386
CRGNL123	B373
CRGNL163	B373
CRGNL164	B373
CRGNLP204D	B374
CRGNR123	B373
CRGNR163	B373
CRGNR164	B373
CRGNR244F	B373
CRGNRP163D	B374
CRGNRP164D	B374
CRGNRP204D	B374
CRGPL162DV	B169, B387
CRGPL203DV	B169, B387
CRGPR162DV	B169, B387
CRGPR204DV	B169, B387
CS412	B168–169, B386–387
CSDNN124	B374
CSDNN164	B374
CSDNN164DMX5	B383
CSDPN103	B172, B376
CSDPN124	B172, B376
CSDPN164	B172, B376
CSDPN644	B172, B376
CSDPN856	B172, B376
CSKNL164DMX5	B384
CSKNR164DMX5	B384
CSKNR856	B375
CSKPL164D	B172, B377
CSKPR12CA4	B174, B394
CSKPR164D	B172, B377
CSRPL124B	B173, B377
CSRPL164D	B173, B377
CSRPL856D	B173, B377
CSRPL866E	B173, B377
CSRPR10CA3	B175, B395
CSRPR164D	B173, B377
CSRPR866E	B173, B377
CSSPL10CA3	B176, B396
CSSPL164D	B173, B378
CSSPL854D	B173, B378
CSSPL856D	B173, B378
CSSPR10CA3	B176, B396
CSSPR164D	B173, B378
CSSPR854D	B173, B378
CSWM 035 040	B217, B220, B222–223
CSWM 040 050	B217–223, B245, B276–278
CSWM 060 050	B72–74, B94, B115–119, B140–142, B174–176, B186–187, B198, B217, B220, B236–237, B245, B249–251, B254–255, B276–279, B394–398, C196, D41
CSWM 080 050	B72–74, B94–95, B115–117, B119, B140–142, B186, B198, B249, B397
CSWM 100 080	B74, B115, B119, C196, D41
CT11 WG	B291–292
CT15	B291–292
CTANR123	B375
CTAPL123B	B179, B378
CTAPL854D	B179, B378
CTAPR082B	B179, B378
CTAPR102B	B179, B378
CTAPR123B	B179, B378
CTAPR163D	B179, B378
CTAPR854D	B179, B378
CTBPL123B	B179, B379
CTBPR123B	B179, B379
CTBPR163D	B179, B379
CTCPL163C	B180, B379
CTCPL164D	B180, B379
CTCPL204D	B180, B379
CTCPL244D	B180, B379
CTCPN124	B180, B380
CTCPN443	B180, B380
CTCPN644	B180, B380
CTCPN664	B180, B380
CTCPR123B	B180, B379
CTCPR163C	B180, B379
CTCPR164C	B180, B379
CTCPR164D	B180, B379
CTCPR204D	B180, B379
CTCPR244D	B180, B379
CTEPL854D	B181, B380
CTEPR123B	B181, B380
CTEPR163D	B181, B380
CTEPR854D	B181, B380
CTFPL10CA2	B186, B397
CTFPL123B	B181, B381
CTFPL163D	B181, B381
CTFPL164D	B181, B381
CTFPL854D	B181, B381
CTFPR082V	B181, B381
CTFPR10CA2	B186, B397
CTFPR123B	B181, B381
CTFPR12CA3	B186, B397
CTFPR163D	B181, B381
CTFPR164C	B181, B381
CTFPR164D	B181, B381
CTFPR204D	B181, B381
CTFPR20CA4	B186, B397
CTFPR854D	B181, B381
CTGNR164	B375
CTGPL102B	B182, B382
CTGPL123B	B182, B382
CTGPL163C	B182, B382
CTGPL163D	B182, B382
CTGPL164D	B182, B382
CTGPL204D	B182, B382
CTGPR082B	B182, B382
CTGPR102B	B182, B382
CTGPR123A	B182, B382
CTGPR123B	B182, B382
CTGPR12CA3	B187, B398
CTGPR163C	B182, B382
CTGPR163D	B182, B382
CTGPR164C	B182, B382
CTGPR164D	B182, B382
CTGPR204D	B182, B382
CV40BDL10162	O53
CV40BDL12162	O53
CV40BDL16200	O53
CV40BDL20200	O53
CV40BDL25225	O53
CV40BDL32250	O53
CV40BKR32157	K91
CV40BKR50236	K91
CV40BSIF80248	K48
CV40FBHM1691	K134
CV40FBHMKIT645	K127, K131
CV50BHTS13M295	J90
CV50BHTS16M295	J90
CV50BHTS22M295	J90
CV50BHTS27M295	J90
CV50BHTS32M314	J90
CV50BHTS40M314	J90
CV50BHTS50M314	J90
CV50BKR32157	K91
CV50BKR50157	K91
CV50BKR63236	K91
CV50BKR80275	K91
CV50BSIF100236	K48
CV50BSIF70236	K48
CV50BT13069	K142
CV50RMHTS13M394	J90
CV50RMHTS16M394	J90
CV50RMHTS22M394	J90
CV50RMHTS27M394	J90
CV50RMHTS32M394	J90
CV50RMHTS40M413	J90
CV50RMHTS50M413	J90
CW16	S30–31
CWLNL164DMX5	B384
CWLNL204DMX5	B384
CWLNR164DMX5	B384
CWLNR204DMX5	B384
CXE0125MTN4-C SP4060	P84
CXE0187MTN4-C SP4060	P84
CXE0250MN4-C SP4060	P84
CXE0375MN4-C SP4060	P84
CXE0500MN4-C SP4060	P84
CXE0750MN4-C SP4060	P84
CXER0125NTN4-C SP4060	P85
CXER0125NTN4-F SP4060	P85
CXER0250NN4-C SP4060	P85
CXER0250NN4-E SP4060	P85
CXER0375NN4-C SP4060	P85
CXER0375NN4-E SP4060	P85
CXER0469NTN4-E SP4060	P85
CXER0500NN4-C SP4060	P85
CXER0500NN4-F SP4060	P85
CXER0500NN4-J SP4060	P85
CXER0500NN4-K SP4060	P85
CXER0500NN4-L SP4060	P85
CXER0625NN4-C SP4060	P85
CXER0625NN4-J SP4060	P85
CXER0750NN4-C SP4060	P85
CXER0750NN4-F SP4060	P85
CXER0750NN4-K SP4060	P85

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
CXER0750NN4-L SP4060	P85
CXER1000NN4-C SP4060	P85
CXER1000NN4-F SP4060	P85
CXER1000NN4-L SP4060	P85
D16TTB16	B409
D20TTB18	B409
D24TTB21	B409
D28TTB25	B409
D28TTB26KM40	B410
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	S31
D32TTB28	B409
D32TTB29KM40	B410
D355CFA	S31
D4007T S	V97
D4008T S	V97–98, V102–103
D400CFA	S31
D4010T S	V17–19, V103, V111–112, V114
D4012T S	V19
D40TTB35	B409
D40TTB36KM40	B410
D48TTB42	B409
D48TTB45KM63	B410
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	S31
D5013T S	V111–112, V114
D5420W	B407
D5424W	B407
D5428W	B407
D5432W	B407
D5440W	B407
D6014T S	V112
D6018S S	V112
D64TTB56	B409
D64TTB58KM63	B410
DCGM3251S0525MTCB1 KBH20	B331
DCGT21505HP K313	B224
DCGT21505HP KC5010	B224
DCGT21505HP KC5025	B224
DCGT21505HP KC5410	B224
DCGT21505HP KCU10	B224
DCGT21505HP KCU25	B224
DCGT2150LF KC5010	B224
DCGT2150LF KC5025	B224
DCGT2150LF KCU10	B224
DCGT2151HP K313	B224
DCGT2151HP KC5010	B224
DCGT2151HP KC5025	B224
DCGT2151HP KC5410	B224
DCGT2151HP KCU10	B224
DCGT2151HP KCU25	B224
DCGT2152HP KC5010	B224
DCGT2152HP KC5025	B224
DCGT2152HP KC5410	B224
DCGT2152HP KCU10	B224
DCGT215X0LF KC5025	B224
DCGT32505HP K313	B224
DCGT32505HP KC5010	B224
DCGT32505HP KC5025	B224
DCGT32505HP KC5410	B224
DCGT32505HP KCU10	B224
DCGT32505HP KCU25	B224
DCGT3250LF KC5010	B224
DCGT3250LF KC5025	B224
DCGT3250LF KCU10	B224
DCGT3251HP K313	B224
DCGT3251HP KC5010	B224
DCGT3251HP KC5025	B224
DCGT3251HP KC5410	B224
DCGT3251HP KCU10	B224
DCGT3251HP KCU25	B224
DCGT3252HP K313	B224
DCGT3252HP KC5010	B224
DCGT3252HP KC5025	B224
DCGT3252HP KC5410	B224
DCGT3252HP KCU10	B224
DCGT3252HP KCU25	B224
DCGT325X0LF KC5025	B224
DCGT432LF KC5010	B224
DCGT432LF KCU10	B224
DCGW21505S0415C KB5630	B311, B332
DCGW21505S0415MT KBH10	B332
DCGW21505S0525MT KBH20	B332
DCGW2151FST KD1400	B364
DCGW2151FST KD1425	B364
DCGW2151S0415C KB5630	B311, B332
DCGW2151S0415MT KBH10	B332
DCGW2151S0415MT KBH20	B332
DCGW2151S0525MT KBH10	B332
DCGW2151S0525MT KBH20	B332
DCGW32505S0415MT KBH10	B332
DCGW32505S0525MT KBH20	B332
DCGW3251FST KD1400	B364
DCGW3251FST KD1425	B364
DCGW3251S0415MT KB1345	B312
DCGW3251S0415MT KB5630	B312, B332
DCGW3251S0415MT KBH10	B332
DCGW3251S0415MT KBH20	B332
DCGW3251S0525MT KBH10	B332
DCGW3251S0525MT KBH20	B332
DCGW3252S0415FWMT KBH10	B332
DCGW3252S0415FWMT KBH20	B332
DCGW3252S0415MT KB1345	B312
DCGW3252S0415MT KB5630	B312, B332
DCGW3252S0415MT KBH10	B332
DCGW3252S0415MT KBH20	B332
DCGW3252S0525FWMT KBH10	B332
DCGW3252S0525MT KBH10	B332
DCGW3252S0525MT KBH20	B332
DCKNL164DKC3	B58
DCKNL204DKC3	B58
DCKNR124BKC3	B58
DCKNR164CKC3	B58
DCKNR164DKC3	B58
DCKNR204DKC3	B58
DCKNR205DKC4	B58
DCKNR206DKC4	B58
DCLNL123BKC3	B59
DCLNL124BKC3	B59
DCLNL163DKC3	B59
DCLNL164CKC3	B59
DCLNL164DKC3	B59
DCLNL165CKC4	B59
DCLNL165DKC4	B59
DCLNL204DKC3	B59
DCLNL205DKC4	B59
DCLNL206DKC4	B59
DCLNL244DKC3	B59
DCLNL245DKC4	B59
DCLNL246DKC4	B59
DCLNR123BKC3	B59
DCLNR124BKC3	B59
DCLNR163DKC3	B59
DCLNR164CKC3	B59
DCLNR164DKC3	B59
DCLNR165CKC4	B59
DCLNR165DKC4	B59
DCLNR166DKC4	B59
DCLNR204DKC3	B59
DCLNR205DKC4	B59
DCLNR206DKC4	B59
DCLNR244DKC3	B59
DCLNR245DKC4	B59
DCLNR246DKC4	B59
DCMT2150511 KT315	B224
DCMT21505FP KCM25	B225
DCMT21505FP KCP25B	B225
DCMT21505FP KCU10	B225
DCMT21505FP KTP10	B225
DCMT21505LF K313	B225
DCMT21505LF KC5010	B225
DCMT21505LF KC5025	B225
DCMT215111 KT315	B224
DCMT2151FP KCM15	B225
DCMT2151FP KCM25	B225
DCMT2151FP KCM25B	B225
DCMT2151FP KCP10	B225
DCMT2151FP KCP25	B225
DCMT2151FP KCU10	B225
DCMT2151FP KCU25	B225
DCMT2151LF K313	B225
DCMT2151LF KC5010	B225
DCMT2151LF KC5025	B225
DCMT2151LF KCK15B	B225
DCMT2151LF KCK20	B225
DCMT2151LF KCM15	B225
DCMT2151LF KCM15B	B225
DCMT2151LF KCM25	B225
DCMT2151LF KCM25B	B225
DCMT2151LF KCM35	B225
DCMT2151LF KCP10	B225
DCMT2151LF KCP10B	B225
DCMT2151LF KCP25	B225
DCMT2151LF KCP25B	B225
DCMT2151LF KCP30	B225
DCMT2151LF KT315	B225
DCMT2151UF KC5010	B226
DCMT2151UF KCP25	B226
DCMT2152FP KCM25	B225
DCMT2152FP KCM25B	B225
DCMT2152FP KCP05	B225
DCMT2152FP KCP25	B225
DCMT2152FP KCP25B	B225
DCMT2152FP KCU10	B225
DCMT32505FP KCM25	B225
DCMT32505FP KCM25B	B225
DCMT32505FP KCP10B	B225
DCMT32505FP KCP25	B225
DCMT32505FP KCP25B	B225
DCMT32505FP KCU10	B225
DCMT32505FP KCU25	B225
DCMT32505FP KTP10	B225
DCMT32505LF KC5010	B225
DCMT32505LF KC5025	B225
DCMT32505LF KT315	B225
DCMT32505UF KC5010	B226
DCMT32505UF KCP05	B226
DCMT325111 KT315	B224
DCMT3251FP KCM15	B225
DCMT3251FP KCM25	B225
DCMT3251FP KCM25B	B225
DCMT3251FP KCP05	B225
DCMT3251FP KCP10	B225
DCMT3251FP KCP10B	B225
DCMT3251FP KCP25	B225
DCMT3251FP KCP25B	B225
DCMT3251FP KCU10	B225
DCMT3251FP KCU25	B225
DCMT3251FP KTP10	B225
DCMT3251FW KC5010	B225
DCMT3251FW KCK20	B225
DCMT3251FW KCP25	B225
DCMT3251FW KCU10	B225
DCMT3251LF K313	B225
DCMT3251LF KC5010	B225
DCMT3251LF KC5025	B225
DCMT3251LF KCK05	B225
DCMT3251LF KCK15	B225
DCMT3251LF KCK20	B225
DCMT3251LF KCK20B	B225
DCMT3251LF KCM15	B225
DCMT3251LF KCM15B	B225
DCMT3251LF KCM25	B225
DCMT3251LF KCM25B	B225
DCMT3251LF KCP05	B225
DCMT3251LF KCP10	B225
DCMT3251LF KCP10B	B225
DCMT3251LF KCP25	B225
DCMT3251LF KCP25B	B225
DCMT3251LF KCP30	B225
DCMT3251LF KT315	B225
DCMT3251MF KCK15	B226
DCMT3251MF KCK20	B226
DCMT3251MF KCM15	B226
DCMT3251MF KCM25	B226
DCMT3251MF KCM25B	B226
DCMT3251MF KCP10	B226
DCMT3251MF KCP10B	B226
DCMT3251MF KCP25	B226
DCMT3251MF KCP25B	B226
DCMT3251MF KCP30	B226
DCMT3251MP KCP10	B226
DCMT3251MP KCP25	B226
DCMT3251MP KCU10	B226
DCMT3251MW KCU10	B226
DCMT3251UF KC5010	B226
DCMT3251UF KCP05	B226
DCMT3251UF KCP10B	B226
DCMT3251UF KCP25B	B226
DCMT325211 KT315	B224
DCMT3252FP KCK20B	B225
DCMT3252FP KCM15	B225
DCMT3252FP KCM25	B225
DCMT3252FP KCM25B	B225
DCMT3252FP KCP05	B225
DCMT3252FP KCP10	B225
DCMT3252FP KCP10B	B225
DCMT3252FP KCP25	B225
DCMT3252FP KCU10	B225
DCMT3252FP KCU25	B225
DCMT3252FP KTP10	B225
DCMT3252FW KCP25	B225
DCMT3252FW KCU10	B225
DCMT3252FW KT315	B225
DCMT3252LF K313	B225
DCMT3252LF KC5010	B225
DCMT3252LF KC5025	B225
DCMT3252LF KCK05	B225
DCMT3252LF KCK15	B225
DCMT3252LF KCK15B	B225
DCMT3252LF KCK20	B225
DCMT3252LF KCK20B	B225
DCMT3252LF KCM15	B225
DCMT3252LF KCM15B	B225
DCMT3252LF KCM25	B225
DCMT3252LF KCM25B	B225
DCMT3252LF KCP10	B225
DCMT3252LF KCP10B	B225
DCMT3252LF KCP25	B225
DCMT3252LF KCP25B	B225
DCMT3252LF KCU10	B225
DCMT3252LF KT315	B225
DCMT3252MF KCK15	B226
DCMT3252MF KCK20	B226
DCMT3252MF KCM15	B226
DCMT3252MF KCM15B	B226

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
DCMT3252MF KCM25	B226
DCMT3252MF KCM35	B226
DCMT3252MF KCP10	B226
DCMT3252MF KCP10B	B226
DCMT3252MF KCP25	B226
DCMT3252MF KCP25B	B226
DCMT3252MF KCP30	B226
DCMT3252MP KCK20	B226
DCMT3252MP KCK20B	B226
DCMT3252MP KCM15	B226
DCMT3252MP KCM25	B226
DCMT3252MP KCM25B	B226
DCMT3252MP KCP10	B226
DCMT3252MP KCP25	B226
DCMT3252MP KCU10	B226
DCMT3252MW KCP25	B226
DCMT3252MW KCU10	B226
DCMT3252UF KC5010	B226
DCMT3252UF KCP05	B226
DCMT3252UF KCP10	B226
DCMT3252UF KCP10B	B226
DCMT3252UF KCP25	B226
DCMT3253FP KCP10	B225
DCMT3253LF KC5010	B225
DCMT3253LF KCP10	B225
DCMT3253LF KCP10B	B225
DCMT3253LF KCP25	B225
DCMT3253MF KCK15	B226
DCMT3253MF KCK20	B226
DCMT3253MF KCK20B	B226
DCMT3253MF KCP10	B226
DCMT3253MF KCP10B	B226
DCMT3253MF KCP25B	B226
DCMT3253MP KCP25	B226
DCMT3253MP KCU10	B226
DCMT431FP KCM25	B225
DCMT431FP KCP10	B225
DCMT431LF KC5010	B225
DCMT431LF KC5025	B225
DCMT431LF KCP10	B225
DCMT431LF KCP25B	B225
DCMT432FP KCM25	B225
DCMT432FP KCP05	B225
DCMT432FP KCP25	B225
DCMT432FP KCU10	B225
DCMT432LF KC5010	B225
DCMT432LF KC5025	B225
DCMT432LF KCK20	B225
DCMT432LF KCP10	B225
DCMT432LF KCP10B	B225
DCMT432LF KCP25	B225
DCMT432LF KCP25B	B225
DCRNL164DKC3	B60
DCRNL204DKC3	B60
DCRNR124BKC3	B60
DCRNR164DKC3	B60
DCRNR204DKC3	B60
DCRNR206DKC4	B60
DCRNR245DKC4	B60
DDJNL123BKC3	B87
DDJNL163CKC3	B87
DDJNL163DKC3	B87
DDJNL164CKC3	B87
DDJNL164DKC3	B87
DDJNL165DKC4	B87
DDJNL204DKC3	B87
DDJNL205DKC4	B87
DDJNR123BKC3	B87
DDJNR163CKC3	B87
DDJNR163DKC3	B87
DDJNR164CKC3	B87
DDJNR164DKC3	B87
DDJNR165DKC4	B87
DDJNR203DKC3	B87
DDJNR204DKC3	B87
DDJNR245DKC4	B87
DDPNN164DKC3	B88
DDQNL164CKC3	B88
DDQNL164DKC3	B88
DDQNL204DKC3	B88
DDQNR164CKC3	B88
DDQNR164DKC3	B88
DDQNR204DKC3	B88
DFC040310D28DS KCU40	H114
DFC040310D28HP KCU25	H114
DFC040310D28HP KCU40	H114
DFC040310D28MD KC7140	H114
DFC05T312D32DS KCU40	H114
DFC05T312D32HP KCU25	H114
DFC05T312D32HP KCU40	H114
DFC05T312D32MD KC7140	H114
DFC06T312D36DS KCU40	H114
DFC06T312D36HP KCU25	H114
DFC06T312D36HP KCU40	H114
DFC06T312D36MD KC7140	H114
DFC070416D45DS KCU40	H114
DFC070416D45HP KCU25	H114
DFC070416D45HP KCU40	H114
DFC070416D45MD KC7140	H114
DFC090520D56DS KCU40	H114
DFC090520D56HP KCU25	H114
DFC090520D56HP KCU40	H114
DFC090520D56MD KC7140	H114
DFR020204GD KC7140	J97
DFR020204GD KCPK10	J97
DFR020204GD KCU25	J97
DFR020204GD KCU40	J97
DFR020204LD KC7140	J97
DFR020204LD KCPK10	J97
DFR020204LD KCU25	J97
DFR020204LD KCU40	J97
DFR020204MD KC7140	J97
DFR020204MD KCU25	J97
DFR020204MD KCU40	J97
DFR030204GD KC7140	J97
DFR030204GD KCPK10	J97
DFR030204GD KCU25	J97
DFR030204GD KCU40	J97
DFR030204LD KC7140	J97
DFR030204LD KCPK10	J97
DFR030204LD KCU25	J97
DFR030204LD KCU40	J97
DFR030204MD KC7140	J97
DFR030204MD KCU25	J97
DFR030204MD KCU40	J97
DFR040304D28GD KCU25	H113
DFR040304D28GD KCU40	H113
DFR040304D28LD KC7225	H113
DFR040304D28MD KC7140	H113, J97
DFR040304GD KC7140	J97
DFR040304GD KCPK10	J97
DFR040304GD KCU25	J97
DFR040304GD KCU40	J97
DFR040304LD KC7140	J97
DFR040304LD KCPK10	J97
DFR040304LD KCU25	J97
DFR040304LD KCU40	J97
DFR040304MD KC7140	J97
DFR040304MD KCU25	J97
DFR040304MD KCU40	J97
DFR040304ST KD1425	J98
DFR0500R2SSF075	J13
DFR0500R3SSF075	J14
DFR0500R4SSF075	J15
DFR0531R3SSF075	J14
DFR0531R4SSF075	J15
DFR0563R2SSF075	J13
DFR0563R3SSF075	J14
DFR0563R4SSF075	J15
DFR0594R3SSF075	J14
DFR0594R4SSF075	J15
DFR0625R2SSF075	J13
DFR0625R3SSF075	J14
DFR0625R3SSF100	J14
DFR0625R4SSF075	J15
DFR0625R4SSF100	J15
DFR0656R3SSF075	J14
DFR0656R3SSF100	J14
DFR0656R4SSF100	J15
DFR0688R2SSF075	J13
DFR0688R3SSF075	J14
DFR0688R3SSF100	J14
DFR0688R4SSF100	J15
DFR0703R3SSF075	J14
DFR0703R3SSF100	J14
DFR0703R4SSF100	J15
DFR0734R3SSF075	J14
DFR0734R3SSF100	J14
DFR0734R4SSF100	J15
DFR0750R2SSF100	J13
DFR0750R3SSF075	J14
DFR0750R3SSF100	J14
DFR0750R4SSF100	J15
DFR0781R3SSF075	J14
DFR0781R3SSF100	J14
DFR0781R4SSF100	J15
DFR0813R2SSF100	J13
DFR0813R3SSF075	J14
DFR0813R3SSF100	J14
DFR0813R4SSF100	J15
DFR0844R3SSF075	J14
DFR0844R3SSF100	J14
DFR0844R4SSF100	J15
DFR0875R2SSF100	J13
DFR0875R3SSF075	J14
DFR0875R3SSF100	J14
DFR0875R4SSF100	J15
DFR0906R3SSF100	J14
DFR0906R4SSF100	J15
DFR0938R2SSF100	J13
DFR0938R3SSF100	J14
DFR0938R4SSF100	J15
DFR0969R3SSF100	J14
DFR0969R4SSF100	J15
DFR0984R3SSF100	J14
DFR0984R4SSF100	J15
DFR1000R2SSF100	J13
DFR1000R3SSF100	J14
DFR1000R3SSF125	J14
DFR1000R4SSF100	J15
DFR1000R4SSF125	J15
DFR125R2WD20M	J10
DFR125R3WD20M	J11
DFR125R4WD20M	J12
DFR127R2WD20M	J10
DFR127R3WD20M	J11
DFR127R4WD20M	J12
DFR130R2WD20M	J10
DFR130R3WD20M	J11
DFR130R4WD20M	J12
DFR135R2WD20M	J10
DFR135R3WD20M	J11
DFR135R4WD20M	J12
DFR140R2WD20M	J10
DFR140R3WD20M	J11
DFR140R4WD20M	J12
DFR145R2WD20M	J10
DFR145R3WD20M	J11
DFR145R4WD20M	J12
DFR150R2WD20M	J10
DFR150R3WD20M	J11
DFR150R4WD20M	J12
DFR155R2WD20M	J10
DFR155R3WD20M	J11
DFR155R4WD20M	J12
DFR160R2WD20M	J10
DFR160R3WD20M	J11
DFR160R4WD20M	J12
DFR165R2WD32M	J10
DFR165R3WD32M	J11
DFR165R4WD32M	J12
DFR170R2WD32M	J10
DFR170R3WD32M	J11
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
DFSP0563R2SSF075	J32
DFSP0563R3SSF075	J34
DFSP0594R2SSF075	J32
DFSP0594R3SSF075	J34
DFSP0625R2SSF075	J32
DFSP0625R3SSF075	J34
DFSP0656R2SSF075	J32
DFSP0656R3SSF075	J34
DFSP0688R2SSF075	J32–33
DFSP0688R3SSF075	J34–35
DFSP0703R2SSF075	J32
DFSP0703R3SSF075	J34
DFSP0734R2SSF075	J32
DFSP0734R3SSF075	J34
DFSP0750R2SSF100	J32
DFSP0750R3SSF100	J34
DFSP0750R4SSF100	J36
DFSP0781R2SSF100	J32
DFSP0781R3SSF100	J34
DFSP0781R4SSF100	J36
DFSP0813R2SSF100	J32
DFSP0813R3SSF100	J34
DFSP0813R4SSF100	J36
DFSP0813R5SSF100	J38
DFSP0844R2SSF100	J32–33
DFSP0844R3SSF100	J34–35
DFSP0844R4SSF100	J36–37
DFSP0844R5SSF100	J38–39
DFSP0875R2SSF100	J32
DFSP0875R3SSF100	J34
DFSP0875R4SSF100	J36
DFSP0875R5SSF100	J38
DFSP0906R2SSF100	J32
DFSP0906R3SSF100	J34
DFSP0906R4SSF100	J36
DFSP0906R5SSF100	J38
DFSP0938R2SSF100	J32
DFSP0938R3SSF100	J34
DFSP0938R4SSF100	J36
DFSP0938R5SSF100	J38
DFSP0969R2SSF100	J32
DFSP0969R3SSF100	J34
DFSP0969R4SSF100	J36
DFSP0969R5SSF100	J38
DFSP0984R2SSF100	J32
DFSP0984R3SSF100	J34
DFSP0984R4SSF100	J36
DFSP0984R5SSF100	J38
DFSP1000R2SSF100	J32
DFSP1000R2SSF125	J32

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
DFSP1000R2SSF150	J32–33
DFSP1000R3SSF100	J34
DFSP1000R3SSF125	J34
DFSP1000R3SSF150	J34–35
DFSP1000R4SSF100	J36
DFSP1000R4SSF125	J36
DFSP1000R4SSF150	J36–37
DFSP1000R5SSF100	J38
DFSP1000R5SSF125	J38
DFSP1000R5SSF150	J38–39
DFSP1031R2SSF125	J32
DFSP1031R3SSF125	J34
DFSP1031R4SSF125	J36
DFSP1031R5SSF125	J38
DFSP1063R2SSF125	J32
DFSP1063R3SSF125	J34
DFSP1063R4SSF125	J36
DFSP1063R5SSF125	J38
DFSP1094R2SSF125	J32
DFSP1094R3SSF125	J34
DFSP1094R4SSF125	J36
DFSP1094R5SSF125	J38
DFSP1125R2SSF125	J32
DFSP1125R3SSF125	J34
DFSP1125R4SSF125	J36
DFSP1125R5SSF125	J38
DFSP1156R2SSF125	J32
DFSP1156R3SSF125	J34
DFSP1156R4SSF125	J36
DFSP1156R5SSF125	J38
DFSP1188R2SSF125	J32
DFSP1188R3SSF125	J34
DFSP1188R4SSF125	J36
DFSP1188R5SSF125	J38
DFSP1219R2SSF125	J32
DFSP1219R3SSF125	J34
DFSP1219R4SSF125	J36
DFSP1219R5SSF125	J38
DFSP1250R2SSF125	J32–33
DFSP1250R3SSF125	J34
DFSP1250R4SSF125	J36
DFSP1250R4SSF150	J36–37
DFSP1250R5SSF125	J38
DFSP1250R5SSF150	J38–39
DFSP1281R3SSF125	J34–35
DFSP1313R2SSF125	J32
DFSP1313R2SSF150	J32
DFSP1313R3SSF125	J34
DFSP1313R3SSF150	J34
DFSP1313R4SSF125	J36
DFSP1313R5SSF125	J38
DFSP1375R2SSF125	J32
DFSP1375R2SSF150	J32
DFSP1375R3SSF125	J34
DFSP1375R3SSF150	J34
DFSP1375R4SSF125	J36
DFSP1375R4SSF150	J36
DFSP1375R5SSF125	J38
DFSP1375R5SSF150	J38
DFSP1406R4SSF150	J36
DFSP140R2WD20M	J24
DFSP140R3WD20M	J26
DFSP140R4WD20M	J28
DFSP1438R2SSF125	J32
DFSP1438R3SSF125	J34
DFSP1438R4SSF125	J36
DFSP1438R5SSF125	J38
DFSP145R2WD20M	J24
DFSP145R3WD20M	J26
DFSP145R4WD20M	J28
DFSP1469R2SSF125	J32
DFSP1469R3SSF125	J34
DFSP1500R2SSF125	J32
DFSP1500R2SSF150	J32
DFSP1500R3SSF125	J34
DFSP1500R3SSF150	J34
DFSP1500R4SSF125	J36
DFSP1500R4SSF150	J36
DFSP1500R5SSF125	J38
DFSP1500R5SSF150	J38
DFSP150R2WD20M	J24
DFSP150R3WD20M	J26
DFSP150R4WD20M	J28
DFSP155R2WD20M	J24
DFSP155R3WD20M	J26
DFSP155R4WD20M	J28
DFSP1563R2SSF125	J32
DFSP1563R2SSF150	J32–33
DFSP1563R3SSF150	J34–35
DFSP1563R4SSF150	J36
DFSP1563R5SSF150	J38–39
DFSP160R2WD20M	J24
DFSP160R3WD20M	J26
DFSP160R4WD20M	J28
DFSP1625R2SSF125	J32
DFSP1625R2SSF150	J32
DFSP1625R3SSF125	J34
DFSP1625R3SSF150	J34
DFSP1625R4SSF150	J36–37
DFSP1625R5SSF150	J38
DFSP1656R2SSF150	J32
DFSP1656R3SSF150	J34
DFSP1656R4SSF150	J36–37
DFSP1656R5SSF150	J38–39
DFSP165R2WD32M	J24
DFSP165R3WD32M	J26
DFSP165R4WD20M	J28
DFSP1688R2SSF150	J32–33
DFSP1688R3SSF150	J34–35
DFSP170R2WD32M	J24–25
DFSP170R3WD32M	J26–27
DFSP170R4WD20M	J28–29
DFSP1750R2SSF150	J32
DFSP1750R3SSF150	J34
DFSP1750R4SSF150	J36
DFSP1750R5SSF150	J38
DFSP175R2WD32M	J24
DFSP175R3WD32M	J26
DFSP175R4WD32M	J28
DFSP180R2WD32M	J24
DFSP180R3WD32M	J26
DFSP180R4WD32M	J28
DFSP1813R2SSF150	J32
DFSP1813R3SSF150	J34
DFSP1813R4SSF150	J36
DFSP1813R5SSF150	J38
DFSP185R2WD32M	J24
DFSP185R3WD32M	J26
DFSP185R4WD32M	J28
DFSP1875R2SSF150	J32–33
DFSP1875R3SSF150	J34–35
DFSP1875R4SSF150	J36–37
DFSP1875R5SSF150	J38–39
DFSP190R2WD32M	J24
DFSP190R3WD32M	J26
DFSP190R4WD32M	J28
DFSP1938R2SSF150	J32
DFSP1938R3SSF150	J34
DFSP1938R4SSF150	J36
DFSP1938R5SSF150	J38
DFSP195R2WD32M	J24
DFSP195R3WD32M	J26
DFSP195R4WD32M	J28
DFSP2000R2SSF150	J32
DFSP2000R2SSF200	J32
DFSP2000R3SSF150	J34
DFSP2000R3SSF200	J34
DFSP2000R4SSF150	J36
DFSP2000R4SSF200	J36
DFSP2000R5SSF150	J38
DFSP2000R5SSF200	J38
DFSP200R2WD32M	J24
DFSP200R3WD32M	J26
DFSP200R4WD32M	J28
DFSP200R5WD32M	J30
DFSP210R2WD32M	J24–25
DFSP210R3WD32M	J26–27
DFSP210R4WD32M	J28–29
DFSP210R5WD32M	J30–31
DFSP2125R2SSF150	J32
DFSP2125R2SSF200	J32–33
DFSP2125R3SSF150	J34
DFSP2125R3SSF200	J34–35
DFSP2125R4SSF150	J36
DFSP2125R4SSF200	J36–37
DFSP2125R5SSF150	J38
DFSP2125R5SSF200	J38–39
DFSP220R2WD32M	J24
DFSP220R3WD32M	J26
DFSP220R4WD32M	J28
DFSP220R5WD32M	J30
DFSP230R2WD32M	J24
DFSP230R3WD32M	J26
DFSP230R4WD32M	J28
DFSP230R5WD32M	J30
DFSP240R2WD32M	J24
DFSP240R3WD32M	J26
DFSP240R4WD32M	J28
DFSP240R5WD32M	J30
DFSP250R2WD32M	J24–25
DFSP250R3WD32M	J26–27
DFSP250R4WD32M	J28–29
DFSP250R5WD32M	J30–31
DFSP260R2WD32M	J24
DFSP260R3WD32M	J26
DFSP260R4WD32M	J28
DFSP260R5WD32M	J30
DFSP265R2WD32M	J24
DFSP265R3WD32M	J26
DFSP265R4WD32M	J28
DFSP265R5WD32M	J30
DFSP270R2WD32M	J24
DFSP270R3WD32M	J26
DFSP270R4WD32M	J28
DFSP270R5WD32M	J30
DFSP280R2WD32M	J24
DFSP280R3WD32M	J26
DFSP280R4WD32M	J28
DFSP280R5WD32M	J30
DFSP290R2WD32M	J24
DFSP290R3WD32M	J26
DFSP290R4WD32M	J28
DFSP290R5WD32M	J30
DFSP300R2WD32M	J24
DFSP300R3WD32M	J26
DFSP300R4WD32M	J28
DFSP300R5WD32M	J30
DFSP310R2WD32M	J24
DFSP310R3WD32M	J26
DFSP310R4WD32M	J28
DFSP310R5WD32M	J30
DFSP320R2WD32M	J24–25
DFSP320R3WD32M	J26–27
DFSP320R4WD32M	J28–29
DFSP320R5WD32M	J30–31
DFSP330R2WD32M	J24
DFSP330R3WD32M	J26
DFSP330R4WD32M	J28
DFSP330R5WD32M	J30
DFSP340R2WD32M	J24
DFSP340R3WD32M	J26
DFSP340R4WD32M	J28
DFSP340R5WD32M	J30
DFSP350R2WD32M	J24
DFSP350R3WD32M	J26
DFSP350R4WD32M	J28
DFSP350R5WD32M	J30
DFSP360R2WD32M	J24
DFSP360R3WD32M	J26
DFSP360R4WD32M	J28
DFSP360R5WD32M	J30
DFSP370R2WD32M	J24
DFSP370R3WD32M	J26
DFSP370R4WD32M	J28
DFSP370R5WD32M	J30
DFSP375R2WD32M	J24
DFSP375R3WD32M	J26
DFSP375R4WD32M	J28
DFSP375R5WD32M	J30
DFSP380R2WD32M	J24
DFSP380R3WD32M	J26
DFSP380R4WD32M	J28
DFSP380R5WD32M	J30
DFSP390R2WD32M	J24
DFSP390R3WD32M	J26
DFSP390R4WD32M	J28
DFSP390R5WD32M	J30
DFSP400R2WD32M	J24–25
DFSP400R3WD32M	J26–27
DFSP400R4WD32M	J28–29
DFSP400R5WD32M	J30–31
DFSP410R2WD32M	J24
DFSP410R3WD32M	J26
DFSP410R4WD32M	J28
DFSP410R5WD32M	J30
DFSP420R2WD32M	J25
DFSP420R3WD32M	J27
DFSP420R4WD32M	J29
DFSP420R5WD32M	J30
DFSP430R2WD32M	J25
DFSP430R3WD32M	J27
DFSP430R4WD32M	J29
DFSP430R5WD32M	J30–31
DFSP440R2WD32M	J25
DFSP440R3WD32M	J27
DFSP440R4WD32M	J29
DFSP440R5WD32M	J30
DFSP450R2WD40M	J25
DFSP450R3WD40M	J27
DFSP450R4WD40M	J29
DFSP450R5WD40M	J30
DFSP460R2WD40M	J25
DFSP460R3WD40M	J27
DFSP460R4WD40M	J29
DFSP460R5WD40M	J30
DFSP470R2WD40M	J25
DFSP470R3WD40M	J27
DFSP470R4WD40M	J29
DFSP470R5WD40M	J30
DFSP480R2WD40M	J25
DFSP480R3WD40M	J27
DFSP480R4WD40M	J29
DFSP480R5WD40M	J30–31
DFSP490R2WD40M	J25
DFSP490R3WD40M	J27
DFSP490R4WD40M	J29
DFSP490R5WD40M	J30
DFSP500R2WD40M	J25
DFSP500R3WD40M	J27
DFSP500R4WD40M	J29
DFSP500R5WD40M	J30
DFSP505R2WD40M	J25
DFSP505R3WD40M	J27
DFSP510R2WD40M	J25
DFSP510R3WD40M	J27
DFSP510R4WD40M	J29
DFSP510R5WD40M	J30
DFSP520R2WD40M	J25
DFSP520R3WD40M	J27
DFSP520R4WD40M	J29
DFSP520R5WD40M	J30
DFSP530R2WD40M	J25
DFSP530R3WD40M	J27
DFSP530R4WD40M	J29
DFSP530R5WD40M	J30
DFSP540R2WD40M	J25
DFSP540R3WD40M	J27
DFSP540R4WD40M	J29
DFSP540R5WD40M	J30
DFSP550R2WD50M	J25
DFSP550R3WD50M	J27
DFSP550R4WD50M	J29
DFSP550R5WD50M	J30–31
DFT030204GD KCPK10	J101
DFT030204GD KCU25	J101
DFT030204GD KCU40	J101
DFT030204HP KC7140	J101
DFT030204HP KCPK10	J101
DFT030204HP KCU25	J101
DFT030204HP KCU40	J101
DFT030204HP KMF	J101
DFT030204MD KC7140	J101
DFT030204MD KCU25	J101
DFT030204MD KCU40	J101
DFT030304DS KCU40	J102
DFT030304GD KC7140	J101
DFT030304GD KCPK10	J101
DFT030304GD KCU25	J101

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
DFT030304GD KCU40	J101
DFT030304HP KC7140	J101
DFT030304HP KCPK10	J101
DFT030304HP KCU25	J101
DFT030304HP KCU40	J101
DFT030304HP KMF	J101
DFT030304MD KC7140	J101
DFT030304MD KCU25	J101
DFT030304MD KCU40	J101
DFT05T308D32DS KCU40	H112
DFT05T308D32HP KCU25	H112
DFT05T308D32HP KCU40	H112
DFT05T308D32MD KC7140	H113
DFT05T308D33DS KCU40	H112
DFT05T308D33HP KCU25	H112
DFT05T308D33HP KCU40	H112
DFT05T308D33MD KC7140	H113
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DFT05T308GD KC7140	J101
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DFT05T308HP KMF	J101
DFT05T308MD KC7140	J101
DFT05T308MD KCU25	J101
DFT05T308MD KCU40	J101
DFT05T308ST KD1425	J98
DFT06T308D36DS KCU40	H112
DFT06T308D36HP KCU25	H112
DFT06T308D36HP KCU40	H112
DFT06T308D36MD KC7140	H113
DFT06T308D39DS KCU40	H112
DFT06T308D39HP KCU25	H112
DFT06T308D39HP KCU40	H112
DFT06T308D39MD KC7140	H113
DFT06T308D44DS KCU40	H112
DFT06T308D44HP KCU25	H112
DFT06T308D44HP KCU40	H112
DFT06T308D44MD KC7140	H113
DFT06T308DS KCU40	J102
DFT06T308GD KC7140	J101
DFT06T308GD KCPK10	J101
DFT06T308GD KCU25	J101
DFT06T308GD KCU40	J101
DFT06T308HP KC7140	J101
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DFT06T308MD KCU40	J101
DFT06T308ST KD1425	J98
DFT070408D45DS KCU40	H112
DFT070408D45HP KCU25	H112
DFT070408D45HP KCU40	H112
DFT070408D45MD KC7140	H113
DFT070408D50DS KCU40	H112
DFT070408D50HP KCU25	H112
DFT070408D50HP KCU40	H112
DFT070408D50MD KC7140	H113
DFT070408DS KCU40	J102
DFT070408GD KC7140	J101
DFT070408GD KCPK10	J101
DFT070408GD KCU25	J101
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DFT070408MD KCU40	J101
DFT070408ST KD1425	J98
DFT0875R2SSF125	J51
DFT090508D56DS KCU40	H112
DFT090508D56HP KCU25	H112
DFT090508D56HP KCU40	H112
DFT090508D56MD KC7140	H113
DFT090508D63DS KCU40	H112
DFT090508D63HP KCU25	H112
DFT090508D63HP KCU40	H112
DFT090508D63MD KC7140	H113
DFT090508DS KCU40	J102
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DFT090508MD KCU40	J101
DFT090508ST KD1425	J98
DFT0906R2SSF125	J51
DFT0938R2SSF125	J51
DFT0969R2SSF125	J51
DFT0984R2SSF125	J51
DFT0984R4SSF100	J53
DFT1000R2SSF125	J51
DFT1000R2SSF150	J51
DFT1000R4SSF100	J53
DFT1000R4SSF125	J53
DFT1000R4SSF150	J53
DFT1031R2SSF125	J51
DFT1031R4SSF125	J53
DFT1063R2SSF125	J51
DFT1063R4SSF125	J53
DFT1094R2SSF125	J51
DFT1094R4SSF125	J53
DFT110508MD KC7140	J101
DFT110508ST KD1425	J98
DFT1125R2SSF125	J51
DFT1125R4SSF125	J53
DFT1125R4SSF150	J53
DFT1156R2SSF125	J51
DFT1156R4SSF125	J53
DFT1188R2SSF125	J51
DFT1188R4SSF125	J53
DFT1219R2SSF125	J51
DFT1219R2SSF150	J51
DFT1219R4SSF125	J53
DFT1250R2SSF125	J51
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DFT1250R4SSF125	J53
DFT1250R4SSF150	J53
DFT1281R2SSF125	J51
DFT1281R2SSF150	J51
DFT1281R4SSF125	J53
DFT1313R2SSF125	J51
DFT1313R2SSF150	J51
DFT1313R4SSF125	J53
DFT1375R2SSF125	J51
DFT1375R2SSF150	J51
DFT1375R4SSF125	J53
DFT1375R4SSF150	J53
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DFT1406R2SSF150	J51
DFT1406R4SSF125	J53
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DFT1500R2SSF150	J51
DFT1500R4SSF125	J53
DFT1500R4SSF150	J53
DFT1531R2SSF125	J51
DFT1531R2SSF150	J51
DFT1531R4SSF125	J53
DFT1531R4SSF150	J53
DFT1563R2SSF125	J51
DFT1563R2SSF150	J51
DFT1563R4SSF125	J53
DFT1563R4SSF150	J53
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DFT1750R4SSF150	J53
DFT1813R2SSF150	J51
DFT1813R4SSF150	J53
DFT1875R2SSF150	J51
DFT1875R4SSF150	J53
DFT1938R2SSF150	J52
DFT1938R4SSF150	J53
DFT2000R2SSF150	J52
DFT2000R2SSF200	J52
DFT2000R4SSF150	J53
DFT2000R4SSF200	J53
DFT2125R2SSF150	J52
DFT2125R2SSF200	J52
DFT2125R4SSF150	J53
DFT2125R4SSF200	J53
DFT2250R2SSF200	J52
DFT2375R2SSF200	J52
DFT2500R2SSF200	J52
DFT250R2WD32M	J48
DFT250R2WD40M	J48
DFT250R4WD32M	J50
DFT250R4WD40M	J50
DFT260R2WD32M	J48
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DFT270R2WD32M	J48
DFT270R2WD40M	J48
DFT270R4WD32M	J50
DFT270R4WD40M	J50
DFT2750R2SSF200	J52
DFT280R2WD32M	J48
DFT280R2WD40M	J48
DFT280R4WD32M	J50
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DFT290R2WD32M	J48
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DFT300R2WD32M	J48
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DFT720R2WD50M	J49
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DFT750R2WD50M	J49
DFT760R2WD50M	J49
DFT770R2WD50M	J49
DFT780R2WD50M	J49
DFT790R2WD50M	J49
DFT800R2WD50M	J49
DFT810R2WD50M	J49
DFT820R2WD50M	J49
DFTX20204DS KCU40	J102
DFTX20204HP KC7140	J101
DFTX20204HP KCU25	J101
DFTX20204HP KCU40	J101
DFTX20204MD KC7140	J101
DFTX20204MD KCU25	J101
DFTX20204MD KCU40	J101
DH35M	S39, T113
DNG451T0820 KY1615	B333
DNG452T0820 KY1615	B333
DNG453T0820 KY1615	B333
DNG454T0820 KY1615	B333

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
DNGA431E KD1405	B364
DNGA431FST KD1400	B365
DNGA431FST KD1425	B365
DNGA431S0415MT KBH10	B334
DNGA431S0415MT KBH20	B334
DNGA431S0425MT KB5630	B310, B334
DNGA431S0525MT KBH20	B334
DNGA431S0735MT KBH20	B334
DNGA431T0820 KY1615	B333
DNGA432FST KD1400	B365
DNGA432FST KD1425	B365
DNGA432S0415FWMT KBH10	B333
DNGA432S0415FWMT KBH20	B333
DNGA432S0415MT KBH10	B334
DNGA432S0415MT KBH20	B334
DNGA432S0420MT KB1345	B310
DNGA432S0425MT KB5630	B310, B334
DNGA432S0525FWMT KBH10	B333
DNGA432S0525MT KBH10	B334
DNGA432S0525MT KBH20	B334
DNGA432S0735MT KBH10	B334
DNGA432S0735MT KBH20	B334
DNGA432T0420 KYS30	B351
DNGA432T0820 KY1615	B333
DNGA432T0820 KY3500	B314
DNGA433S0415FWMT KBH20	B333
DNGA433S0415MT KBH10	B334
DNGA433S0415MT KBH20	B334
DNGA433S0525FWMT KBH10	B333
DNGA433S0525MT KBH10	B334
DNGA433S0525MT KBH20	B334
DNGA433S0735MT KBH10	B334
DNGA433S0735MT KBH20	B334
DNGA433T0420 KYS30	B351
DNGA433T0820 KY1615	B333
DNGA433T0820 KY3500	B314
DNGA434T0820 KY1615	B333
DNGA434T0820 KY3500	B314
DNGA434T0820 KYK10	B314
DNGA434T0820 KYK25	B314
DNGA441S0415MT KBH10	B334
DNGA441S0415MT KBH20	B334
DNGA441S0525MT KBH20	B334
DNGA441S0735MT KBH20	B334
DNGA441T0820 KY1615	B333
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DNGA442S0415MT KBH20	B334
DNGA442S0525MT KBH10	B334
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DNGA442S0735MT KBH20	B334
DNGA442T0820 KY1615	B333
DNGA442T0820 KY3500	B314
DNGA443S0415MT KBH10	B334
DNGA443S0415MT KBH20	B334
DNGA443S0525MT KBH10	B334
DNGA443S0525MT KBH20	B334
DNGA443S0735MT KBH20	B334
DNGA443T0820 KY1615	B333
DNGA443T0820 KY3500	B314
DNGG3305FS KC5010	B77
DNGG3305FS KCU10	B77
DNGG331FS KCU10	B77
DNGG332FS KCU10	B77
DNGG4305FS KC5010	B77
DNGG4305FS KCU10	B77
DNGG4305LF KC5010	B77
DNGG4305LF KCU10	B77
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DNGG431FS KC5025	B77
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DNGG432FS KCU25	B77
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DNGG442FS KCU10	B77
DNGM432S0525MTCB1 KBH20	B334
DNGM433S0525MTCB1 KBH20	B334
DNGM442S0525MTCB1 KBH20	B334
DNGM443S0525MTCB1 KBH20	B334
DNGN120408S02020 KBK45	B304
DNGN120412S02020 KBK45	B304
DNGP430 KC5010	B77
DNGP4305 KC5010	B77
DNGP4305 KC5410	B77
DNGP4305 KCU10	B77
DNGP431 K313	B77
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DNGP431 KC5410	B77
DNGP431 KCU10	B77
DNGP432 K313	B77
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DNGP432 KC5410	B77
DNGP432 KCU10	B77
DNGP441 K313	B77
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DNGP441 KCU10	B77
DNGP442 KC5010	B77
DNGP442 KCU10	B77
DNGX120708T02020 KY3500	B317
DNGX120712T02020 KY3500	B317
DNGX120712T02020 KYK25	B317
DNGX120716T02020 KY3500	B317
DNGX452T0420 KYS25	B351
DNGX452T0820 KY1615	B317, B335
DNGX452T0820 KY3500	B317
DNGX453T0420 KYS25	B351
DNGX453T0420 KYS30	B351
DNGX453T0820 KY3500	B317
DNGX453T0820 KYK25	B317
DNGX454T0420 KYS30	B351
DNGX454T0820 KY3500	B317
DNMA332 KCK05	B78
DNMA332 KCK20B	B78
DNMA332S0820 KB1340	B309
DNMA333S0820 KB1340	B309
DNMA432 KCK05	B78
DNMA432 KCK15	B78
DNMA432 KCK20	B78
DNMA432 KCK20B	B78
DNMA433 KCK05	B78
DNMA433 KCK15	B78
DNMA433 KCK20	B78
DNMA434 KCK20B	B78
DNMA442 KCK05	B78
DNMA442 KCK15	B78
DNMA442 KCK20	B78
DNMA443 KCK20	B78
DNMA443 KCK20B	B78
DNMG33133 KT315	B78
DNMG331FF KC5010	B79
DNMG331FF KCP05	B79
DNMG331FF KCP10	B79
DNMG331FF KCU10	B79
DNMG331FF KT315	B79
DNMG331FN KCK05	B79
DNMG331FN KCP05	B79
DNMG331FN KCP10	B79
DNMG331FN KCP10B	B79
DNMG331FN KCP25B	B79
DNMG331FN KT315	B79
DNMG331FP KC5010	B80
DNMG331FP KCM15	B80
DNMG331FP KCM15B	B80
DNMG331FP KCPK05	B80
DNMG331FP KCU10	B80
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DNMG331FW KT315	B80
DNMG331MN KCP05	B81
DNMG331MN KCP10B	B81
DNMG331MN KCP25	B81
DNMG331MN KCP25B	B81
DNMG331MN KCP30	B81
DNMG33233 KT315	B78
DNMG332CT KCP05	B79
DNMG332CT KCP10	B79
DNMG332CT KCP10B	B79
DNMG332FF KCP05	B79
DNMG332FF KCP05B	B79
DNMG332FF KCP10	B79
DNMG332FF KCP10B	B79
DNMG332FF KCU10	B79
DNMG332FF KT315	B79
DNMG332FN KCK05	B79
DNMG332FN KCP05	B79
DNMG332FN KCP10	B79
DNMG332FN KCP10B	B79
DNMG332FN KCP25B	B79
DNMG332FN KT315	B79
DNMG332FP KC5010	B80
DNMG332FP KCM15	B80
DNMG332FP KCP10	B80
DNMG332FP KCPK05	B80
DNMG332FP KCU10	B80
DNMG332FP KT315	B80
DNMG332FW KCM15B	B80
DNMG332FW KCP05	B80
DNMG332FW KCP10	B80
DNMG332FW KCP10B	B80
DNMG332FW KT315	B80
DNMG332MN KCP05	B81
DNMG332MN KCP10	B81
DNMG332MN KCP10B	B81
DNMG332MN KCP25	B81
DNMG332MN KCP25B	B81
DNMG332MN KCP30	B81
DNMG332MP KC5010	B81
DNMG332MP KCM15	B81
DNMG332MP KCM25	B81
DNMG332MP KCM25B	B81
DNMG332MP KCM35	B81
DNMG332MP KCU10	B81
DNMG332MR KCP10B	B82
DNMG332MR KCP25B	B82
DNMG332MS KC5010	B82
DNMG332MS KC5025	B82
DNMG332MS KCU10	B82
DNMG332MS KCU25	B82
DNMG332RP KC5010	B84
DNMG332RP KCK20B	B84
DNMG332RP KCM15	B84
DNMG332RP KCP10	B84
DNMG332RP KCP25B	B84
DNMG332RP KCU10	B84
DNMG332RP KCU25	B84
DNMG332UN KCK15	B84
DNMG332UN KCK15B	B84
DNMG332UN KCK20	B84
DNMG332UP KCM25	B84
DNMG333CT KCP10B	B79
DNMG333FN KCP05	B79
DNMG333FN KCP10B	B79
DNMG333MN KCP10	B81
DNMG333MN KCP25	B81
DNMG333MN KCP25B	B81
DNMG333MP KCM15	B81
DNMG333MP KCM25B	B81
DNMG333RP KCP25B	B84
DNMG333UN KCK15	B84
DNMG333UN KCK15B	B84
DNMG333UN KCK20	B84
DNMG4305MS KC5010	B82
DNMG4305MS KCU10	B82
DNMG4305MS KCU25	B82
DNMG430MS KCU10	B82
DNMG431CT KC5010	B79
DNMG431CT KCP10	B79
DNMG431CT KCP25	B79
DNMG431CT KCP25B	B79
DNMG431CT KCU10	B79
DNMG431FF KC5010	B79
DNMG431FF KCM15B	B79
DNMG431FF KCP10	B79
DNMG431FF KCU10	B79
DNMG431FF KT315	B79
DNMG431FN KCK05	B79
DNMG431FN KCK15B	B79
DNMG431FN KCP05	B79
DNMG431FN KCP10	B79
DNMG431FN KCP10B	B79
DNMG431FN KCP25	B79
DNMG431FN KCP25B	B79
DNMG431FN KT315	B79
DNMG431FP KC5010	B80
DNMG431FP KCM15	B80
DNMG431FP KCU10	B80
DNMG431FP KT315	B80
DNMG431FW KC5010	B80
DNMG431FW KCP10	B80
DNMG431FW KCU10	B80
DNMG431FW KT315	B80
DNMG431MN KCP10	B81
DNMG431MN KCP10B	B81
DNMG431MN KCP25	B81
DNMG431MN KCP25B	B81
DNMG431MN KCP30	B81
DNMG431MP KC5010	B81
DNMG431MP KCM15B	B81
DNMG431MP KCM25	B81
DNMG431MP KCM25B	B81
DNMG431MP KCM35	B81
DNMG431MP KCU10	B81
DNMG431MS K313	B82
DNMG431MS KC5010	B82
DNMG431MS KC5025	B82
DNMG431MS KCU10	B82
DNMG431MS KCU25	B82
DNMG431P KC5010	B83
DNMG431P KCU10	B83
DNMG431UP KCM15	B84
DNMG431UP KCM25	B84
DNMG431UP KCU10	B84
DNMG432 K68	B78
DNMG432CT KC5010	B79
DNMG432CT KCP10	B79
DNMG432CT KCP10B	B79
DNMG432CT KCP25	B79
DNMG432FF KC5010	B79
DNMG432FF KCP05	B79
DNMG432FF KCP10	B79
DNMG432FF KCP10B	B79
DNMG432FF KCU10	B79
DNMG432FF KT315	B79
DNMG432FN KCK05	B79
DNMG432FN KCP05	B79
DNMG432FN KCP10	B79
DNMG432FN KCP10B	B79
DNMG432FN KCP25	B79
DNMG432FN KCP25B	B79
DNMG432FN KCPK05	B79
DNMG432FN KT315	B79
DNMG432FP KC5010	B80
DNMG432FP KCM15	B80
DNMG432FP KCP10	B80
DNMG432FP KCP25	B80
DNMG432FP KCU10	B80
DNMG432FP KT315	B80
DNMG432FW KCK15B	B80
DNMG432FW KCP05	B80
DNMG432FW KCP10B	B80
DNMG432FW KCU10	B80
DNMG432FW KT315	B80
DNMG432MN KCP05B	B81
DNMG432MN KCP10	B81
DNMG432MN KCP10B	B81
DNMG432MN KCP25	B81
DNMG432MN KCP25B	B81
DNMG432MN KCP30	B81
DNMG432MN KCP30B	B81
DNMG432MN KCP40	B81
DNMG432MN KCPK05	B81
DNMG432MP KC5010	B81
DNMG432MP KCM15B	B81
DNMG432MP KCM25	B81
DNMG432MP KCM25B	B81
DNMG432MP KCM35	B81
DNMG432MP KCP10	B81
DNMG432MP KCP25	B81
DNMG432MP KCU10	B81
DNMG432MR KCM15	B82
DNMG432MR KCM25B	B82
DNMG432MR KCP10B	B82
DNMG432MR KCP25B	B82

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
DNMG432MR KCP30B	B82
DNMG432MR KCPK05	B82
DNMG432MR KCU10	B82
DNMG432MS K313	B82
DNMG432MS KC5010	B82
DNMG432MS KC5025	B82
DNMG432MS KCU10	B82
DNMG432MS KCU25	B82
DNMG432MW KCP05	B82
DNMG432MW KCP10B	B82
DNMG432MW KCP25	B82
DNMG432P KC5010	B83
DNMG432P KCU10	B83
DNMG432RN KCP10	B83
DNMG432RN KCP10B	B83
DNMG432RN KCP25	B83
DNMG432RN KCP25B	B83
DNMG432RN KCP30B	B83
DNMG432RN KCP40	B83
DNMG432RP KC5010	B84
DNMG432RP KC5025	B84
DNMG432RP KCK05	B84
DNMG432RP KCK20	B84
DNMG432RP KCK20B	B84
DNMG432RP KCM15	B84
DNMG432RP KCM25	B84
DNMG432RP KCM25B	B84
DNMG432RP KCM35	B84
DNMG432RP KCP10	B84
DNMG432RP KCP10B	B84
DNMG432RP KCP25	B84
DNMG432RP KCP25B	B84
DNMG432RP KCU10	B84
DNMG432RP KCU25	B84
DNMG432UN KCK05	B84
DNMG432UN KCK15	B84
DNMG432UN KCK15B	B84
DNMG432UN KCK20	B84
DNMG432UN KCK20B	B84
DNMG432UP KC5010	B84
DNMG432UP KCM15	B84
DNMG432UP KCM25	B84
DNMG432UP KCM25B	B84
DNMG432UP KCM35	B84
DNMG432UP KCU10	B84
DNMG433CT KCP10B	B79
DNMG433CT KCU10	B79
DNMG433FN KCK05	B79
DNMG433FN KCP05	B79
DNMG433FN KCP10B	B79
DNMG433FN KT315	B79
DNMG433FP KCU10	B80
DNMG433MN KCP05	B81
DNMG433MN KCP10B	B81
DNMG433MN KCP25	B81
DNMG433MN KCP25B	B81
DNMG433MN KCP30B	B81
DNMG433MN KCP40B	B81
DNMG433MP KC5010	B81
DNMG433MP KCM25	B81
DNMG433MP KCU10	B81
DNMG433MR KCP10B	B82
DNMG433MR KCPK05	B82
DNMG433MS KC5010	B82
DNMG433MS KCU10	B82
DNMG433MS KCU25	B82
DNMG433MW KCP05	B82
DNMG433RN KCP10B	B83
DNMG433RN KCP25	B83
DNMG433RN KCP25B	B83
DNMG433RN KCPK05	B83
DNMG433RP KCM35	B84
DNMG433RP KCP10B	B84
DNMG433RP KCP25	B84
DNMG433RP KCP25B	B84
DNMG433RP KCP30	B84
DNMG433RP KCU10	B84
DNMG433RP KCU25	B84
DNMG433UN KCK20B	B84
DNMG434RN KCP25	B83
DNMG434RN KCP40B	B83
DNMG434RP KC5010	B84
DNMG434RP KCU10	B84
DNMG434UN KCK20	B84
DNMG434UN KCK20B	B84
DNMG44133 KT315	B78
DNMG441CT KCP10	B79
DNMG441FF KC5010	B79
DNMG441FF KCP10B	B79
DNMG441FF KT315	B79
DNMG441FN KCK05	B79
DNMG441FN KCK15B	B79
DNMG441FN KCP05	B79
DNMG441FN KCP10	B79
DNMG441FN KCP10B	B79
DNMG441FN KCP25	B79
DNMG441FN KCP25B	B79
DNMG441FN KT315	B79
DNMG441FP KC5010	B80
DNMG441FP KCM15	B80
DNMG441FP KCU10	B80
DNMG441FW KCP05	B80
DNMG441FW KCP10B	B80
DNMG441FW KCU10	B80
DNMG441MN KCP10	B81
DNMG441MN KCP10B	B81
DNMG441MN KCP25	B81
DNMG441MN KCP25B	B81
DNMG441MN KCP30	B81
DNMG441MP KC5010	B81
DNMG441MP KCM15B	B81
DNMG441MP KCM25	B81
DNMG441MP KCM25B	B81
DNMG441MP KCM35	B81
DNMG441MP KCU10	B81
DNMG441MS K313	B82
DNMG441MS KC5010	B82
DNMG441MS KC5025	B82
DNMG441MS KCU10	B82
DNMG441MS KCU25	B82
DNMG441UP KCM25	B84
DNMG44233 KT315	B78
DNMG442CT KCP10	B79
DNMG442CT KCP10B	B79
DNMG442CT KCP25	B79
DNMG442FF KC5010	B79
DNMG442FF KCP10	B79
DNMG442FF KCP10B	B79
DNMG442FF KT315	B79
DNMG442FN KCK05	B79
DNMG442FN KCK15B	B79
DNMG442FN KCP05	B79
DNMG442FN KCP10	B79
DNMG442FN KCP10B	B79
DNMG442FN KCP25	B79
DNMG442FN KCP25B	B79
DNMG442FN KT315	B79
DNMG442FP KC5010	B80
DNMG442FP KCM15	B80
DNMG442FP KCP10	B80
DNMG442FP KCP10B	B80
DNMG442FP KCP25	B80
DNMG442FP KCP25B	B80
DNMG442FP KCU10	B80
DNMG442FW KCK15B	B80
DNMG442FW KCP05	B80
DNMG442FW KCP10	B80
DNMG442FW KCP10B	B80
DNMG442FW KCU10	B80
DNMG442MN KCP05B	B81
DNMG442MN KCP10	B81
DNMG442MN KCP10B	B81
DNMG442MN KCP25	B81
DNMG442MN KCP25B	B81
DNMG442MN KCP40	B81
DNMG442MP KC5010	B81
DNMG442MP KCM15	B81
DNMG442MP KCM15B	B81
DNMG442MP KCM25	B81
DNMG442MP KCM25B	B81
DNMG442MP KCM35	B81
DNMG442MP KCP10	B81
DNMG442MP KCP25	B81
DNMG442MP KCU10	B81
DNMG442MP KCU25	B81
DNMG442MR KCK15B	B82
DNMG442MR KCM15B	B82
DNMG442MR KCM25	B82
DNMG442MR KCM25B	B82
DNMG442MR KCP10B	B82
DNMG442MR KCP25B	B82
DNMG442MR KCU10	B82
DNMG442MS K313	B82
DNMG442MS KC5010	B82
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DNMG442MW KCP05	B82
DNMG442MW KCP10	B82
DNMG442MW KCP10B	B82
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DNMG442MW KCPK05	B82
DNMG442P KC5010	B83
DNMG442RN KCP05	B83
DNMG442RN KCP10	B83
DNMG442RN KCP10B	B83
DNMG442RN KCP25	B83
DNMG442RN KCP25B	B83
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DNMG442RP KCK15B	B84
DNMG442RP KCK20	B84
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DNMG442RP KCM25B	B84
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DNMG442RP KCP30	B84
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DNMG442UN KCK15	B84
DNMG442UN KCK15B	B84
DNMG442UN KCK20	B84
DNMG442UN KCK20B	B84
DNMG442UP KC5010	B84
DNMG442UP KCM15	B84
DNMG442UP KCM25B	B84
DNMG442UP KCU10	B84
DNMG443CT KC5010	B79
DNMG443CT KCP05	B79
DNMG443CT KCP05B	B79
DNMG443CT KCP10	B79
DNMG443CT KCP10B	B79
DNMG443CT KCP25	B79
DNMG443CT KCP25B	B79
DNMG443FN KCK05	B79
DNMG443FN KCP05	B79
DNMG443FN KCP10	B79
DNMG443FN KCP10B	B79
DNMG443FN KCP25	B79
DNMG443FN KT315	B79
DNMG443FP KCM15B	B80
DNMG443FP KT315	B80
DNMG443MG KCP10B	B83
DNMG443MN KCP10	B81
DNMG443MN KCP10B	B81
DNMG443MN KCP25	B81
DNMG443MN KCP25B	B81
DNMG443MN KCP40B	B81
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DNMG443MP KCM25B	B81
DNMG443MP KCP10	B81
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DNMG443MP KCU25	B81
DNMG443MR KCP10B	B82
DNMG443MR KCP25B	B82
DNMG443MS KC5025	B82
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DNMG443MS KCU25	B82
DNMG443MW KCP05	B82
DNMG443MW KCP10B	B82
DNMG443MW KCP25	B82
DNMG443RN KCP05	B83
DNMG443RN KCP10	B83
DNMG443RN KCP10B	B83
DNMG443RN KCP25	B83
DNMG443RN KCP25B	B83
DNMG443RN KCP30	B83
DNMG443RN KCP40B	B83
DNMG443RN KCPK05	B83
DNMG443RP KCK05	B84
DNMG443RP KCK15	B84
DNMG443RP KCK20	B84
DNMG443RP KCK20B	B84
DNMG443RP KCM25	B84
DNMG443RP KCM35B	B84
DNMG443RP KCP10	B84
DNMG443RP KCP10B	B84
DNMG443RP KCP25	B84
DNMG443RP KCP25B	B84
DNMG443RP KCU10	B84
DNMG443RP KCU25	B84
DNMG443UN KCK15	B84
DNMG443UN KCK15B	B84
DNMG443UN KCK20	B84
DNMG443UN KCK20B	B84
DNMG444MG KCP10B	B83
DNMG444MN KCP10	B81
DNMG444MR KCP25B	B82
DNMG444RN KCP10	B83
DNMG444RN KCP25	B83
DNMG444RN KCP25B	B83
DNMG444RN KCP40B	B83
DNMG444RP KCP10	B84
DNMG444RP KCP10B	B84
DNMG444RP KCP25	B84
DNMG444RP KCP25B	B84
DNMG444RP KCU25	B84
DNMG444UN KCK15B	B84
DNMG444UN KCK20	B84
DNMG542RN KCP10B	B83
DNMG542RN KCP25	B83
DNMG542RN KCP30	B83
DNMG543MN KCP30	B81
DNMG543RN KCP10B	B83
DNMG543RN KCP25	B83
DNMG543RN KCP30	B83
DNMM432RM KCP25	B85
DNMM433RM KCP25B	B85
DNMM442RM KCP10	B85
DNMM442RM KCP25B	B85
DNMM442RM KCP30	B85
DNMM442RP KCP10	B85
DNMM442RP KCP25	B85
DNMM443RM KCP10	B85
DNMM443RM KCP25	B85
DNMM443RM KCP25B	B85
DNMM443RM KCP40	B85
DNMM443RP KCP10B	B85
DNMM443RP KCP25	B85
DNMM443RP KCP25B	B85
DNMM444RM KCP25	B85
DNMM444RP KCP10B	B85
DNMM444RP KCP25	B85
DNMP332K KCP25B	B86
DNMP431 K68	B85
DNMP431K KCP25	B86
DNMP431K KCP25B	B86
DNMP432 K68	B85
DNMP432K KCP10B	B86
DNMP432K KCP25	B86
DNMP432K KCP25B	B86
DNMP433 K68	B85
DNMP433K KCP10B	B86
DNMP433K KCP25	B86
DNMP441K KCP25B	B86
DNMP442K KCP10B	B86
DNMP442K KCP25B	B86
DNMS431FST KD1400	B365
DNMS432 K68	B86
DNMS432 KC5410	B86
DNMS432FST KD1400	B365

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
DNMS432FST KD1425	B365
DP5009A S	T96–99
DP5013T S	V25–26
DPA07T3D25 KCU40	H114
DPA09T4D32 KCU40	H114
DPA13T5D50 KCU40	H114
DPGR431 KC5010	E32
DPGR431 KCU10	E32
DPGR431 KCU25	E32
DPGR431FP KCP25	E32
DPGR431FP KCU10	E32
DPGR432 K68	E32
DPGR432 KC5010	E32
DPGR432 KCU10	E32
DPGR432 KCU25	E32
DPGR432 KD1425	E32
DPGR432FP KCM25	E32
DPGR432FP KCP10	E32
DPGR433 KC5010	E32
DPGR433 KCU25	E32
DPGT21505HP KC5010	B231
DPGT21505LF KC5010	B231
DPGT21505LF KCU10	B231
DPGT2150LF KC5010	B231
DPGT2151HP KC5010	B231
DPGT2151HP KC5410	B231
DPGT2151HP KCU10	B231
DPGT2151HP KCU25	B231
DPGT2151LF KC5010	B231
DPGT2151LF KC5025	B231
DPGT2151LF KCU10	B231
DPGT2152HP KCU25	B231
DPGT32505LF KC5010	B231
DPGT32505LF KC5025	B231
DPGT32505LF KCU10	B231
DPGT3250LF KC5010	B231
DPGT3251HP K313	B231
DPGT3251HP KC5010	B231
DPGT3251HP KC5410	B231
DPGT3251HP KCU10	B231
DPGT3251HP KCU25	B231
DPGT3251LF KC5010	B231
DPGT3251LF KC5025	B231
DPGT3251LF KCU10	B231
DPGT3252HP KC5010	B231
DPGT3252HP KCU10	B231
DPGT3252HP KCU25	B231
DPGT3252LF KC5010	B231
DPGT3252LF KCU10	B231
DPGW21505FST KD1400	B366
DPGW21505FST KD1425	B366
DPGW2151FST KD1400	B366
DPGW2151FST KD1425	B366
DPGW3251E KD1405	B365
DPGW3251FST KD1400	B366
DPGW3251FST KD1425	B366
DPGW3251FWST KD1425	B366
DPMT21505FP KCU10	B231
DPMT21505LF KC5010	B232
DPMT21505LF KC5025	B232
DPMT2151FP KCM15	B231
DPMT2151FP KCP10	B231
DPMT2151FP KCP25	B231
DPMT2151FP KCU10	B231
DPMT2151FP KCU25	B231
DPMT2151FP KTP10	B231
DPMT2151FW KCP25	B232
DPMT2151LF KC5010	B232
DPMT2151LF KC5025	B232
DPMT2151LF KCK05	B232
DPMT2151LF KCK20	B232
DPMT2151LF KCM25	B232
DPMT2151LF KCP10	B232
DPMT2151LF KCP10B	B232
DPMT2151LF KCP25	B232
DPMT2151LF KCP25B	B232
DPMT2151LF KT315	B232
DPMT2151UF KC5010	B233
DPMT2151UF KCP25	B233
DPMT2152FP KCU10	B231
DPMT2152FP KCU25	B231
DPMT2152FW KCK20B	B232
DPMT2152FW KCU10	B232
DPMT32505LF KC5010	B232
DPMT3251FP KCP10	B231
DPMT3251FP KCP25	B231
DPMT3251FP KCU10	B231
DPMT3251FP KCU25	B231
DPMT3251LF KC5010	B232
DPMT3251LF KC5025	B232
DPMT3251LF KCK05	B232
DPMT3251LF KCK20	B232
DPMT3251LF KCM25B	B232
DPMT3251LF KCP10	B232
DPMT3251LF KCP10B	B232
DPMT3251LF KCP25	B232
DPMT3251LF KCP25B	B232
DPMT3251LF KT315	B232
DPMT3251UF KCP10	B233
DPMT3252FP KCU10	B231
DPMT3252FP KTP10	B231
DPMT3252LF KC5010	B232
DPMT3252LF KC5025	B232
DPMT3252LF KCK20	B232
DPMT3252LF KCM25	B232
DPMT3252LF KCP10	B232
DPMT3252LF KCP10B	B232
DPMT3252LF KCP25	B232
DPMT3252LF KCP25B	B232
DPMT3252MF KCM25	B232
DPMT3252MF KCP25	B232
DPMT3252MP KCP25	B233
DPMT3252MP KCU10	B233
DPMT3252UF KCP10	B233
DRGNL164DKC3	B98
DRGNL204DKC3	B98
DRGNR164DKC3	B98
DRGNR206DKC4	B98
DSDNN124KC3	B109
DSDNN164KC3	B109
DSDNN204KC3	B109
DSDNN206KC4	B109
DSKNL164CKC3	B109
DSKNR164CKC3	B109
DSRNL164DKC3	B110
DSRNL204DKC3	B110
DSRNL206DKC4	B110
DSSNL164DKC3	B110
DSSNR164DKC3	B110
DT10	U3, W40–43
DT15	S56, S58, T89–92, U3, V155–156
DT15IP	S39, T14–17, T75–80, T113, U32–34, V68–70, V75–77, V82–83, V139–141
DT3IP	W34–35
DT7	U13, W40
DT7IP	T30–33, T41–43
DT8	U3, W29–31, W40, W42–43
DT8IP	W4–5, W10–13, W17–19, W24–25
DT9	V156
DT9IP	T4–7, T49–54, T63–64, T107–109, U25–27, V36–38
DTGNL163DKC3	B131
DTGNR123BKC3	B131
DTGNR164DKC3	B131
DTJNR164DKC3	B131
DTQ3054	S94, S98, S100
DTQ50140	S30
DV40BKR32041M	K91
DV40BKR50060M	K91
DV40BSIF80061M	K49
DV40BT13069	K142
DV40FBHM1691	K133
DV40FBHMKIT164M	K127, K131
DV50BKR32040M	K91
DV50BKR32041M	K91
DV50BKR50040M	K91
DV50BKR63060M	K91
DV50BKR80070M	K91
DV50BSIF100060M	K49
DV50BSIF70060M	K49
DV50BT13069	K142
DVJNL123CKC3	B150
DVJNL163DKC3	B150
DVJNL164DKC3	B150
DVJNL853DKC3	B150
DVJNL854DKC3	B150
DVJNR123CKC3	B150
DVJNR163DKC3	B150
DVJNR164DKC3	B150
DVJNR853DKC3	B150
DVJNR854DKC3	B150
DVONL123CKC3	B151
DVONL163DKC3	B151
DVONL853DKC3	B151
DVONR123CKC3	B151
DVONR163DKC3	B151
DVONR853DKC3	B151
DVVNN123CKC3	B151
DVVNN163DKC3	B151
DVVNN164DKC3	B151
DVVNN853DKC3	B151
DWLNL123BKC3	B163
DWLNL163CKC3	B163
DWLNL164CKC3	B163
DWLNL164DKC3	B163
DWLNL204DKC3	B163
DWLNR123BKC3	B163
DWLNR163CKC3	B163
DWLNR163DKC3	B163
DWLNR164CKC3	B163
DWLNR164DKC3	B163
DWLNR204DKC3	B163
E03HSCFDR12	B200
E03HSCLDL12A	B202
E03HSCLDR12	B202
E03HSCLDR12A	B202
E03HSTLDR128	B265
E03HSWLPR15 KWH	B290
E03MSCFDR12	B200
E03MSCLDL12A	B202
E03MSCLDR12	B202
E03MSCLDR12A	B202
E03MSTLDR128	B265
E03MSWUPR15	B292
E0408HSCLDR1225	B203
E0410HSCLDR12125	B203
E04HSCFDL12	B200
E04HSCFDR12	B200
E04HSCLDL12	B202
E04HSCLDR12	B202
E04HSTFDR128	B264
E04HSTLDR128	B265
E04HSWLPL15 KWH	B290
E04HSWLPR15 KWH	B290
E04MSCFDR12	B200
E04MSCLDL12	B202
E04MSCLDR12	B202
E04MSTLDL128	B265
E04MSTLDR128	B265
E04MSWUPR15	B292
E05HSTFDR128	B264
E05HSTLDR128	B265
E05KSCLPL18 KWH	B214
E05KSCLPR18 KWH	B214
E05MSCFDR12	B200
E05MSCLDL12	B202
E05MSCLDR12	B202
E05MSTFDR128	B264
E05MSTLDR128	B265
E05MSWUPR15	B292
E05STFPL18 KWH	B272
E05STFPR18	B272
E05SWLPL15 KWH	B290
E05SWLPR15 KWH	B290
E06LSEL2 KWH	D75
E06LSER2 KWH	D75
E06MSCLCL2	B197
E06MSCLCR2	B197
E06MSTLDL07	B265
E06MSTLDR07	B265
E06MSWUPR2	B292
E06SCLPL2 KWH	B214
E06SCLPR2 KWH	B214
E06SDUPL2 KWH	B234
E06SDUPR2 KWH	B234
E06SSTLDR2	B265
E06STFPL2 KWH	B272
E06STFPR2 KWH	B272
E06STLPL2 KWH	B275
E06STLPR2 KWH	B275
E06SWLPL2 KWH	B290
E06SWLPR2 KWH	B290
E08KCTFPR2 KWH	B184, B392
E08LSEL2 KWH	D75
E08LSER2 KWH	D75
E08MSTLDL07	B265
E08MSTLDR07	B265
E08NEL2 KWH	C193, D36
E08NELR05 KWH	E44
E08NER2 KWH	C193, D36
E08NKLCL05 KWH	E45
E08NKLCR05 KWH	E45
E08RCTFPR2 KWH	B184, B392
E08RSCLCR2	B197
E08RSWUPR2	B292
E08SCLPL2 KWH	B214
E08SCLPR2 KWH	B214
E08SDUPL2 KWH	B234
E08SDUPR2 KWH	B234
E08STFPL2 KWH	B272
E08STFPR2 KWH	B272
E08STLPL2 KWH	B275
E08STLPR2 KWH	B275
E08SWLPL2 KWH	B290
E08SWLPR2 KWH	B290
E10LSEL3 KWH	D75
E10LSER3 KWH	D75
E10MCTFPR2 KWH	B184, B392
E10NEL2 KWH	C193, D36
E10NER2 KWH	C193, D36
E10NKLCL05 KWH	E45
E10NKLCR05 KWH	E45
E10SCLPL2 KWH	B214
E10SCLPL3 KWH	B214
E10SCLPR2 KWH	B214
E10SCLPR3 KWH	B214
E10SCTFPR2 KWH	B184, B392
E10SDUPL2 KWH	B234
E10SDUPR2 KWH	B234
E10SSCLCL3	B197
E10SSCLCR2	B197
E10SSCLCR3	B197
E10STFPL2 KWH	B272
E10STFPR2 KWH	B272
E10STLPL2 KWH	B275
E10STLPR2 KWH	B275
E10SWLPL3 KWH	B290
E10SWLPR3 KWH	B290
E12CTLNR2 KWH	B392
E12LSEL3 KWH	D75
E12LSER3 KWH	D75
E12NEL2 KWH	C193, D36
E12NER2 KWH	C193, D36
E12NKLCL05 KWH	E45
E12NKLCR05 KWH	E45
E12QCTFPL3 KWH	B184, B392
E12QCTFPR3 KWH	B184, B392
E12SCLPL2 KWH	B214
E12SCLPL3 KWH	B214
E12SCLPL3AP5 KWH	B216
E12SCLPR2 KWH	B214
E12SCLPR3 KWH	B214
E12SCLPR3AP5 KWH	B216
E12SCTFPL3 KWH	B184, B392
E12SCTFPR3 KWH	B184, B392
E12SDUPR2 KWH	B234
E12SSCLCL3	B197
E12SSCLCR3	B197
E12SSDUPL3 KWH	B234
E12SSDUPR3 KWH	B234
E12STFPL3 KWH	B272
E12STFPR3 KWH	B272
E12STLPL3 KWH	B275
E12STLPR3 KWH	B275
E12SWLPR3 KWH	B290
E16LSER3 KWH	D75
E16LSER4 KWH	D75
E16NEL3 KWH	C193, D36

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
E16NER3 KWH	C193, D36
E16NKLNR1 KWH	E45
E16RNNTOL2 KWH	C193
E16RNNTOR2 KWH	C193
E16SCLPL3 KWH	B214
E16SCLPL3AP5 KWH	B216
E16SCLPR3 KWH	B214
E16SCLPR3AP5 KWH	B216
E16STFPR3 KWH	B272
E16STLPL3 KWH	B275
E16STLPR3 KWH	B275
E16SWLPR3 KWH	B290
E16TCTFPR3 KWH	B184, B392
E16TSCLCR3	B197
E16TSDUPL3 KWH	B234
E16TSDUPR3 KWH	B234
E20SNNTOR2 KWH	C193
E25MSC7DR12	B204
E2908XSCLDR12088	B203
E2910XSCLDR12088	B203
E2FIX100505LHP KCU10	E11
E2FIX100505RHP KCU10	E11
E3208XSCLDR121	B203
E3210KSCLDR122	B203
EADE0178J4AQX KYS40	P156
EADE0188J4AQX KYS40	P156
EADE0188J6ARX KYS40	P157
EADE0238J4AQB KYS40	P156
EADE0250J4AQB KYS40	P156
EADE0250J6ARB KYS40	P157
EADE0297J4AQX KYS40	P156
EADE0313J4AQX KYS40	P156
EADE0313J6ARX KYS40	P157
EADE0356J4AQX KYS40	P156
EADE0375J4AQX KYS40	P156
EADE0375J6ARX KYS40	P157
EADE0475J4AQC KYS40	P156
EADE0500J4AQC KYS40	P156
EADE0500J6ARC KYS40	P157
EB10801281100	K144
EB13030150	K143
EB16301281650	K144
EB18030200	K143
EB23035250	K143
EB28035300	K143
EB33040350	K143
EB38040400	K143
EB43040450	K143
EB48040500	K143
EB53050550	K143
EB58050600	K143
EB630128650	K144
EBM1580160162	K136
EBM8015086	K136
EBSLD1105	K144
EBSLD2205	K144
EBUCW0074	K145
EBUFF0975	K145
EBURF1975PKG	K145
EC014M1BL06CF01 KCM35B	C22
EC014M1BL06CF01 KCU25	C22
EC014M1BL06CL01 KCM35B	C23
EC014M1BL06CL01 KCU25	C23
EC014M1BL06CM01 KCU25	C24
EC014M1BN00CF01 KCM35B	C22
EC014M1BN00CF01 KCU25	C22
EC014M1BN00CL01 KCM35B	C23
EC014M1BN00CL01 KCU25	C23
EC014M1BN00CM01 KCU25	C24
EC014M1BR06CF01 KCM35B	C22
EC014M1BR06CF01 KCU25	C22
EC014M1BR06CL01 KCM35B	C23
EC014M1BR06CL01 KCU25	C23
EC014M1BR06CM01 KCU25	C24
EC020M02L06CF02 KCM35B	C22
EC020M02L06CF02 KCU25	C22
EC020M02L06CL02 KCM35B	C23
EC020M02L06CL02 KCU25	C23
EC020M02L06CM02 KCU25	C24
EC020M02L06CR02 KCU25	C25
EC020M02N00CF02 KCM35B	C22
EC020M02N00CF02 KCU25	C22
EC020M02N00CL02 KCM35B	C23
EC020M02N00CL02 KCU25	C23
EC020M02N00CM02 KCU25	C24
EC020M02N00CR02 KCU25	C25
EC020M02R06CF02 KCM35B	C22
EC020M02R06CF02 KCU25	C22
EC020M02R06CL02 KCM35B	C23
EC020M02R06CL02 KCU25	C23
EC020M02R06CM02 KCU25	C24
EC020M02R06CR02 KCU25	C25
EC030M03L06CF02 KCM35B	C22
EC030M03L06CF02 KCU25	C22
EC030M03L06CL02 KCM35B	C23
EC030M03L06CL02 KCU25	C23
EC030M03L06CM02 KCU25	C24
EC030M03L06CR02 KCU25	C25
EC030M03N00CF02 KCM35B	C22
EC030M03N00CF02 KCU25	C22
EC030M03N00CL02 KCM35B	C23
EC030M03N00CL02 KCU25	C23
EC030M03N00CM02 KCU25	C24
EC030M03N00CR02 KCU25	C25
EC030M03R06CF02 KCM35B	C22
EC030M03R06CF02 KCU25	C22
EC030M03R06CL02 KCM35B	C23
EC030M03R06CL02 KCU25	C23
EC030M03R06CM02 KCU25	C24
EC030M03R06CR02 KCU25	C25
EC040M04L06CF02 KCM35B	C22
EC040M04L06CF02 KCU25	C22
EC040M04L06CL02 KCU25	C23
EC040M04L06CM02 KCU25	C24
EC040M04L06CR02 KCU25	C25
EC040M04N00CF02 KCM35B	C22
EC040M04N00CF02 KCU25	C22
EC040M04N00CL02 KCM35B	C23
EC040M04N00CL02 KCU25	C23
EC040M04N00CM02 KCU25	C24
EC040M04N00CR02 KCU25	C25
EC040M04R06CF02 KCM35B	C22
EC040M04R06CF02 KCU25	C22
EC040M04R06CL02 KCU25	C23
EC040M04R06CM02 KCU25	C24
EC040M04R06CR02 KCU25	C25
EC050M05N00CF03 KCM35B	C22
EC050M05N00CF03 KCU25	C22
EC050M05N00CM03 KCU25	C24
EC050M05N00CR03 KCU25	C25
EC060M06L06CR04 KCU25	C25
EC060M06N00CM03 KCU25	C24
EC060M06N00CR03 KCU25	C25
EC060M06R06CR04 KCU25	C25
EC070M06N00CM04 KCU25	C24
EC070M06N00CR04 KCU25	C25
EC080M08L06CR04 KCU25	C25
EC080M08N00CM04 KCU25	C24
EC080M08N00CR04 KCU25	C25
EC080M08R06CR04 KCU25	C25
EC1002ELD KC725M	T36, T45
EC1002ELD KCPK30	T36, T45
EC1002FLDJ KC410M	T35, T44
EC1004ELD KC520M	T36, T45
EC1004ELD KC522M	T36, T45
EC1004ELD KC725M	T36, T45
EC1004ELD KCPK30	T36, T45
EC1004ELDJ KC422M	T35, T45
EC1004FLDJ KC410M	T35, T44
EC1004FR-PCD KD1410	T34
EC1008ELD KC510M	T36, T45
EC1008ELD KC520M	T36, T45
EC1008ELD KC522M	T36, T45
EC1008ELD KC725M	T36, T45
EC1008ELD KCK15	T36, T45
EC1008ELD KCPK30	T36, T45
EC1008ELD KCPM40	T36
EC1008ELD KCSM40	T36
EC1008ELDJ KC422M	T35, T45
EC1008FLDJ KC410M	T35, T44
EC1008FR-PCD KD1410	T34
EC1012ELD KC522M	T36, T45
EC1012ELD KC725M	T36, T45
EC1012ELD KCSM40	T36
EC1012FLDJ KC410M	T35, T44
EC1016ELD KC522M	T36, T45
EC1016ELD KC725M	T36, T45
EC1016ELD KCPK30	T36, T45
EC1016ELD KCSM40	T36
EC1016ELDJ KC422M	T35, T45
EC1016FLDJ KC410M	T35, T44
EC1020ELD KC725M	T36, T45
EC1020ELD KCPK30	T36, T45
EC1020ELDJ KC422M	T35, T45
EC1020FLDJ KC410M	T35, T44
EC1024ELD KC522M	T36, T45
EC1024ELD KC725M	T36, T45
EC1024ELD KCSM40	T36
EC1024ELDJ KC422M	T35, T45
EC1031ELD KC725M	T36
EC1031ELD KCPK30	T36, T45
EC1031ELD KCSM40	T36
EC1031FLDJ KC410M	T35, T44
EC1402FLDJ KC410M	T55, T66
EC1404EGD KC725M	T57, T68
EC1404EGD KCPM40	T57, T68
EC1404ELD KC522M	T56, T67
EC1404ELDJ KC422M	T56, T67
EC1404FLDJ KC410M	T55, T66
EC1408EGD KC725M	T57, T68
EC1408EGD KCPM40	T57, T68
EC1408EGD KCSM40	T57, T68
EC1408ELD KC522M	T56, T67
EC1408ELDJ KC422M	T56, T67
EC1408FLDJ KC410M	T55, T66
EC1412EGD KC725M	T57, T68
EC1412EGD KCSM40	T57, T68
EC1412ELD KC522M	T56, T67
EC1412FLDJ KC410M	T55, T66
EC1416EGD KC725M	T57, T68
EC1416EGD KCSM40	T57, T68
EC1416ELD KC522M	T56, T67
EC1416FLDJ KC410M	T55, T66
EC1424ELDJ KC422M	T56, T67
EC1431EGD KC725M	T57, T68
EC1431EGD KCSM40	T57, T68
EC1431ELD KC522M	T56, T67
EC1431FLDJ KC410M	T55, T66
EC1440FLDJ KC410M	T55, T66
EC1804E KC725M	T83
EC1804E KCPM40	T83
EC1804FJ KC410M	T81
EC1808E KC725M	T83
EC1808E KCPM40	T83
EC1808E2 KC522M	T82
EC1808EJ KC422M	T82
EC1808FJ KC410M	T81
EC1812E KC725M	T83
EC1812E KCPM40	T83
EC1812EJ KC422M	T82
EC1812FJ KC410M	T81
EC1816E KC522M	T82
EC1816EJ KC422M	T82
EC1816FJ KC410M	T81
EC1820FJ KC410M	T81
EC1824EJ KC422M	T82
EC1824FJ KC410M	T81
EC1832E KC522M	T82
EC1832EJ KC422M	T82
EC1832FJ KC410M	T81
EC1840E KC522M	T82
EC1840FJ KC410M	T81
EC1848E KC522M	T82
EC1848FJ KC410M	T81
EC1850FJ KC410M	T81
EC1864E KC522M	T82
EC1864EJ KC422M	T82
EC1864FJ KC410M	T81
EG0200M02P02GUP K313	C17
EG0200M02P02GUP KCU10	C17
EG0200M02P02GUP KCU25	C17
EG0212M02U02GUN KCK20B	C20
EG0212M02U02GUN KCP10B	C20
EG0212M02U02GUN KCP25B	C20
EG0212M02U02GUN KCU10	C20
EG0212M02U02GUN KCU25	C20
EG0212M02U02GUP KCP10B	C17
EG0212M02U02GUP KCP25B	C17
EG0212M02U02GUP KCU10	C17
EG0212M02U02GUP KCU25	C17
EG0251M02U02GUN KCK20B	C20
EG0251M02U02GUN KCP10B	C20
EG0251M02U02GUN KCP25B	C20
EG0251M02U02GUN KCU10	C20
EG0251M02U02GUN KCU25	C20
EG0251M02U02GUP KCP10B	C17
EG0251M02U02GUP KCP25B	C17
EG0251M02U02GUP KCU10	C17
EG0251M02U02GUP KCU25	C17
EG0300M03P02GUP K313	C17
EG0300M03P02GUP KCU10	C17
EG0300M03P02GUP KCU25	C17
EG0300M03P04GUP K313	C17
EG0300M03P04GUP KCU10	C17
EG0300M03P04GUP KCU25	C17
EG0312M03U02GUN KCK20B	C20
EG0312M03U02GUN KCP10B	C20
EG0312M03U02GUN KCP25B	C20
EG0312M03U02GUN KCU10	C20
EG0312M03U02GUN KCU25	C20
EG0312M03U02GUP KCP10B	C17
EG0312M03U02GUP KCU10	C17
EG0312M03U02GUP KCU25	C17
EG0312M03U04GUN KCK20B	C20
EG0312M03U04GUN KCP10B	C20
EG0312M03U04GUN KCP25B	C20
EG0312M03U04GUN KCU10	C20
EG0312M03U04GUN KCU25	C20
EG0312M03U04GUP KCP10B	C17
EG0312M03U04GUP KCP25B	C17
EG0312M03U04GUP KCU10	C17
EG0312M03U04GUP KCU25	C17
EG0400M04P04GUP K313	C17
EG0400M04P04GUP KCU10	C17
EG0400M04P04GUP KCU25	C17
EG0400M04P08GUP K313	C17
EG0400M04P08GUP KCU10	C17
EG0400M04P08GUP KCU25	C17
EG0412M04U04GUN KCK20B	C20
EG0412M04U04GUN KCP10B	C20
EG0412M04U04GUN KCP25B	C20
EG0412M04U04GUN KCU10	C20
EG0412M04U04GUN KCU25	C20
EG0412M04U04GUP KCP10B	C17
EG0412M04U04GUP KCP25B	C17
EG0412M04U04GUP KCU10	C17
EG0412M04U04GUP KCU25	C17
EG0412M04U08GUN KCK20B	C20
EG0412M04U08GUN KCP10B	C20
EG0412M04U08GUN KCP25B	C20
EG0412M04U08GUN KCU10	C20
EG0412M04U08GUN KCU25	C20
EG0412M04U08GUP KCP10B	C17
EG0412M04U08GUP KCP25B	C17
EG0412M04U08GUP KCU10	C17
EG0412M04U08GUP KCU25	C17
EG0500M05P04GUP K313	C17
EG0500M05P04GUP KCU10	C17
EG0500M05P04GUP KCU25	C17
EG0500M05P08GUP K313	C17
EG0500M05P08GUP KCU10	C17
EG0500M05P08GUP KCU25	C17
EG0512M05U04GUN KCK20B	C20
EG0512M05U04GUN KCP10B	C20
EG0512M05U04GUN KCP25B	C20
EG0512M05U04GUN KCU10	C20
EG0512M05U04GUN KCU25	C20
EG0512M05U04GUP KCP10B	C17
EG0512M05U04GUP KCP25B	C17
EG0512M05U04GUP KCU10	C17
EG0512M05U04GUP KCU25	C17
EG0512M05U08GUN KCK20B	C20
EG0512M05U08GUN KCP10B	C20
EG0512M05U08GUN KCP25B	C20
EG0512M05U08GUN KCU10	C20
EG0512M05U08GUN KCU25	C20
EG0512M05U08GUP KCP10B	C17
EG0512M05U08GUP KCP25B	C17

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
EG0512M05U08GUP KCU10	C17
EG0512M05U08GUP KCU25	C17
EG0600M06P04GUP K313	C17
EG0600M06P04GUP KCU10	C17
EG0600M06P04GUP KCU25	C17
EG0600M06P08GUP K313	C17
EG0600M06P08GUP KCU10	C17
EG0600M06P08GUP KCU25	C17
EG0612M06U04GUN KCK20B	C20
EG0612M06U04GUN KCP10B	C20
EG0612M06U04GUN KCU10	C20
EG0612M06U04GUN KCU25	C20
EG0612M06U04GUP KCP10B	C17
EG0612M06U04GUP KCP25B	C17
EG0612M06U04GUP KCU10	C17
EG0612M06U04GUP KCU25	C17
EG0612M06U08GUN KCK20B	C20
EG0612M06U08GUN KCP25B	C20
EG0612M06U08GUN KCU10	C20
EG0612M06U08GUN KCU25	C20
EG0612M06U08GUP KCP10B	C17
EG0612M06U08GUP KCP25B	C17
EG0612M06U08GUP KCU10	C17
EG0612M06U08GUP KCU25	C17
EG0631I1FP05GUP K313	C18
EG0631I1FP05GUP KCU10	C18
EG0631I1FP05GUP KCU25	C18
EG0631I1FU05GUN KCK20B	C21
EG0631I1FU05GUN KCP10B	C21
EG0631I1FU05GUN KCP25B	C21
EG0631I1FU05GUN KCU10	C21
EG0631I1FU05GUN KCU25	C21
EG0700M06P08GUP K313	C17
EG0700M06P08GUP KCU10	C17
EG0700M06P08GUP KCU25	C17
EG0712M06U08GUP KCP10B	C17
EG0712M06U08GUP KCP25B	C17
EG0712M06U08GUP KCU10	C17
EG0712M06U08GUP KCU25	C17
EG0800M08P08GUP K313	C17
EG0800M08P08GUP KCU10	C17
EG0800M08P08GUP KCU25	C17
EG0800M08P12GUP K313	C17
EG0800M08P12GUP KCU10	C17
EG0800M08P12GUP KCU25	C17
EG0812M08U08GUN KCK20B	C20
EG0812M08U08GUN KCP10B	C20
EG0812M08U08GUN KCP25B	C20
EG0812M08U08GUN KCU10	C20
EG0812M08U08GUN KCU25	C20
EG0812M08U08GUP KCP10B	C17
EG0812M08U08GUP KCP25B	C17
EG0812M08U08GUP KCU10	C17
EG0812M08U08GUP KCU25	C17
EG0812M08U12GUN KCK20B	C20
EG0812M08U12GUN KCP10B	C20
EG0812M08U12GUN KCP25B	C20
EG0812M08U12GUN KCU10	C20
EG0812M08U12GUN KCU25	C20
EG0812M08U12GUP KCP10B	C17
EG0812M08U12GUP KCP25B	C17
EG0812M08U12GUP KCU10	C17
EG0812M08U12GUP KCU25	C17
EG0941I02P05GUP K313	C18
EG0941I02P05GUP KCU10	C18
EG0941I02P05GUP KCU25	C18
EG0941I02U05GUN KCK20B	C21
EG0941I02U05GUN KCP10B	C21
EG0941I02U05GUN KCP25B	C21
EG0941I02U05GUN KCU10	C21
EG0941I02U05GUN KCU25	C21
EG1000M10P12GUP K313	C17
EG1000M10P12GUP KCU10	C17
EG1000M10P12GUP KCU25	C17
EG1012M10U12GUN KCK20B	C20
EG1012M10U12GUN KCP10B	C20
EG1012M10U12GUN KCP25B	C20
EG1012M10U12GUN KCU10	C20
EG1012M10U12GUN KCU25	C20
EG1012M10U12GUP KCP10B	C17
EG1012M10U12GUP KCP25B	C17
EG1012M10U12GUP KCU10	C17
EG1012M10U12GUP KCU25	C17
EG125I03P05GUP K313	C18
EG125I03P05GUP KCU10	C18
EG125I03P05GUP KCU25	C18
EG125I03P1GUP K313	C18
EG125I03P1GUP KCU10	C18
EG125I03P1GUP KCU25	C18
EG125I03U05GUN KCK20B	C21
EG125I03U05GUN KCP10B	C21
EG125I03U05GUN KCP25B	C21
EG125I03U05GUN KCU10	C21
EG125I03U05GUN KCU25	C21
EG125I03U1GUN KCK20B	C21
EG125I03U1GUN KCP10B	C21
EG125I03U1GUN KCP25B	C21
EG125I03U1GUN KCU10	C21
EG125I03U1GUN KCU25	C21
EG130I03U05GUN KCK20B	C21
EG130I03U05GUN KCP10B	C21
EG130I03U05GUN KCP25B	C21
EG130I03U05GUN KCU10	C21
EG130I03U05GUN KCU25	C21
EG130I03U05GUP KCP10B	C18
EG130I03U05GUP KCP25B	C18
EG130I03U05GUP KCU10	C18
EG130I03U05GUP KCU25	C18
EG130I03U1GUN KCK20B	C21
EG130I03U1GUN KCP10B	C21
EG130I03U1GUN KCP25B	C21
EG130I03U1GUN KCU10	C21
EG130I03U1GUN KCU25	C21
EG130I03U1GUP KCP10B	C18
EG130I03U1GUP KCP25B	C18
EG130I03U1GUP KCU10	C18
EG130I03U1GUP KCU25	C18
EG187I04P1GUP K313	C18
EG187I04P1GUP KCU10	C18
EG187I04P1GUP KCU25	C18
EG187I04P2GUP K313	C18
EG187I04P2GUP KCU10	C18
EG187I04P2GUP KCU25	C18
EG187I04U1GUN KCK20B	C21
EG187I04U1GUN KCP10B	C21
EG187I04U1GUN KCP25B	C21
EG187I04U1GUN KCU10	C21
EG187I04U1GUN KCU25	C21
EG187I04U2GUN KCK20B	C21
EG187I04U2GUN KCP10B	C21
EG187I04U2GUN KCP25B	C21
EG187I04U2GUN KCU10	C21
EG187I04U2GUN KCU25	C21
EG192I04U1GUN KCK20B	C21
EG192I04U1GUN KCP10B	C21
EG192I04U1GUN KCP25B	C21
EG192I04U1GUN KCU10	C21
EG192I04U1GUN KCU25	C21
EG192I04U1GUP KCP10B	C18
EG192I04U1GUP KCP25B	C18
EG192I04U1GUP KCU10	C18
EG192I04U1GUP KCU25	C18
EG192I04U2GUN KCK20B	C21
EG192I04U2GUN KCP10B	C21
EG192I04U2GUN KCP25B	C21
EG192I04U2GUN KCU10	C21
EG192I04U2GUN KCU25	C21
EG192I04U2GUP KCP10B	C18
EG192I04U2GUP KCP25B	C18
EG192I04U2GUP KCU10	C18
EG192I04U2GUP KCU25	C18
EG250I06P1GUP K313	C18
EG250I06P1GUP KCU10	C18
EG250I06P1GUP KCU25	C18
EG250I06P2GUP K313	C18
EG250I06P2GUP KCU10	C18
EG250I06P2GUP KCU25	C18
EG250I06U1GUN KCK20B	C21
EG250I06U1GUN KCP10B	C21
EG250I06U1GUN KCP25B	C21
EG250I06U1GUN KCU10	C21
EG250I06U1GUN KCU25	C21
EG250I06U2GUN KCK20B	C21
EG250I06U2GUN KCP10B	C21
EG250I06U2GUN KCP25B	C21
EG250I06U2GUN KCU10	C21
EG250I06U2GUN KCU25	C21
EG255I06U1GUN KCK20B	C21
EG255I06U1GUN KCP10B	C21
EG255I06U1GUN KCP25B	C21
EG255I06U1GUN KCU10	C21
EG255I06U1GUN KCU25	C21
EG255I06U1GUP KCP10B	C18
EG255I06U1GUP KCP25B	C18
EG255I06U1GUP KCU10	C18
EG255I06U1GUP KCU25	C18
EG255I06U2GUN KCK20B	C21
EG255I06U2GUN KCP10B	C21
EG255I06U2GUN KCP25B	C21
EG255I06U2GUN KCU10	C21
EG255I06U2GUN KCU25	C21
EG255I06U2GUP KCP10B	C18
EG255I06U2GUP KCP25B	C18
EG255I06U2GUP KCU10	C18
EG255I06U2GUP KCU25	C18
EG312I08P3GUP K313	C18
EG312I08P3GUP KCU10	C18
EG312I08P3GUP KCU25	C18
EG312I08U3GUN KCK20B	C21
EG312I08U3GUN KCP10B	C21
EG312I08U3GUN KCP25B	C21
EG312I08U3GUN KCU10	C21
EG312I08U3GUN KCU25	C21
EG317I08U3GUN KCK20B	C21
EG317I08U3GUN KCP10B	C21
EG317I08U3GUN KCP25B	C21
EG317I08U3GUN KCU10	C21
EG317I08U3GUN KCU25	C21
EG317I08U3GUP KCP10B	C18
EG317I08U3GUP KCP25B	C18
EG317I08U3GUP KCU10	C18
EG317I08U3GUP KCU25	C18
EG375I10P3GUP K313	C18
EG375I10P3GUP KCU10	C18
EG375I10P3GUP KCU25	C18
EG375I10U3GUN KCK20B	C21
EG375I10U3GUN KCP10B	C21
EG375I10U3GUN KCP25B	C21
EG375I10U3GUN KCU10	C21
EG375I10U3GUN KCU25	C21
EG380I10U3GUN KCK20B	C21
EG380I10U3GUN KCP10B	C21
EG380I10U3GUN KCP25B	C21
EG380I10U3GUN KCU10	C21
EG380I10U3GUN KCU25	C21
EG380I10U3GUP KCP10B	C18
EG380I10U3GUP KCP25B	C18
EG380I10U3GUP KCU10	C18
EG380I10U3GUP KCU25	C18
ENG451T0820 KY1615	B335
ENG452T0820 KY1615	B335
ENG453T0820 KY1615	B335
ENG454T0820 KY1615	B335
ENGX454T0820 KY3500	B317
EP0708SGE KC522M	T25
EP0708SGE KC725M	T25
EP0708SGE KCPK30	T25
EP0708SGE KCPM40	T25
EP0708SGE KCSM30	T25
EP1004EHD KC520M	T36, T46
EP1004EHD KC522M	T36, T46
EP1004EHD KC725M	T36, T46
EP1004EHD KCK15	T36, T46
EP1004EHD KCPK30	T36, T46
EP1004EHD KCPM40	T36
EP1004SGD KC725M	T37, T47
EP1004SGD KCK15	T37, T47
EP1004SGD KCPK30	T37, T47
EP1004SGD KCPM40	T37
EP1004SGE KC522M	T37, T46
EP1004SGE KC725M	T37, T46
EP1004SGE KCPK30	T37, T46
EP1004SGE KCPM40	T37
EP1008EHD KC520M	T36, T46
EP1008EHD KC522M	T36, T46
EP1008EHD KC725M	T36, T46
EP1008EHD KCK15	T36, T46
EP1008EHD KCPK30	T36, T46
EP1008EHD KCPM40	T36
EP1008EHD KCSM40	T36
EP1008SGD KC520M	T37, T47
EP1008SGD KC725M	T37, T47
EP1008SGD KCK15	T37, T47
EP1008SGD KCPK30	T37, T47
EP1008SGD KCPM40	T37
EP1008SGE KC522M	T37, T46
EP1008SGE KC725M	T37, T46
EP1008SGE KCPK30	T37, T46
EP1008SGE KCPM40	T37
EP1008SGE KCSM40	T37
EP1010EHD KC522M	T36, T46
EP1010EHD KC725M	T36, T46
EP1010EHD KCK15	T36, T46
EP1010EHD KCPK30	T36, T46
EP1012EHD KC520M	T36, T46
EP1012EHD KC522M	T36, T46
EP1012EHD KC725M	T36, T46
EP1012EHD KCPK30	T36, T46
EP1012EHD KCPM40	T36
EP1012EHD KCSM40	T36
EP1012SGD KC520M	T37, T47
EP1012SGD KC725M	T37, T47
EP1012SGD KCK15	T37, T47
EP1012SGD KCPK30	T37, T47
EP1012SGE KC522M	T37, T46
EP1012SGE KC725M	T37, T46
EP1012SGE KCPK30	T37, T46
EP1012SGE KCSM40	T37
EP1016EHD KC522M	T36, T46
EP1016EHD KC725M	T36, T46
EP1016EHD KCPK30	T36, T46
EP1016EHD KCPM40	T36
EP1016EHD KCSM30	T36
EP1016EHD KCSM40	T36
EP1016SGD KC725M	T37, T47
EP1016SGD KCPK30	T37, T47
EP1016SGE KC522M	T37, T46
EP1016SGE KC725M	T37, T46
EP1016SGE KCPK30	T37, T46
EP1016SGE KCSM40	T37
EP1020EHD KC725M	T36, T46
EP1020EHD KCPK30	T36, T46
EP1020EHD KCPM40	T36
EP1020EHD KCSM40	T36
EP1024EHD KC725M	T36, T46
EP1024EHD KCPK30	T36, T46
EP1024EHD KCSM40	T36
EP1031EHD KC522M	T36, T46
EP1031EHD KC725M	T36, T46
EP1031EHD KCPK30	T36, T46
EP1031EHD KCSM40	T36
EP1031SGE KC522M	T37, T46
EP1031SGE KC725M	T37, T46
EP1031SGE KCPK30	T37, T46
EP1031SGE KCSM40	T37
EP1404EHD KC520M	T57, T68
EP1404EHD KC522M	T57, T68
EP1404EHD KC725M	T57, T68
EP1404EHD KCK15	T57, T68
EP1404EHD KCPK30	T57, T68
EP1404EHD KCPM40	T57, T68
EP1404SGE KC522M	T58, T69
EP1404SGE KC725M	T58, T69
EP1404SGE KCPK30	T58, T69
EP1408EHD KC520M	T57, T68
EP1408EHD KC522M	T57, T68
EP1408EHD KC725M	T57, T68
EP1408EHD KCK15	T57, T68
EP1408EHD KCPK30	T57, T68
EP1408EHD KCPM40	T57, T68
EP1408EHD KCSM40	T57, T68
EP1408EHD2 KC522M	T58, T69
EP1408EHD2 KC725M	T58, T69
EP1408EHD2 KCK15	T58, T69
EP1408EHD2 KCPK30	T58, T69
EP1408EHD2 KCPM40	T58, T69
EP1408SGD KC520M	T58, T70
EP1408SGD KC725M	T58, T70
EP1408SGD KCPK30	T58, T70

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
EP1408SGD KCPM40	T58, T70
EP1408SGD KCSM40	T58, T70
EP1408SGD2 KC520M	T59, T70
EP1408SGD2 KC725M	T59, T70
EP1408SGD2 KCPK30	T59, T70
EP1408SGD2 KCPM40	T59, T70
EP1408SGE KC522M	T58, T69
EP1408SGE KC725M	T58, T69
EP1408SGE KCPK30	T58, T69
EP1408SGE KCPM40	T58, T69
EP1408SGE KCSM40	T58, T69
EP1412EHD KC520M	T57, T68
EP1412EHD KC522M	T57, T68
EP1412EHD KC725M	T57, T68
EP1412EHD KCK15	T57, T68
EP1412EHD KCPK30	T57, T68
EP1412EHD KCPM40	T57, T68
EP1412EHD KCSM40	T57, T68
EP1412SGD KC520M	T58, T70
EP1412SGD KC725M	T58, T70
EP1412SGD KCPK30	T58, T70
EP1412SGD KCPM40	T58, T70
EP1412SGD KCSM40	T58, T70
EP1412SGE KC522M	T58, T69
EP1412SGE KC725M	T58, T69
EP1412SGE KCPK30	T58, T69
EP1412SGE KCSM40	T58, T69
EP1416EHD KC522M	T57, T68
EP1416EHD KC725M	T57, T68
EP1416EHD KCK15	T57, T68
EP1416EHD KCPK30	T57, T68
EP1416EHD KCPM40	T57, T68
EP1416EHD KCSM30	T57, T68
EP1416EHD KCSM40	T57, T68
EP1416SGD KC520M	T58, T70
EP1416SGD KC725M	T58, T70
EP1416SGD KCPK30	T58, T70
EP1416SGD KCPM40	T58, T70
EP1416SGD KCSM40	T58, T70
EP1416SGE KC522M	T58, T69
EP1416SGE KC725M	T58, T69
EP1416SGE KCPK30	T58, T69
EP1416SGE KCSM40	T58, T69
EP1420EHD KC522M	T57, T68
EP1420EHD KC725M	T57, T68
EP1420EHD KCPK30	T57, T68
EP1420EHD KCSM40	T57, T68
EP1424EHD KC522M	T57, T68
EP1424EHD KC725M	T57, T68
EP1424EHD KCPK30	T57, T68
EP1424EHD KCPM40	T57, T68
EP1424EHD KCSM40	T57, T68
EP1431EHD KC522M	T57, T68
EP1431EHD KC725M	T57, T68
EP1431EHD KCPK30	T57, T68
EP1431EHD KCSM30	T57, T68
EP1431EHD KCSM40	T57, T68
EP1431SGE KC725M	T58, T69
EP1431SGE KCPK30	T58, T69
EP1431SGE KCSM40	T58, T69
EP1440EHD KC522M	T57, T68
EP1440EHD KC725M	T57, T68
EP1440EHD KCPK30	T57, T68
EP1440EHD KCSM30	T57, T68
EP1440EHD KCSM40	T57, T68
EP1808E KC520M	T83
EP1808E KC725M	T83
EP1808E KCPK30	T83
EP1808E KCPM40	T83
EP1808E KCSM40	T83
EP1808EHD KC725M	T84
EP1808EHD KCPK30	T84
EP1808EHD KCPM40	T84
EP1808EHD KCSM40	T84
EP1808S KC725M	T85
EP1808S KCK15	T85
EP1808S KCPK30	T85
EP1808S KCPM40	T85
EP1808S KCSM40	T85
EP1808SGE KC522M	T84
EP1808SGE KC725M	T84
EP1808SGE KCPK30	T84
EP1808SGE KCSM40	T84
EP1812E KC725M	T83
EP1812E KCPM40	T83
EP1812EHD KC725M	T84
EP1812EHD KCPK30	T84
EP1812EHD KCSM40	T84
EP1812S KC725M	T85
EP1812S KCK15	T85
EP1812S KCPK30	T85
EP1812S KCPM40	T85
EP1812S KCSM40	T85
EP1812SGE KC522M	T84
EP1812SGE KCPK30	T84
EP1812SGE KCSM40	T84
EP1816E KC522M	T83
EP1816E KC725M	T83
EP1816E KCPK30	T83
EP1816E KCPM40	T83
EP1816E KCSM40	T83
EP1816EHD KC725M	T84
EP1816EHD KCPK30	T84
EP1816EHD KCPM40	T84
EP1816EHD KCSM40	T84
EP1816S KC725M	T85
EP1816S KCPK30	T85
EP1816S KCPM40	T85
EP1816S KCSM40	T85
EP1816SGE KCSM40	T84
EP1824E KC725M	T83
EP1832E KC520M	T83
EP1832E KC522M	T83
EP1832E KC725M	T83
EP1832E KCPK30	T83
EP1832E KCSM40	T83
EP1832EHD KC725M	T84
EP1832EHD KCPK30	T84
EP1832EHD KCPM40	T84
EP1832EHD KCSM40	T84
EP1832S KC725M	T85
EP1832S KCPK30	T85
EP1832S KCSM40	T85
EP1832SGE KCPK30	T84
EP1832SGE KCSM40	T84
EP1840EHD KC725M	T84
EP1840EHD KCSM40	T84
EP1848E KC725M	T83
EP1848E KCSM40	T83
EP1848EHD KC725M	T84
EP1848EHD KCPK30	T84
EP1848EHD KCSM40	T84
EP1848S KCSM40	T85
EP1864E KC522M	T83
EP1864E KC725M	T83
EP1864E KCPK30	T83
EP1864E KCSM40	T83
EP1864EHD KC725M	T84
EP1864EHD KCPK30	T84
EP1864S KC725M	T85
EP1864S KCSM40	T85
ER0200M02P00GUP KCU10	C19
ER0200M02P00GUP KCU25	C19
ER0212M02U00GUN KCK20B	C21
ER0212M02U00GUN KCP10B	C21
ER0212M02U00GUN KCP25B	C21
ER0212M02U00GUN KCU10	C21
ER0212M02U00GUN KCU25	C21
ER0212M02U00GUP KCP10B	C19
ER0212M02U00GUP KCP25B	C19
ER0212M02U00GUP KCU10	C19
ER0212M02U00GUP KCU25	C19
ER0300M03P00GUP K313	C19
ER0300M03P00GUP KCU10	C19
ER0300M03P00GUP KCU25	C19
ER0312M03U00GUN KCK20B	C21
ER0312M03U00GUN KCP10B	C21
ER0312M03U00GUN KCP25B	C21
ER0312M03U00GUN KCU10	C21
ER0312M03U00GUN KCU25	C21
ER0312M03U00GUP KCP10B	C19
ER0312M03U00GUP KCP25B	C19
ER0312M03U00GUP KCU10	C19
ER0312M03U00GUP KCU25	C19
ER0400M04P00GUP K313	C19
ER0400M04P00GUP KCU10	C19
ER0400M04P00GUP KCU25	C19
ER0412M04U00GUN KCK20B	C21
ER0412M04U00GUN KCP10B	C21
ER0412M04U00GUN KCP25B	C21
ER0412M04U00GUN KCU10	C21
ER0412M04U00GUN KCU25	C21
ER0412M04U00GUP KCP10B	C19
ER0412M04U00GUP KCP25B	C19
ER0412M04U00GUP KCU10	C19
ER0412M04U00GUP KCU25	C19
ER0500M05P00GUP K313	C19
ER0500M05P00GUP KCU10	C19
ER0500M05P00GUP KCU25	C19
ER0512M05U00GUN KCK20B	C21
ER0512M05U00GUN KCP10B	C21
ER0512M05U00GUN KCP25B	C21
ER0512M05U00GUN KCU10	C21
ER0512M05U00GUN KCU25	C21
ER0512M05U00GUP KCP10B	C19
ER0512M05U00GUP KCP25B	C19
ER0512M05U00GUP KCU10	C19
ER0512M05U00GUP KCU25	C19
ER0600M06P00GUP K313	C19
ER0600M06P00GUP KCU10	C19
ER0600M06P00GUP KCU25	C19
ER0612M06U00GUN KCK20B	C21
ER0612M06U00GUN KCP10B	C21
ER0612M06U00GUN KCP25B	C21
ER0612M06U00GUN KCU10	C21
ER0612M06U00GUN KCU25	C21
ER0612M06U00GUP KCP10B	C19
ER0612M06U00GUP KCP25B	C19
ER0612M06U00GUP KCU10	C19
ER0612M06U00GUP KCU25	C19
ER0800M08P00GUP K313	C19
ER0800M08P00GUP KCU10	C19
ER0800M08P00GUP KCU25	C19
ER0812M08U00GUN KCK20B	C21
ER0812M08U00GUN KCP10B	C21
ER0812M08U00GUN KCP25B	C21
ER0812M08U00GUN KCU10	C21
ER0812M08U00GUN KCU25	C21
ER0812M08U00GUP KCP10B	C19
ER0812M08U00GUP KCP25B	C19
ER0812M08U00GUP KCU10	C19
ER0812M08U00GUP KCU25	C19
ER094I02U00GUN KCK20B	C22
ER094I02U00GUN KCP10B	C22
ER094I02U00GUN KCP25B	C22
ER094I02U00GUN KCU10	C22
ER094I02U00GUN KCU25	C22
ER125I03P00GUP K313	C20
ER125I03P00GUP KCU10	C20
ER125I03P00GUP KCU25	C20
ER125I03U00GUN KCK20B	C22
ER125I03U00GUN KCP10B	C22
ER125I03U00GUN KCP25B	C22
ER125I03U00GUN KCU10	C22
ER125I03U00GUN KCU25	C22
ER130I03U00GUN KCK20B	C22
ER130I03U00GUN KCP10B	C22
ER130I03U00GUN KCP25B	C22
ER130I03U00GUN KCU10	C22
ER130I03U00GUN KCU25	C22
ER130I03U00GUP KCP10B	C19
ER130I03U00GUP KCP25B	C19
ER130I03U00GUP KCU10	C19
ER130I03U00GUP KCU25	C19
ER187I04P00GUP K313	C20
ER187I04P00GUP KCU10	C20
ER187I04P00GUP KCU25	C20
ER187I04U00GUN KCK20B	C22
ER187I04U00GUN KCP10B	C22
ER187I04U00GUN KCP25B	C22
ER187I04U00GUN KCU10	C22
ER187I04U00GUN KCU25	C22
ER192I04U00GUN KCK20B	C22
ER192I04U00GUN KCP10B	C22
ER192I04U00GUN KCP25B	C22
ER192I04U00GUN KCU10	C22
ER192I04U00GUN KCU25	C22
ER192I04U00GUP KCP10B	C19
ER192I04U00GUP KCP25B	C19
ER192I04U00GUP KCU10	C19
ER192I04U00GUP KCU25	C19
ER250I06P00GUP K313	C20
ER250I06P00GUP KCU10	C20
ER250I06P00GUP KCU25	C20
ER250I06U00GUN KCK20B	C22
ER250I06U00GUN KCP10B	C22
ER250I06U00GUN KCP25B	C22
ER250I06U00GUN KCU10	C22
ER250I06U00GUN KCU25	C22
ER255I06U00GUN KCK20B	C22
ER255I06U00GUN KCP10B	C22
ER255I06U00GUN KCP25B	C22
ER255I06U00GUN KCU10	C22
ER255I06U00GUN KCU25	C22
ER255I06U00GUP KCP10B	C19
ER255I06U00GUP KCP25B	C19
ER255I06U00GUP KCU10	C19
ER255I06U00GUP KCU25	C19
ER25FBHS40	K138
ER25RBHT40	K123
ER312I08P00GUP K313	C20
ER312I08P00GUP KCU10	C20
ER312I08P00GUP KCU25	C20
ER312I08U00GUN KCK20B	C22
ER312I08U00GUN KCP10B	C22
ER312I08U00GUN KCP25B	C22
ER312I08U00GUN KCU10	C22
ER312I08U00GUN KCU25	C22
ER317I08U00GUN KCK20B	C22
ER317I08U00GUN KCP10B	C22
ER317I08U00GUN KCP25B	C22
ER317I08U00GUN KCU10	C22
ER317I08U00GUN KCU25	C22
ER317I08U00GUP KCP10B	C19
ER317I08U00GUP KCP25B	C19
ER317I08U00GUP KCU10	C19
ER317I08U00GUP KCU25	C19
ER32FBHS51	K138
ER32RBHT50	K123
ER40FBHS67	K138
ER40RBHT66	K123
EVBSN19G0220	C58
EVBSN19G1B14	C58
EVBSN19G1F16	C58
EVBSN26J0230	C58
EVBSN26J0340	C58
EVBSN26J0440	C58
EVBSN26J0540	C58
EVBSN26J0640	C58
EVBSN26J1B15	C58
EVBSN26J1F17	C58
EVBSN26M0230	C58
EVBSN26M0340	C58
EVBSN32M0250	C58
EVBSN32M0350	C58
EVBSN32M0450	C58
EVBSN32M0560	C58
EVBSN32M0660	C58
EVBSN32M0860	C58
EVBSN52X06120	C58
EVBSN52X08120	C58
EVM50L0212M	C60
EVM50L0216M	C60
EVM50L0312A035040C	C62
EVM50L0312A040050C	C62
EVM50L0312A050060C	C62
EVM50L0312A060075C	C62
EVM50L0312A075100C	C62
EVM50L0312A100180C	C62
EVM50L0312A180250C	C62
EVM50L0312A250350C	C62
EVM50L0312A350999C	C62
EVM50L0312B035040C	C64
EVM50L0312B040050C	C64
EVM50L0312B050060C	C64
EVM50L0312B060075C	C64
EVM50L0312B075100C	C64
EVM50L0312B100180C	C64

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
EVM50L0312B180250C	C64
EVM50L0312B250350C	C64
EVM50L0312B350999C	C64
EVM50L0312MC	C60
EVM50L0316MC	C60
EVM50L0320A075100C	C62
EVM50L0320A100180C	C62
EVM50L0320A180250C	C62
EVM50L0320A250350C	C62
EVM50L0320A350999C	C62
EVM50L0320B075100C	C64
EVM50L0320B100180C	C64
EVM50L0320B180250C	C64
EVM50L0320B250350C	C64
EVM50L0320B350999C	C64
EVM50L0322MC	C60
EVM50L0412MC	C60
EVM50L0416A040050C	C62
EVM50L0416A050060C	C62
EVM50L0416A060075C	C62
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EVM50L0416A350999C	C62
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EVM50L0416B050060C	C64
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EVM50L0416B100180C	C64
EVM50L0416B180250C	C64
EVM50L0416B250350C	C64
EVM50L0416B350999C	C64
EVM50L0416MC	C60
EVM50L0422MC	C60
EVM50L0426A100180C	C62
EVM50L0426A180250C	C62
EVM50L0426A250350C	C62
EVM50L0426A350999C	C62
EVM50L0426B100180C	C64
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EVM50L0426B250350C	C64
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EVM50L0426MC	C60
EVM50L0432MC	C60
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EVM50L0516MC	C60
EVM50L0520A050060C	C62
EVM50L0520A060075C	C62
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EVM50L0520A100180C	C62
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EVM50L1F12M	C60
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EVM50R0216M	C59
EVM50R0312A035040C	C61
EVM50R0312A040050C	C61
EVM50R0312A050060C	C61
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EVM50R0416A075100C	C61
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EVM50R0416B050060C	C63
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EVM50R0416B250350C	C63
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EVM50R0416MC	C59
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EVM50R0426A250350C	C61
EVM50R0426A350999C	C61
EVM50R0426B100180C	C63
EVM50R0426B180250C	C63
EVM50R0426B250350C	C63
EVM50R0426B350999C	C63
EVM50R0426MC	C59
EVM50R0432MC	C59
EVM50R0512MC	C59
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EVM50R0520A050060C	C61
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EVSBL160312180250C	C47
EVSBL160320060075C	C47
EVSBL160320075100C	C47
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EVSBL160416180250C	C47
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EVSBL160426075100C	C47
EVSBL160426001180C	C47–48
EVSBL160426180250C	C47–48
EVSBL160516050060C	C47–48
EVSBL160516060075C	C47–48
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EVSBL160516001180C	C47–48
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EVSBL160526060075C	C47–48
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EVSBL200632350999C	C48
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EVSBL3232P0632180250C	C51
EVSBL3232P0632250350C	C51
EVSBL3232P0632350999C	C51
EVSBR120312035040C	C46
EVSBR120312040050C	C46
EVSBR120312050060C	C46
EVSBR120312060075C	C46
EVSBR120312075100C	C46
EVSBR120416040050C	C46
EVSBR120416050060C	C46
EVSBR120416060075C	C46
EVSBR120416075100C	C46
EVSBR160312001180C	C46
EVSBR160312180250C	C46
EVSBR160320060075C	C46
EVSBR160320075100C	C46
EVSBR160321001180C	C46
EVSBR160321180250C	C46
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EVSBR160416180250C	C46
EVSBR160426060075C	C46
EVSBR160426075100C	C46
EVSBR160426001180C	C46
EVSBR160426180250C	C46
EVSBR160516050060C	C46
EVSBR160516060075C	C46
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EVSBR160516001180C	C46
EVSBR160516180250C	C46
EVSBR160516250350C	C46
EVSBR160516350999C	C47
EVSBR160526050060C	C47
EVSBR160526060075C	C47
EVSBR160526075100C	C47
EVSBR160616060075C	C47
EVSBR160616075100C	C47
EVSBR160616001180C	C47
EVSBR160616180250C	C47
EVSBR160616250350C	C47
EVSBR160616350999C	C47
EVSBR160626060075C	C47
EVSBR160626075100C	C47
EVSBR200532001180C	C47
EVSBR200532180250C	C47
EVSBR200532250350C	C47
EVSBR200532350999C	C47
EVSBR200632001180C	C47
EVSBR200632180250C	C47
EVSBR200632250350C	C47
EVSBR200632350999C	C47

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
EVSBR2020K0312035040C	C49
EVSBR2020K0312040050C	C49
EVSBR2020K0312050060C	C49
EVSBR2020K0312060075C	C49
EVSBR2020K0312075100C	C49
EVSBR2020K0416040050C	C49
EVSBR2020K0416050060C	C49
EVSBR2020K0416060075C	C49
EVSBR2020K0416075100C	C49
EVSBR2525M0312100180C	C49
EVSBR2525M0312180250C	C49
EVSBR2525M0320060075C	C49
EVSBR2525M0320075100C	C49
EVSBR2525M0320100180C	C49
EVSBR2525M0320180250C	C49
EVSBR2525M0416100180C	C49
EVSBR2525M0416180250C	C49
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EVSBR2525M0426100180C	C49
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EVSBR2525M0516050060C	C49
EVSBR2525M0516060075C	C49
EVSBR2525M0516075100C	C49
EVSBR2525M0516100180C	C49
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EVSBR2525M0516250350C	C49
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EVSBR2525M0526050060C	C50
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EVSBR3232P0632180250C	C50
EVSBR3232P0632250350C	C50
EVSBR3232P0632350999C	C50
EVSCFL060210	C43
EVSCFL061B10	C43
EVSCFL061F10	C43
EVSCFL080210	C43
EVSCFL080216	C43
EVSCFL080310C	C43
EVSCFL080316C	C43
EVSCFL081B10	C43
EVSCFL081B13	C43
EVSCFL081F10	C43
EVSCFL081F13	C43
EVSCFL100216	C43
EVSCFL100316C	C43
EVSCFL1010K0210	C45
EVSCFL1010K1B10	C45
EVSCFL1010K1F10	C45
EVSCFL101B16	C43
EVSCFL101F16	C43
EVSCFL120216	C43
EVSCFL120316C	C43
EVSCFL1212K0210	C45
EVSCFL1212K0216	C45
EVSCFL1212K0310C	C45
EVSCFL1212K0316C	C45
EVSCFL1212K1B10	C45
EVSCFL1212K1B13	C45
EVSCFL1212K1F10	C45
EVSCFL1212K1F13	C45
EVSCFL121B16	C43
EVSCFL121F16	C43
EVSCFL1616K0216	C45
EVSCFL1616K0316C	C45
EVSCFL1616K1B16	C45
EVSCFL1616K1F16	C45
EVSCFL2020K0216	C45
EVSCFL2020K0316C	C45
EVSCFL2020K1B16	C45
EVSCFL2020K1F16	C45
EVSCFR060210	C42
EVSCFR061B10	C42
EVSCFR061F10	C42
EVSCFR080210	C42
EVSCFR080216	C42
EVSCFR080310C	C42
EVSCFR080316C	C42
EVSCFR081B10	C42
EVSCFR081B13	C42
EVSCFR081F10	C42
EVSCFR081F13	C42
EVSCFR100216	C42
EVSCFR100316C	C42
EVSCFR1010K0210	C44
EVSCFR1010K1B10	C44
EVSCFR1010K1F10	C44
EVSCFR101B16	C42
EVSCFR101F16	C42
EVSCFR120216	C42
EVSCFR120316C	C42
EVSCFR1212K0210	C44
EVSCFR1212K0216	C44
EVSCFR1212K0310C	C44
EVSCFR1212K0316C	C44
EVSCFR1212K1B10	C44
EVSCFR1212K1B13	C44
EVSCFR1212K1F10	C44
EVSCFR1212K1F13	C44
EVSCFR121B16	C42
EVSCFR121F16	C42
EVSCFR1616K0216	C44
EVSCFR1616K0316C	C44
EVSCFR1616K1B16	C44
EVSCFR1616K1F16	C44
EVSCFR2020K0216	C44
EVSCFR2020K0316C	C44
EVSCFR2020K1B16	C44
EVSCFR2020K1F16	C44
EVSCTL080216	C38
EVSCTL080316C	C39
EVSCTL081B16	C38
EVSCTL081F16	C38
EVSCTL100216	C38
EVSCTL100316C	C39
EVSCTL100416C	C39
EVSCTL120216	C39
EVSCTL120316C	C39
EVSCTL120326C	C39
EVSCTL120416C	C39
EVSCTL120426C	C39
EVSCTL1212K0216	C41
EVSCTL1212K0316C	C41
EVSCTL1212K1B16	C41
EVSCTL1212K1F16	C41
EVSCTL160216	C39
EVSCTL160226	C39
EVSCTL160316C	C39
EVSCTL160326C	C39
EVSCTL160426C	C39
EVSCTL160432C	C39
EVSCTL160526C	C39
EVSCTL160532C	C39
EVSCTL1616K0216	C41
EVSCTL1616K0316C	C41
EVSCTL1616K0416C	C41
EVSCTL200432C	C39
EVSCTL200540C	C39
EVSCTL2020K0216	C41
EVSCTL2020K0316C	C41
EVSCTL2020K0326C	C41
EVSCTL2020K0416C	C41
EVSCTL2020K0426C	C41
EVSCTL2525M0216	C41
EVSCTL2525M0226	C41
EVSCTL2525M0316C	C41
EVSCTL2525M0326C	C41
EVSCTL2525M0426C	C41
EVSCTL2525M0432C	C41
EVSCTL2525M0526C	C41
EVSCTL2525M0532C	C41
EVSCTL3232P0432C	C41
EVSCTL3232P0540C	C41
EVSCTR080216	C38
EVSCTR080316C	C38
EVSCTR081B16	C38
EVSCTR081F16	C38
EVSCTR100216	C38
EVSCTR100316C	C38
EVSCTR100416C	C38
EVSCTR120216	C38
EVSCTR120316C	C38
EVSCTR120326C	C38
EVSCTR120416C	C38
EVSCTR120426C	C38
EVSCTR1212K0216	C40
EVSCTR1212K0316C	C40
EVSCTR1212K1B16	C40
EVSCTR1212K1F16	C40
EVSCTR160216	C38
EVSCTR160226	C38
EVSCTR160316C	C38
EVSCTR160326C	C38
EVSCTR160426C	C38
EVSCTR160432C	C38
EVSCTR160526C	C38
EVSCTR160532C	C38
EVSCTR1616K0216	C40
EVSCTR1616K0316C	C40
EVSCTR1616K0416C	C40
EVSCTR200432C	C38
EVSCTR200540C	C38
EVSCTR2020K0216	C40
EVSCTR2020K0316C	C40
EVSCTR2020K0326C	C40
EVSCTR2020K0416C	C40
EVSCTR2020K0426C	C40
EVSCTR2525M0216	C40
EVSCTR2525M0226	C40
EVSCTR2525M0316C	C40
EVSCTR2525M0326C	C40
EVSCTR2525M0426C	C40
EVSCTR2525M0432C	C40
EVSCTR2525M0526C	C40
EVSCTR2525M0532C	C40
EVSCTR3232P0432C	C40
EVSCTR3232P0540C	C40
EVSML120216	C35
EVSML120222	C35
EVSML120316C	C35
EVSML120322C	C35
EVSML120416C	C35
EVSML120422C	C35
EVSML120516C	C35
EVSML120522C	C35
EVSML120616C	C35
EVSML120622C	C35
EVSML160216	C35
EVSML160226	C35
EVSML160316C	C35
EVSML160326C	C35
EVSML160416C	C35
EVSML160426C	C35
EVSML160516C	C35
EVSML160526C	C35
EVSML160616C	C35
EVSML160626C	C35
EVSML160826C	C35
EVSML200426C	C35
EVSML200432C	C35
EVSML200526C	C35
EVSML200532C	C35
EVSML200626C	C35
EVSML200632C	C35
EVSML200826C	C35
EVSML200832C	C35
EVSML201032C	C35
EVSML2020K0216	C37
EVSML2020K0222	C37
EVSML2020K0316C	C37
EVSML2020K0322C	C37
EVSML2020K0416C	C37
EVSML2020K0422C	C37
EVSML2020K0516C	C37
EVSML2020K0522C	C37
EVSML2020K0616C	C37
EVSML2020K0622C	C37
EVSML240640C	C35
EVSML240840C	C35
EVSML241040C	C35
EVSML2525M0216	C37
EVSML2525M0216C	C37
EVSML2525M0226	C37
EVSML2525M0316C	C37
EVSML2525M0326C	C37
EVSML2525M0416C	C37
EVSML2525M0426C	C37
EVSML2525M0516C	C37
EVSML2525M0526C	C37
EVSML2525M0616C	C37
EVSML2525M0626C	C37
EVSML2525M0826C	C37
EVSML3232P0426C	C37
EVSML3232P0432C	C37
EVSML3232P0526C	C37
EVSML3232P0532C	C37
EVSML3232P0626C	C37
EVSML3232P0632C	C37
EVSML3232P0826C	C37
EVSML3232P0832C	C37
EVSML3232P1032C	C37
EVSML4040R0640C	C37
EVSML4040R0840C	C37
EVSML4040R1040C	C37
EVSMR120216	C34
EVSMR120222	C34
EVSMR120222C	C34
EVSMR120316C	C34
EVSMR120322C	C34
EVSMR120416C	C34
EVSMR120422C	C34
EVSMR120516C	C34
EVSMR120522C	C34
EVSMR120616C	C34
EVSMR120622C	C34
EVSMR160216	C34
EVSMR160216C	C34
EVSMR160226	C34
EVSMR160226C	C34
EVSMR160316C	C34
EVSMR160326C	C34
EVSMR160416C	C34
EVSMR160426C	C34
EVSMR160516C	C34
EVSMR160526C	C34
EVSMR160616C	C34
EVSMR160626C	C34
EVSMR160826C	C34
EVSMR200426C	C34
EVSMR200432C	C34
EVSMR200526C	C34
EVSMR200532C	C34
EVSMR200626C	C34
EVSMR200632C	C34
EVSMR200826C	C34
EVSMR200832C	C34
EVSMR201032C	C34
EVSMR2020K0216	C36
EVSMR2020K0216C	C36
EVSMR2020K0222	C36
EVSMR2020K0222C	C36
EVSMR2020K0316C	C36
EVSMR2020K0322C	C36
EVSMR2020K0416C	C36
EVSMR2020K0422C	C36
EVSMR2020K0516C	C36
EVSMR2020K0522C	C36
EVSMR2020K0616C	C36
EVSMR2020K0622C	C36
EVSMR240640C	C34
EVSMR240840C	C34
EVSMR241040C	C34
EVSMR2525M0216	C36
EVSMR2525M0216C	C36

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
EVSMR2525M0226	C36
EVSMR2525M0226C	C36
EVSMR2525M0316C	C36
EVSMR2525M0326C	C36
EVSMR2525M0416C	C36
EVSMR2525M0426C	C36
EVSMR2525M0516C	C36
EVSMR2525M0526C	C36
EVSMR2525M0616C	C36
EVSMR2525M0626C	C36
EVSMR2525M0826C	C36
EVSMR3232P0426C	C36
EVSMR3232P0432C	C36
EVSMR3232P0526C	C36
EVSMR3232P0532C	C36
EVSMR3232P0626C	C36
EVSMR3232P0632C	C36
EVSMR3232P0826C	C36
EVSMR3232P0832C	C36
EVSMR3232P1032C	C36
EVSMR4040R0640C	C36
EVSMR4040R0840C	C36
EVSMR4040R1040C	C36
F3508T S	T127–128, V9–11
F3510T S	V9–12
F4011T S	T131
F7IP	T29, T40
FAS100302GD KC7015	H42
FAS100302GD KC7215	H42
FBSCFCL09CA06F	K116
FBSCFCR09CA06F	K116
FBSCLCL09CA06F	K116
FBSCLCR09CA06F	K116
FBSCUCR09CA06F	K117
FBSTFCR09CA11F	K117
FC11	B265
FC14	B264–265
FMDF0375Y6CQA KCPM15	042
FMDF0500Y6CQB KCPM15	042
FMDF0625Y6CQB KCPM15	042
FMDF0750Y6CQB KCPM15	042
FMDF1000Y6CQB KCPM15	042
FP2506T	V4–5
FP2507T	V4–5
FP3006T	V111, V114
FP3007T S	V111, V114
FSDE0250J7DYA KC643M	P100
FSDE0375J9BCA KC643M	P98
FSDE0375J9BCB KC643M	P98
FSDE0375J9DYA KC643M	P100
FSDE0375J9DYB KC643M	P100
FSDE0375Y9CQA KC643M	043
FSDE0375Y9CQB KC643M	043
FSDE0375Y9CQC KC643M	043
FSDE0375Y9CQD KC643M	043
FSDE0500J9BCA KC643M	P98
FSDE0500J9BCB KC643M	P98
FSDE0500J9BCC KC643M	P98
FSDE0500N9DYA KC643M	P100
FSDE0500N9DYB KC643M	P100
FSDE0500N9DYC KC643M	P100
FSDE0500Y9CQA KC643M	043
FSDE0500Y9CQB KC643M	043
FSDE0500Y9CQC KC643M	043
FSDE0500Y9CQD KC643M	043
FSDE0500Y9CQE KC643M	043
FSDE0625JBBCB KC643M	P98
FSDE0625NBDYB KC643M	P100
FSDE0625Y11CQA KC643M	043
FSDE0625Y11CQB KC643M	043
FSDE0625Y11CQC KC643M	043
FSDE0625Y11CQD KC643M	043
FSDE0625Y11CQE KC643M	043
FSDE0750JFBCA KC643M	P98
FSDE0750JFBCB KC643M	P98
FSDE0750JFBCC KC643M	P98
FSDE0750JFBCE KC643M	P98
FSDE0750NFDYA KC643M	P100
FSDE0750NFDYB KC643M	P100
FSDE0750NFDYC KC643M	P100
FSDE0750NFDYE KC643M	P100
FSDE0750Y15CQB KC643M	043
FSDE0750Y15CQC KC643M	043
FSDE0750Y15CQD KC643M	043
FSDE0750Y15CQE KC643M	043
FSDE1000JJBCA KC643M	P98
FSDE1000JJBCB KC643M	P98
FSDE1000JJBCC KC643M	P98
FSDE1000JJBCE KC643M	P98
FSDE1000NJDYA KC643M	P100
FSDE1000NJDYB KC643M	P100
FSDE1000NJDYC KC643M	P100
FSDE1000NJDYE KC643M	P100
FSDE1000Y19CQB KC643M	043
FSDE1000Y19CQC KC643M	043
FSDE1000Y19CQD KC643M	043
FSDE1000Y19CQE KC643M	043
FSDE1000Y19CQF KC643M	043
FT10	K42
FT15	K85, K124–125
FT20	K124–125
FT5	K78
FT6	K79, T24
FT7	K78–80, K85, K89–90, K124–125
FT8	K42, K85
FUWTCL	E63
FUWTCR	E63
G14-G18-RED	C83
G18-JIC	C83
G32TTB41KM40	B410
G40TTB51KM40	B410
G48TTB63KM63	B410
GPCD505 KC5025	B238
GPCD505 KCU25	B238
GPCD51 KCU25	B238
H16LSER3	D76
H16MCLNL4	B76
H16MCLNR4	B76
H16MDUNL3	B96
H16MDUNR3	B96
H16MWLNL3	B163
H16SCLCR3	B198
H16SDUPL3	B237
H16SDUPR3	B237
H16STFPR2	B279
H20CTFPR3W	B188, B393
H20LSER3	D76
H20MCFNR4	B75
H20MCLNL4	B76
H20MCLNR4	B76
H20MDUNL4	B96
H20MDUNR4	B96
H20MTFNR3	B143
H20MVUNL3	B155
H20MVUNR3	B155
H20MWLNR4	B163
H20NDLPR4W	E48
H20NDXPL4W	E49
H20NEL3W	C195, D38
H20NER3W	C195, D38
H24CRGNR4	B170, B393
H24LSER3	D76
H24LSER4	D76
H24MCFNR4	B75
H24MCKNR4	B75
H24MCLNL4	B76
H24MCLNL5	B76
H24MCLNR4	B76
H24MCLNR5	B76
H24MDPNR4	B96
H24MDUNL4	B96
H24MDUNR3	B96
H24MDUNR4	B96
H24MSKNR4	B120
H24MSSNR4	B120
H24MTFNR3	B143
H24MVUNL3	B155
H24MVUNR3	B155
H24MWLNL4	B163
H24MWLNR4	B163
H24NDLPR4W	E48
H24NDXPR4W	E49
H24NEL3W	C195, D38
H24NER3W	C195, D38
H24NER8W	C195, D38
H24NVLPR3W	E49
H28MCLNL4	B76
H28MCLNR4	B76
H28MDUNL4	B96
H28MDUNR4	B96
H28MTFNR3	B143
H28MWLNR4	B163
H28NEL3W	C195, D38
H28NER3W	C195, D38
H28NER4W	C195, D38
H28NER6W	C195, D38
H32CRGNR4	B170, B393
H32LSER3	D76
H32LSER4	D76
H32LSER5	D76
H32MCFNR5	B75
H32MCKNR4	B75
H32MCLNL4	B76
H32MCLNL5	B76
H32MCLNL6	B76
H32MCLNR4	B76
H32MCLNR5	B76
H32MCLNR6	B76
H32MDUNL4	B96
H32MDUNR3	B96
H32MDUNR4	B96
H32MSKNR4	B120
H32MTFNR4	B143
H32MVUNL3	B155
H32MVUNL4	B155
H32MVUNR3	B155
H32MVUNR4	B155
H32MWLNL4	B163
H32MWLNR4	B163
H32NDQPL4W	E48
H32NEL3W	C195, D38
H32NEL4W	C195, D38
H32NER3W	C195, D38
H32NER4W	C195, D38
H32NER6W	C195, D38
H36NER4W	C195, D38
H40CTFPR4W	B188, B393
H40LSER5	D76
H40MCFNR6	B75
H40MCKNL5	B75
H40MCKNR5	B75
H40MCKNR6	B75
H40MCLNL4	B76
H40MCLNL5	B76
H40MCLNL6	B76
H40MCLNR4	B76
H40MCLNR5	B76
H40MCLNR6	B76
H40MDUNL4	B96
H40MDUNR4	B96
H40MSKNL6	B120
H40MSKNR6	B120
H40MSSNR6	B120
H40MTFNR4	B143
H40MVUNL3	B155
H40MVUNL4	B155
H40MVUNR3	B155
H40MVUNR4	B155
H40NDXPL4W	E49
H40NEL3W	C195, D38
H40NEL4W	C195, D38
H40NER3W	C195, D38
H40NER4W	C195, D38
H40NER6W	C195, D38
HDWM5EUS	S104
HFB1023SCFPR06	K130
HFB1223SCFPR06	K130
HFB14FBHS1440	K130
HFB1627SCFPR06	K130
HFB16FBHS1640	K130
HFB19FBHS1840	K130
HFB2127SCFPR06	K130
HFB2427SCFPR06	K130
HFB2727SCFPR06	K130
HFB3127SCFPR06	K130
HFB3427SCFPR06	K130
HNEC535ANSN KY3500	S23
HNEN090508S KY3500	S79
HNEN0905ANSN KD200	S79
HNEN0905ANSN KY3500	S79
HNEN0905XNSN KY3500	S79
HNGJ438ANENLD KC725M	S6, S12, S15
HNGJ438ANENLD KCPK30	S6, S12, S15
HNGJ43ANENLD KC510M	S6, S12, S15
HNGJ43ANENLD KC520M	S6, S12, S15
HNGJ43ANENLD KC522M	S6, S12, S15
HNGJ43ANENLD KC725M	S6, S12, S15
HNGJ43ANENLD KCK15	S6, S12, S15
HNGJ43ANENLD KCPK30	S6, S12, S15
HNGJ43ANENLD KCPM40	S6, S12, S15
HNGJ43ANFNLDJ K313	S6, S11, S15
HNGJ43ANFNLDJ KC410M	S6, S11, S15
HNGJ43ANSNHD KC522M	S7, S12, S16
HNGJ43ANSNHD KCK15	S7, S16
HNGJ43ANSNHD KCPK30	S7, S16
HNGJ43ANSNHD KCPM40	S7, S12, S16
HNGJ43ANSNHD KCSM40	S7, S12, S16
HNGJ53511ANSNHD KC520M	S19, S22
HNGJ53511ANSNHD KC725M	S19, S22
HNGJ53511ANSNHD KCPK30	S19, S22
HNGJ53511ANSNHD KCPM40	S19, S22
HNGJ53511ANSNHD KCSM40	S19, S22
HNGJ535ANENLD KC520M	S18, S21
HNGJ535ANENLD KC522M	S18, S21
HNGJ535ANENLD KC725M	S18, S21
HNGJ535ANENLD KCK15	S18, S21
HNGJ535ANENLD KCPK30	S18, S21
HNGJ535ANENLD KCSM40	S18, S21
HNGJ535ANFNLDJ KC410M	S18, S21
HNGJ535ANSNGD KC725M	S18, S22
HNGJ535ANSNGD KCK15	S18, S22
HNGJ535ANSNGD KCPK30	S18, S22
HNGJ535ANSNGD KCPM40	S18, S22
HNGJ535ANSNGD KCSM40	S18, S22
HNGJ535ANSNHD KC520M	S19, S22
HNGJ535ANSNHD KC725M	S19, S22
HNGJ535ANSNHD KCK15	S19, S22
HNGJ535ANSNHD KCPK30	S19, S22
HNGJ535ANSNHD KCPM40	S19, S22
HNGJ535ANSNHD KCSM40	S19, S22
HNGJ75ANENGD KC725M	S25
HNGJ75ANENGD KCPK30	S25
HNGJ75ANENGD KCPM40	S25
HNGX5358MCI KCK15	S79
HNHX5354ENLE KC514M	S78
HNHX5354ENLE KCK15	S78
HNHX5354SNGE KC514M	S79
HNHX5354SNGE KCK15	S79
HNHX5355ENLE KC514M	S78
HNHX5355ENLE KCK15	S78
HNHX5355SNGE KC514M	S79
HNHX5355SNGE KCK15	S79
HNHX5358SNGE KCK15	S79
HNHX53ANSNGE KC514M	S78
HNHX53ANSNGE KCK15	S78
HNPJ438ANSNHD KC522M	S7, S13, S16
HNPJ438ANSNHD KC725M	S7, S13, S16
HNPJ438ANSNHD KCK15	S7, S13, S16
HNPJ438ANSNHD KCPK30	S7, S13, S16
HNPJ438ANSNHD KCPM40	S7, S13, S16
HNPJ438ANSNHD KCSM40	S7, S13, S16
HNPJ43ANSNGD KC520M	S7, S13, S16
HNPJ43ANSNGD KC522M	S7, S13, S16
HNPJ43ANSNGD KC725M	S7, S13, S16
HNPJ43ANSNGD KCK15	S7, S13, S16
HNPJ43ANSNGD KCPK30	S7, S13, S16
HNPJ43ANSNGD KCPM40	S7, S13, S16
HNPJ43ANSNGD KCSM40	S7, S13
HNPJ43ANSNHD KC520M	S7, S13, S16
HNPJ43ANSNHD KC522M	S7, S13, S16
HNPJ43ANSNHD KC725M	S7, S13, S16
HNPJ43ANSNHD KCK15	S7, S13, S16
HNPJ43ANSNHD KCPK30	S7, S13, S16
HNPJ43ANSNHD KCPM40	S7, S13, S16
HNPJ43ANSNHD KCSM40	S7, S13, S16
HNPJ53511ANSNHD KC522M	S19, S23
HNPJ53511ANSNHD KC725M	S19, S23
HNPJ53511ANSNHD KCK15	S19, S23

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
HNPJ53511ANSNHD KCPK30	S19, S23
HNPJ53511ANSNHD KCPM40	S19, S23
HNPJ53511ANSNHD KCSM40	S19, S23
HNPJ535ANSNGD KC520M	S19, S22
HNPJ535ANSNGD KC522M	S19, S22
HNPJ535ANSNGD KC725M	S19, S22
HNPJ535ANSNGD KCK15	S19, S22
HNPJ535ANSNGD KCPK30	S19, S22
HNPJ535ANSNGD KCPM40	S19, S22
HNPJ535ANSNHD KC520M	S19, S23
HNPJ535ANSNHD KC522M	S19, S23
HNPJ535ANSNHD KC725M	S19, S23
HNPJ535ANSNHD KCK15	S19, S23
HNPJ535ANSNHD KCPK30	S19, S23
HNPJ535ANSNHD KCPM40	S19, S23
HNPJ535ANSNHD KCSM40	S19, S23
HNPJ755ANSNGD KC520M	S25
HNPJ755ANSNGD KC725M	S25
HNPJ755ANSNGD KCPK30	S25
HNPJ755ANSNHD KC725M	S26
HNPJ755ANSNHD KCPK30	S26
HNPJ755ANSNHD KCPM40	S26
HNPJ759ANSNHD KC520M	S26
HNPJ759ANSNHD KCK15	S26
HNPJ759ANSNHD KCPK30	S26
HNPJ75ANSNHD KC725M	S26
HNPJ75ANSNHD KCK15	S26
HNPJ75ANSNHD KCPK30	S26
HNPJ75ANSNHD KCPM40	S26
HNPJ75ANSNHD KCSM40	S26
HNPX5354SNGE KCK15	S80
HNPX5355SNGE KCK15	S80
HNPX5358SNGE KCK15	S80
HPBNDM125S4013 KC633M	P150
HPBNDM188S4019 KC633M	P150
HPBNDM250S4025 KC633M	P150
HPBNDM375S4038 KC633M	P150
HPBNDM500S4050 KC633M	P150
HPBNDM625S4063 KC633M	P150
HPBNDM750S4075 KC633M	P150
HPFDM1000S5150 KC633M	P148
HPFDM1000S6250 KC633M	P148
HPFDM1000S6350 KC633M	P148
HPFDM250S4038 KC633M	P148
HPFDM250S4063 KC633M	P148
HPFDM250S4088 KC633M	P148
HPFDM312S4050 KC633M	P148
HPFDM312S4075 KC633M	P148
HPFDM312S4113 KC633M	P148
HPFDM375S4056 KC633M	P148
HPFDM375S5094 KC633M	P148
HPFDM375S5131 KC633M	P148
HPFDM500S4075 KC633M	P148
HPFDM500S6125 KC633M	P148
HPFDM500S6175 KC633M	P148
HPFDM625S4094 KC633M	P148
HPFDM625S6156 KC633M	P148
HPFDM625S6219 KC633M	P148
HPFDM750S4113 KC633M	P148
HPFDM750S6188 KC633M	P148
HPFDM750S6263 KC633M	P148
HPFSS1000S5200 KCPM15	P109
HPFSS1000S5325 KCPM15	P109
HPFSS125S3025 KC635M	P108
HPFSS125S5025 KC635M	P109
HPFSS156S5056 KC635M	P109
HPFSS188S3031 KC635M	P108
HPFSS188S5031 KC635M	P109
HPFSS188S5056 KCPM15	P109
HPFSS250S3038 KC635M	P108
HPFSS250S3050 KC635M	P108
HPFSS250S5038 KCPM15	P109
HPFSS250S5075 KCPM15	P109
HPFSS250S5125 KCPM15	P109
HPFSS312S3081 KC635M	P108
HPFSS375S3050 KC635M	P108
HPFSS375S3088 KC635M	P108
HPFSS375S5050 KCPM15	P109
HPFSS375S5088 KCPM15	P109
HPFSS375S5150 KCPM15	P109
HPFSS500S3063 KC635M	P108
HPFSS500S3125 KC635M	P108
HPFSS500S5063 KCPM15	P109
HPFSS500S5125 KCPM15	P109
HPFSS500S5200 KCPM15	P109
HPFSS625S5075 KCPM15	P109
HPFSS625S5163 KCPM15	P109
HPFSS750S5088 KCPM15	P109
HPFSS750S5163 KCPM15	P109
HPFSS750S5325 KCPM15	P109
HPFT1000S6150 KC635M	P110
HPFT1000S6225 KC635M	P110
HPFT1000S6400 KC635M	P110
HPFT250S6038 KC635M	P110
HPFT250S6075 KC635M	P110
HPFT312S6081 KC635M	P110
HPFT375S6088 KC635M	P110
HPFT375S6113 KC635M	P110
HPFT500S6063 KC635M	P110
HPFT500S6100 KC635M	P110
HPFT500S6200 KC635M	P110
HPFT625S6125 KC635M	P110
HPFT750S6150 KC635M	P110
HPFT750S6225 KC635M	P110
HPFT750S6300 KC635M	P110
HPFT750S6400 KC635M	P110
HPHV1000S4150 KCPM15	P19
HPHV1000S4150CH KCPM15	P19
HPHV1000S4150R030 KCPM15	P19
HPHV1000S4150R120 KCPM15	P19
HPHV1000S4150R250 KCPM15	P19
HPHV1000S4200 KCPM15	P20
HPHV1000S4200R030 KCPM15	P19
HPHV1000S4200R060 KCPM15	P19
HPHV1000S4200R120 KCPM15	P19
HPHV1000S4225 KCPM15	P20
HPHV1000S4225CH KCPM15	P20
HPHV1000S4225R030 KCPM15	P20
HPHV1000S4225R060 KCPM15	P20
HPHV1000S4263 KCPM15	P20
HPHV1000S4263CH KCPM15	P20
HPHV1000S4263R030 KCPM15	P20
HPHV1000S4300CH KCPM15	P20
HPHV1000S4300R030 KCPM15	P20
HPHV1000S4300R060 KCPM15	P20
HPHV1000S4400CH KCPM15	P20
HPHV1000S4400R030 KCPM15	P20
HPHV1000S4400R060 KCPM15	P20
HPHV1250S4225CH KCPM15	P20
HPHV1250S4225R030 KCPM15	P20
HPHV125S4025 KCPM15	P16
HPHV125S4025CH KCPM15	P16
HPHV125S4025LR015 KCPM15	P16
HPHV125S4050 KCPM15	P16
HPHV125S4050CH KCPM15	P16
HPHV125S4050L KCPM15	P16
HPHV125S4050R015 KCPM15	P16
HPHV188S4031 KCPM15	P16
HPHV188S4031CH KCPM15	P16
HPHV188S4031L KCPM15	P16
HPHV188S4031LR015 KCPM15	P16
HPHV188S4063 KCPM15	P16
HPHV188S4063CH KCPM15	P16
HPHV188S4063L KCPM15	P16
HPHV188S4063LR015 KCPM15	P16
HPHV188S4063LR030 KCPM15	P16
HPHV188S4063R015 KCPM15	P16
HPHV188S4063R030 KCPM15	P16
HPHV250S4038 KCPM15	P16
HPHV250S4038CH KCPM15	P16
HPHV250S4038LR015 KCPM15	P16
HPHV250S4038R030 KCPM15	P16
HPHV250S4050 KCPM15	P16
HPHV250S4050R015 KCPM15	P16
HPHV250S4050R030 KCPM15	P16
HPHV250S4050R060 KCPM15	P16
HPHV250S4075 KCPM15	P17
HPHV250S4075CH KCPM15	P17
HPHV250S4075R015 KCPM15	P16
HPHV250S4075R030 KCPM15	P16
HPHV250S4075R060 KCPM15	P17
HPHV250S4100 KCPM15	P17
HPHV250S4100R015 KCPM15	P17
HPHV250S4125 KCPM15	P17
HPHV250S4125CH KCPM15	P17
HPHV250S4125R030 KCPM15	P17
HPHV250S4175R015 KCPM15	P17
HPHV250S4175R030 KCPM15	P17
HPHV312S4050 KCPM15	P17
HPHV312S4050CH KCPM15	P17
HPHV312S4050L KCPM15	P17
HPHV312S4050LR015 KCPM15	P17
HPHV312S4050R030 KCPM15	P17
HPHV312S4075 KCPM15	P17
HPHV312S4075CH KCPM15	P17
HPHV312S4075R015 KCPM15	P17
HPHV312S4075R030 KCPM15	P17
HPHV312S4075R060 KCPM15	P17
HPHV312S4125R030 KCPM15	P17
HPHV375S4050 KCPM15	P17
HPHV375S4050CH KCPM15	P17
HPHV375S4050L KCPM15	P17
HPHV375S4050LR015 KCPM15	P17
HPHV375S4050LR030 KCPM15	P17
HPHV375S4050R030 KCPM15	P17
HPHV375S4088 KCPM15	P17
HPHV375S4088CH KCPM15	P17
HPHV375S4088L KCPM15	P17
HPHV375S4088LR015 KCPM15	P17
HPHV375S4088LR030 KCPM15	P17
HPHV375S4088LR090 KCPM15	P17
HPHV375S4088R015 KCPM15	P17
HPHV375S4088R030 KCPM15	P17
HPHV375S4088R060 KCPM15	P17
HPHV375S4088R090 KCPM15	P17
HPHV375S4100 KCPM15	P17
HPHV375S4100R015 KCPM15	P17
HPHV375S4100R030 KCPM15	P17
HPHV375S4100R060 KCPM15	P17
HPHV375S4125 KCPM15	P17
HPHV375S4125R015 KCPM15	P17
HPHV375S4125R030 KCPM15	P17
HPHV375S4125R060 KCPM15	P17
HPHV375S4150 KCPM15	P17
HPHV375S4150R030 KCPM15	P17
HPHV375S4150R060 KCPM15	P17
HPHV375S4250R030 KCPM15	P17
HPHV375S4250R060 KCPM15	P17
HPHV438S4063CH KCPM15	P18
HPHV438S4088CH KCPM15	P18
HPHV438S4113R015 KCPM15	P18
HPHV500S4063 KCPM15	P18
HPHV500S4063CH KCPM15	P18
HPHV500S4063L KCPM15	P18
HPHV500S4063LR015 KCPM15	P18
HPHV500S4063LR030 KCPM15	P18
HPHV500S4063LR060 KCPM15	P18
HPHV500S4063R030 KCPM15	P18
HPHV500S4063R060 KCPM15	P18
HPHV500S4100 KCPM15	P18
HPHV500S4100CH KCPM15	P18
HPHV500S4100R030 KCPM15	P18
HPHV500S4100R060 KCPM15	P18
HPHV500S4125 KCPM15	P18
HPHV500S4125CH KCPM15	P18
HPHV500S4125R015 KCPM15	P18
HPHV500S4125R030 KCPM15	P18
HPHV500S4125R060 KCPM15	P18
HPHV500S4125R090 KCPM15	P18
HPHV500S4125R120 KCPM15	P18
HPHV500S4150 KCPM15	P18
HPHV500S4150CH KCPM15	P18
HPHV500S4150R030 KCPM15	P18
HPHV500S4150R060 KCPM15	P18
HPHV500S4163 KCPM15	P18
HPHV500S4163R030 KCPM15	P18
HPHV500S4163R060 KCPM15	P18
HPHV500S4163R120 KCPM15	P18
HPHV500S4200 KCPM15	P18
HPHV500S4200CH KCPM15	P18
HPHV500S4200R030 KCPM15	P18
HPHV500S4250R030 KCPM15	P18
HPHV500S4300R030 KCPM15	P18
HPHV500S4300R060 KCPM15	P18
HPHV625S4075 KCPM15	P18
HPHV625S4075CH KCPM15	P18
HPHV625S4075L KCPM15	P19
HPHV625S4075LR015 KCPM15	P18
HPHV625S4075LR030 KCPM15	P18
HPHV625S4075LR060 KCPM15	P18
HPHV625S4075R060 KCPM15	P18
HPHV625S4125 KCPM15	P19
HPHV625S4125CH KCPM15	P19
HPHV625S4125R030 KCPM15	P19
HPHV625S4125R060 KCPM15	P19
HPHV625S4125R090 KCPM15	P19
HPHV625S4163 KCPM15	P19
HPHV625S4163R030 KCPM15	P19
HPHV625S4163R060 KCPM15	P19
HPHV625S4163R120 KCPM15	P19
HPHV625S4213 KCPM15	P19
HPHV625S4213R030 KCPM15	P19
HPHV625S4213R120 KCPM15	P19
HPHV625S4225R060 KCPM15	P19
HPHV750S4088 KCPM15	P19
HPHV750S4088CH KCPM15	P19
HPHV750S4088L KCPM15	P19
HPHV750S4088LR030 KCPM15	P19
HPHV750S4150 KCPM15	P19
HPHV750S4150CH KCPM15	P19
HPHV750S4150R015 KCPM15	P19
HPHV750S4150R030 KCPM15	P19
HPHV750S4150R060 KCPM15	P19
HPHV750S4150R090 KCPM15	P19
HPHV750S4150R120 KCPM15	P19
HPHV750S4163CH KCPM15	P19
HPHV750S4163R030 KCPM15	P19
HPHV750S4163R060 KCPM15	P19
HPHV750S4163R120 KCPM15	P19
HPHV750S4225 KCPM15	P19
HPHV750S4225CH KCPM15	P19
HPHV750S4225R030 KCPM15	P19
HPHV750S4225R060 KCPM15	P19
HPHV750S4300 KCPM15	P19
HPHV750S4300CH KCPM15	P19
HPHV750S4400R030 KCPM15	P19
HPHV750S4400R060 KCPM15	P19
HPHVBN1000S4150 KCPM15	P23
HPHVBN125S4050 KCPM15	P23
HPHVBN188S4063 KCPM15	P23
HPHVBN250S4075 KCPM15	P23
HPHVBN312S4075 KCPM15	P23
HPHVBN375S4088 KCPM15	P23
HPHVBN438S4088 KCPM15	P23
HPHVBN500S4100 KCPM15	P23
HPHVBN500S4125 KCPM15	P23
HPHVBN625S4125 KCPM15	P23
HPHVBN750S4150 KCPM15	P23
HPHVT1000S4150 KC643M	P24
HPHVT1000S4150CH KC643M	P24
HPHVT500S4063 KC643M	P24
HPHVT500S4063CH KC643M	P24
HPHVT500S4125 KC643M	P24
HPHVT500S4125CH KC643M	P24
HPHVT625S4075 KC643M	P24
HPHVT625S4075CH KC643M	P24
HPHVT625S4125 KC643M	P24
HPHVT625S4125CH KC643M	P24
HPHVT750S4088 KC643M	P24
HPHVT750S4088CH KC643M	P24
HPHVT750S4150 KC643M	P24
HPHVT750S4150CH KC643M	P24
HPRDM188S3019 KC633M	P149
HPRDM250S4025 KC633M	P149
HPRDM312S4031 KC633M	P149
HPRDM375S4038 KC633M	P149
HPRDM500S4050 KC633M	P149
HPRSHV1000S4700CH KCPM15	P22
HPRSHV500S4600 KCPM15	P22
HPRSHV500S4600CH KCPM15	P22
HPRSHV625S4600 KCPM15	P22
HPRSHV625S4600CH KCPM15	P22
HPRSHV750S4500CH KCPM15	P22
HPRSHV750S4600 KCPM15	P22
HPRSHV750S4600CH KCPM15	P22
HPRSS250S3075 KCPM15	P90
HPRSS375S3100 KCPM15	P90
HPRSS500S3125 KCPM15	P90

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
HPRSS625S3163 KCPM15	P90
HPRSS750S3163 KCPM15	P90
HPRST1000S4150 KC643M	P92
HPRST1000S6150 KC643M	P92
HPRST250S4038 KC643M	P92
HPRST250S4075 KC643M	P92
HPRST375S4050 KC643M	P92
HPRST375S4088 KC643M	P92
HPRST500S4063 KC643M	P92
HPRST500S4125 KC643M	P92
HPRST625S4075 KC643M	P92
HPRST625S4125 KC643M	P92
HPRST625S6125 KC643M	P92
HPRST750S4088 KC643M	P92
HPRST750S4150 KC643M	P92
HPRST750S6150 KC643M	P92
HSFS0125	H86, H128–129, J13–15, J52–53, J89
HSFS0500	H128–129
HSK100AHTS40085M	J92
HSK100AHTS50090M	J92
HSK100AKR32075M	K92
HSK100AKR50085M	K92
HSK100AKR63100M	K92
HSK100AKR80090M	K92
HSK100ASIF100070M	K50
HSK100ASIF70050M	K50
HSK100ASVUBB2124MCLB	K78
HSK100BT13075	K143
HSK63AAVS00B126MCLB	K83
HSK63AAVS0B143MCLB	K83
HSK63AAVS1B127MCLB	K83
HSK63AAVS2B139MCLB	K83
HSK63AAVS3B139MCLB	K83
HSK63ADL10200	O52
HSK63ADL12225	O52
HSK63ADL16225	O52
HSK63ADL20225	O52
HSK63ADL25250	O52
HSK63ADL32288	O52
HSK63AKR32075M	K92
HSK63AKR50080M	K92
HSK63ASIF70066M	K50
HSK63ASIF80063M	K50
HSK63ASVS4B139M	K84
HSK63ASVS5B139M	K84
HSK63ASVUBB1095MCLB	K76
HSK63ASVUBB2116MCLB	K78
HSK63FBHM1696	K132
HSK63FBHMKIT164M	K127, K131
HSK63FBHO1695	K128
HSK63FBHS24	K137
HSK63FBHS31	K137
HSK63FBHS40	K137
HSK63FBHS51	K137
HSK63FBHS67	K137
HSK63FBHS87	K137
HSK63RBHT24	K122
HSK63RBHT30	K122
HSK63RBHT40	K122
HSK63RBHT50	K122
HSK63RBHT66	K122
HSK63RBHT87	K122
HSK80ASIF70066M	K50
HTSR040R025M	J75
HTSR043R025M	J75
HTSR046R028M	J75
HTSR049R028M	J75
HTSR052R028M	J75
HTSR10CE	J75
HTSR10CI	J75
HTSR11CE	J75
HTSR11CI	J75
HTSR12CE	J75
HTSR12CI	J75
HTSR13CE	J75
HTSR13CI	J75
HTSR14CE	J75
HTSR14CI	J75
HUWTCL	E63
HUWTCR	E63
ICSN332 K9	B59, B63
ICSN432 K9	B72–74
ICSN433 K9	B58–65, B67–71, B75–76
ICSN442 K9	B66, B371
ICSN443 K9	B58–60
ICSN533 K9	B61–65, B67–69, B71, B74–76
ICSN543 K9	B58–60
ICSN633 K9	B59, B61–65, B68, B71, B74–76
ICSN643 K9	B58–60
ICSN846 K9	B63–64
IDSN322 K9	B87, B89–90, B92, B96
IDSN432 K9	B94–95
IDSN443 K9	B87–93, B96
IDSN533 K9	B89–90
IDSN543 K9	B87
IRSN33 K9	B98
IRSN43 K9	B98
IRSN44 K9	B98–99, B371
IRSN63 K9	B98
IRSN64 K9	B98
IRSN84 K9	B98
ISSN322 K9	B111, B113
ISSN332 K9	B113
ISSN432 K9	B115–117, B119
ISSN433 K9	B109, B111–113, B120
ISSN443 K9	B109–110
ISSN533 K9	B111–113
ISSN633 K9	B111–115, B119–120
ISSN643 K9	B109–110
ISSN846 K9	B111–112
ITSN322 K9	B140–142
ITSN323 K9	B131–135, B137, B139, B143
ITSN333 K9	B135–136
ITSN433 K9	B132–143
ITSN443 K9	B131
ITSN534 K9	B133–137
ITSN636 K9	B134, B137
IVSN322 K9	B150–155
IVSN432 K9	B150–151
IVSN433 K9	B152–155
IWSN322 K9	B163
IWSN433 K9	B163
JICM-JICF-ELB	C83
JICM-JICM-STR	C83
K067TM2RW075STN11D	W43
K102TM2RW100STN16D	W43
K1200Z328RF60HN09WSC	S82
K165TM2RW125STN27D	W43
K315A62RF60HN09C	S82
K400B14RF45HN09C	S77
K500B18RF45HN09C	S77
K600B164RF60HN09C	S82
KAP1250632	U7–8
KAP1250634	U7–8
KAP1250764	U7–8
KAP1871004	U7–8
KAP2251254	U7–8
KAP3121254	U7–8
KAP3502004	U7–8
KAP5502004	U8
KBDM250SD06	S104
KBDM300SD08	S104
KBDM400SD12	S104
KBDM500SD16	S104
KBDM600SD18	S104
KBDM800SD24	S104
KBFI10	I15
KBFI11	I15
KBFI12	I15
KBFI13	I15
KBFI14	I15
KBFI15	I15
KBFI16	I15
KBFI17	I15
KBFI18	I15
KBFI4	I15
KBFI5B	I15
KBFI6B	I15
KBFI7	I15
KBFI8	I15
KBFI9	I15
KCI1	V156
KCI2	V155–156
KCI3M	V155–156
KCRA150RN4303C125L400	V148
KCRA200RN4304S075L175	V149
KCRA200RN4306S075L175	V149
KCRA250RN4306S075L175	V149
KCRA250RN4309S075L175	V149
KCRA300RN4308S100L200	V149
KCRA300RN4311S100L200	V149
KDMB0250M0ERGP KC515M	V126
KDMB0250M0ERLD K115M	V126
KDMB025R394A025HN	V123
KDMB025R394A038HN	V123
KDMB025R591A025HN	V123
KDMB025R788A025HN	V123
KDMB0312M0ERGP KC505M	V126
KDMB0312M0ERLD K115M	V126
KDMB0312R551A031ST	V122
KDMB0312R591A038HN	V123
KDMB0375M0ERGP KC505M	V126
KDMB0375M0ERGP KC515M	V126
KDMB0375M0ERLD K115M	V126
KDMB0375R354A038SN	V121
KDMB0375R472A038HNC	V123
KDMB0375R591A038HNC	V123
KDMB0375R591A038ST	V122
KDMB0500M0ERGN KC515M	V126
KDMB0500M0ERGP KC505M	V126
KDMB0500M0ERGP KC515M	V126
KDMB0500M0ERHC KC530M	V126
KDMB0500M0ERLD K115M	V126
KDMB0500R472A050HNC	V123
KDMB0500R512A050SN	V121
KDMB0500R591A050SN	V121
KDMB0500R630A050HNC	V123
KDMB0500R630A050ST	V122
KDMB0625M0ERGP KC505M	V126
KDMB0625M0ERGP KC515M	V126
KDMB0625M0ERHC KC530M	V126
KDMB0625M0ERLD K115M	V126
KDMB0625R551A063SN	V121
KDMB0625R630A063SN	V121
KDMB0625R689A063HNC	V123
KDMB0750M0ERGN KC515M	V126
KDMB0750M0ERGP KC505M	V126
KDMB0750M0ERGP KC515M	V126
KDMB0750M0ERHC KC530M	V126
KDMB0750M0ERLD K115M	V126
KDMB0750R551A075HNC	V123
KDMB0750R630A075SN	V121
KDMB0750R689A075SN	V121
KDMB0750R748A075ST	V122
KDMB0750R827A075HNC	V123
KDMB0750R827A075SN	V121
KDMB1000M0ERGN KC515M	V126
KDMB1000M0ERGP KC505M	V126
KDMB1000M0ERGP KC515M	V126
KDMB1000M0ERHC KC530M	V126
KDMB1000M0ERLD K115M	V126
KDMB1000R630A100HNC	V123
KDMB1000R630A100SN	V121
KDMB1000R748A100SN	V121
KDMB1000R827A100ST	V122
KDMB1000R906A100HNC	V123
KDMB1250M0ERGP KC505M	V126
KDMB1250M0ERGP KC515M	V126
KDMB1250M0ERLD K115M	V126
KDMB1250R689A125SN	V121
KDMB1250R827A125SN	V121
KDMB1250R945A125ST	V122
KDMT05002ERGC KC515M	V134
KDMT05002ERGN KC515M	V134
KDMT05004ERGC KC515M	V134
KDMT05004ERGN KC515M	V134
KDMT0500R512A050SN	V132
KDMT0500R591A050SN	V132
KDMT0500R630A050HNC	V133
KDMT06254ERGN KC515M	V134
KDMT0625R630A063SN	V132
KDMT07502ERGC KC515M	V134
KDMT07502ERGN KC515M	V134
KDMT07504ERGN KC515M	V134
KDMT0750R630A075SN	V132
KDMT0750R748A075HNC	V133
KDMT0750R827A075SN	V132
KDMT0750SRHF KC515M	V135
KDMT10002ERGC KC515M	V134
KDMT10004ERGC KC515M	V134
KDMT1000R630A100SN	V132
KDMT1000R906A100SN	V132
KDR100R1003C100L600	V46
KDR100R1003M12L125	V44
KDR100R1003W100L200	V45
KDR125R1202C125L900	V53
KDR125R1202W100L200	V52
KDR150R1005S050L157	V47
KDR150R1204M16L150	V51
KDR150R1204S050L157	V54
KDR200R1006S075L200	V47
KDR200R1204S075L200	V54
KDR200R1205S075L200	V54
KDR200R1604S075L200	V58
KDR250R1207S075L200	V54
KDR300R1208S100L200	V54
KDR300R1208S125L200	V54
KDR300R1607S100L200	V58
KDR300R1607S125L200	V58
KDR400R1606S150L200	V58
KDR400R1608S150L200	V58
KDR40Z04S16RN12X	V62
KDR500R1608S150L200	V58
KDR50Z05S22RN12X	V62
KDR63Z06S22RN12X	V62
KDR80Z07S27RN12X	V62
KF2X100W0902C100L600	V37
KF2X100W0902C100L800	V37
KF2X100W0902M12L138	V36
KF2X125W0903C125L600	V37
KF2X125W0903C125L800	V37
KF2X125W0903M16L169	V36
KF2X150W0903C125L600	V37
KF2X150W0903C125L800	V37
KF2X150W0904M16L169	V36
KF2X150W0904S050L157	V38
KF2X200W0905S075L157	V38
KF2X200W0906S075L157	V38
KF2X250W0906S075L175	V38
KF2X300W0907S100L175	V38
KG2508ELDJ KC410M	T93
KG2512ELDJ KC410M	T93
KG2516ELDJ KC410M	T93
KG2520ELDJ KC410M	T93
KG2531ELDJ KC410M	T93
KG2540ELDJ KC410M	T93
KG2550ELDJ KC410M	T93
KG2564ELDJ KC410M	T93
KGEM0750R1SS075	H100
KGEM0750R3SS075	H100
KGEM1588R1WN20M	H100
KGEM1905R1WN20M	H100
KGEM1905R3WN20M	H100
KGIP0125N0189GD KCU45	H101
KGIP0300N0189GD KCU45	H101
KGMEL1650C	C67
KGMEL1650N	C145
KGMEL1665C	C67
KGMEL1665N	C145
KGMEL2050C	C67
KGMEL2050N	C145
KGMEL2065C	C67
KGMEL2065N	C145
KGMEL2450C	C67
KGMEL2465C	C67
KGMEL2465N	C145
KGMEL2525M50	C145
KGMEL2525M50C	C68
KGMEL2525M65	C145
KGMEL2525M65C	C68
KGMEL3232P50	C145
KGMEL3232P50C	C68
KGMEL3232P65	C145
KGMEL3232P65C	C68
KGMER1650C	C67
KGMER1650N	C145
KGMER1665C	C67

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KGMER1665N	C145
KGMER2050C	C67
KGMER2050N	C145
KGMER2065C	C67
KGMER2065N	C145
KGMER2450C	C67
KGMER2450N	C145
KGMER2465C	C67
KGMER2525M50	C145
KGMER2525M50C	C68
KGMER2525M65	C145
KGMER2525M65C	C68
KGMER3232P50	C145
KGMER3232P50C	C68
KGMER3232P65	C145
KGMER3232P65C	C68
KGMSL1650C	C65
KGMSL1650N	C143
KGMSL1665C	C65
KGMSL1665N	C143
KGMSL2050C	C65
KGMSL2050N	C143
KGMSL2065C	C65
KGMSL2065N	C143
KGMSL2450C	C65
KGMSL2450N	C143
KGMSL2465C	C65
KGMSL2465N	C143
KGMSL2525M50	C144
KGMSL2525M50C	C66
KGMSL2525M65	C144
KGMSL2525M65C	C66
KGMSL3232P50	C144
KGMSL3232P50C	C66
KGMSL3232P65	C144
KGMSL3232P65C	C66
KGMSR1650C	C65
KGMSR1650N	C143
KGMSR1665C	C65
KGMSR1665N	C143
KGMSR2050C	C65
KGMSR2050N	C143
KGMSR2065C	C65
KGMSR2065N	C143
KGMSR2450C	C65
KGMSR2450N	C143
KGMSR2465C	C65
KGMSR2465N	C143
KGMSR2525M50	C144
KGMSR2525M50C	C66
KGMSR2525M65	C144
KGMSR2525M65C	C66
KGMSR3232P50	C144
KGMSR3232P50C	C66
KGMSR3232P65	C144
KGMSR3232P65C	C66
KHDA0250J6ANA KC639M	P143
KHDA0312J6ANA KC639M	P143
KHDA0375J6ANA KC639M	P143
KHDA0500J6ANA KC639M	P143
KHDA0625J6ANA KC639M	P143
KHDA0750J6ANA KC639M	P143
KHSST08003	M124
KHSST08015	M124
KHSST08039	M124
KHSST08043	M36
KHSST08044	M40
KHSST08061	M36
KHSST08067	M124
KHSST08082	M124
KHSST08083	M127
KHSST08087	M124
KHSST08088	M127
KHSST08090	M36
KHSST08091	M40
KHSST08101	M124
KHSST08104	M36
KHSST08112	M124
KHSST08116	M124
KHSST08117	M127
KHSST08119	M36
KHSST08140	M124
KHSST08148	M124
KHSST08149	M127
KHSST08151	M124
KHSST08152	M127
KHSST08156	M36
KHSST08157	M36
KHSST08159	M40
KHSST08160	M40
KHSST08172	M124
KHSST08173	M127
KHSST08175	M36
KHSST08192	M124
KHSST08193	M127
KHSST08197	M127
KHSST08203	M36
KHSST08205	M36
KHSST08218	M124
KHSST08234	M124
KHSST08235	M127
KHSST08238	M124
KHSST08239	M127
KHSST08243	M36
KHSST08245	M36
KHSST08246	M40
KHSST08261	M124
KHSST08262	M127
KHSST08268	M124
KHSST08269	M127
KHSST08272	M124
KHSST08273	M127
KHSST08280	M36
KHSST08282	M36
KHSST08294	M124
KHSST08295	M127
KHSST08296	M36
KHSST08316	M125
KHSST08317	M128
KHSST08320	M125
KHSST08321	M128
KHSST08324	M125
KHSST08327	M128
KHSST08331	M36
KHSST08332	M36
KHSST08333	M40
KHSST08334	M36
KHSST08336	M36
KHSST08353	M125
KHSST08354	M128
KHSST08355	M125
KHSST08356	M128
KHSST08364	M36
KHSST08380	M125
KHSST08381	M128
KHSST08391	M36
KHSST08392	M128
KHSST08393	M36
KHSST08409	M125
KHSST08411	M125
KHSST08419	M36
KHSST08434	M125
KHSST08435	M128
KHSST08443	M36
KHSST08444	M36
KHSST08459	M125
KHSST08460	M128
KHSST08461	M125
KHSST08467	M36
KHSST08477	M125
KHSST08478	M128
KHSST08484	M36
KHSST08493	M125
KHSST08494	M128
KHSST08498	M36
KHSST08508	M125
KHSST08510	M125
KHSST08516	M36
KHSST08530	M125
KHSST08531	M128
KHSST08537	M36
KHSST08545	M125
KHSST08546	M128
KHSST08553	M125
KHSST08554	M128
KHSST08561	M125
KHSST08562	M128
KHSST08566	M36
KHSST08574	M125
KHSST08575	M128
KHSST08578	M36
KHSST08595	M125–126
KHSST08596	M128
KHSST08599	M36
KHSST08608	M126
KHSST08609	M128
KHSST08616	M126
KHSST08617	M128–129
KHSST08630	M126
KHSST08631	M129
KHSST08703	M157
KHSST08704	M157
KHSST08705	M157
KHSST08709	M157
KHSST08712	M157
KHSST08715	M157
KHSST08724	M157
KHSST09000	M124
KHSST09003	M127
KHSST09004	M124
KHSST09008	M124
KHSST09009	M127
KHSST09010	M124
KHSST09011	M127
KHSST09012	M124
KHSST09013	M127
KHSST09014	M124
KHSST09015	M127
KHSST09018	M125
KHSST09019	M128
KHSST09021	M128
KHSST09022	M125
KHSST09025	M128–129
KHSST09026	M125
KHSST09027	M128
KHSST09028	M125
KHSST09029	M128
KHSST09030	M125
KHSST09035	M128
KHSST09039	M128
KHSST09041	M128
KHSST09042	M126
KHSST09043	M128
KHSST09047	M129
KHSST09048	M126
KHSST09054	M130
KHSST09101	M36
KHSST09103	M36
KHSST09104	M36
KHSST09105	M36
KHSST09106	M36
KHSST09108	M36
KHSST09109	M36
KHSST09111	M36
KHSST09112	M36
KHSST09113	M36
KHSST09114	M36
KHSST09115	M36
KHSST09116	M36
KHSST09119	M36
KHSST09120	M36
KHSST09121	M36
KHSST09122	M36
KHSST09123	M36
KHSST09124	M36
KHSST09125	M36
KHSST09126	M36
KHSST09127	M36
KHSST09128	M36
KHSST09129	M41
KHSST09130	M41
KHSST09131	M41
KHSST09132	M41
KHSST09133	M41
KHSST09135	M41
KHSST09137	M157
KHSST09140	M157
KHSST09143	M157
KHSST09147	M157
KHSST09151	M157
KHSST09608	M36
KHSST09609	M36
KHSST09611	M36
KHSST09615	M36
KHSST27709	M130
KHSST27710	M131
KHSST27711	M41
KHSST27719	M41
KHSST27721	M130
KHSST27722	M131
KHSST27723	M41
KHSST27729	M130
KHSST27730	M131
KHSST27731	M41
KHSST27737	M130
KHSST27738	M131
KHSST27739	M41
KHSST27741	M130
KHSST27742	M131
KHSST27743	M41
KHSST27749	M130
KHSST27750	M131
KHSST27751	M41
KHSST27757	M130
KHSST27758	M131
KHSST27759	M41
KHSST27765	M130
KHSST27766	M131
KHSST27767	M41
KHSST27773	M130
KHSST27781	M130
KHSST27787	M41
KHSST27793	M130
KHSST27796	M130
KHSST27798	M41
KHSST27800	M130
KHSST27809	M130
KHSST28002	M157
KHSST28003	M128–129
KHSST28004	M126
KHSST28008	M129
KHSST28009	M126
KHSST28015	M129
KHSST28016	M126
KHSST28020	M129
KHSST28021	M126
KHSST28028	M129
KHSST28029	M126
KHSST28032	M129
KHSST28033	M126
KHSST28040	M126
KHSST28043	M126
KHSST28047	M102
KHSST28048	M104
KHSST28049	M102
KHSST28053	M132
KHSST28057	M158
KHSST28058	M158
KHSST28060	M157
KHSST28062	M102
KHSST28064	M132
KHSST28067	M158
KHSST28068	M158
KHSST28072	M38
KHSST28073	M104
KHSST28074	M102
KHSST28077	M134
KHSST28078	M133
KHSST28080	M38
KHSST28081	M102
KHSST28082	M104
KHSST28083	M102
KHSST28085	M133
KHSST28086	M132
KHSST28091	M158
KHSST28092	M158
KHSST28093	M158
KHSST28094	M158

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KHSST28102	M128
KHSST28104	M158
KHSST28106	M157
KHSST28107	M157
KHSST28109	M157
KHSST28111	M36
KHSST28112	M36
KHSST28113	M36
KHSST28114	M129
KHSST28115	M126
KHSST28116	M125
KHSST28117	M128
KHSST28118	M126
KHSST28119	M128
KHSST28120	M125
KHSST28121	M125
KHSST28122	M128
KHSST28123	M125
KHSST28124	M129
KHSST28125	M126
KHSST28127	M125
KHSST28128	M127
KHSST28129	M124
KHSST28130	M127
KHSST28131	M127
KHSST28132	M124
KHSST28133	M127
KHSST28134	M124
KHSST28135	M127
KHSST28136	M124
KHSST28137	M102
KHSST28139	M157
KHSST28140	M157
KHSST28141	M157
KHSST28142	M157
KHSST28152	M41
KHSST28162	M39
KHSST28163	M104
KHSST28165	M102
KHSST28167	M132
KHSST28172	M158
KHSST28173	M158
KHSST28177	M157
KHSST28178	M157
KHSST28181	M157
KHSST28184	M132
KHSST28187	M102
KHSST28188	M104
KHSST28189	M102
KHSST28192	M38
KHSST28194	M134
KHSST28195	M133
KHSST28196	M158
KHSST28197	M158
KHSST28201	M102
KHSST28204	M38
KHSST28207	M132
KHSST28209	M38
KHSST28210	M102
KHSST28211	M102
KHSST28212	M104
KHSST28213	M102
KHSST28217	M134
KHSST28218	M133
KHSST28219	M40
KHSST28220	M38
KHSST28221	M102
KHSST28223	M102
KHSST28226	M134
KHSST28228	M39
KHSST28231	M102
KHSST28233	M132
KHSST28235	M128–129
KHSST28239	M132
KHSST28242	M125–126
KHSST28244	M36
KHSST28245	M36
KHSST28246	M37
KHSST28247	M37
KHSST28248	M36
KHSST28249	M36
KHSST28250	M37
KHSST28251	M37
KHSST28252	M36
KHSST28253	M36
KHSST28254	M36
KHSST28255	M36
KHSST28256	M36
KHSST28257	M36
KHSST28258	M36
KHSST28259	M36
KHSST28260	M36
KHSST28261	M36
KHSST28262	M36
KHSST28263	M36
KHSST28264	M36
KHSST28265	M36
KHSST28266	M36
KHSST28267	M36
KHSST28268	M36
KHSST28269	M36
KHSST28270	M36
KHSST28271	M36
KHSST28272	M36
KHSST28273	M36
KHSST28274	M36
KHSST28275	M36
KHSST28276	M36
KHSST28277	M36
KHSST28278	M129
KHSST28279	M126
KHSST28281	M126
KHSST28282	M129
KHSST28283	M126
KHSST28286	M126
KHSST28287	M128
KHSST28289	M128
KHSST28290	M128
KHSST28291	M125
KHSST28293	M125
KHSST28294	M128
KHSST28295	M128
KHSST28296	M125
KHSST28298	M125
KHSST28301	M128
KHSST28302	M126
KHSST28304	M128
KHSST28305	M126
KHSST28308	M128
KHSST28309	M125
KHSST28311	M128
KHSST28313	M128
KHSST28314	M125
KHSST28317	M128
KHSST28318	M125
KHSST28319	M128
KHSST28323	M125
KHSST28329	M129
KHSST28330	M126
KHSST28338	M129
KHSST28339	M126
KHSST28340	M128
KHSST28341	M125
KHSST28342	M128
KHSST28343	M125
KHSST28344	M128
KHSST28345	M126
KHSST28346	M126
KHSST28347	M128
KHSST28348	M125
KHSST28349	M125
KHSST28350	M128
KHSST28351	M125
KHSST28352	M126
KHSST28353	M128
KHSST28356	M125
KHSST28358	M125
KHSST28359	M125
KHSST28361	M125
KHSST28364	M125
KHSST28365	M126
KHSST28366	M125
KHSST28368	M127
KHSST28371	M127
KHSST28372	M124
KHSST28373	M127
KHSST28374	M127
KHSST28375	M127
KHSST28376	M124
KHSST28379	M127
KHSST28380	M124
KHSST28384	M127
KHSST28388	M127
KHSST28389	M124
KHSST28394	M127
KHSST28395	M127
KHSST28396	M124
KHSST28397	M124
KHSST28399	M127
KHSST28400	M124
KHSST28401	M124
KHSST28403	M127
KHSST28406	M127
KHSST28407	M124
KHSST28410	M124
KHSST28412	M127
KHSST28413	M124
KHSST28416	M127
KHSST28417	M124
KHSST28419	M127
KHSST28420	M127
KHSST28423	M127
KHSST28425	M124
KHSST28426	M124
KHSST28427	M124
KHSST28428	M124
KHSST28429	M127
KHSST28433	M124
KHSST28440	M124
KHSST28443	M157
KHSST28444	M157
KHSST28445	M157
KHSST28446	M157
KHSST28447	M41
KHSST28448	M41
KHSST28455	M131
KHSST28458	M131
KHSST28462	M131
KHSST28465	M131
KHSST28476	M103
KHSST28478	M103
KHSST28526	M39
KHSST28527	M39
KHSST28528	M39
KHSST28529	M39
KHSST28531	M39
KHSST28532	M39
KHSST28534	M39
KHSST28670	M102
KHSST28671	M104
KHSST28672	M102
KHSST28674	M102
KHSST28675	M132
KHSST28681	M41
KHSST28682	M130
KHSST28683	M103
KHSST28692	M103
KHSST28695	M130
KHSST28698	M130
KHSST28700	M103
KHSST28707	M103
KHSST28709	M103
KHSST28716	M103
KHSST28721	M103
KHSST28723	M103
KHSST28726	M103
KHSST28730	M40
KHSST28731	M36
KHSST28732	M36
KHSST28733	M36
KHSST28737	M38
KHSST28738	M102
KHSST28739	M104
KHSST28740	M102
KHSST28742	M133
KHSST28743	M40
KHSST28744	M38
KHSST28745	M102
KHSST28746	M104
KHSST28747	M102
KHSST28751	M134
KHSST28752	M133
KHSST28757	M36
KHSST28761	M102
KHSST28762	M102
KHSST28774	M102
KHSST28776	M38
KHSST28779	M102
KHSST28780	M104
KHSST28781	M133
KHSST28784	M38
KHSST28785	M102
KHSST28786	M104
KHSST28787	M102
KHSST28791	M133
KIPR062RP21229	V156
KIPR075RP21332	V156
KIPR100RP32438	V156
KIPR100RP32M1203	V155
KIPR125RP43540	V156
KIPR125RP43555	V156
KIPR125RP43M1603	V155
KIPR150RP43655	V156
KISBR150SP10T30F	T107
KISBR200SP10T30F	T107
KISR075SP10T30F	T108
KISR100SP10T30F	T108
KISR125SP10T30F	T108
KISR150SP10T30F	T108
KISZR125SD430C4A02	V140
KISZR150SD430C5A03	V140
KISZR200SD430C6A04	V140
KL23	B132, B134–136
KL33	B63, B71
KL33L	B93, B96, B139, B143, B163
KL34	B111, B113
KL34L	B63, B89–90, B96, B98, B132–137, B139, B143, B152–155
KL44	B69, B71, B76, B114
KL46	B60–65, B69–71, B75–76, B98, B111–113, B120, B132–139, B143, B152–155, B163
KL46L	B66, B89–90, B92–93, B96, B99, B371
KL58	B61–65, B69, B71, B75–76, B89–90, B111–113, B133–137
KL68	B61–65, B71, B75–76, B98, B111–114, B120
KL68L	B134, B137
KL810	B63–64, B98, B111–112
KLM33	B72, B115–119
KLM33L	B94, B140–142
KLM34L	B140–142
KLM43	B72–74, B115–119
KLM46	B72, B74, B94–95, B140–142
KLM46S	B72–74, B94–95, B115–117, B119
KLM54	B115–117, B119
KLM58	B74
KLM68	B74, B115, B119
KLS20C	T78
KLSS0714C	S30, S32, V19, V26
KM25LSEL1630	D77
KM25LSER1630	D77
KM25LSSL1630	D77
KM25LSSL2230	D77
KM25LSSR1630	D77
KM25LSSR2230	D77
KM25NEL330	D30
KM25NEL430	D30
KM25NER230	D30
KM25NER330	D30
KM25NER430	D30
KM25NSL230	D30
KM25NSL330	D30
KM25NSL430	D30
KM25NSR230	D30
KM25NSR330	D30
KM32FBHS24	K137
KM32FBHS31	K137

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KM32RBHT24	K122
KM32RBHT30	K122
KM40FBHO1660	K128
KM40FBHS40	K137
KM40RBHT40	K122
KM40TSAVS00B111MCLB	K82
KM40TSAVS0B128MCLB	K82
KM40TSAVS1B112MCLB	K82
KM40TSAVS2B127MCLB	K82
KM40TSE16JNEL2 KWH	D40
KM40TSE16JNER2 KWH	D40
KM40TSKGMEL50C	C70, C147
KM40TSKGMER50C	C70, C147
KM40TSKGMSL50C	C69, C146
KM40TSKGMSR50C	C69, C146
KM40TSLSEL16N	D79
KM40TSLSER16N	D79
KM40TSLSER22N	D79
KM40TSLSER27N	D79
KM40TSLSSL16	D78
KM40TSLSSL22	D78
KM40TSLSSL27	D78
KM40TSLSSR16	D78
KM40TSLSSR22	D78
KM40TSLSSR27	D78
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
KM40TSS12ENEL2	D39
KM40TSS12ENER2	D39
KM40TSS16FNEL2	D39
KM40TSS16FNER2	D39
KM40TSS20GNEL2	D39
KM40TSS20GNER2	D39
KM40TSS25ENEL2	D39
KM40TSS25ENEL3	D39
KM40TSS25ENER2	D39
KM40TSS25ENER3	D39
KM40TSS25HNEL3	D39
KM40TSS25HNER2	D39
KM40TSS25HNER3	D39
KM40TSS32GNEL3	D39
KM40TSS32GNER3	D39
KM40TSS32JNER3	D39
KM4X100NEL3	D32
KM4X100NEL4	D32
KM4X100NEL5	D32
KM4X100NEL6	D32
KM4X100NER3	D32
KM4X100NER4	D32
KM4X100NER5	D32
KM4X100NER6	D32
KM4X63KGMEL50C	C71, C149
KM4X63KGMEL65C	C71, C149
KM4X63KGMER50C	C71, C149
KM4X63KGMER65C	C71, C149
KM4X63KGMSL50C	C71, C148–149
KM4X63KGMSL65C	C71, C148
KM4X63KGMSR50C	C71, C148–149
KM4X63KGMSR65C	C71, C148
KM50FBHO1670	K128
KM50FBHS51	K137
KM50FBHS67	K137
KM50FBHS87	K137
KM50RBHT50	K122
KM50RBHT66	K122
KM50RBHT87	K122
KM50SVS4B125M	K84
KM50SVS5B125M	K84
KM50TSAVS00B117MCLB	K82
KM50TSAVS0B134MCLB	K82
KM50TSAVS1B118MCLB	K82
KM50TSAVS2B128MCLB	K82
KM50TSAVS3B128MCLB	K82
KM50TSFBHM1677	K132
KM50TSFBHMKIT164M	K127, K131
KM50TSKGMEL50C	C70, C147
KM50TSKGMEL65C	C70, C147
KM50TSKGMER50C	C70, C147
KM50TSKGMER65C	C70, C147
KM50TSKGMSL50C	C69, C146
KM50TSKGMSL65C	C69, C146
KM50TSKGMSR50C	C69, C146
KM50TSKGMSR65C	C69, C146
KM50TSSVUBB2100MCLB	K77
KM63BT13065	K141
KM63SVS4B110M	K84
KM63SVS5B110M	K84
KM63TSAVS3B130MCLB	K82
KM63TSKGMEL50C	C70, C147
KM63TSKGMEL65C	C70, C147
KM63TSKGMER50C	C70, C147
KM63TSKGMER65C	C70, C147
KM63TSKGMSL50C	C69, C146
KM63TSKGMSL65C	C69, C146
KM63TSKGMSR50C	C69, C146
KM63TSKGMSR65C	C69, C146
KM63UTFBHS116	K137
KM63UTFBHS87	K137
KM63UTRBHT115	K122
KM63UTRBHT87	K122
KM63XMZKGMELF50CY	C70, C147
KM63XMZKGMELF65CY	C70, C147
KM63XMZKGMER50CY	C70, C147
KM63XMZKGMER65CY	C70, C147
KM63XMZKGMSLF50CY	C69, C146
KM63XMZKGMSLF50Y	C148
KM63XMZKGMSLF65Y	C148
KM63XMZKGMSR50CY	C69, C146
KM63XMZKGMSR50Y	C148
KM63XMZKR5060Y	K92
KM80ATCKGMEL50C	C70, C147
KM80ATCKGMEL65C	C70, C147
KM80ATCKGMER50C	C70, C147
KM80ATCKGMER65C	C70, C147
KM80ATCKGMSL50C	C69, C146
KM80ATCKGMSR50C	C69, C146
KM80BT13070	K141
KM80SVS6B150M	K84
KM80TSKGMEL50C	C70, C147
KM80TSKGMEL65C	C70, C147
KM80TSKGMER50C	C70, C147
KM80TSKGMER65C	C70, C147
KM80TSKGMSL50C	C69, C146
KM80TSKGMSL65C	C69, C146
KM80TSKGMSR50C	C69, C146
KM80TSKGMSR65C	C69, C146
KMDA0250J6ANA KC639M	P142
KMDA0312J6ANA KC639M	P142
KMDA0375J6ANA KC639M	P142
KMDA0500J6ANA KC639M	P142
KMDA0625J6ANA KC639M	P142
KMDA0750J6ANA KC639M	P142
KMSP315IP	B59, B87, B92, B113, B131, B150–151, B154, B163
KMSP415IP	B58–60, B67–68, B87–88, B91–92, B98, B109–110, B131, B150–151, B163
KMSP4S15IP	B68
KMSP515IP	B58–60, B67–68, B87
KMSP5S15IP	B68
KMSP625IP	B58–60, B68, B98, B109–110
KNUX160405L1 KCM15B	E35
KNUX160405L1 KCM25B	E35
KNUX160405L2 KU10	E35
KNUX160405R1 KCM15B	E35
KNUX160405R1 KCM25B	E35
KNUX160405R1 KCU25	E35
KNUX160405R2 KCM25B	E35
KNUX160410R1 KCM25B	E35
KNUX160410R2 KCM25B	E35
KR32AVS00B099MCLB	K82
KR32AVS0B116MCLB	K82
KR32AVS1B100MCLB	K82
KR32AVS2B115MCLB	K82
KR32AVS3B115MCLB	K82
KR32KR32038050M	K93
KR32KR32038100M	K93
KR32KR32047050M	K93
KR32KR32047100M	K93
KR32SVUBB1060MCLB	K76
KR32SVUBB2085MCLB	K77
KR50KR50065050M	K93
KR50KR50065100M	K93
KR50SVS4B094M	K83
KR50SVS5B094M	K83
KR50SVU65110MCLB	K88
KR50SVUBB2075MCLB	K77
KR63KR63085050M	K93
KR63KR63085100M	K93
KR63SVS6B126M	K83
KR80KR80095050M	K93
KR80KR80095100M	K93
KR80SVU92152MCLB	K88
KRBB10FABDRS204C	K78, K100
KRBB10SCFPR06085C	K78, K100
KRBB10SCFPR06110C	K78, K101
KRBB10SCFPR06135C	K78, K101
KRBB10SCLDR4060C	K78, K100
KRBB16SCFPR06085A	K79, K102
KRBB16SCFPR0611A	K79, K102
KRBB16SCFPR06135A	K79, K102
KRBB16SCFPR0616A	K79, K103
KRBB16SCFPR0619A	K79, K103
KRBB16SCFPR0622A	K79, K103
KRBB16SCLDRS406A	K79, K102
KRCSCFPR061A	K86
KRCSCFPR061B	K86
KRCSCFPR061C	K86
KRCSCFPR061D	K86
KRCSCFPR061E	K89, K108–109
KRCSCFPR061F	K89, K110–114
KRCSCFPR061L	K86
KRCSCFPR061W	K85
KRCSCFPR061X	K85
KRCSCFPR061Y	K85
KRCSCFPR062A	K86
KRCSCFPR062B	K86
KRCSCFPR062C	K86
KRCSCFPR062D	K86
KRCSCFPR062E	K89, K108–109
KRCSCFPR062F	K89, K110–114
KRCSCFPR062L	K86
KRCSCFPR062W	K85
KRCSCFPR062X	K85
KRCSCFPR062Y	K85
KRCSCFPR063A	K86
KRCSCFPR063B	K86
KRCSCFPR063C	K86
KRCSCFPR063D	K86
KRCSCFPR063E	K89, K108–109
KRCSCFPR063F	K89, K110–114
KRCSCFPR063L	K86
KRCSCFPR063W	K85
KRCSCFPR063X	K85
KRCSCFPR063Y	K85
KRCSTFPR113F	K90
KRCW032A	K80
KRDCKR32M	K91–93
KRDCKR50M	K91–93
KRDCKR63M	K91–93
KRDCKR80M	K91–93
KRDE025010M	K80
KRDE033010M	K80
KRDE043010M	K80
KRDE065012M	K80
KRDE070019M	K89, K108
KRDE083019M	K89, K108
KRDE096019M	K89, K109
KRDE101023M	K89, K110
KRDE120023M	K89, K110–111
KRDE139026M	K89, K111
KRDE156026M	K89, K112
KRDE175026M	K89, K113
KRDE193026M	K89, K114
KRDEA012AM	K79
KRDEA046AM	K79
KRDEA051AM	K79
KRM018030CLB004NE	K94
KS254BLNE1240	U18
KS255BLNE1245	U18
KS33SNH1103	U13
KS34LNE1240	U17
KS426SNH1102	U13
KS43SNH1103	U13
KS44BLNE1240	U18
KS44LNE1240	U17
KS45BLNE1245	U18
KS45LNE1245	U17
KS46BLNE1245	U18
KS46LNE1245	U17
KS48BLNE1255	U18
KS48LNE1255	U17
KS526SNH1102	U13
KS53SNH1103	U13
KS54LNE1240	U17
KS55LNE1245	U17
KS56LNE1245	U17
KS58LNE1255	U17
KS63SNH1103	U13
KS64LNE1240	U17
KS65LNE1245	U17
KS66LNE1245	U17
KS68LNE1255	U17
KS84LNE1240	U17
KS85LNE1245	U17
KS86LNE1245	U17
KS88LNE1255	U17
KSCM125R16CAB40U	S109
KSCMA90QFBF KD1400	S110
KSCMA90QFBF KD1420	S110
KSCMA90UNBF KD1400	S110
KSCMA90UNBF KD1420	S110
KSCMCA75HR KD1420	S111
KSCMCA75PT KD1420	S111
KSCMCA75QF KD1420	S111
KSCMCA75UN KD1420	S111
KSCMCA90QF KD1420	S110
KSCMCA90QFBF KD1420	S110
KSCMCA90UN KD1420	S110
KSCMCA90UNBF KD1420	S110
KSDR100031E0W0S KD1400	S105
KSDR100031E0W0S KD1425	S105
KSDR100031E0W4S KD1400	S105
KSDR100031E0W4S KD1425	S105
KSDR100031E1W4S KD1400	S105
KSDR100031E1W4S KD1425	S105
KSDR100031E3W4S KD1400	S106
KSDR100031E3W4S KD1425	S106
KSDR100093E1W4S KD1400	S105
KSDR100093E1W4S KD1425	S105
KSDR102S KD1400	S106
KSDR102S KD1425	S106
KSEM0493R1SSF075	H81
KSEM0493R1SSF075F45	H86
KSEM0500HP KC7315	H52
KSEM0500HPCCL KC7410	H60
KSEM0500HPG KC7315	H54
KSEM0500HPG KCPM45	H57
KSEM0500HPL KC7320	H62
KSEM0500R10SS075	H79
KSEM0500R3SS075	H77
KSEM0500R3SSF075	H82
KSEM0500R5SS050	H77
KSEM0500R5SS075	H77
KSEM0500R5SSF075	H82
KSEM0500R7SS050	H79
KSEM0500R7SS075	H79
KSEM0500SPL KCMS35	H64
KSEM0509HPCCL KC7410	H60
KSEM0509HPG KC7315	H54
KSEM0509HPG KCPM45	H57
KSEM0509HPL KC7320	H62
KSEM0509R10SS075	H79
KSEM0509R3SS075	H77
KSEM0509R3SSF075	H82

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KSEM0509R5SS075	H77
KSEM0509R5SSF075	H82
KSEM0509R7SS075	H79
KSEM0516HP KC7315	H52
KSEM0516HPCCL KC7410	H60
KSEM0516HPG KC7315	H54
KSEM0516HPL KC7320	H62
KSEM0516R10SS075	H79
KSEM0516R3SSF075	H82
KSEM0516R5SS075	H77
KSEM0516R5SSF075	H82
KSEM0516R7SS075	H79
KSEM0531R10SS075	H79
KSEM0531R3SS075	H77
KSEM0531R3SSF075	H82
KSEM0531R5SS075	H77
KSEM0531R5SSF075	H82
KSEM0531R7SS075	H79
KSEM0532R1SSF075	H81
KSEM0532R1SSF075F45	H86
KSEM0547HP KC7315	H52
KSEM0547HPCCL KC7410	H60
KSEM0547HPG KC7315	H54
KSEM0547HPG KCPM45	H57
KSEM0547HPL KC7320	H62
KSEM0547R10SS075	H79
KSEM0547R3SS075	H77
KSEM0547R3SSF075	H82
KSEM0547R5SS075	H77
KSEM0547R5SSF075	H82
KSEM0547R7SS075	H79
KSEM0563HP KC7315	H52
KSEM0563HPCCL KC7410	H60
KSEM0563HPG KC7315	H54
KSEM0563HPG KCPM45	H57
KSEM0563HPL KC7320	H62
KSEM0563R10SS075	H79
KSEM0563R3SS075	H77
KSEM0563R3SSF075	H82
KSEM0563R5SS075	H77
KSEM0563R5SSF075	H82
KSEM0563R7SS075	H79
KSEM0563SPL KCMS35	H64
KSEM0571R1SSF075	H81
KSEM0571R1SSF075F45	H86
KSEM0578HP KC7315	H52
KSEM0578HPCCL KC7410	H60
KSEM0578HPG KC7315	H54
KSEM0578HPG KCPM45	H57
KSEM0578HPL KC7320	H62
KSEM0578R10SS075	H79
KSEM0578R3SS075	H77
KSEM0578R3SSF075	H82
KSEM0578R5SS075	H77
KSEM0578R5SSF075	H82
KSEM0578R7SS075	H79
KSEM0594HP KC7315	H52
KSEM0594HPG KC7315	H54
KSEM0594HPG KCPM45	H57
KSEM0594HPL KC7320	H62
KSEM0594R10SS075	H79
KSEM0594R3SS075	H77
KSEM0594R3SSF075	H82
KSEM0594R5SS075	H77
KSEM0594R5SSF075	H82
KSEM0594R7SS075	H79
KSEM0609HPCCL KC7410	H60
KSEM0609HPG KC7315	H54
KSEM0609HPL KC7320	H62
KSEM0609R10SS075	H79
KSEM0609R3SS075	H77
KSEM0609R3SSF075	H82
KSEM0609R5SS075	H77
KSEM0609R5SSF075	H82
KSEM0609R7SS075	H79
KSEM0625HP KC7315	H52
KSEM0625HPCCL KC7410	H60
KSEM0625HPG KC7315	H54
KSEM0625HPG KCPM45	H57
KSEM0625HPL KC7320	H62
KSEM0625R10SS075	H79
KSEM0625R1SSF075	H81
KSEM0625R1SSF075F45	H86
KSEM0625R3SS075	H77
KSEM0625R3SSF075	H82
KSEM0625R5SS075	H77
KSEM0625R5SSF075	H82
KSEM0625R7SS075	H79
KSEM0625R8SSF075	H84
KSEM0625SPL KCMS35	H64
KSEM0634HP KC7315	H52
KSEM0634HPCCL KC7410	H60
KSEM0634HPG KC7315	H54
KSEM0634HPG KCPM45	H57
KSEM0634HPL KC7320	H62
KSEM0634R10SS075	H79
KSEM0634R3SS075	H77
KSEM0634R3SSF075	H82
KSEM0634R5SS075	H77
KSEM0634R7SS075	H79
KSEM0634SPL KCMS35	H64
KSEM0641HP KC7315	H52
KSEM0641HPCCL KC7410	H60
KSEM0641HPG KC7315	H54
KSEM0641HPG KCPM45	H57
KSEM0641HPL KC7320	H62
KSEM0641R3SS075	H77
KSEM0641R3SSF075	H82
KSEM0641R5SS075	H77
KSEM0641SPL KCMS35	H64
KSEM0656HP KC7315	H52
KSEM0656HPCCL KC7410	H60
KSEM0656HPG KC7315	H54
KSEM0656HPG KCPM45	H57
KSEM0656HPL KC7320	H62
KSEM0656R10SS075	H79
KSEM0656R3SS075	H77
KSEM0656R5SS075	H77
KSEM0656R7SS075	H79
KSEM0656SPL KCMS35	H64
KSEM0672HP KC7315	H52
KSEM0672HPCCL KC7410	H60
KSEM0672HPG KC7315	H54
KSEM0672HPG KCPM45	H57
KSEM0672HPL KC7320	H62
KSEM0672R3SS075	H77
KSEM0672R3SSF075	H82
KSEM0672R5SS075	H77
KSEM0688HP KC7315	H52
KSEM0688HPCCL KC7410	H60
KSEM0688HPG KC7315	H54
KSEM0688HPG KCPM45	H57
KSEM0688HPL KC7320	H62
KSEM0688R10SS075	H79
KSEM0688R3SS075	H77
KSEM0688R3SSF075	H82
KSEM0688R5SS075	H77
KSEM0688R5SSF075	H82
KSEM0688R7SS075	H79
KSEM0688R8SSF075	H84
KSEM0688SPL KCMS35	H64
KSEM0703HP KC7315	H52
KSEM0703HPG KC7315	H54
KSEM0703HPG KCPM45	H57
KSEM0703HPL KC7320	H62
KSEM0703R3SS075	H77
KSEM0703R3SSF075	H82
KSEM0703R5SS075	H77
KSEM0709R1SSF075	H81
KSEM0709R1SSF075F45	H86
KSEM0719HP KC7315	H52
KSEM0719HPCCL KC7410	H60
KSEM0719HPG KC7315	H54
KSEM0719HPG KCPM45	H57
KSEM0719HPL KC7320	H62
KSEM0719R10SS075	H79
KSEM0719R3SS075	H77
KSEM0719R5SS075	H77
KSEM0719R7SS075	H79
KSEM0734HP KC7315	H52
KSEM0734HPG KC7315	H54
KSEM0734HPG KCPM45	H57
KSEM0734HPL KC7320	H62
KSEM0734R3SS075	H77
KSEM0734R3SSF075	H82
KSEM0734R5SS075	H77
KSEM0750FEG KCPM45	H67
KSEM0750HP KC7315	H52
KSEM0750HPCCL KC7410	H60
KSEM0750HPG KC7315	H54
KSEM0750HPG KCPM45	H57
KSEM0750HPL KC7320	H62
KSEM0750R10SS075	H79
KSEM0750R10SS100	H79
KSEM0750R3SS075	H77
KSEM0750R3SS100	H77
KSEM0750R3SSF075	H82
KSEM0750R3SSF100	H82
KSEM0750R5SS075	H77
KSEM0750R5SS100	H77
KSEM0750R5SSF075	H82
KSEM0750R5SSF100	H82
KSEM0750R7SS075	H79
KSEM0750R7SS100	H79
KSEM0750R8SSF075	H84
KSEM0750R8SSF100	H84
KSEM0750SPL KCMS35	H64
KSEM0757HP KC7315	H52
KSEM0757HPG KCPM45	H57
KSEM0757HPL KC7320	H62
KSEM0757SPL KCMS35	H64
KSEM0758HPG KC7315	H54
KSEM0758HPG KCPM45	H57
KSEM0758HPL KC7320	H62
KSEM0758SPL KCMS35	H64
KSEM0759HP KC7315	H52
KSEM0759HPCCL KC7410	H60
KSEM0759HPG KC7315	H54
KSEM0759HPG KCPM45	H57
KSEM0759HPL KC7320	H62
KSEM0759R10SS100	H79
KSEM0759R3SS075	H77
KSEM0759R3SSF100	H82
KSEM0759R5SS075	H77
KSEM0759R7SS075	H79
KSEM0759SPL KCMS35	H64
KSEM0766HP KC7315	H52
KSEM0766HPCCL KC7410	H60
KSEM0766HPG KC7315	H54
KSEM0766HPG KCPM45	H57
KSEM0766HPL KC7320	H62
KSEM0766R3SS100	H77
KSEM0766R3SSF100	H82
KSEM0766R5SS100	H77
KSEM0766SPL KCMS35	H64
KSEM0781FEG KCPM45	H67
KSEM0781HP KC7315	H52
KSEM0781HPCCL KC7410	H60
KSEM0781HPG KC7315	H54
KSEM0781HPG KCPM45	H57
KSEM0781HPL KC7320	H62
KSEM0781R10SS100	H79
KSEM0781R3SS100	H77
KSEM0781R3SSF100	H82
KSEM0781R5SS100	H77
KSEM0781R7SS100	H79
KSEM0781SPL KCMS35	H64
KSEM0788R1SSF100	H81
KSEM0788R1SSF100F45	H86
KSEM0797HP KC7315	H52
KSEM0797HPCCL KC7410	H60
KSEM0797HPG KC7315	H54
KSEM0797HPG KCPM45	H57
KSEM0797HPL KC7320	H62
KSEM0797R3SS100	H77
KSEM0797R3SSF100	H82
KSEM0797R5SS100	H77
KSEM0797SPL KCMS35	H64
KSEM0813HP KC7315	H52
KSEM0813HPCCL KC7410	H60
KSEM0813HPG KC7315	H54
KSEM0813HPG KCPM45	H57
KSEM0813HPL KC7320	H62
KSEM0813R10SS100	H79
KSEM0813R3SS100	H77
KSEM0813R3SSF100	H82
KSEM0813R5SS100	H77
KSEM0813R5SSF100	H82
KSEM0813R7SS100	H79
KSEM0813R8SSF100	H84
KSEM0813SPL KCMS35	H64
KSEM0844HP KC7315	H52
KSEM0844HPCCL KC7410	H60
KSEM0844HPG KC7315	H55
KSEM0844HPG KCPM45	H57
KSEM0844HPL KC7320	H62
KSEM0844R10SS100	H79
KSEM0844R3SS100	H77
KSEM0844R5SS100	H77
KSEM0844R7SS100	H79
KSEM0859HP KC7315	H52
KSEM0859HPG KC7315	H55
KSEM0859HPG KCPM45	H57
KSEM0859HPL KC7320	H62
KSEM0859R3SS100	H77
KSEM0859R3SSF100	H82
KSEM0859R5SS100	H77
KSEM0867R1SSF100	H81
KSEM0867R1SSF100F45	H86
KSEM0875HP KC7315	H52
KSEM0875HPCCL KC7410	H60
KSEM0875HPG KC7315	H55
KSEM0875HPG KCPM45	H57
KSEM0875HPL KC7320	H62
KSEM0875R10SS100	H79
KSEM0875R3SS100	H77
KSEM0875R3SS125	H77
KSEM0875R3SSF100	H82
KSEM0875R3SSF125	H82
KSEM0875R5SS100	H77
KSEM0875R5SS125	H77
KSEM0875R5SSF100	H82
KSEM0875R5SSF125	H82
KSEM0875R7SS100	H79
KSEM0875R7SS125	H79
KSEM0875R8SSF100	H84
KSEM0875R8SSF125	H84
KSEM0875SPL KCMS35	H64
KSEM0884HP KC7315	H52
KSEM0884HPCCL KC7410	H60
KSEM0884HPG KC7315	H55
KSEM0884HPG KCPM45	H57
KSEM0884HPL KC7320	H62
KSEM0884R10SS100	H79
KSEM0884R3SS100	H77
KSEM0884R3SSF100	H82
KSEM0884R5SS100	H77
KSEM0884R7SS100	H79
KSEM0890HPG KC7315	H55
KSEM0906R10SS100	H79
KSEM0906R3SS100	H78
KSEM0906R3SSF100	H82
KSEM0906R5SS100	H78
KSEM0906R7SS100	H79
KSEM0922HP KC7315	H52
KSEM0922HPCCL KC7410	H60
KSEM0922HPG KC7315	H55
KSEM0922HPG KCPM45	H57
KSEM0922HPL KC7320	H62
KSEM0922R3SS100	H78
KSEM0922R3SSF100	H82
KSEM0922R5SS100	H78
KSEM0929HPG KCPM45	H57
KSEM0938HP KC7315	H52
KSEM0938HPCCL KC7410	H60
KSEM0938HPG KC7315	H55
KSEM0938HPG KCPM45	H57
KSEM0938HPL KC7320	H62
KSEM0938R10SS100	H79
KSEM0938R3SS100	H78
KSEM0938R3SSF100	H82
KSEM0938R5SS100	H78
KSEM0938R5SSF100	H82
KSEM0938R7SS100	H79
KSEM0938R8SSF100	H84
KSEM0938SPL KCMS35	H64
KSEM0945R1SSF100	H81
KSEM0945R1SSF100F45	H86

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KSEM0969HP KC7315	H52
KSEM0969HPCCL KC7410	H60
KSEM0969HPG KC7315	H55
KSEM0969HPG KCPM45	H58
KSEM0969HPL KC7320	H62
KSEM0969R10SS100	H79
KSEM0969R3SS100	H78
KSEM0969R3SSF100	H82
KSEM0969R5SS100	H78
KSEM0969R5SSF100	H82
KSEM0969R7SS100	H79
KSEM0984R10SS100	H79
KSEM0984R3SS100	H78
KSEM0984R3SSF100	H82
KSEM0984R5SS100	H78
KSEM0984R5SSF100	H82
KSEM0984R7SS100	H79
KSEM0984R8SSF100	H84
KSEM1000FEG KCPM45	H67
KSEM1000HP KC7315	H52
KSEM1000HPCCL KC7410	H60
KSEM1000HPG KC7315	H55
KSEM1000HPG KCPM45	H58
KSEM1000HPL KC7320	H62
KSEM1000R10SS100	H79
KSEM1000R10SS125	H79
KSEM1000R3SS100	H78
KSEM1000R3SSF100	H83
KSEM1000R3SSF125	H83
KSEM1000R5SS100	H78
KSEM1000R5SS125	H78
KSEM1000R5SSF100	H83
KSEM1000R5SSF125	H83
KSEM1000R7SS100	H79
KSEM1000R7SS125	H79
KSEM1000R8SSF100	H84
KSEM1000R8SSF125	H84
KSEM1000SPL KCMS35	H64
KSEM1008HP KC7315	H52
KSEM1008HPG KC7315	H55
KSEM1008HPG KCPM45	H58
KSEM1008HPL KC7320	H62
KSEM1008SPL KCMS35	H64
KSEM1010HPG KC7315	H55
KSEM1010HPG KCPM45	H58
KSEM1011HP KC7315	H52
KSEM1011HPCCL KC7410	H60
KSEM1011HPG KC7315	H55
KSEM1011HPG KCPM45	H58
KSEM1011HPL KC7320	H63
KSEM1011R10SS125	H79
KSEM1011R3SS125	H78
KSEM1011R3SSF100	H83
KSEM1011R5SS125	H78
KSEM1011R7SS125	H79
KSEM1011SPL KCMS35	H64
KSEM1016FEG KCPM45	H67
KSEM1016HPG KCPM45	H58
KSEM1016HPL KC7320	H63
KSEM1016SPL KCMS35	H64
KSEM1024R1SSF125	H81
KSEM1024R1SSF125F45	H86
KSEM1031FEG KCPM45	H67
KSEM1031HP KC7315	H53
KSEM1031HPCCL KC7410	H60
KSEM1031HPG KC7315	H55
KSEM1031HPG KCPM45	H58
KSEM1031HPL KC7320	H63
KSEM1031R10SS125	H80
KSEM1031R3SS125	H78
KSEM1031R3SSF125	H83
KSEM1031R5SS125	H78
KSEM1031R7SS125	H80
KSEM1031SPL KCMS35	H64
KSEM1047HP KC7315	H53
KSEM1047HPCCL KC7410	H60
KSEM1047HPG KC7315	H55
KSEM1047HPG KCPM45	H58
KSEM1047HPL KC7320	H63
KSEM1047R3SSF125	H83
KSEM1047R5SS125	H78
KSEM1047SPL KCMS35	H64
KSEM1063R10SS125	H80
KSEM1063R3SS125	H78
KSEM1063R3SSF125	H83
KSEM1063R5SS125	H78
KSEM1063R5SSF125	H83
KSEM1063R7SS125	H80
KSEM1063R8SSF125	H84
KSEM1094HP KC7315	H53
KSEM1094HPCCL KC7410	H60
KSEM1094HPG KC7315	H55
KSEM1094HPG KCPM45	H58
KSEM1094HPL KC7320	H63
KSEM1094R10SS125	H80
KSEM1094R3SSF125	H83
KSEM1094R5SS125	H78
KSEM1094R7SS125	H80
KSEM1103R1SSF125	H81
KSEM1103R1SSF125F45	H86
KSEM1109HP KC7315	H53
KSEM1109HPCCL KC7410	H61
KSEM1109HPG KC7315	H55
KSEM1109HPG KCPM45	H58
KSEM1109HPL KC7320	H63
KSEM1109R3SS125	H78
KSEM1109R3SSF125	H83
KSEM1109R5SS125	H78
KSEM1125HP KC7315	H53
KSEM1125HPCCL KC7410	H61
KSEM1125HPG KC7315	H55
KSEM1125HPG KCPM45	H58
KSEM1125HPL KC7320	H63
KSEM1125R10SS125	H80
KSEM1125R3SS125	H78
KSEM1125R3SSF125	H83
KSEM1125R5SS125	H78
KSEM1125R5SSF125	H83
KSEM1125R7SS125	H80
KSEM1125R8SSF125	H84
KSEM1125SPL KCMS35	H65
KSEM1156HP KC7315	H53
KSEM1156HPCCL KC7410	H61
KSEM1156HPG KC7315	H55
KSEM1156HPG KCPM45	H58
KSEM1156HPL KC7320	H63
KSEM1156R10SS125	H80
KSEM1156R3SS125	H78
KSEM1156R3SSF125	H83
KSEM1156R5SS125	H78
KSEM1156R7SS125	H80
KSEM1172HP KC7315	H53
KSEM1172HPCCL KC7410	H61
KSEM1172HPG KC7315	H55
KSEM1172HPG KCPM45	H58
KSEM1172HPL KC7320	H63
KSEM1172R3SS125	H78
KSEM1172R5SS125	H78
KSEM1182R1SSF125	H81
KSEM1182R1SSF125F45	H86
KSEM1188HP KC7315	H53
KSEM1188HPCCL KC7410	H61
KSEM1188HPG KC7315	H55
KSEM1188HPG KCPM45	H58
KSEM1188HPL KC7320	H63
KSEM1188R10SS125	H80
KSEM1188R3SS125	H78
KSEM1188R3SSF125	H83
KSEM1188R5SS125	H78
KSEM1188R5SSF125	H83
KSEM1188R7SS125	H80
KSEM1188R8SSF125	H84
KSEM1203HPG KC7315	H55
KSEM1203R3SSF125	H83
KSEM1203R5SS125	H78
KSEM1219HP KC7315	H53
KSEM1219HPG KC7315	H55
KSEM1219HPG KCPM45	H58
KSEM1219R10SS125	H80
KSEM1219R3SS125	H78
KSEM1219R5SS125	H78
KSEM1219R7SS125	H80
KSEM1250FEG KCPM45	H67
KSEM1250HP KC7315	H53
KSEM1250HPCCL KC7410	H61
KSEM1250HPCCLM KC7410	H60
KSEM1250HPG KC7315	H55
KSEM1250HPG KCPM45	H58
KSEM1250HPGM KC7315	H54
KSEM1250HPGM KCPM45	H57
KSEM1250HPL KC7320	H63
KSEM1250HPLM KC7320	H62
KSEM1250HPM KC7315	H52
KSEM1250PCM KC7135	H70
KSEM1250R10SS125	H80
KSEM1250R10SS150	H80
KSEM1250R3SS125	H78
KSEM1250R3SS150	H78
KSEM1250R3SSF125	H83
KSEM1250R3SSF150	H83
KSEM1250R5SS125	H78
KSEM1250R5SS150	H78
KSEM1250R5SSF125	H83
KSEM1250R5SSF150	H83
KSEM1250R7SS125	H80
KSEM1250R7SS150	H80
KSEM1250R8SSF125	H84
KSEM1250R8SSF150	H84
KSEM1250SPL KCMS35	H65
KSEM1250SPLM KCMS35	H64
KSEM125R10WN16M	H75
KSEM125R1WN16F45M	H85–86
KSEM125R1WN16M	H72
KSEM125R3WN16M	H73
KSEM125R5WN16M	H73
KSEM125R7WN16M	H75
KSEM125SEFM	H87
KSEM1260HPGM KC7315	H54
KSEM1260R1SSF125	H81
KSEM1260R1SSF125F45	H86
KSEM1280HPGM KC7315	H54
KSEM1280HPGM KCPM45	H57
KSEM1280HPLM KC7320	H62
KSEM1280HPM KC7315	H52
KSEM1280PCM KC7135	H70
KSEM1281HPG KC7315	H55
KSEM1281HPG KCPM45	H58
KSEM1281HPL KC7320	H63
KSEM1281R3SS150	H78
KSEM1281R3SSF150	H83
KSEM1281R5SS150	H78
KSEM1281R5SSF150	H83
KSEM1297HPG KC7315	H55
KSEM1297R3SS150	H78
KSEM1297R3SSF150	H83
KSEM1297R5SS150	H78
KSEM1297R5SSF150	H83
KSEM1300HPCCLM KC7410	H60, H111
KSEM1300HPGM KC7315	H54
KSEM1300HPGM KCPM45	H57
KSEM1300HPLM KC7320	H62
KSEM1300HPM KC7315	H52
KSEM1300PCM KC7135	H70, H111
KSEM1300SPLM KCMS35	H64
KSEM130R10WN16M	H75
KSEM130R3WN16M	H73
KSEM130R5WN16M	H73
KSEM130R7WN16M	H75
KSEM130SEFM	H87
KSEM1313HP KC7315	H53
KSEM1313HPG KC7315	H55
KSEM1313HPG KCPM45	H58
KSEM1313HPL KC7320	H63
KSEM1313R3SS150	H78
KSEM1313R3SSF150	H83
KSEM1313R5SS150	H78
KSEM1313R5SSF150	H83
KSEM1320HPGM KC7315	H54
KSEM1320HPM KC7315	H52
KSEM1328HPG KC7315	H55
KSEM1328R3SS150	H78
KSEM1328R3SSF150	H83
KSEM1328R5SS150	H78
KSEM1328R5SSF150	H83
KSEM1344HP KC7315	H53
KSEM1344HPG KC7315	H55
KSEM1344R3SSF150	H83
KSEM1344R5SS150	H78
KSEM1344R5SSF150	H83
KSEM1350HPCCLM KC7410	H60
KSEM1350HPGM KC7315	H54
KSEM1350HPGM KCPM45	H57
KSEM1350HPLM KC7320	H62
KSEM1350HPM KC7315	H52
KSEM1350PCM KC7135	H70
KSEM1350SPLM KCMS35	H64
KSEM135R10WN16M	H75
KSEM135R3WN16M	H73
KSEM135R5WN16M	H73
KSEM135R7WN16M	H75
KSEM135SEFM	H87
KSEM1360HPGM KC7315	H54
KSEM1360HPGM KCPM45	H57
KSEM1360HPLM KC7320	H62
KSEM136R10WN16M	H75
KSEM136R1WN16F45M	H85–86
KSEM136R1WN16M	H72
KSEM136R3WN16M	H73
KSEM136R5WN16M	H73
KSEM136R7WN16M	H75
KSEM1370HPGM KC7315	H54
KSEM1370HPM KC7315	H52
KSEM1375HP KC7315	H53
KSEM1375HPG KC7315	H55
KSEM1375HPG KCPM45	H58
KSEM1375HPL KC7320	H63
KSEM1375R3SS150	H78
KSEM1375R3SSF150	H83
KSEM1375R5SS150	H78
KSEM1375R5SSF150	H83
KSEM1380HPGM KC7315	H54
KSEM1380HPGM KCPM45	H57
KSEM1380HPLM KC7320	H62
KSEM1380HPM KC7315	H52
KSEM1380PCM KC7135	H70
KSEM1400HPCCLM KC7410	H60, H111
KSEM1400HPGM KC7315	H54
KSEM1400HPGM KCPM45	H57
KSEM1400HPLM KC7320	H62
KSEM1400HPM KC7315	H52
KSEM1400PCM KC7135	H70, H111
KSEM1400SPLM KCMS35	H64
KSEM1406HPG KC7315	H55
KSEM1406HPL KC7320	H63
KSEM1406R3SS150	H78
KSEM1406R3SSF150	H83
KSEM1406R5SS150	H78
KSEM1406R5SSF150	H83
KSEM140R10WN16M	H75
KSEM140R3WN16M	H73
KSEM140R5WN16M	H73
KSEM140R7WN16M	H75
KSEM140SEFM	H87
KSEM1410HPGM KC7315	H54
KSEM1410HPGM KCPM45	H57
KSEM1410HPLM KC7320	H62
KSEM1410HPM KC7315	H52
KSEM1410PCM KC7135	H70
KSEM1415HPLM KC7320	H62
KSEM1418R1SSF125	H81
KSEM1418R1SSF125F45	H86
KSEM1420HPGM KC7315	H54
KSEM1420HPLM KC7320	H62
KSEM1420HPM KC7315	H52
KSEM1422HPG KC7315	H55
KSEM1422R3SSF150	H83
KSEM1422R5SS150	H78
KSEM1422R5SSF150	H83
KSEM1438HPG KC7315	H55
KSEM1438HPG KCPM45	H58
KSEM1438R3SS150	H78
KSEM1438R3SSF150	H83
KSEM1438R5SS150	H78
KSEM1438R5SSF150	H83
KSEM1440HPGM KC7315	H54
KSEM1440HPM KC7315	H52
KSEM1450HPCCLM KC7410	H60
KSEM1450HPGM KC7315	H54

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KSEM1450HPGM KCPM45	H57
KSEM1450HPLM KC7320	H62
KSEM1450HPM KC7315	H52
KSEM1450PCM KC7135	H70
KSEM1450SPLM KCMS35	H64
KSEM145R10WN20M	H75
KSEM145R3WN20M	H73
KSEM145R5WN20M	H73
KSEM145R7WN20M	H75
KSEM145SEFM	H87
KSEM1460HPGM KC7315	H54
KSEM1460HPLM KC7320	H62
KSEM1460PCM KC7135	H70
KSEM1469HPG KC7315	H55
KSEM1469HPG KCPM45	H58
KSEM1469R3SSF150	H83
KSEM1469R5SS150	H78
KSEM1469R5SSF150	H83
KSEM146R10WN20M	H75
KSEM146R1WN20F45M	H85–86
KSEM146R1WN20M	H72
KSEM146R3WN20M	H73
KSEM146R5WN20M	H73
KSEM146R7WN20M	H75
KSEM1480HPGM KC7315	H54
KSEM1480HPLM KC7320	H62
KSEM1480HPM KC7315	H52
KSEM1480PCM KC7135	H70
KSEM1500FEG KCPM45	H68
KSEM1500HP KC7315	H53
KSEM1500HPCCLM KC7410	H60, H111
KSEM1500HPG KC7315	H55
KSEM1500HPG KCPM45	H58
KSEM1500HPGM KC7315	H54
KSEM1500HPGM KCPM45	H57
KSEM1500HPL KC7320	H63
KSEM1500HPLM KC7320	H62
KSEM1500HPM KC7315	H52
KSEM1500PCM KC7135	H70, H111
KSEM1500R3SS150	H78
KSEM1500R3SSF150	H83
KSEM1500R5SS150	H78
KSEM1500R5SSF150	H83
KSEM1500SPLM KCMS35	H64
KSEM150R10WN20M	H75
KSEM150R3WN20M	H73
KSEM150R5WN20M	H73
KSEM150R7WN20M	H75
KSEM150SEFM	H87
KSEM1514HPG KC7315	H55
KSEM1514HPG KCPM45	H58
KSEM1514HPL KC7320	H63
KSEM1514R3SS150	H78
KSEM1514R3SSF150	H83
KSEM1514R5SS150	H78
KSEM1514R5SSF150	H83
KSEM1514SPL KCMS35	H65
KSEM1530HPGM KC7315	H54
KSEM1530HPM KC7315	H52
KSEM1550HPCCLM KC7410	H60
KSEM1550HPGM KC7315	H54
KSEM1550HPGM KCPM45	H57
KSEM1550HPLM KC7320	H62
KSEM1550HPM KC7315	H52
KSEM1550PCM KC7135	H70
KSEM1550SPLM KCMS35	H64
KSEM155R10WN20M	H75
KSEM155R3WN20M	H73
KSEM155R5WN20M	H73
KSEM155R7WN20M	H75
KSEM155SEFM	H87
KSEM1560HPGM KC7315	H54
KSEM1560HPLM KC7320	H62
KSEM1560HPM KC7315	H52
KSEM1560PCM KC7135	H70
KSEM1570HPGM KC7315	H54
KSEM1570HPM KC7315	H52
KSEM1580HPGM KC7315	H54
KSEM1580HPGM KCPM45	H57
KSEM1580HPM KC7315	H52
KSEM1580PCM KC7135	H70
KSEM1600FEGM KCPM45	H67
KSEM1600HPCCLM KC7410	H60, H111
KSEM1600HPGM KC7315	H54
KSEM1600HPGM KCPM45	H57
KSEM1600HPLM KC7320	H62
KSEM1600HPM KC7315	H52
KSEM1600PCM KC7135	H70, H111
KSEM1600SPLM KCMS35	H64
KSEM1604HPGM KC7315	H54
KSEM160R10WN20M	H75
KSEM160R1WN20F45M	H85–86
KSEM160R1WN20M	H72
KSEM160R3WN20M	H73
KSEM160R5WN20M	H73
KSEM160R7WN20M	H75
KSEM160SEFM	H87
KSEM1610HPLM KC7320	H62
KSEM1615HPLM KC7320	H62
KSEM1615SPLM KCMS35	H64
KSEM1619HPGM KC7315	H54
KSEM1620HPGM KC7315	H54
KSEM1620HPGM KCPM45	H57
KSEM1620HPLM KC7320	H62
KSEM1620HPM KC7315	H52
KSEM1620PCM KC7135	H70
KSEM1650FEGM KCPM45	H67
KSEM1650HPCCLM KC7410	H60
KSEM1650HPGM KC7315	H54
KSEM1650HPGM KCPM45	H57
KSEM1650HPLM KC7320	H62
KSEM1650HPM KC7315	H52
KSEM1650PCM KC7135	H70
KSEM1650SPLM KCMS35	H64
KSEM165R10WN20M	H75
KSEM165R3WN20M	H73
KSEM165R5WN20M	H73
KSEM165R7WN20M	H75
KSEM165SEFM	H87
KSEM1660HPGM KC7315	H54
KSEM1700FEGM KCPM45	H67
KSEM1700HPCCLM KC7410	H60, H111
KSEM1700HPGM KC7315	H54
KSEM1700HPGM KCPM45	H57
KSEM1700HPLM KC7320	H62
KSEM1700HPM KC7315	H52
KSEM1700PCM KC7135	H70, H111
KSEM1700SPLM KCMS35	H64
KSEM170R10WN20M	H75
KSEM170R3WN20M	H73
KSEM170R5WN20M	H73
KSEM170R7WN20M	H75
KSEM170SEFM	H87
KSEM1735HPGM KC7315	H54
KSEM1750FEGM KCPM45	H67
KSEM1750HPCCLM KC7410	H60
KSEM1750HPGM KC7315	H54
KSEM1750HPGM KCPM45	H57
KSEM1750HPLM KC7320	H62
KSEM1750HPM KC7315	H52
KSEM1750PCM KC7135	H70
KSEM1750SPLM KCMS35	H64
KSEM175R10WN20M	H75
KSEM175R3WN20M	H73
KSEM175R5WN20M	H73
KSEM175R7WN20M	H75
KSEM175SEFM	H87
KSEM1760HPCCLM KC7410	H60
KSEM1760HPGM KC7315	H54
KSEM1770HPGM KC7315	H54
KSEM1775HPLM KC7320	H62
KSEM1780HPLM KC7320	H62
KSEM1790HPLM KC7320	H62
KSEM1800FEGM KCPM45	H67
KSEM1800HPCCLM KC7410	H60, H111
KSEM1800HPGM KC7315	H54
KSEM1800HPGM KCPM45	H57
KSEM1800HPLM KC7320	H62
KSEM1800HPM KC7315	H52
KSEM1800PCM KC7135	H70, H111
KSEM1800SPLM KCMS35	H64
KSEM180R10WN20M	H75
KSEM180R3WN20M	H73
KSEM180R5WN20M	H73
KSEM180R7WN20M	H75
KSEM180SEFM	H87
KSEM181R10WN25M	H75
KSEM181R1WN25F45M	H85–86
KSEM181R1WN25M	H72
KSEM181R5WN25M	H73
KSEM1830SPLM KCMS35	H64
KSEM1850FEGM KCPM45	H67
KSEM1850HPCCLM KC7410	H60
KSEM1850HPGM KC7315	H54
KSEM1850HPGM KCPM45	H57
KSEM1850HPLM KC7320	H62
KSEM1850HPM KC7315	H52
KSEM1850PCM KC7135	H70
KSEM1850SPLM KCMS35	H64
KSEM185R10WN25M	H75
KSEM185R3WN25M	H73
KSEM185R5WN25M	H73
KSEM185R7WN25M	H75
KSEM185SEFM	H87
KSEM1860HPGM KC7315	H54
KSEM1860HPLM KC7320	H62
KSEM1880HPGM KC7315	H54
KSEM1890HPLM KC7320	H62
KSEM1900FEGM KCPM45	H67
KSEM1900HPCCLM KC7410	H60, H111
KSEM1900HPGM KC7315	H54
KSEM1900HPGM KCPM45	H57
KSEM1900HPLM KC7320	H62
KSEM1900HPM KC7315	H52
KSEM1900PCM KC7135	H70, H111
KSEM1900SPLM KCMS35	H64
KSEM190R10WN25M	H75
KSEM190R3WN25M	H73
KSEM190R5WN25M	H73
KSEM190R7WN25M	H75
KSEM190SEFM	H87
KSEM1920HPGM KCPM45	H57
KSEM1920HPLM KC7320	H62
KSEM1920SPLM KCMS35	H64
KSEM1932HPGM KC7315	H54
KSEM1935HPGM KC7315	H54
KSEM1935HPLM KC7320	H62
KSEM1935SPLM KCMS35	H64
KSEM1936HPLM KC7320	H62
KSEM1938HPLM KC7320	H62
KSEM1950FEGM KCPM45	H67
KSEM1950HPCCLM KC7410	H60
KSEM1950HPGM KC7315	H54
KSEM1950HPGM KCPM45	H57
KSEM1950HPLM KC7320	H62
KSEM1950HPM KC7315	H52
KSEM1950PCM KC7135	H70
KSEM1950SPLM KCMS35	H64
KSEM195R10WN25M	H75
KSEM195R3WN25M	H73
KSEM195R5WN25M	H73
KSEM195R7WN25M	H75
KSEM195SEFM	H87
KSEM1965HPGM KCPM45	H57
KSEM1970HPGM KC7315	H54
KSEM2000FEGM KCPM45	H67
KSEM2000HPCCLM KC7410	H60, H111
KSEM2000HPGM KC7315	H54
KSEM2000HPGM KCPM45	H57
KSEM2000HPLM KC7320	H62
KSEM2000HPM KC7315	H52
KSEM2000PCM KC7135	H70, H111
KSEM2000SPLM KCMS35	H64
KSEM200R10WN25M	H75
KSEM200R1WN25F45M	H85–86
KSEM200R1WN25M	H72
KSEM200R3WN25M	H73
KSEM200R5WN25M	H73
KSEM200R7WN25M	H75
KSEM200SEFM	H87
KSEM2010HPLM KC7320	H62
KSEM2035HPLM KC7320	H62
KSEM2050FEGM KCPM45	H67
KSEM2050HPCCLM KC7410	H60
KSEM2050HPGM KC7315	H54
KSEM2050HPGM KCPM45	H57
KSEM2050HPLM KC7320	H62
KSEM2050HPM KC7315	H52
KSEM2050PCM KC7135	H70
KSEM2050SPLM KCMS35	H64
KSEM205R10WN25M	H75
KSEM205R3WN25M	H73
KSEM205R5WN25M	H73
KSEM205R7WN25M	H75
KSEM205SEFM	H87
KSEM2070HPGM KC7315	H54
KSEM2100FEGM KCPM45	H67
KSEM2100HPCCLM KC7410	H60, H111
KSEM2100HPGM KC7315	H54
KSEM2100HPGM KCPM45	H57
KSEM2100HPLM KC7320	H62
KSEM2100HPM KC7315	H52
KSEM2100PCM KC7135	H70, H111
KSEM2100SPLM KCMS35	H64
KSEM210R10WN25M	H75
KSEM210R3WN25M	H73
KSEM210R5WN25M	H73
KSEM210R7WN25M	H75
KSEM210SEFM	H87
KSEM2110HPGM KC7315	H54
KSEM2115HPLM KC7320	H62
KSEM2120HPGM KC7315	H54
KSEM2133HPGM KC7315	H55
KSEM2133HPLM KC7320	H62
KSEM2150FEGM KCPM45	H67
KSEM2150HPCCLM KC7410	H60
KSEM2150HPGM KC7315	H55
KSEM2150HPGM KCPM45	H57
KSEM2150HPLM KC7320	H62
KSEM2150HPM KC7315	H52
KSEM2150PCM KC7135	H70
KSEM2150SPLM KCMS35	H64
KSEM215R10WN25M	H75
KSEM215R3WN25M	H73
KSEM215R5WN25M	H73
KSEM215R7WN25M	H75
KSEM215SEFM	H87
KSEM2170HPGM KC7315	H55
KSEM2200FEGM KCPM45	H67
KSEM2200HPCCLM KC7410	H60, H111
KSEM2200HPGM KC7315	H55
KSEM2200HPGM KCPM45	H57
KSEM2200HPLM KC7320	H62
KSEM2200HPM KC7315	H52
KSEM2200PCM KC7135	H70, H111
KSEM2200SPLM KCMS35	H64
KSEM220R10WN25M	H75
KSEM220R3WN25M	H73
KSEM220R5WN25M	H73
KSEM220R7WN25M	H75
KSEM220SEFM	H87
KSEM2210HPCCLM KC7410	H60
KSEM2210HPGM KC7315	H55
KSEM2215HPGM KC7315	H55
KSEM221R10WN25M	H75
KSEM221R1WN25F45M	H85–86
KSEM221R1WN25M	H72
KSEM221R5WN25M	H73
KSEM2250FEGM KCPM45	H67
KSEM2250HPCCLM KC7410	H60
KSEM2250HPGM KC7315	H55
KSEM2250HPGM KCPM45	H57
KSEM2250HPLM KC7320	H62
KSEM2250HPM KC7315	H52
KSEM2250PCM KC7135	H70
KSEM2250SPLM KCMS35	H64
KSEM225R10WN25M	H75
KSEM225R3WN25M	H74
KSEM225R5WN25M	H74
KSEM225R7WN25M	H75
KSEM225SEFM	H87
KSEM2277HPLM KC7320	H62
KSEM2300FEGM KCPM45	H67
KSEM2300HPCCLM KC7410	H60, H111
KSEM2300HPGM KC7315	H55
KSEM2300HPGM KCPM45	H57
KSEM2300HPLM KC7320	H62
KSEM2300HPM KC7315	H52

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KSEM2300PCM KC7135	H70, H111
KSEM2300SPLM KCMS35	H64
KSEM2305HPGM KC7315	H55
KSEM230R10WN25M	H75
KSEM230R3WN25M	H74
KSEM230R5WN25M	H74
KSEM230R7WN25M	H75
KSEM230SEFM	H87
KSEM2310HPGM KC7315	H55
KSEM2325HPGM KC7315	H55
KSEM2330HPGM KC7315	H55
KSEM2350FEGM KCPM45	H67
KSEM2350HPCCLM KC7410	H60
KSEM2350HPGM KC7315	H55
KSEM2350HPGM KCPM45	H57
KSEM2350HPLM KC7320	H62
KSEM2350HPM KC7315	H52
KSEM2350PCM KC7135	H70
KSEM2350SPLM KCMS35	H64
KSEM235R10WN25M	H75
KSEM235R3WN25M	H74
KSEM235R5WN25M	H74
KSEM235R7WN25M	H75
KSEM235SEFM	H87
KSEM2370HPGM KCPM45	H57
KSEM2400FEGM KCPM45	H67
KSEM2400HPCCLM KC7410	H60, H111
KSEM2400HPGM KC7315	H55
KSEM2400HPGM KCPM45	H57
KSEM2400HPLM KC7320	H62
KSEM2400HPM KC7315	H52
KSEM2400PCM KC7135	H70, H111
KSEM2400SPLM KCMS35	H64
KSEM240R10WN25M	H75
KSEM240R3WN25M	H74
KSEM240R5WN25M	H74
KSEM240R7WN25M	H75
KSEM240SEFM	H87
KSEM241R10WN32M	H75
KSEM241R1WN32F45M	H85–86
KSEM241R1WN32M	H72
KSEM241R5WN32M	H74
KSEM2430HPGM KC7315	H55
KSEM2450FEGM KCPM45	H67
KSEM2450HPCCLM KC7410	H60
KSEM2450HPGM KC7315	H55
KSEM2450HPGM KCPM45	H57
KSEM2450HPLM KC7320	H62
KSEM2450HPM KC7315	H52
KSEM2450PCM KC7135	H70
KSEM2450SPLM KCMS35	H64
KSEM245R10WN32M	H75
KSEM245R3WN32M	H74
KSEM245R5WN32M	H74
KSEM245R7WN32M	H75
KSEM245SEFM	H87
KSEM2470HPGM KC7315	H55
KSEM2500FEGM KCPM45	H67
KSEM2500HPCCLM KC7410	H60, H111
KSEM2500HPGM KC7315	H55
KSEM2500HPGM KCPM45	H58
KSEM2500HPLM KC7320	H62
KSEM2500HPM KC7315	H52
KSEM2500PCM KC7135	H70, H111
KSEM2500SPLM KCMS35	H64
KSEM2507HPLM KC7320	H62
KSEM250R10WN32M	H75
KSEM250R3WN32M	H74
KSEM250R5WN32M	H74
KSEM250R7WN32M	H75
KSEM250SEFM	H87
KSEM2525SPLM KCMS35	H64
KSEM2530SPLM KCMS35	H64
KSEM2550FEGM KCPM45	H67
KSEM2550HPCCLM KC7410	H60
KSEM2550HPGM KC7315	H55
KSEM2550HPGM KCPM45	H58
KSEM2550HPLM KC7320	H62
KSEM2550HPM KC7315	H52
KSEM2550PCM KC7135	H70
KSEM2550SPLM KCMS35	H64
KSEM2554HPGM KC7315	H55
KSEM255R10WN32M	H75
KSEM255R3WN32M	H74
KSEM255R5WN32M	H74
KSEM255R7WN32M	H75
KSEM255SEFM	H87
KSEM2565HPLM KC7320	H63
KSEM2565SPLM KCMS35	H64
KSEM2580FEGM KCPM45	H67
KSEM2600FEGM KCPM45	H67
KSEM2600HPCCLM KC7410	H60, H111
KSEM2600HPGM KC7315	H55
KSEM2600HPGM KCPM45	H58
KSEM2600HPLM KC7320	H63
KSEM2600HPM KC7315	H53
KSEM2600PCM KC7135	H70, H111
KSEM2600SPLM KCMS35	H64
KSEM260R10WN32M	H76
KSEM260R3WN32M	H74
KSEM260R5WN32M	H74
KSEM260R7WN32M	H76
KSEM260SEFM	H87
KSEM261R10WN32M	H76
KSEM261R1WN32F45M	H85–86
KSEM261R1WN32M	H72
KSEM261R5WN32M	H74
KSEM2630SPLM KCMS35	H64
KSEM2650FEGM KCPM45	H67
KSEM2650HPCCLM KC7410	H60
KSEM2650HPGM KC7315	H55
KSEM2650HPGM KCPM45	H58
KSEM2650HPLM KC7320	H63
KSEM2650HPM KC7315	H53
KSEM2650PCM KC7135	H70
KSEM2650SPLM KCMS35	H64
KSEM2653HPGM KC7315	H55
KSEM265R10WN32M	H76
KSEM265R3WN32M	H74
KSEM265R5WN32M	H74
KSEM265R7WN32M	H76
KSEM265SEFM	H87
KSEM2670FEGM KCPM45	H67
KSEM2670HPGM KC7315	H55
KSEM2670HPLM KC7320	H63
KSEM2700FEGM KCPM45	H67
KSEM2700HPCCLM KC7410	H60, H111
KSEM2700HPGM KC7315	H55
KSEM2700HPGM KCPM45	H58
KSEM2700HPLM KC7320	H63
KSEM2700HPM KC7315	H53
KSEM2700PCM KC7135	H70, H111
KSEM2700SPLM KCMS35	H64
KSEM270R10WN32M	H76
KSEM270R3WN32M	H74
KSEM270R5WN32M	H74
KSEM270R7WN32M	H76
KSEM270SEFM	H87
KSEM2750FEGM KCPM45	H67
KSEM2750HPCCLM KC7410	H60
KSEM2750HPGM KC7315	H55
KSEM2750HPGM KCPM45	H58
KSEM2750HPLM KC7320	H63
KSEM2750HPM KC7315	H53
KSEM2750SPLM KCMS35	H64
KSEM275R10WN32M	H76
KSEM275R3WN32M	H74
KSEM275R5WN32M	H74
KSEM275R7WN32M	H76
KSEM275SEFM	H87
KSEM2800FEGM KCPM45	H67
KSEM2800HPCCLM KC7410	H61, H111
KSEM2800HPGM KC7315	H55
KSEM2800HPGM KCPM45	H58
KSEM2800HPLM KC7320	H63
KSEM2800HPM KC7315	H53
KSEM2800PCM KC7135	H70, H111
KSEM2800SPLM KCMS35	H64
KSEM280R10WN32M	H76
KSEM280R3WN32M	H74
KSEM280R5WN32M	H74
KSEM280R7WN32M	H76
KSEM280SEFM	H87
KSEM2810HPLM KC7320	H63
KSEM281R10WN32M	H76
KSEM281R1WN32F45M	H85–86
KSEM281R1WN32M	H72
KSEM281R5WN32M	H74
KSEM2835HPGM KCPM45	H58
KSEM2850FEGM KCPM45	H67
KSEM2850HPCCLM KC7410	H61
KSEM2850HPGM KC7315	H55
KSEM2850HPGM KCPM45	H58
KSEM2850HPLM KC7320	H63
KSEM2850HPM KC7315	H53
KSEM2850PCM KC7135	H70
KSEM2850SPLM KCMS35	H64
KSEM285R10WN32M	H76
KSEM285R3WN32M	H74
KSEM285R5WN32M	H74
KSEM285R7WN32M	H76
KSEM285SEFM	H87
KSEM2900FEGM KCPM45	H67
KSEM2900HPCCLM KC7410	H61, H111
KSEM2900HPGM KC7315	H55
KSEM2900HPGM KCPM45	H58
KSEM2900HPLM KC7320	H63
KSEM2900HPM KC7315	H53
KSEM2900PCM KC7135	H70, H111
KSEM2900SPLM KCMS35	H65
KSEM290R10WN32M	H76
KSEM290R3WN32M	H74
KSEM290R5WN32M	H74
KSEM290R7WN32M	H76
KSEM290SEFM	H87
KSEM2950FEGM KCPM45	H67
KSEM2950HPCCLM KC7410	H61
KSEM2950HPGM KC7315	H55
KSEM2950HPGM KCPM45	H58
KSEM2950HPLM KC7320	H63
KSEM2950HPM KC7315	H53
KSEM2950PCM KC7135	H70
KSEM2950SPLM KCMS35	H65
KSEM2955HPGM KC7315	H55
KSEM295R10WN32M	H76
KSEM295R3WN32M	H74
KSEM295R5WN32M	H74
KSEM295R7WN32M	H76
KSEM295SEFM	H87
KSEM2973HPGM KC7315	H55
KSEM3000FEGM KCPM45	H67
KSEM3000HPCCLM KC7410	H61, H111
KSEM3000HPGM KC7315	H55
KSEM3000HPGM KCPM45	H58
KSEM3000HPLM KC7320	H63
KSEM3000HPM KC7315	H53
KSEM3000PCM KC7135	H70, H111
KSEM3000SPLM KCMS35	H65
KSEM300R10WN32M	H76
KSEM300R3WN32M	H74
KSEM300R5WN32M	H74
KSEM300R7WN32M	H76
KSEM300SEFM	H87
KSEM301R10WN32M	H76
KSEM301R1WN32F45M	H85–86
KSEM301R1WN32M	H72
KSEM301R5WN32M	H74
KSEM3050FEGM KCPM45	H67
KSEM3050HPCCLM KC7410	H61
KSEM3050HPGM KC7315	H55
KSEM3050HPGM KCPM45	H58
KSEM3050HPLM KC7320	H63
KSEM3050HPM KC7315	H53
KSEM3050PCM KC7135	H70
KSEM3050SPLM KCMS35	H65
KSEM305R3WN32M	H74
KSEM305R5WN32M	H74
KSEM305R7WN32M	H76
KSEM305SEFM	H87
KSEM3100FEGM KCPM45	H67
KSEM3100HPCCLM KC7410	H61, H111
KSEM3100HPGM KC7315	H55
KSEM3100HPGM KCPM45	H58
KSEM3100HPLM KC7320	H63
KSEM3100HPM KC7315	H53
KSEM3100PCM KC7135	H70, H111
KSEM3100SPLM KCMS35	H65
KSEM310R10WN32M	H76
KSEM310R3WN32M	H74
KSEM310R5WN32M	H74
KSEM310R7WN32M	H76
KSEM310SEFM	H87
KSEM3115HPGM KCPM45	H58
KSEM3125HPGM KC7315	H55
KSEM3150FEGM KCPM45	H67
KSEM3150HPGM KC7315	H55
KSEM3150HPGM KCPM45	H58
KSEM3150HPLM KC7320	H63
KSEM3150HPM KC7315	H53
KSEM3150SPLM KCMS35	H65
KSEM315R3WN32M	H74
KSEM315R5WN32M	H74
KSEM315R7WN32M	H76
KSEM315SEFM	H87
KSEM3200FEGM KCPM45	H67
KSEM3200HPCCLM KC7410	H61, H111
KSEM3200HPGM KC7315	H55
KSEM3200HPGM KCPM45	H58
KSEM3200HPLM KC7320	H63
KSEM3200HPM KC7315	H53
KSEM3200PCM KC7135	H70, H111
KSEM3200SPLM KCMS35	H65
KSEM320R10WN32M	H76
KSEM320R3WN32M	H74
KSEM320R5WN32M	H74
KSEM320R7WN32M	H76
KSEM320SEFM	H87
KSEM321R1WD50F45M	H85–86
KSEM321R1WD50M	H72
KSEM321R3WD40M	H74
KSEM321R3WD50M	H74
KSEM321R5WD40M	H74
KSEM321R5WD50M	H74
KSEM3220HPGM KC7315	H55
KSEM3234HPGM KC7315	H55
KSEM3250FEGM KCPM45	H67
KSEM3250HPGM KC7315	H55
KSEM3250HPGM KCPM45	H58
KSEM3250HPM KC7315	H53
KSEM3250SPLM KCMS35	H65
KSEM3300FEGM KCPM45	H67
KSEM3300HPCCLM KC7410	H61, H111
KSEM3300HPGM KC7315	H55
KSEM3300HPGM KCPM45	H58
KSEM3300HPLM KC7320	H63
KSEM3300HPM KC7315	H53
KSEM3300PCM KC7135	H70, H111
KSEM330R3WD40M	H74
KSEM330R3WD50M	H74
KSEM330R5WD40M	H74
KSEM330R5WD50M	H74
KSEM3350FEGM KCPM45	H67
KSEM3350HPGM KC7315	H55
KSEM3350HPGM KCPM45	H58
KSEM3350SPLM KCMS35	H65
KSEM3400FEGM KCPM45	H67
KSEM3400HPCCLM KC7410	H61, H111
KSEM3400HPGM KC7315	H55
KSEM3400HPGM KCPM45	H58
KSEM3400HPLM KC7320	H63
KSEM3400HPM KC7315	H53
KSEM3400PCM KC7135	H70, H111
KSEM3400SPLM KCMS35	H65
KSEM340R3WD40M	H74
KSEM340R3WD50M	H74
KSEM340R5WD40M	H74
KSEM340R5WD50M	H74
KSEM3450FEGM KCPM45	H67
KSEM3450HPGM KC7315	H55
KSEM3450HPGM KCPM45	H58
KSEM3450SPLM KCMS35	H65
KSEM3500FEGM KCPM45	H67
KSEM3500HPCCLM KC7410	H61, H111
KSEM3500HPGM KC7315	H55
KSEM3500HPGM KCPM45	H58
KSEM3500HPLM KC7320	H63
KSEM3500HPM KC7315	H53
KSEM3500PCM KC7135	H70, H111

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KSEM3500SPLM KCMS35	H65
KSEM350R3WD40M	H74
KSEM350R3WD50M	H74
KSEM350R5WD40M	H74
KSEM350R5WD50M	H74
KSEM3550FEGM KCPM45	H67
KSEM3550HPGM KC7315	H55
KSEM3550HPM KC7315	H53
KSEM3550SPLM KCMS35	H65
KSEM3600FEGM KCPM45	H68
KSEM3600HPCCLM KC7410	H61, H111
KSEM3600HPGM KC7315	H55
KSEM3600HPGM KCPM45	H58
KSEM3600HPLM KC7320	H63
KSEM3600HPM KC7315	H53
KSEM3600PCM KC7135	H70, H111
KSEM3600SPLM KCMS35	H65
KSEM360R3WD40M	H74
KSEM360R3WD50M	H74
KSEM360R5WD40M	H74
KSEM360R5WD50M	H74
KSEM361R1WD50F45M	H85–86
KSEM361R1WD50M	H72
KSEM361R3WD40M	H74
KSEM361R3WD50M	H74
KSEM361R5WD40M	H74
KSEM361R5WD50M	H74
KSEM3650FEGM KCPM45	H68
KSEM3650HPGM KC7315	H55
KSEM3650SPLM KCMS35	H65
KSEM3700FEGM KCPM45	H68
KSEM3700HPCCLM KC7410	H61, H111
KSEM3700HPGM KC7315	H55
KSEM3700HPGM KCPM45	H58
KSEM3700HPLM KC7320	H63
KSEM3700PCM KC7135	H70, H111
KSEM3700SPLM KCMS35	H65
KSEM370R3WD40M	H74
KSEM370R3WD50M	H74
KSEM370R5WD40M	H74
KSEM370R5WD50M	H74
KSEM3750FEGM KCPM45	H68
KSEM3750HPGM KC7315	H55
KSEM3750HPGM KCPM45	H58
KSEM3750HPLM KC7320	H63
KSEM3750HPM KC7315	H53
KSEM3750SPLM KCMS35	H65
KSEM3800FEGM KCPM45	H68
KSEM3800HPCCLM KC7410	H61, H111
KSEM3800HPGM KC7315	H55
KSEM3800HPGM KCPM45	H58
KSEM3800HPLM KC7320	H63
KSEM3800HPM KC7315	H53
KSEM3800PCM KC7135	H70, H111
KSEM3800SPLM KCMS35	H65
KSEM380R3WD40M	H74
KSEM380R3WD50M	H74
KSEM380R5WD40M	H74
KSEM380R5WD50M	H74
KSEM3850FEGM KCPM45	H68
KSEM3850HPGM KC7315	H55
KSEM3850HPM KC7315	H53
KSEM3850SPLM KCMS35	H65
KSEM3900FEGM KCPM45	H68
KSEM3900HPCCLM KC7410	H61, H111
KSEM3900HPGM KC7315	H55
KSEM3900HPGM KCPM45	H58
KSEM3900HPLM KC7320	H63
KSEM3900HPM KC7315	H53
KSEM3900PCM KC7135	H70, H111
KSEM3900SPLM KCMS35	H65
KSEM390R3WD40M	H74
KSEM390R3WD50M	H74
KSEM390R5WD40M	H74
KSEM390R5WD50M	H74
KSEM3920HPCCLM KC7410	H61
KSEM3950FEGM KCPM45	H68
KSEM3950HPGM KC7315	H55
KSEM3950HPM KC7315	H53
KSEM3950SPLM KCMS35	H65
KSEM3975HPGM KC7315	H55
KSEM4000FEGM KCPM45	H68
KSEM4000HPCCLM KC7410	H61, H111
KSEM4000HPGM KC7315	H55
KSEM4000HPGM KCPM45	H58
KSEM4000HPLM KC7320	H63
KSEM4000HPM KC7315	H53
KSEM4000PCM KC7135	H70, H111
KSEM4000SPLM KCMS35	H65
KSEM400R3WD40M	H74
KSEM400R3WD50M	H74
KSEM400R5WD40M	H74
KSEM400R5WD50M	H74
KSEMP10000FDS90A1M	H106, H117, H123
KSEMP10000FDS90B1M	H110, H120
KSEMP1125FDS28A1	H104, H115, H122
KSEMP1125FDS28B1	H108, H118
KSEMP1156FDS28A1	H104, H115, H122
KSEMP1156FDS28B1	H108, H118
KSEMP1188FDS28A1	H104, H115, H122
KSEMP1188FDS28B1	H108, H118
KSEMP1219FDS28A1	H104, H115, H122
KSEMP1219FDS28B1	H108, H118
KSEMP1250FDS32A1	H104, H115, H122
KSEMP1250FDS32B1	H108, H118
KSEMP1300HPGM KC7315	H111
KSEMP1313FDS32A1	H104, H115, H122
KSEMP1313FDS32B1	H108, H118
KSEMP1375FDS32A1	H104, H115, H122
KSEMP1375FDS32B1	H108, H118
KSEMP1400HPGM KC7315	H111
KSEMP1438FDS36A1	H104, H116, H122
KSEMP1438FDS36B1	H108, H118
KSEMP1500FDS36A1	H104, H116, H122
KSEMP1500FDS36B1	H108, H119
KSEMP1500HPGM KC7315	H111
KSEMP1563FDS36A1	H104, H116, H122
KSEMP1563FDS36B1	H108, H119
KSEMP1600HPGM KC7315	H111
KSEMP1625FDS40A1	H104, H116, H122
KSEMP1625FDS40B1	H108, H119
KSEMP1700HPGM KC7315	H111
KSEMP1750FDS40A1	H104, H116, H122
KSEMP1750FDS40B1	H108, H119
KSEMP1800HPGM KC7315	H111
KSEMP1875FDS45A1	H105, H116, H122
KSEMP1875FDS45B1	H109, H119
KSEMP1900HPGM KC7315	H111
KSEMP2000FDS50A1	H105, H116, H122
KSEMP2000FDS50B1	H109, H119
KSEMP2000HPGM KC7315	H111
KSEMP2100HPGM KC7315	H111
KSEMP2125FDS50A1	H105, H116, H122
KSEMP2125FDS50B1	H109, H119
KSEMP2200HPGM KC7315	H111
KSEMP2250FDS56A1	H105, H116, H122
KSEMP2250FDS56B1	H109, H119
KSEMP2300HPGM KC7315	H111
KSEMP2375FDS56A1	H105, H116, H122
KSEMP2375FDS56B1	H109, H119
KSEMP2400HPGM KC7315	H111
KSEMP2500FDS63A1	H105, H116, H123
KSEMP2500FDS63B1	H109, H119
KSEMP2500HPGM KC7315	H111
KSEMP2600HPGM KC7315	H111
KSEMP2625FDS63A1	H105, H116, H123
KSEMP2625FDS63B1	H109, H119
KSEMP2700HPGM KC7315	H111
KSEMP2750FDS63A1	H105, H116, H123
KSEMP2750FDS63B1	H109, H119
KSEMP2800FDS28A1M	H104, H115, H122
KSEMP2800FDS28B1M	H108, H118
KSEMP2800HPGM KC7315	H111
KSEMP2875FDS71A1	H106, H116, H123
KSEMP2875FDS71B1	H110, H119
KSEMP2900FDS28A1M	H104, H115, H122
KSEMP2900FDS28B1M	H108, H118
KSEMP2900HPGM KC7315	H111
KSEMP3000FDS28A1M	H104, H115, H122
KSEMP3000FDS28B1M	H108, H118
KSEMP3000FDS71A1	H106, H117, H123
KSEMP3000FDS71B1	H110, H119
KSEMP3000HPGM KC7315	H111
KSEMP3100FDS28A1M	H104, H115, H122
KSEMP3100FDS28B1M	H108, H118
KSEMP3100HPGM KC7315	H111
KSEMP3125FDS80A1	H106, H117, H123
KSEMP3125FDS80B1	H110, H120
KSEMP3200FDS32A1M	H104, H115, H122
KSEMP3200FDS32B1M	H108, H118
KSEMP3200HPGM KC7315	H111
KSEMP3250FDS80A1	H106, H117, H123
KSEMP3250FDS80B1	H110, H120
KSEMP3300FDS32A1M	H104, H115, H122
KSEMP3300FDS32B1M	H108, H118
KSEMP3300HPGM KC7315	H111
KSEMP3320FDS32A1M	H104, H115, H122
KSEMP3320FDS32B1M	H108, H118
KSEMP3375FDS80A1	H106, H117, H123
KSEMP3375FDS80B1	H110, H120
KSEMP3400FDS32A1M	H104, H115, H122
KSEMP3400FDS32B1M	H108, H118
KSEMP3400HPGM KC7315	H111
KSEMP3500FDS32A1M	H104, H115, H122
KSEMP3500FDS32B1M	H108, H118
KSEMP3500FDS80A1	H106, H117, H123
KSEMP3500FDS80B1	H110, H120
KSEMP3500HPGM KC7315	H111
KSEMP3600FDS36A1M	H104, H116, H122
KSEMP3600FDS36B1M	H108, H118
KSEMP3600HPGM KC7315	H111
KSEMP3625FDS90A1	H106, H117, H123
KSEMP3625FDS90B1	H110, H120
KSEMP3700FDS36A1M	H104, H116, H122
KSEMP3700FDS36B1M	H108, H118
KSEMP3700HPGM KC7315	H111
KSEMP3750FDS36A1M	H104, H116, H122
KSEMP3750FDS36B1M	H108, H118
KSEMP3750FDS90A1	H106, H117, H123
KSEMP3750FDS90B1	H110, H120
KSEMP3800FDS36A1M	H104, H116, H122
KSEMP3800FDS36B1M	H108, H119
KSEMP3800HPGM KC7315	H111
KSEMP3875FDS90A1	H106, H117, H123
KSEMP3875FDS90B1	H110, H120
KSEMP3900FDS36A1M	H104, H116, H122
KSEMP3900FDS36B1M	H108, H119
KSEMP3900HPGM KC7315	H111
KSEMP3920FDS36A1M	H104, H116, H122
KSEMP3920FDS36B1M	H108, H119
KSEMP4000FDS40A1M	H104, H116, H122
KSEMP4000FDS40B1M	H108, H119
KSEMP4000FDS90A1	H106, H117, H123
KSEMP4000FDS90B1	H110, H120
KSEMP4000HPGM KC7315	H111
KSEMP4100FDS40A1M	H104, H116, H122
KSEMP4100FDS40B1M	H108, H119
KSEMP4200FDS40A1M	H104, H116, H122
KSEMP4200FDS40B1M	H108, H119
KSEMP4300FDS40A1M	H104, H116, H122
KSEMP4300FDS40B1M	H108, H119
KSEMP4400FDS40A1M	H104, H116, H122
KSEMP4400FDS40B1M	H108, H119
KSEMP4500FDS45A1M	H105, H116, H122
KSEMP4500FDS45B1M	H109, H119
KSEMP4600FDS45A1M	H105, H116, H122
KSEMP4600FDS45B1M	H109, H119
KSEMP4700FDS45A1M	H105, H116, H122
KSEMP4700FDS45B1M	H109, H119
KSEMP4800FDS45A1M	H105, H116, H122
KSEMP4800FDS45B1M	H109, H119
KSEMP4900FDS45A1M	H105, H116, H122
KSEMP4900FDS45B1M	H109, H119
KSEMP5000FDS50A1M	H105, H116, H122
KSEMP5000FDS50B1M	H109, H119
KSEMP5100FDS50A1M	H105, H116, H122
KSEMP5100FDS50B1M	H109, H119
KSEMP5200FDS50A1M	H105, H116, H122
KSEMP5200FDS50B1M	H109, H119
KSEMP5300FDS50A1M	H105, H116, H122
KSEMP5300FDS50B1M	H109, H119
KSEMP5400FDS50A1M	H105, H116, H122
KSEMP5400FDS50B1M	H109, H119
KSEMP5500FDS50A1M	H105, H116, H122
KSEMP5500FDS50B1M	H109, H119
KSEMP5600FDS56A1M	H105, H116, H122
KSEMP5600FDS56B1M	H109, H119
KSEMP5700FDS56A1M	H105, H116, H122
KSEMP5700FDS56B1M	H109, H119
KSEMP5800FDS56A1M	H105, H116, H122
KSEMP5800FDS56B1M	H109, H119
KSEMP5900FDS56A1M	H105, H116, H122
KSEMP5900FDS56B1M	H109, H119
KSEMP6000FDS56A1M	H105, H116, H122
KSEMP6000FDS56B1M	H109, H119
KSEMP6100FDS56A1M	H105, H116, H122
KSEMP6100FDS56B1M	H109, H119
KSEMP6200FDS56A1M	H105, H116, H122
KSEMP6200FDS56B1M	H109, H119
KSEMP6300FDS63A1M	H105, H116, H122
KSEMP6300FDS63B1M	H109, H119
KSEMP6400FDS63A1M	H105, H116, H123
KSEMP6400FDS63B1M	H109, H119
KSEMP6500FDS63A1M	H105, H116, H123
KSEMP6500FDS63B1M	H109, H119
KSEMP6600FDS63A1M	H105, H116, H123
KSEMP6600FDS63B1M	H109, H119
KSEMP6700FDS63A1M	H105, H116, H123
KSEMP6700FDS63B1M	H109, H119
KSEMP6800FDS63A1M	H105, H116, H123
KSEMP6800FDS63B1M	H109, H119
KSEMP6900FDS63A1M	H105, H116, H123
KSEMP6900FDS63B1M	H109, H119
KSEMP7000FDS63A1M	H105, H116, H123
KSEMP7000FDS63B1M	H109, H119
KSEMP7100FDS71A1M	H106, H116, H123
KSEMP7100FDS71B1M	H110, H119
KSEMP7200FDS71A1M	H106, H116, H123
KSEMP7200FDS71B1M	H110, H119
KSEMP7300FDS71A1M	H106, H116, H123
KSEMP7300FDS71B1M	H110, H119
KSEMP7400FDS71A1M	H106, H116, H123
KSEMP7400FDS71B1M	H110, H119
KSEMP7500FDS71A1M	H106, H116, H123
KSEMP7500FDS71B1M	H110, H119
KSEMP7600FDS71A1M	H106, H117, H123
KSEMP7600FDS71B1M	H110, H119
KSEMP7700FDS71A1M	H106, H117, H123
KSEMP7700FDS71B1M	H110, H119
KSEMP7800FDS71A1M	H106, H117, H123
KSEMP7800FDS71B1M	H110, H119
KSEMP7900FDS71A1M	H106, H117, H123
KSEMP7900FDS71B1M	H110, H120
KSEMP8000FDS80A1M	H106, H117, H123
KSEMP8000FDS80B1M	H110, H120
KSEMP8100FDS80A1M	H106, H117, H123
KSEMP8100FDS80B1M	H110, H120
KSEMP8200FDS80A1M	H106, H117, H123
KSEMP8200FDS80B1M	H110, H120
KSEMP8300FDS80A1M	H106, H117, H123
KSEMP8300FDS80B1M	H110, H120
KSEMP8400FDS80A1M	H106, H117, H123
KSEMP8400FDS80B1M	H110, H120
KSEMP8500FDS80A1M	H106, H117, H123
KSEMP8500FDS80B1M	H110, H120
KSEMP8600FDS80A1M	H106, H117, H123
KSEMP8600FDS80B1M	H110, H120
KSEMP8700FDS80A1M	H106, H117, H123
KSEMP8700FDS80B1M	H110, H120
KSEMP8800FDS80A1M	H106, H117, H123
KSEMP8800FDS80B1M	H110, H120
KSEMP8900FDS80A1M	H106, H117, H123
KSEMP8900FDS80B1M	H110, H120
KSEMP9000FDS90A1M	H106, H117, H123
KSEMP9000FDS90B1M	H110, H120
KSEMP9100FDS90A1M	H106, H117, H123
KSEMP9100FDS90B1M	H110, H120
KSEMP9200FDS90A1M	H106, H117, H123
KSEMP9200FDS90B1M	H110, H120
KSEMP9300FDS90A1M	H106, H117, H123
KSEMP9300FDS90B1M	H110, H120
KSEMP9400FDS90A1M	H106, H117, H123
KSEMP9400FDS90B1M	H110, H120
KSEMP9500FDS90A1M	H106, H117, H123
KSEMP9500FDS90B1M	H110, H120
KSEMP9600FDS90A1M	H106, H117, H123
KSEMP9600FDS90B1M	H110, H120
KSEMP9700FDS90A1M	H106, H117, H123

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KSEMP9700FDS90B1M	H110, H120
KSEMP9800FDS90A1M	H106, H117, H123
KSEMP9800FDS90B1M	H110, H120
KSEMP9900FDS90A1M	H106, H117, H123
KSEMP9900FDS90B1M	H110, H120
KSHR1000HN5345C10	S20
KSHR1000HN7545C10	S24
KSHR1000HN7545M10	S24
KSHR100D02C075HN06L480	S9
KSHR100D02W075HN06	S8
KSHR100D03C075HN06L480	S9
KSHR100D03C100HN06L800	S9
KSHR100D03W075HN06	S8
KSHR1200HN5345C10	S20
KSHR125D03C100HN06L520	S9
KSHR125D03W100HN06	S8
KSHR125D04C100HN06L520	S9
KSHR125D04W100HN06	S8
KSHR150HN4345F2	S10
KSHR150HN4345M3	S10
KSHR200HN4345C3	S10
KSHR200HN4345F3	S10
KSHR200HN4345M3	S10
KSHR200HN5345C3	S20
KSHR200HN5345M3	S20
KSHR250HN4345C3	S10
KSHR250HN4345F3	S10
KSHR250HN4345M3	S10
KSHR250HN5345C3	S20
KSHR250HN5345M3	S20
KSHR250HN5345XC3	S20
KSHR300HN4345C4	S10
KSHR300HN4345F4	S10
KSHR300HN4345M4	S10
KSHR300HN5345C4	S20
KSHR300HN5345M4	S20
KSHR300HN5345XC4	S20
KSHR300HN7545M4	S24
KSHR400HN4345C6	S10
KSHR400HN4345F6	S10
KSHR400HN4345M6	S10
KSHR400HN5345C5	S20
KSHR400HN5345M5	S20
KSHR400HN5345XC5	S20
KSHR400HN7545M5	S24
KSHR500HN4345C6	S10
KSHR500HN4345F6	S10
KSHR500HN4345M6	S10
KSHR500HN5345C6	S20
KSHR500HN5345M6	S20
KSHR500HN5345XC6	S20
KSHR500HN7545M6	S24
KSHR600HN5345C8	S20
KSHR600HN5345M8	S20
KSHR600HN5345XC8	S20
KSHR600HN7545M8	S24
KSHR800HN5345C10	S20
KSHR800HN7545M10	S24
KSHRHD150HN43F2	S14
KSHRHD150HN43M2	S14
KSHRHD200HN43C3	S14
KSHRHD200HN43M3	S14
KSHRHD250HN43M3	S14
KSHRHD300HN43C4	S14
KSHRHD300HN43M4	S14
KSHRHD400HN43C6	S14
KSHRHD500HN43C6	S14
KSHRHD500HN43M6	S14
KSHRHF100D02C075HN43L480	S4
KSHRHF100D03C075HN43L480	S4
KSHRHF125D04C100HN43L520	S4
KSHRHF150HN43F3	S5
KSHRHF200HN43M3	S5
KSHRHF200HN5315C3	S17
KSHRHF250HN43M3	S5
KSHRHF250HN5315C3	S17
KSHRHF300HN43M4	S5
KSHRHF300HN5315C4	S17
KSHRHF400HN5315C5	S17
KSHRHF500HN5315C6	S17
KSHRHF600HN5315C8	S17
KSOM1250F5345F5	S44
KSOM1250F5345M3	S44
KSOM125Z03C1000F53X	S44
KSOM1500F5345F3	S44
KSOM1500F5345M3	S44
KSOM150Z040F53S050X	S45
KSOM2000F5345M3	S45
KSOM200Z060F53S075X	S45
KSOM2500F5345M3	S45
KSOM2500F6445F3	S50
KSOM2500F6445M3	S50
KSOM250Z070F53S075X	S45
KSOM3000F5345M4	S45
KSOM3000F6445F4	S50
KSOM3000F6445M4	S50
KSOM300Z090F53S100X	S45
KSOM4000F5345M5	S45
KSOM4000F6445F5	S50
KSOM4000F6445M5	S50
KSOM5000F5345F6	S45
KSOM5000F5345M6	S45
KSOM5000F6445F6	S50
KSOM5000F6445M6	S50
KSOM6000F6445F8	S50
KSOM6000F6445M8	S50
KSRM125R4302C125L600	V82
KSRM125R4303C125L1000	V82
KSRM125R4303M16L150	V81
KSRM150R4304C125L1000	V82
KSRM150R4304C125L600	V82
KSRM150R4304M16L150	V81
KSRM200R4303S075L197	V83
KSRM200R4305S075L197	V83
KSRM250R4304S075L197	V83
KSRM250R4306S075L197	V83
KSRM300R4305S100L197	V83
KSRM300R4307S100L197	V83
KSSC551-630L	U28–29
KSSC551-630R	U28–29
KSSC630-709L	U28
KSSC630-709R	U28
KSSC709-813L	U35, U37
KSSC709-813R	U35, U37
KSSC709813LX	U35
KSSC709813RX	U35
KSSC813-917L	U36
KSSC813-917R	U36
KSSC813917LX	U36
KSSC813917RX	U36
KSSCP551-709	U28–29
KSSCP709-917	U35–37
KSSISR1000SD430M10	T113
KSSISR197SE44345C3	S39
KSSISR197SE44345M3	S39
KSSISR200SD430C3	T113
KSSISR200SD430F3	T113
KSSISR200SD430M3	T113
KSSISR248SE44345C4	S39
KSSISR248SE44345M4	S39
KSSISR250SD430F4	T113
KSSISR250SD430M4	T113
KSSISR300SD430C4	T113
KSSISR300SD430F4	T113
KSSISR300SD430M4	T113
KSSISR315SE44345C4	S39
KSSISR315SE44345M4	S39
KSSISR394SE44345C5	S39
KSSISR394SE44345M5	S39
KSSISR400SD430C5	T113
KSSISR400SD430C6	T113
KSSISR400SD430F5	T113
KSSISR400SD430F6	T113
KSSISR400SD430M5	T113
KSSISR400SD430M6	T113
KSSISR492SE44345C6	S39
KSSISR492SE44345M6	S39
KSSISR500SD430C6	T113
KSSISR500SD430F6	T113
KSSISR500SD430M6	T113
KSSISR600SD430C6	T113
KSSISR600SD430C8	T113
KSSISR600SD430F6	T113
KSSISR600SD430M6	T113
KSSISR600SD430M8	T113
KSSISR630SE44345C6	S39
KSSISR630SE44345M6	S39
KSSISR787SE44345C10	S39
KSSISR787SE44345M10	S39
KSSISR800SD430C10	T113
KSSISR800SD430F10	T113
KSSISR800SD430M10	T113
KSSM87D200SN440S075Z05	S58
KSSM87D300SN440S100Z07	S58
KSSM87D300SN440S100Z09	S58
KSSM87D400SN440S150Z08	S58
KSSM87D400SN440S150Z11	S58
KSSM87D600SN440S150Z12	S58
KSSM87D600SN440S150Z16	S58
KSSM88D200SN3125S075Z05	S56
KSSM88D200SN3125S075Z06	S56
KSSM88D300SN3125S100Z07	S56
KSSM88D300SN3125S100Z09	S56
KSSM88D400SN3125S150Z08	S56
KSSP200R3SD43L125	T120
KSSP200R3SD43L168	T120
KSSP200R3SD43L200HC	T120
KSSP200R3SD43W125L169	T119
KSSP250R3SD43L200	T120
KSSP300R4SD43L240	T120
KSSP300R5SD43L400HC	T120
KSSR150SP10T30F2	T109
KSSR200SP10T30F3	T109
KSSR250SN434M3	S88
KSSR250SP10T30F4	T109
KSSR300SN434M4	S88
KSSR300SP10T30F4	T109
KSSR400SN434M5	S88
KSSR400SP10T30F5	T109
KSSS1000ASD43N709-813	U35
KSSS1000ASD43N750	U33
KSSS1000ASD43R750	U32
KSSS1200ASD43N709-813	U35
KSSS1200ASD43N813-917	U36
KSSS1200ASP10N630-709	U28
KSSS1200BSD43N709-813	U37
KSSS400ASP10L625	U25
KSSS400ASP10N551-630	U28
KSSS400ASP10N625	U26
KSSS400ASP10R625	U25
KSSS400BSP10N551-630	U29
KSSS400BSP10N625	U27
KSSS500ASD43N709-813	U35
KSSS500ASP10L625	U25
KSSS500ASP10N625	U26
KSSS500ASP10N630-709	U28
KSSS500BSD43N709-813	U37
KSSS500BSP10N625	U27
KSSS600ASD43L750	U32
KSSS600ASD43N709-813	U35
KSSS600ASD43N750	U33
KSSS600ASD43N813-917	U36
KSSS600ASD43R750	U32
KSSS600ASP10N551-630	U28
KSSS600ASP10N625	U26
KSSS600BSD43N750	U34
KSSS800ASD43L750	U32
KSSS800ASD43N750	U33
KSSS800ASD43N813-917	U36
KSSS800ASD43R750	U32
KSSS800ASP10N551-630	U28
KSSS800BSD43N750	U34
KSSS800BSP10N625	U27
KSSW551-630	U28–29
KSSW630-709	U28
KSSW709-813	U35, U37
KSSW813-917	U36
KSSZR200SD430C3A04	V141
KSSZR200SD430M3A05	V141
KSSZR250SD430C3A05	V141
KSSZR250SD430M3A06	V141
KSSZR300SD430C4A05	V141
KSSZR300SD430F4A07	V141
KSSZR300SD430M4A06	V141
KSSZR400SD430C5A07	V141
KSSZR400SD430C6A07	V141
KSSZR400SD430F5A09	V141
KSSZR400SD430F6A09	V141
KSSZR400SD430M5A08	V141
KSSZR400SD430M6A08	V141
KSSZR500SD430M6A09	V141
KST115115AS	K42
KST135155AS	K42
KST175200AS	K42
KST175200RK	K43
KST175CS	K43
KST200CS	K43
KST250250AS	K42
KST250250RK	K43
KST250CS	K43
KST300350AS	K42
KST300350RK	K43
KST300CS	K43
KST350CS	K43
KT15	K76, K89–90, S122–123, V121–123
KT20	V121–123, V132–133
KT25	C143, C145
KT27	K77–78, K88
KT30	V121–123, V132
KT30L	C143, C145
KT6	V123
KT8	K76, V122–123
KT9	S64, S67, S70
KTFS0237R03SS031	H20
KTFS0237R05SS031	H20
KTFS0237R08SS031	H20
KTFS0249R03SS031	H20
KTFS0249R05SS031	H20
KTFS0249R08SS031	H20
KTFS0260R03SS031	H20
KTFS0260R05SS031	H20
KTFS0260R08SS031	H20
KTFS0276R03SS031	H20
KTFS0276R05SS031	H20
KTFS0276R08SS031	H20
KTFS0296R03SS031	H20
KTFS0296R05SS031	H20
KTFS0296R08SS031	H20
KTFS0315R03SS038	H20
KTFS0315R05SS038	H20
KTFS0315R08SS038	H20
KTFS0335R03SS038	H20
KTFS0335R05SS038	H20
KTFS0335R08SS038	H20
KTFS0355R03SS038	H20
KTFS0355R05SS038	H20
KTFS0355R08SS038	H20
KTFS0375R03SS038	H20
KTFS0375R05SS038	H20
KTFS0375R08SS038	H20
KTFS0394R03SS044	H20
KTFS0394R05SS044	H20
KTFS0394R08SS044	H20
KTFS0414R03SS044	H20
KTFS0414R05SS044	H20
KTFS0414R08SS044	H20
KTFS0434R03SS044	H20
KTFS0434R05SS044	H20
KTFS0434R08SS044	H20
KTFS0453R03SS050	H20
KTFS0453R05SS050	H20
KTFS0453R08SS050	H20
KTFS0473R03SS050	H20
KTFS0473R05SS050	H20
KTFS0473R08SS050	H20
KTFS0493R03SS050	H20
KTFS0493R05SS050	H20
KTFS0493R08SS050	H20
KTFS0512R03SS056	H20
KTFS0512R05SS056	H20
KTFS0512R08SS056	H20
KTFS0532R03SS056	H20
KTFS0532R05SS056	H20
KTFS0532R08SS056	H20
KTFS0552R03SS056	H20
KTFS0552R05SS056	H20
KTFS0552R08SS056	H20
KTFS0571R03SS063	H20

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KTFS0571R05SS063	H20
KTFS0571R08SS063	H20
KTFS0591R03SS063	H20
KTFS0591R05SS063	H20
KTFS0591R08SS063	H20
KTFS060R01SS08M	H18
KTFS060R03SS08M	H18
KTFS060R05SS08M	H18
KTFS060R08SS08M	H18
KTFS060R12SF12M	H18
KTFS0630R03SS063	H20
KTFS0630R05SS063	H20
KTFS0630R08SS063	H20
KTFS063R01SS08M	H18
KTFS063R03SS08M	H18
KTFS063R05SS08M	H18
KTFS063R08SS08M	H18
KTFS063R12SF12M	H18
KTFS066R01SS08M	H18
KTFS066R03SS08M	H18
KTFS066R05SS08M	H18
KTFS066R08SS08M	H18
KTFS066R12SF12M	H18
KTFS0670R03SS075	H20
KTFS0670R05SS075	H20
KTFS0670R08SS075	H20
KTFS0709R03SS075	H20
KTFS0709R05SS075	H20
KTFS0709R08SS075	H20
KTFS070R01SS08M	H18
KTFS070R03SS08M	H18
KTFS070R05SS08M	H18
KTFS070R08SS08M	H18
KTFS070R12SF12M	H18
KTFS0749R03SS075	H20
KTFS0749R05SS075	H20
KTFS0749R08SS075	H20
KTFS075R01SS08M	H18
KTFS075R03SS08M	H18
KTFS075R05SS08M	H18
KTFS075R08SS08M	H18
KTFS075R12SF12M	H18
KTFS0788R03SCF100	H20
KTFS0788R05SCF100	H20
KTFS0788R08SCF100	H20
KTFS080R01SS10M	H18
KTFS080R03SCF12M	H19
KTFS080R03SS10M	H18
KTFS080R05SCF12M	H19
KTFS080R05SS10M	H18
KTFS080R08SCF12M	H19
KTFS080R08SS10M	H18
KTFS080R12SF12M	H18
KTFS0827R03SCF100	H20
KTFS0827R05SCF100	H20
KTFS0827R08SCF100	H20
KTFS085R01SS10M	H18
KTFS085R03SCF12M	H19
KTFS085R03SS10M	H18
KTFS085R05SCF12M	H19
KTFS085R05SS10M	H18
KTFS085R08SCF12M	H19
KTFS085R08SS10M	H18
KTFS085R12SF12M	H18
KTFS0867R03SCF100	H20
KTFS0867R05SCF100	H20
KTFS0867R08SCF100	H20
KTFS0906R03SCF100	H20
KTFS0906R05SCF100	H20
KTFS0906R08SCF100	H20
KTFS090R01SS10M	H18
KTFS090R03SCF12M	H19
KTFS090R03SS10M	H18
KTFS090R05SCF12M	H19
KTFS090R05SS10M	H18
KTFS090R08SCF12M	H19
KTFS090R08SS10M	H18
KTFS090R12SF12M	H18
KTFS0945R03SCF100	H20
KTFS0945R05SCF100	H20
KTFS0945R08SCF100	H20
KTFS095R01SS10M	H18
KTFS095R03SCF12M	H19
KTFS095R03SS10M	H18
KTFS095R05SCF12M	H19
KTFS095R05SS10M	H18
KTFS095R08SCF12M	H19
KTFS095R08SS10M	H18
KTFS095R12SF12M	H18
KTFS0985R03SCF100	H20
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KTFS100R01SS12M	H18
KTFS100R03SCF16M	H19
KTFS100R03SS12M	H18
KTFS100R05SCF16M	H19
KTFS100R05SS12M	H18
KTFS100R08SCF16M	H19
KTFS100R08SS12M	H18
KTFS100R12SF16M	H18
KTFS105R01SS12M	H18
KTFS105R03SCF16M	H19
KTFS105R03SS12M	H18
KTFS105R05SCF16M	H19
KTFS105R05SS12M	H18
KTFS105R08SCF16M	H19
KTFS105R08SS12M	H18
KTFS105R12SF16M	H18
KTFS110R01SS12M	H18
KTFS110R03SCF16M	H19
KTFS110R03SS12M	H18
KTFS110R05SCF16M	H19
KTFS110R05SS12M	H18
KTFS110R08SCF16M	H19
KTFS110R08SS12M	H18
KTFS110R12SF16M	H18
KTFS115R01SS12M	H18
KTFS115R03SCF16M	H19
KTFS115R03SS12M	H18
KTFS115R05SCF16M	H19
KTFS115R05SS12M	H18
KTFS115R08SCF16M	H19
KTFS115R08SS12M	H18
KTFS115R12SF16M	H18
KTFS120R01SS14M	H18
KTFS120R03SCF16M	H19
KTFS120R03SS14M	H18
KTFS120R05SCF16M	H19
KTFS120R05SS14M	H18
KTFS120R08SCF16M	H19
KTFS120R08SS14M	H18
KTFS120R12SF16M	H18
KTFS125R01SS14M	H18
KTFS125R03SCF16M	H19
KTFS125R03SS14M	H18
KTFS125R05SCF16M	H19
KTFS125R05SS14M	H18
KTFS125R08SCF16M	H19
KTFS125R08SS14M	H18
KTFS125R12SF16M	H18
KTFS130R01SS14M	H18
KTFS130R03SCF16M	H19
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KTFS135R03SS14M	H18
KTFS135R05SCF16M	H19
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KTFS135R08SCF16M	H19
KTFS135R08SS14M	H18
KTFS135R12SF16M	H18
KTFS140R01SS16M	H18
KTFS140R03SCF16M	H19
KTFS140R03SS16M	H18
KTFS140R05SCF16M	H19
KTFS140R05SS16M	H18
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KTFS140R08SS16M	H18
KTFS140R12SF16M	H18
KTFS145R01SS16M	H18
KTFS145R03SCF16M	H19
KTFS145R03SS16M	H18
KTFS145R05SCF16M	H19
KTFS145R05SS16M	H18
KTFS145R08SCF16M	H19
KTFS145R08SS16M	H18
KTFS145R12SF16M	H18
KTFS150R01SS16M	H18
KTFS150R03SCF20M	H19
KTFS150R03SS16M	H18
KTFS150R05SCF20M	H19
KTFS150R05SS16M	H18
KTFS150R08SCF20M	H19
KTFS150R08SS16M	H18
KTFS150R12SF20M	H18
KTFS160R01SS16M	H18
KTFS160R03SCF20M	H19
KTFS160R03SS16M	H18
KTFS160R05SCF20M	H19
KTFS160R05SS16M	H18
KTFS160R08SCF20M	H19
KTFS160R08SS16M	H18
KTFS160R12SF20M	H18
KTFS170R01SS20M	H18
KTFS170R03SCF20M	H19
KTFS170R03SS20M	H18
KTFS170R05SCF20M	H19
KTFS170R05SS20M	H18
KTFS170R08SCF20M	H19
KTFS170R08SS20M	H18
KTFS170R12SF20M	H18
KTFS180R01SS20M	H18
KTFS180R03SCF25M	H19
KTFS180R03SS20M	H18
KTFS180R05SCF25M	H19
KTFS180R05SS20M	H18
KTFS180R08SCF25M	H19
KTFS180R08SS20M	H18
KTFS180R12SF25M	H18
KTFS190R01SS20M	H18
KTFS190R03SCF25M	H19
KTFS190R03SS20M	H18
KTFS190R05SCF25M	H19
KTFS190R05SS20M	H18
KTFS190R08SCF25M	H19
KTFS190R08SS20M	H18
KTFS190R12SF25M	H18
KTFS200R01SCF25M	H19
KTFS200R03SCF25M	H19
KTFS200R05SCF25M	H19
KTFS200R08SCF25M	H19
KTFS200R12SCF25M	H19
KTFS210R01SCF25M	H19
KTFS210R03SCF25M	H19
KTFS210R05SCF25M	H19
KTFS210R08SCF25M	H19
KTFS210R12SCF25M	H19
KTFS220R01SCF25M	H19
KTFS220R03SCF25M	H19
KTFS220R05SCF25M	H19
KTFS220R08SCF25M	H19
KTFS220R12SCF25M	H19
KTFS230R01SCF25M	H19
KTFS230R03SCF25M	H19
KTFS230R05SCF25M	H19
KTFS230R08SCF25M	H19
KTFS230R12SCF25M	H19
KTFS240R01SCF25M	H19
KTFS240R03SCF25M	H19
KTFS240R05SCF25M	H19
KTFS240R08SCF25M	H19
KTFS240R12SCF25M	H19
KTFS250R01SCF25M	H19
KTFS250R03SCF25M	H19
KTFS250R05SCF25M	H19
KTFS250R08SCF25M	H19
KTFS250R12SCF25M	H19
KTFSS02500HPG KCP15A	H8
KTFSS02610HPG KCP15A	H8
KTFSS02656HPG KCP15A	H8
KTFSS02720HPG KCP15A	H8
KTFSS02813HPG KCP15A	H8
KTFSS02900HPG KCP15A	H8
KTFSS02969HPG KCP15A	H8
KTFSS03125HPG KCP15A	H8
KTFSS03214HPG KCP15A	H8
KTFSS03230HPG KCP15A	H8
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KTFSS03320HPG KCP15A	H8
KTFSS03390HPG KCP15A	H8
KTFSS03438HPG KCP15A	H8
KTFSS03480HPG KCP15A	H8
KTFSS03580HPG KCP15A	H8
KTFSS03594HPG KCP15A	H8
KTFSS03680HPG KCP15A	H8
KTFSS03750HPG KCP15A	H8
KTFSS03763HPG KCP15A	H8
KTFSS03906HPG KCP15A	H8
KTFSS03946HPG KCP15A	H8
KTFSS03970HPG KCP15A	H8
KTFSS04040HPG KCP15A	H8
KTFSS04063HPG KCP15A	H8
KTFSS04130HPG KCP15A	H8
KTFSS04219HPG KCP15A	H8
KTFSS04375HPG KCP15A	H8
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KTFSS04688HPG KCP15A	H9
KTFSS04844HPG KCP15A	H9
KTFSS04911HPG KCP15A	H9
KTFSS05000HPG KCP15A	H9
KTFSS05156HPG KCP15A	H9
KTFSS05312HPG KCP15A	H9
KTFSS05469HPG KCP15A	H9
KTFSS05471HPG KCP15A	H9
KTFSS05625HPG KCP15A	H9
KTFSS05774HPG KCP15A	H9
KTFSS05781HPG KCP15A	H9
KTFSS05938HPG KCP15A	H9
KTFSS06000HPGM KCP15A	H8
KTFSS06094HPG KCP15A	H9
KTFSS06100HPGM KCP15A	H8
KTFSS06200HPGM KCP15A	H8
KTFSS06250HPG KCP15A	H9
KTFSS06300HPGM KCP15A	H8
KTFSS06310HPG KCP15A	H9
KTFSS06340HPG KCP15A	H9
KTFSS06400HPGM KCP15A	H8
KTFSS06406HPG KCP15A	H9
KTFSS06500HPGM KCP15A	H8
KTFSS06530HPGM KCP15A	H8
KTFSS06563HPG KCP15A	H9
KTFSS06600HPGM KCP15A	H8
KTFSS06700HPGM KCP15A	H8
KTFSS06719HPG KCP15A	H9
KTFSS06800HPGM KCP15A	H8
KTFSS06875HPG KCP15A	H9
KTFSS06900HPGM KCP15A	H8
KTFSS07000HPGM KCP15A	H8
KTFSS07031HPG KCP15A	H9
KTFSS07100HPGM KCP15A	H8
KTFSS07188HPG KCP15A	H9
KTFSS07200HPGM KCP15A	H8
KTFSS07344HPG KCP15A	H9
KTFSS07400HPGM KCP15A	H8
KTFSS07500HPG KCP15A	H9
KTFSS07500HPGM KCP15A	H8
KTFSS07570HPG KCP15A	H9
KTFSS07580HPG KCP15A	H9
KTFSS07590HPG KCP15A	H9
KTFSS07600HPGM KCP15A	H8
KTFSS07620HPG KCP15A	H9
KTFSS07656HPG KCP15A	H10
KTFSS07700HPGM KCP15A	H8
KTFSS07800HPGM KCP15A	H8
KTFSS07813HPG KCP15A	H10
KTFSS07900HPGM KCP15A	H8
KTFSS07969HPG KCP15A	H10
KTFSS08000HPGM KCP15A	H8
KTFSS08100HPGM KCP15A	H8
KTFSS08125HPG KCP15A	H10
KTFSS08300HPGM KCP15A	H8
KTFSS08400HPGM KCP15A	H8
KTFSS08438HPG KCP15A	H10

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KTFSS08500HPGM KCP15A	H8
KTFSS08594HPG KCP15A	H10
KTFSS08600HPGM KCP15A	H8
KTFSS08700HPGM KCP15A	H8
KTFSS08750HPG KCP15A	H10
KTFSS08800HPGM KCP15A	H8
KTFSS08900HPGM KCP15A	H8
KTFSS09000HPGM KCP15A	H8
KTFSS09100HPGM KCP15A	H8
KTFSS09200HPGM KCP15A	H8
KTFSS09219HPG KCP15A	H10
KTFSS09300HPGM KCP15A	H8
KTFSS09375HPG KCP15A	H10
KTFSS09400HPGM KCP15A	H8
KTFSS09500HPGM KCP15A	H8
KTFSS09600HPGM KCP15A	H8
KTFSS09688HPG KCP15A	H10
KTFSS09700HPGM KCP15A	H8
KTFSS09800HPGM KCP15A	H8
KTFSS09900HPGM KCP15A	H8
KTFSS10000HPG KCP15A	H10
KTFSS10000HPGM KCP15A	H8
KTFSS10100HPGM KCP15A	H8
KTFSS10110HPG KCP15A	H10
KTFSS10160HPG KCP15A	H10
KTFSS10200HPGM KCP15A	H8
KTFSS10300HPGM KCP15A	H8
KTFSS10400HPGM KCP15A	H8
KTFSS10500HPGM KCP15A	H8
KTFSS10600HPGM KCP15A	H8
KTFSS10700HPGM KCP15A	H8
KTFSS10800HPGM KCP15A	H8
KTFSS10900HPGM KCP15A	H8
KTFSS11000HPGM KCP15A	H8
KTFSS11100HPGM KCP15A	H8
KTFSS11200HPGM KCP15A	H8
KTFSS11300HPGM KCP15A	H9
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KTFSS19400HPGM KCP15A	H10
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KTFSS19500HPGM KCP15A	H10
KTFSS19600HPGM KCP15A	H10
KTFSS19700HPGM KCP15A	H10
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KTFSS19900HPGM KCP15A	H10
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KTFSS22700HPGM KCP15A	H10
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KTFSS22900HPGM KCP15A	H10
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KTFST10700HPLM KCMS15	H15
KTFST10800HPCM KC7410	H12
KTFST10800HPLM KCMS15	H15
KTFST10900HPLM KCMS15	H15
KTFST11000HPCM KC7410	H12
KTFST11000HPLM KCMS15	H15

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KTFST11100HPCM KC7410	H12
KTFST11100HPLM KCMS15	H15
KTFST11200HPLM KCMS15	H15
KTFST11400HPCM KC7410	H12
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KTIP0787R3SCF100	H41
KTIP0787R3SS081	H39
KTIP0787R5SCF100	H41
KTIP0787R5SS081	H39
KTIP0787R8SCF100	H41

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KTIP0787R8SS081	H39
KTIP07969HP KCP15	H34
KTIP0800FEGM KCPM45	H36
KTIP0800HPM KCP15	H32
KTIP080R12SS10M	H38
KTIP080R1SCF12M	H40
KTIP080R1SS10M	H38
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KTIP080R3BF09M	I11
KTIP080R3SCF12M	H40
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KTIP080R5SCF12M	H40
KTIP080R5SS10M	H38
KTIP080R8SCF12M	H40
KTIP080R8SS10M	H38
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KTIP08125HP KCP15	H34
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KTIP085R5SS10M	H38
KTIP085R8SCF12M	H40
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KTIP0900FEGM KCPM45	H36
KTIP0900HPM KCP15	H32
KTIP0906R12SS094	H39
KTIP0906R3SCF100	H41
KTIP0906R3SS094	H39
KTIP0906R5SCF100	H41
KTIP0906R5SS094	H39
KTIP0906R8SCF100	H41
KTIP0906R8SS094	H39
KTIP090R12SS10M	H38
KTIP090R1SCF12M	H40
KTIP090R1SS10M	H38
KTIP090R3BF09M	I11
KTIP090R3BF10M	I11
KTIP090R3SCF12M	H40
KTIP090R3SS10M	H38
KTIP090R4BF10M	I12
KTIP090R5BF10M	I13
KTIP090R5SCF12M	H40
KTIP090R5SS10M	H38
KTIP090R8SCF12M	H40
KTIP090R8SS10M	H38
KTIP0910HPM KCP15	H32
KTIP0920HPM KCP15	H32
KTIP0930HPM KCP15	H32
KTIP09375HP KCP15	H34
KTIP0940HPM KCP15	H32
KTIP0945R12SS100	H39
KTIP0945R3SCF100	H41
KTIP0945R3SS100	H39
KTIP0945R5SCF100	H41
KTIP0945R5SS100	H39
KTIP0945R8SCF100	H41
KTIP0945R8SS100	H39
KTIP0950FEGM KCPM45	H36
KTIP0950HPM KCP15	H32
KTIP095R12SS10M	H38
KTIP095R1SCF12M	H40
KTIP095R1SS10M	H38
KTIP095R3BF10M	I11
KTIP095R3SCF12M	H40
KTIP095R3SS10M	H38
KTIP095R4BF10M	I12
KTIP095R5BF10M	I13
KTIP095R5SCF12M	H40
KTIP095R5SS10M	H38
KTIP095R8SCF12M	H40
KTIP095R8SS10M	H38
KTIP0960HPM KCP15	H32
KTIP09688HP KCP15	H34
KTIP0983HPM KCP15	H32
KTIP0984R12SS100	H39
KTIP0984R3SCF100	H41
KTIP0984R3SS100	H39
KTIP0984R5SCF100	H41
KTIP0984R5SS100	H39
KTIP0984R8SCF100	H41
KTIP0984R8SS100	H39
KTIP0990HPM KCP15	H32
KTIP10000HP KCP15	H34
KTIP1000FEGM KCPM45	H36
KTIP1000HPM KCP15	H32
KTIP100R12SS12M	H38
KTIP100R1SCF16M	H40
KTIP100R1SS12M	H38
KTIP100R3BF10M	I11
KTIP100R3BF11M	I11
KTIP100R3SCF16M	H40
KTIP100R3SS12M	H38
KTIP100R4BF11M	I12
KTIP100R5BF11M	I13
KTIP100R5SCF16M	H40
KTIP100R5SS12M	H38
KTIP100R8SCF16M	H40
KTIP100R8SS12M	H38
KTIP1010FEGM KCPM45	H36
KTIP1010HPM KCP15	H32
KTIP10110HP KCP15	H34
KTIP10160HP KCP15	H34
KTIP1020HPM KCP15	H32
KTIP1024R12SS125	H39
KTIP1024R3SCF100	H41
KTIP1024R3SS125	H39
KTIP1024R5SCF100	H41
KTIP1024R5SS125	H39
KTIP1024R8SCF100	H41
KTIP1024R8SS125	H39
KTIP1030HPM KCP15	H32
KTIP10310HP KCP15	H34
KTIP1040HPM KCP15	H32
KTIP10469HP KCP15	H34
KTIP1050FEGM KCPM45	H36
KTIP1050HPM KCP15	H32
KTIP105R12SS12M	H38
KTIP105R1SCF16M	H40
KTIP105R1SS12M	H38
KTIP105R3BF11M	I11
KTIP105R3SCF16M	H40
KTIP105R3SS12M	H38
KTIP105R4BF11M	I12
KTIP105R5BF11M	I13
KTIP105R5SCF16M	H40
KTIP105R5SS12M	H38
KTIP105R8SCF16M	H40
KTIP105R8SS12M	H38
KTIP1060HPM KCP15	H32
KTIP1063R12SS125	H39
KTIP1063R3SCF100	H41
KTIP1063R3SS125	H39
KTIP1063R5SCF100	H41
KTIP1063R5SS125	H39
KTIP1063R8SCF100	H41
KTIP1063R8SS125	H39
KTIP1070HPM KCP15	H32
KTIP1080FEGM KCPM45	H36
KTIP1080HPM KCP15	H32
KTIP1090HPM KCP15	H32
KTIP10938HP KCP15	H34
KTIP1100FEGM KCPM45	H36
KTIP1100HPM KCP15	H32
KTIP110R12SS12M	H38
KTIP110R1SCF16M	H40
KTIP110R1SS12M	H38
KTIP110R3BF11M	I11
KTIP110R3BF12M	I11
KTIP110R3SCF16M	H40
KTIP110R3SS12M	H38
KTIP110R4BF12M	I12
KTIP110R5BF12M	I13
KTIP110R5SCF16M	H40
KTIP110R5SS12M	H38
KTIP110R8SCF16M	H40
KTIP110R8SS12M	H38
KTIP1110HPM KCP15	H32
KTIP1120HPM KCP15	H32
KTIP1130HPM KCP15	H32
KTIP1140HPM KCP15	H32
KTIP1150FEGM KCPM45	H36
KTIP1150HPM KCP15	H32
KTIP115R12SS12M	H38
KTIP115R1SCF16M	H40
KTIP115R1SS12M	H38
KTIP115R3BF12M	I11
KTIP115R3SCF16M	H40
KTIP115R3SS12M	H38
KTIP115R4BF12M	I12
KTIP115R5BF12M	I13
KTIP115R5SCF16M	H40
KTIP115R5SS12M	H38
KTIP115R8SCF16M	H40
KTIP115R8SS12M	H38
KTIP1160HPM KCP15	H32
KTIP1170FEGM KCPM45	H36
KTIP1170HPM KCP15	H32
KTIP1180HPM KCP15	H32
KTIP1190HPM KCP15	H32
KTIP1200FEGM KCPM45	H36
KTIP1200HPM KCP15	H33
KTIP120R12SS14M	H38
KTIP120R1SCF16M	H40
KTIP120R1SS14M	H38
KTIP120R3BF12M	I11
KTIP120R3BF13M	I11
KTIP120R3SCF16M	H40
KTIP120R3SS14M	H38
KTIP120R4BF13M	I12
KTIP120R5BF13M	I13
KTIP120R5SCF16M	H40
KTIP120R5SS14M	H38
KTIP120R8SCF16M	H40
KTIP120R8SS14M	H38
KTIP1210HPM KCP15	H33
KTIP1220HPM KCP15	H33
KTIP1240HPM KCP15	H33
KTIP1250FEGM KCPM45	H36
KTIP1250HPM KCP15	H33
KTIP125R12SS14M	H38
KTIP125R1SCF16M	H40
KTIP125R1SS14M	H38
KTIP125R3BF13M	I11
KTIP125R3SCF16M	H40
KTIP125R3SS14M	H38
KTIP125R4BF13M	I12
KTIP125R5BF13M	I13
KTIP125R5SCF16M	H40
KTIP125R5SS14M	H38
KTIP125R8SCF16M	H40
KTIP125R8SS14M	H38
KTIP1260HPM KCP15	H33
KTIP1280HPM KCP15	H33
KTIP1300FEGM KCPM45	H36
KTIP1300HPM KCP15	H33
KTIP130R12SS14M	H38
KTIP130R1SCF16M	H40
KTIP130R1SS14M	H38
KTIP130R3BF13M	I11
KTIP130R3BF14M	I11
KTIP130R3SCF16M	H40
KTIP130R3SS14M	H38
KTIP130R4BF14M	I12
KTIP130R5BF14M	I13
KTIP130R5SCF16M	H40
KTIP130R5SS14M	H38
KTIP130R8SCF16M	H40
KTIP130R8SS14M	H38
KTIP1320HPM KCP15	H33
KTIP1328HPM KCP15	H33
KTIP1330HPM KCP15	H33
KTIP1338HPM KCP15	H33
KTIP1340HPM KCP15	H33
KTIP1350FEGM KCPM45	H36
KTIP1350HPM KCP15	H33
KTIP135R12SS14M	H38
KTIP135R1SCF16M	H40
KTIP135R1SS14M	H38
KTIP135R3BF14M	I11
KTIP135R3SCF16M	H40
KTIP135R3SS14M	H38
KTIP135R4BF14M	I12
KTIP135R5BF14M	I13
KTIP135R5SCF16M	H40
KTIP135R5SS14M	H38
KTIP135R8SCF16M	H40
KTIP135R8SS14M	H38
KTIP1360HPM KCP15	H33
KTIP1370HPM KCP15	H33
KTIP1380HPM KCP15	H33
KTIP1394HPM KCP15	H33
KTIP1400FEGM KCPM45	H36
KTIP1400HPM KCP15	H33
KTIP140R12SS16M	H38
KTIP140R1SCF16M	H40
KTIP140R1SS16M	H38
KTIP140R3BF14M	I11
KTIP140R3BF15M	I11
KTIP140R3SCF16M	H40
KTIP140R3SS16M	H38
KTIP140R4BF15M	I12
KTIP140R5BF15M	I13
KTIP140R5SCF16M	H40
KTIP140R5SS16M	H38
KTIP140R8SCF16M	H40
KTIP140R8SS16M	H38
KTIP1410HPM KCP15	H33
KTIP1420HPM KCP15	H33
KTIP1430HPM KCP15	H33
KTIP1440HPM KCP15	H33
KTIP1450FEGM KCPM45	H36
KTIP1450HPM KCP15	H33
KTIP145R12SS16M	H38
KTIP145R1SCF16M	H40
KTIP145R1SS16M	H38
KTIP145R3BF15M	I11
KTIP145R3SCF16M	H40
KTIP145R3SS16M	H38
KTIP145R4BF15M	I12
KTIP145R5BF15M	I13
KTIP145R5SCF16M	H40
KTIP145R5SS16M	H38
KTIP145R8SCF16M	H40
KTIP145R8SS16M	H38
KTIP1460HPM KCP15	H33
KTIP1470HPM KCP15	H33
KTIP1480HPM KCP15	H33
KTIP1490FEGM KCPM45	H36
KTIP1490HPM KCP15	H33
KTIP1500FEGM KCPM45	H36
KTIP1500HPM KCP15	H33
KTIP150R12SS16M	H38
KTIP150R1SCF20M	H40
KTIP150R1SS16M	H38
KTIP150R3BF15M	I11

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
KTIP150R3BF16M	I11
KTIP150R3SCF20M	H40
KTIP150R3SS16M	H38
KTIP150R4BF16M	I12
KTIP150R5BF16M	I13
KTIP150R5SCF20M	H40
KTIP150R5SS16M	H38
KTIP150R8SCF20M	H40
KTIP150R8SS16M	H38
KTIP1510HPM KCP15	H33
KTIP1520HPM KCP15	H33
KTIP1530HPM KCP15	H33
KTIP1538HPM KCP15	H33
KTIP1540HPM KCP15	H33
KTIP1550FEGM KCPM45	H36
KTIP1550HPM KCP15	H33
KTIP1560HPM KCP15	H33
KTIP1570HPM KCP15	H33
KTIP1580HPM KCP15	H33
KTIP1595FEGM KCPM45	H36
KTIP1600FEGM KCPM45	H36
KTIP1600HPM KCP15	H33
KTIP160R12SS18M	H38
KTIP160R1SCF20M	H40
KTIP160R1SS18M	H38
KTIP160R3BF16M	I11
KTIP160R3BF17M	I11
KTIP160R3SCF20M	H40
KTIP160R3SS18M	H38
KTIP160R4BF17M	I12
KTIP160R5BF17M	I13
KTIP160R5SCF20M	H40
KTIP160R5SS18M	H38
KTIP160R8SCF20M	H40
KTIP160R8SS18M	H38
KTIP1610HPM KCP15	H33
KTIP1620HPM KCP15	H33
KTIP1630HPM KCP15	H33
KTIP1640HPM KCP15	H33
KTIP1650FEGM KCPM45	H36
KTIP1650HPM KCP15	H33
KTIP1660HPM KCP15	H33
KTIP1670HPM KCP15	H33
KTIP1680HPM KCP15	H33
KTIP1690HPM KCP15	H33
KTIP1700FEGM KCPM45	H36
KTIP1700HPM KCP15	H33
KTIP170R12SS18M	H38
KTIP170R1SCF20M	H40
KTIP170R1SS18M	H38
KTIP170R3BF17M	I11
KTIP170R3BF18M	I11
KTIP170R3SCF20M	H40
KTIP170R3SS18M	H38
KTIP170R4BF18M	I12
KTIP170R5BF18M	I13
KTIP170R5SCF20M	H40
KTIP170R5SS18M	H38
KTIP170R8SCF20M	H40
KTIP170R8SS18M	H38
KTIP1710HPM KCP15	H33
KTIP1720HPM KCP15	H33
KTIP1730HPM KCP15	H33
KTIP1740HPM KCP15	H33
KTIP1750FEGM KCPM45	H36
KTIP1750HPM KCP15	H33
KTIP1760HPM KCP15	H33
KTIP1770FEGM KCPM45	H36
KTIP1770HPM KCP15	H33
KTIP1780HPM KCP15	H33
KTIP1790HPM KCP15	H33
KTIP1800FEGM KCPM45	H36
KTIP1800HPM KCP15	H33
KTIP180R12SS20M	H38
KTIP180R1SCF25M	H40
KTIP180R1SS20M	H38
KTIP180R3BF18M	I11
KTIP180R3SCF25M	H40
KTIP180R3SS20M	H38
KTIP180R4BF18M	I12
KTIP180R5BF18M	I13
KTIP180R5SCF25M	H40
KTIP180R5SS20M	H38
KTIP180R8SCF25M	H40
KTIP180R8SS20M	H38
KTIP1810HPM KCP15	H33
KTIP1820HPM KCP15	H33
KTIP1830HPM KCP15	H33
KTIP1840HPM KCP15	H33
KTIP1850FEGM KCPM45	H36
KTIP1850HPM KCP15	H33
KTIP1860HPM KCP15	H33
KTIP1870HPM KCP15	H33
KTIP1880HPM KCP15	H33
KTIP1890HPM KCP15	H33
KTIP1900FEGM KCPM45	H36
KTIP1900HPM KCP15	H33
KTIP190R12SS20M	H38
KTIP190R1SCF25M	H40
KTIP190R1SS20M	H38
KTIP190R3SCF25M	H40
KTIP190R3SS20M	H38
KTIP190R5SCF25M	H40
KTIP190R5SS20M	H38
KTIP190R8SCF25M	H40
KTIP190R8SS20M	H38
KTIP1910HPM KCP15	H33
KTIP1920HPM KCP15	H33
KTIP1930HPM KCP15	H33
KTIP1940HPM KCP15	H33
KTIP1950FEGM KCPM45	H36
KTIP1950HPM KCP15	H33
KTIP1960HPM KCP15	H33
KTIP1970HPM KCP15	H34
KTIP1980HPM KCP15	H34
KTIP1990HPM KCP15	H34
KTIP2000FEGM KCPM45	H36
KTIP2000HPM KCP15	H34
KTIP200R12SS25M	H38
KTIP200R1SCF25M	H40
KTIP200R1SS25M	H38
KTIP200R3SCF25M	H40
KTIP200R3SS25M	H38
KTIP200R5SCF25M	H40
KTIP200R5SS25M	H38
KTIP200R8SCF25M	H40
KTIP200R8SS25M	H38
KTIP2010HPM KCP15	H34
KTIP2020HPM KCP15	H34
KTIP2030HPM KCP15	H34
KTIP2050HPM KCP15	H34
KTIP2060HPM KCP15	H34
KTIP2070HPM KCP15	H34
KTIP2080HPM KCP15	H34
KTIP2090HPM KCP15	H34
KTIP2099HPM KCP15	H34
KTIP2100HPM KCP15	H34
KTIP210R12SS25M	H38
KTIP210R1SCF25M	H40
KTIP210R1SS25M	H38
KTIP210R3SCF25M	H40
KTIP210R3SS25M	H38
KTIP210R5SCF25M	H40
KTIP210R5SS25M	H38
KTIP210R8SCF25M	H40
KTIP210R8SS25M	H38
KTIP2110HPM KCP15	H34
KTIP2150HPM KCP15	H34
KTIP2200HPM KCP15	H34
KTIP220R12SS25M	H38
KTIP220R1SCF25M	H40
KTIP220R1SS25M	H38
KTIP220R3SCF25M	H40
KTIP220R3SS25M	H38
KTIP220R5SCF25M	H40
KTIP220R5SS25M	H38
KTIP220R8SCF25M	H40
KTIP220R8SS25M	H38
KTIP2250HPM KCP15	H34
KTIP2280HPM KCP15	H34
KTIP2300HPM KCP15	H34
KTIP230R12SS25M	H38
KTIP230R1SCF25M	H40
KTIP230R1SS25M	H38
KTIP230R3SCF25M	H40
KTIP230R3SS25M	H38
KTIP230R5SCF25M	H40
KTIP230R5SS25M	H38
KTIP230R8SCF25M	H40
KTIP230R8SS25M	H38
KTIP2350HPM KCP15	H34
KTIP2400HPM KCP15	H34
KTIP240R12SS25M	H38
KTIP240R1SCF25M	H40
KTIP240R1SS25M	H38
KTIP240R3SCF25M	H40
KTIP240R3SS25M	H38
KTIP240R5SCF25M	H40
KTIP240R5SS25M	H38
KTIP240R8SCF25M	H40
KTIP240R8SS25M	H38
KTIP2450HPM KCP15	H34
KTIP2500HPM KCP15	H34
KTIP250R12SS32M	H38
KTIP250R1SCF25M	H40
KTIP250R1SS32M	H38
KTIP250R3SCF25M	H40
KTIP250R3SS32M	H38
KTIP250R5SCF25M	H40
KTIP250R5SS32M	H38
KTIP250R8SCF25M	H40
KTIP250R8SS32M	H38
KTIP2550HPM KCP15	H34
KTIP2599HPM KCP15	H34
KTIP2600HPM KCP15	H34
KTIP260R12SS32M	H38
KTIP260R1SCF25M	H40
KTIP260R1SS32M	H38
KTIP260R3SCF25M	H40
KTIP260R3SS32M	H38
KTIP260R5SCF25M	H40
KTIP260R5SS32M	H38
KTIP260R8SCF25M	H40
KTIP260R8SS32M	H38
KTIP2650HPM KCP15	H34
KTIP2700HPM KCP15	H34
KTIP270R12SS32M	H38
KTIP270R1SCF25M	H40
KTIP270R1SS32M	H38
KTIP270R3SCF25M	H40
KTIP270R3SS32M	H38
KTIP270R5SCF25M	H40
KTIP270R5SS32M	H38
KTIP270R8SCF25M	H40
KTIP270R8SS32M	H38
KTIP2750HPM KCP15	H34
KTIP2799HPM KCP15	H34
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
KTMDUCD058L236Z1	W30
KTMDUCD068L256Z2	W30
KTMDUCD081L315Z2	W30
KTMDUED091L300Z2	W31
KTMDUED102L415Z3	W31
KTMDUED122L452Z4	W31
KTMDUED144L512Z3	W34
KTMDUSCREW1	W29–31
KTMDUSD169L158Z4	W35
KTMDUSD209L158Z5	W35
KTMDUWD058L157Z1	W29
KTMDUWD081L236Z2	W29
KTMDUWD091L276Z2	W29
KTMDUWD102L315Z3	W29
KTMDUWD122L374Z4	W29
KTMDUWD144L374Z3	W34
KTMDUWD165L472Z4	W34
KTMS21S25SD06H	U3
KTMS25S25SD06H	U3
KTMS32S32SD08H	U3
KTMS40S32SD12H	U3
KTMS50S32SD12H	U3
KTSZR125SD430CM16A02	V139
KTSZR150SD430CM16A03	V139
KTSZR200SD430CM16A04	V139
KUAM20	B217–223, B245, B276–278
KUAM22	B72–74, B94, B115–119, B140–142, B174, B186–187, B394, B397–398
KUAM23	B198, B245, B249–251, B276–279, C196, D41
KUAM25	B72–74, B94–95, B115–117, B119, B140–142, B186, B198, B249, B397
KUAM26	B74, C196, D41
KUAM27	B74, B115, B119, T91–92
KUAM28	B72, B115–119, B175–176, B186, B217, B220, B236–237, B254–255, B276–279, B395–397
KUAM30	B72, B115–119, B175–176, B186, B217, B220, B236–237, B254–255, B276–279, B395–397
KUAM31	B72–74, B94, B115–119, B140–142, B174, B186–187, B198, B245, B249–251, B276–279, B394, B397–398, C196, D41
KUAM32	B72–74, B94–95, B115–117, B119, B140–142, B186, B198, B249, B397
KUAM33	B119, B142, C196, D41
KUAM34	B217–223, B245, B276–278
KUAM35	B217, B220, B222–223
KVNS020630D	U7
KVNS021180D	U7
KVNS030630D	U7
KVNS030870D	U7
KVNS031180D	U7
KVNS031580D	U7
KVNS031970D	U8
KVNS032360D	U8
KVNS040630D	U7
KVNS040870D	U7
KVNS041180D	U7
KVNS041580D	U7
KVNS042360D	U8
KVNS050630D	U7
KVNS050870D	U7
KVNS051180D	U7
KVNS051580D	U7
KVNS060870D	U7
KVNS061180D	U7
KVNS081180D	U7
KVNS101180D	U7
KVNS102360D	U8
KW1008	V148–149
L05MNER1S	D37
L05MSCLPL2	B215
L05MSCLPR2	B215
L06MNER1S	D37
L06MSCFPR2	B213
L06MSCLPL2	B215
L06MSCLPR2	B215
L06MSDUPL2	B235
L06MSDUPR2	B235

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
L06MSTFPR2	B273
L08RNEL2	D37
L08RNER1S	D37
L08RNER2	D37
L08RSCFPL2	B213
L08RSCFPR2	B213
L08RSCLPL2	B215
L08RSCLPR2	B215
L08RSDUPL2	B235
L08RSDUPR2	B235
L08RSTFPR2	B273
L10RNER2	D37
L10RSCFPR2	B213
L10RSCLPL3	B215
L10RSCLPR2	B215
L10RSCLPR3	B215
L10RSDUPR2	B235
L10RSTFPR2	B273
L12RNER2	D37
L12RSCFPR3	B213
L12RSCLPL3	B215
L12RSCLPR3	B215
L12RSDUPR3	B235
L12RSTFPR3	B273
L16SNER3	D37
L16SSCFPR3	B213
L16SSCLPL3	B215
L16SSCLPR3	B215
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
LNEU1255R08 KCPM40	U19
LNEU1255R16 KC725M	U19
LNEU1255R32 KC725M	U19
LNEU1260R04 KC725M	U19
LNEU1260R04 KCPM40	U19
LNGU431ERGE KC522M	T9
LNGU431ERGE KC725M	T9
LNGU431ERGE KCPM40	T9
LNGU431ERLEJ KC422M	T8
LNGU431SRGE KC522M	T9
LNGU431SRGE KCPM40	T9
LNGU431SRGE KCSM40	T9
LNGU432ERGE KC522M	T9
LNGU432ERGE KC725M	T9
LNGU432ERGE KCPM40	T9
LNGU432ERGE KCSM30	T9
LNGU432ERGE KCSM40	T9
LNGU432ERLEJ KC422M	T8
LNGU432SRGE KC522M	T9
LNGU432SRGE KC725M	T9
LNGU432SRGE KCK15	T9
LNGU432SRGE KCPK30	T9
LNGU432SRGE KCPM40	T9
LNGU432SRGE KCSM40	T9
LNGU432SRGEM KC520M	T10
LNGU432SRGEM KC522M	T10
LNGU432SRGEM KCK15	T10
LNGU432SRGEM KCPK30	T10
LNGU432SRGEM KCPM40	T10
LNGU433ERGE KC522M	T9
LNGU433ERGE KCPM40	T9
LNGU433ERGE KCSM40	T9
LNGU433SRGEM KC520M	T10
LNGU433SRGEM KCK15	T10
LNGU433SRGEM KCPK30	T10
LNGU433SRGEM KCPM40	T10
LNGU434SRGEM KC520M	T10
LNGU434SRGEM KCK15	T10
LNGU434SRGEM KCPK30	T10
LNGU434SRGEM KCPM40	T10
LNGU541ERGE KC522M	T18
LNGU541ERGE KC725M	T18
LNGU541ERGE KCPM40	T18
LNGU541ERGE KCSM30	T18
LNGU541ERGEJ KC422M	T18
LNGU541SRGE KC520M	T19
LNGU541SRGE KC522M	T19
LNGU541SRGE KC725M	T19
LNGU541SRGE KCK15	T19
LNGU541SRGE KCPK30	T19
LNGU542ERGE KC522M	T18
LNGU542ERGE KC725M	T18
LNGU542ERGE KCPM40	T18
LNGU542ERGE KCSM30	T18
LNGU542ERGE KCSM40	T18
LNGU542ERGEJ KC422M	T18
LNGU542SRGE KC520M	T19
LNGU542SRGE KC522M	T19
LNGU542SRGE KC725M	T19
LNGU542SRGE KCK15	T19
LNGU542SRGE KCPK30	T19
LNGU542SRGE KCSM40	T19
LNGU542SRGEH KCSM40	T20
LNGU542SRGEM KC520M	T19
LNGU542SRGEM KCK15	T19
LNGU542SRGEM KCPK30	T19
LNGU542SRGEM KCPM40	T19
LNGU543ERGE KC522M	T18
LNGU543ERGE KC725M	T18
LNGU543ERGE KCPM40	T18
LNGU543ERGE KCSM30	T18
LNGU543ERGE KCSM40	T18
LNGU543SRGE KC520M	T19
LNGU543SRGE KC522M	T19
LNGU543SRGE KC725M	T19
LNGU543SRGE KCK15	T19
LNGU543SRGE KCPK30	T19
LNGU543SRGE KCSM40	T19
LNGU543SRGEM KC520M	T19
LNGU543SRGEM KCK15	T19
LNGU543SRGEM KCPM40	T19
LNGU544ERGE KC725M	T18
LNGU544ERGE KCPM40	T18
LNGU544ERGE KCSM30	T18
LNGU544SRGE KC520M	T19
LNGU544SRGE KC522M	T19
LNGU544SRGE KC725M	T19
LNGU544SRGE KCK15	T19
LNGU544SRGE KCPK30	T19
LNGU544SRGEM KC520M	T19
LNGU544SRGEM KCK15	T19
LNGU544SRGEM KCPK30	T19
LNGU544SRGEM KCPM40	T19
LNGU545SRGEM KC520M	T19
LNGU545SRGEM KCK15	T19
LNGU545SRGEM KCPK30	T19
LNGU545SRGEM KCPM40	T19
LNPU432SRGE KC520M	T10
LNPU432SRGE KC522M	T10
LNPU432SRGE KC725M	T10
LNPU432SRGE KCK15	T10
LNPU432SRGE KCPK30	T10
LNPU432SRGE KCPM40	T10
LNPU433SRGE KC520M	T10
LNPU433SRGE KC522M	T10
LNPU433SRGE KC725M	T10
LNPU433SRGE KCK15	T10
LNPU433SRGE KCPK30	T10
LNPU433SRGE KCPM40	T10
LNPU434SRGE KC520M	T10
LNPU434SRGE KC522M	T10
LNPU434SRGE KC725M	T10
LNPU434SRGE KCPK30	T10
LNPU434SRGE KCPM40	T10
LNPU541SRGE KC520M	T19
LNPU541SRGE KC522M	T19
LNPU541SRGE KC725M	T19
LNPU541SRGE KCK15	T19
LNPU541SRGE KCPK30	T19
LNPU542SRGE KC520M	T19
LNPU542SRGE KC522M	T19
LNPU542SRGE KC725M	T19
LNPU542SRGE KCK15	T19
LNPU542SRGE KCPK30	T19
LNPU542SRGE KCPM40	T19
LNPU543SRGE KC520M	T19
LNPU543SRGE KC522M	T19
LNPU543SRGE KC725M	T19
LNPU543SRGE KCPK30	T19
LNPU543SRGE KCPM40	T19
LNPU544SRGE KC520M	T19
LNPU544SRGE KC522M	T19
LNPU544SRGE KC725M	T19
LNPU544SRGE KCK15	T19
LNPU544SRGE KCPK30	T19
LNPU544SRGE KCPM40	T19
LNPU545SRGE KC522M	T19
LNPU545SRGE KC725M	T19
LNPU545SRGE KCK15	T19
LNPU545SRGE KCPK30	T19
LNPU545SRGE KCPM40	T19
LNPU763PNSLHD2 KC520M	S99, S101
LNPU763PNSLHD2 KCPK30	S99, S101
LNPU763PNSLHD2 KCPM40	S99, S101
LNPU763PNSRHD KC725M	S99, S101
LNPU763PNSRHD KCK15	S99, S101
LNPU763PNSRHD KCPK30	S99, S101
LNPU763PNSRHD KCPM40	S99, S101
LNPU763PNSRHD2 KCPK30	S99, S101
LNPU763PNSRHD2 KCPM40	S99, S101
LNPU763PNSRHD2 KCSM40	S99, S101
LNPU863ANSLHD KCPK30	S95
LNPU863ANSLHD KCPM40	S95
LNPU863ANSLHD2 KCPK30	S95
LNPU863ANSLHD2 KCPM40	S95
LNPU863ANSRHD KC725M	S95
LNPU863ANSRHD KCK15	S95
LNPU863ANSRHD KCPK30	S95
LNPU863ANSRHD2 KCPK30	S95
LNPU863ANSRHD2 KCPM40	S95
LNPU863ANSRHD2 KCSM40	S95
LNUX191940RRF KCP10	E57
LNUX191940RRF KCP25	E57
LNUX191940RRH KCP10	E57
LNUX191940RRH KCP25	E57
LNUX191940RRP KCP10	E58
LNUX191940RRP KCP25	E58
LNUX191940RRSM KCP25B	E58
LNUX191940S-WT5 KCP25B	E59
LNUX191950RRF KCP10B	E54
LNUX191950RRF KCP25B	E54
LNUX191950RRP KCP10B	E54
LNUX191950RRP KCP25B	E54
LNUX301940RRF KCP10	E57
LNUX301940RRH KCP10B	E57
LNUX301940RRH KCP25	E57
LNUX301940RRP KCP25	E58
LNUX301940RRSM KCP10B	E58
LNUX301960RRP KCP10B	E54
LNUX301960RRP KCP25B	E54
LS103	S104
LSASL103	D71
LSASL123	D71
LSASL163	D71
LSASL164	D71
LSASL83	D71
LSASR103	D71
LSASR123	D71
LSASR163	D71
LSASR164	D71
LSASR203	D71
LSASR83	D71
LSSL123D	D71
LSSL163D	D71
LSSL164D	D71
LSSR123D	D71
LSSR163D	D71
LSSR164D	D71
LSSR203D	D71
LSSR204D	D71
LSSRDH123C	D72
LSSRDH164D	D72
LT11NL10ISO KC5025	D63
LT11NL15ISO KC5025	D63
LT11NL32UN KC5025	D67
LT11NLA60 KC5025	D60
LT11NR05ISO KC5025	D63
LT11NR075ISO KC5025	D63
LT11NR075ISOCB KC5025	D64
LT11NR10ISO KC5025	D63
LT11NR10ISOCB KC5025	D64
LT11NR125ISO KC5025	D63
LT11NR125ISOCB KC5025	D64
LT11NR14BSPT KC5025	D62
LT11NR14NPT KC5010	D64
LT11NR14NPT KC5025	D64
LT11NR14NPTF KC5025	D65
LT11NR14UNJ KC5025	D68
LT11NR14W KC5025	D69
LT11NR15ISO KC5010	D63
LT11NR15ISO KC5025	D63
LT11NR15ISOCB KC5025	D64
LT11NR16UN KC5010	D67
LT11NR16UN KC5025	D67
LT11NR16UNCB KC5025	D68
LT11NR16UNJ KC5025	D68
LT11NR175ISO KC5025	D63
LT11NR18NPT KC5025	D64
LT11NR18UN KC5025	D67
LT11NR18UNCB KC5025	D68
LT11NR18UNJ KC5025	D68
LT11NR19W KC5025	D69
LT11NR20ISO KC5025	D63
LT11NR20UN KC5025	D67
LT11NR20UNCB KC5025	D68
LT11NR24UN KC5025	D67
LT11NR24UNCB KC5025	D68
LT11NR28UN KC5025	D67
LT11NR32UN KC5025	D67
LT11NR32UNCB KC5025	D68
LT11NR40UN KC5025	D67
LT11NRA55 KC5025	D60
LT11NRA60 KC5010	D60
LT11NRA60 KC5025	D60
LT11NRA60CB KC5025	D61
LT16EL05ISO KC5025	D54
LT16EL075ISO KC5025	D54
LT16EL10ISO KC5025	D54
LT16EL11W KC5025	D59

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
LT16EL125ISO KC5025	D54
LT16EL12UN KC5025	D57
LT16EL14UN KC5025	D57
LT16EL14W KC5025	D59
LT16EL15ISO KC5010	D54
LT16EL15ISO KC5025	D54
LT16EL16UN KC5025	D57
LT16EL16UNJ KC5025	D58
LT16EL175ISO KC5025	D54
LT16EL18UN KC5025	D57
LT16EL20ISO KC5025	D54
LT16EL20UN KC5025	D57
LT16EL24UN KC5025	D57
LT16EL25ISO KC5025	D54
LT16EL28UN KC5025	D57
LT16EL30ISO KC5025	D54
LT16EL8APIRD KC5025	D53
LT16EL8UN KC5025	D57
LT16ELA60 KC5025	D51
LT16ELAG55 KC5025	D51
LT16ELAG60 KC5025	D51
LT16ELG60 KC5025	D51
LT16ER05ISO KC5025	D54
LT16ER05ISOCB KC5010	D54
LT16ER05ISOCB KC5025	D54
LT16ER075ISO KC5025	D54
LT16ER075ISOCB KC5010	D54
LT16ER075ISOCB KC5025	D54
LT16ER10ACME KC5025	D52
LT16ER10APIRD KC5025	D53
LT16ER10ISO KC5010	D54
LT16ER10ISO KC5025	D54
LT16ER10ISOCB KC5010	D54
LT16ER10ISOCB KC5025	D54
LT16ER10STACME KC5025	D56
LT16ER10UN KC5025	D57
LT16ER10UNCB KC5025	D58
LT16ER10W KC5025	D59
LT16ER115NPT KC5010	D55
LT16ER115NPT KC5025	D55
LT16ER115NPTF KC5025	D55
LT16ER115NPTFCB KC5025	D56
LT16ER11BSPT KC5025	D53
LT16ER11W KC5010	D59
LT16ER11W KC5025	D59
LT16ER11WCB KC5025	D59
LT16ER125ISO KC5010	D54
LT16ER125ISO KC5025	D54
LT16ER125ISOCB KC5010	D54
LT16ER125ISOCB KC5025	D54
LT16ER12ACME KC5025	D52
LT16ER12STACME KC5025	D56
LT16ER12UN KC5010	D57
LT16ER12UN KC5025	D57
LT16ER12UNCB KC5010	D58
LT16ER12UNCB KC5025	D58
LT16ER12UNJ KC5010	D58
LT16ER12UNJ KC5025	D58
LT16ER12W KC5025	D59
LT16ER14BSPT KC5025	D53
LT16ER14NPT KC5010	D55
LT16ER14NPT KC5025	D55
LT16ER14NPTCB KC5010	D55
LT16ER14NPTCB KC5025	D55
LT16ER14NPTF KC5025	D55
LT16ER14UN KC5010	D57
LT16ER14UN KC5025	D57
LT16ER14UNCB KC5010	D58
LT16ER14UNCB KC5025	D58
LT16ER14UNJ KC5010	D58
LT16ER14UNJ KC5025	D58
LT16ER14W KC5010	D59
LT16ER14W KC5025	D59
LT16ER14WCB KC5010	D59
LT16ER14WCB KC5025	D59
LT16ER15ISO KC5010	D54
LT16ER15ISO KC5025	D54
LT16ER15ISOCB KC5010	D54
LT16ER15ISOCB KC5025	D54
LT16ER16ACME KC5025	D52
LT16ER16STACME KC5025	D56
LT16ER16UN KC5010	D57
LT16ER16UN KC5025	D57
LT16ER16UNCB KC5010	D58
LT16ER16UNCB KC5025	D58
LT16ER16UNJ KC5010	D58
LT16ER16UNJ KC5025	D58
LT16ER16W KC5025	D59
LT16ER175ISO KC5010	D54
LT16ER175ISO KC5025	D54
LT16ER175ISOCB KC5010	D54
LT16ER175ISOCB KC5025	D54
LT16ER18NPT KC5010	D55
LT16ER18NPT KC5025	D55
LT16ER18UN KC5010	D57
LT16ER18UN KC5025	D57
LT16ER18UNCB KC5010	D58
LT16ER18UNCB KC5025	D58
LT16ER18UNJ KC5010	D58
LT16ER18UNJ KC5025	D58
LT16ER18W KC5025	D59
LT16ER19W KC5010	D59
LT16ER19W KC5025	D59
LT16ER20ISO KC5010	D54
LT16ER20ISO KC5025	D54
LT16ER20ISOCB KC5010	D54
LT16ER20ISOCB KC5025	D54
LT16ER20UN KC5010	D57
LT16ER20UN KC5025	D57
LT16ER20UNCB KC5010	D58
LT16ER20UNCB KC5025	D58
LT16ER20UNJ KC5010	D58
LT16ER20UNJ KC5025	D58
LT16ER20W KC5025	D59
LT16ER24UN KC5010	D57
LT16ER24UN KC5025	D57
LT16ER24UNCB KC5010	D58
LT16ER24UNCB KC5025	D58
LT16ER24UNJ KC5025	D58
LT16ER24W KC5025	D59
LT16ER25ISO KC5010	D54
LT16ER25ISO KC5025	D54
LT16ER25ISOCB KC5025	D54
LT16ER27NPT KC5025	D55
LT16ER28UN KC5010	D57
LT16ER28UN KC5025	D57
LT16ER28UNCB KC5010	D58
LT16ER28UNCB KC5025	D58
LT16ER28UNJ KC5025	D58
LT16ER28W KC5025	D59
LT16ER2TR KC5025	D57
LT16ER30ISO KC5010	D54
LT16ER30ISO KC5025	D54
LT16ER30ISOCB KC5010	D54
LT16ER30ISOCB KC5025	D54
LT16ER32UN KC5010	D57
LT16ER32UN KC5025	D57
LT16ER32UNCB KC5010	D58
LT16ER32UNCB KC5025	D58
LT16ER32UNJ KC5025	D58
LT16ER36UN KC5025	D57
LT16ER3TR KC5025	D57
LT16ER40UN KC5025	D57
LT16ER48UN KC5025	D57
LT16ER6STACME KC5025	D56
LT16ER8ACME KC5025	D52
LT16ER8APIRD KC5025	D53
LT16ER8NPT KC5025	D55
LT16ER8RD KC5025	D56
LT16ER8STACME KC5025	D56
LT16ER8UN KC5025	D57
LT16ER8UNCB KC5010	D58
LT16ER8UNCB KC5025	D58
LT16ER8W KC5025	D59
LT16ER9W KC5025	D59
LT16ERA55 KC5025	D51
LT16ERA60 KC5010	D51
LT16ERA60 KC5025	D51
LT16ERAG55 KC5010	D51
LT16ERAG55 KC5025	D51
LT16ERAG60 KC5010	D51
LT16ERAG60 KC5025	D51
LT16ERAG60CB KC5010	D51
LT16ERAG60CB KC5025	D51
LT16ERAG60K KU25T	D52
LT16ERG55 KC5025	D51
LT16ERG60 KC5010	D51
LT16ERG60 KC5025	D51
LT16NL10ISO KC5025	D63
LT16NL10UN KC5025	D67
LT16NL11W KC5025	D69
LT16NL12UN KC5025	D67
LT16NL15ISO KC5025	D63
LT16NL16UN KC5025	D67
LT16NL20ISO KC5025	D63
LT16NL25ISO KC5025	D63
LT16NL30ISO KC5025	D63
LT16NLA60 KC5025	D60
LT16NLAG60 KC5025	D60
LT16NLG60 KC5025	D60
LT16NR05ISO KC5025	D63
LT16NR075ISO KC5025	D63
LT16NR10ACME KC5025	D61
LT16NR10APIRD KC5025	D62
LT16NR10ISO KC5010	D63
LT16NR10ISO KC5025	D63
LT16NR10ISOCB KC5025	D64
LT16NR10STACME KC5025	D66
LT16NR10UN KC5025	D67
LT16NR10UNCB KC5025	D68
LT16NR10W KC5025	D69
LT16NR115NPT KC5010	D64
LT16NR115NPT KC5025	D64
LT16NR115NPTCB KC5025	D65
LT16NR11BSPT KC5025	D62
LT16NR11W KC5010	D69
LT16NR11W KC5025	D69
LT16NR11WCB KC5025	D69
LT16NR125ISO KC5025	D63
LT16NR12ACME KC5025	D61
LT16NR12STACME KC5025	D66
LT16NR12UN KC5010	D67
LT16NR12UN KC5025	D67
LT16NR12UNCB KC5025	D68
LT16NR12UNJ KC5025	D68
LT16NR12W KC5025	D69
LT16NR14BSPT KC5025	D62
LT16NR14NPT KC5025	D64
LT16NR14NPTCB KC5025	D65
LT16NR14NPTF KC5025	D65
LT16NR14STACME KC5025	D66
LT16NR14UN KC5025	D67
LT16NR14UNCB KC5025	D68
LT16NR14W KC5025	D69
LT16NR14WCB KC5025	D69
LT16NR15ISO KC5010	D63
LT16NR15ISO KC5025	D63
LT16NR15ISOCB KC5025	D64
LT16NR16STACME KC5025	D66
LT16NR16UN KC5025	D67
LT16NR16UNCB KC5025	D68
LT16NR16UNJ KC5025	D68
LT16NR16W KC5025	D69
LT16NR175ISO KC5025	D63
LT16NR18UN KC5025	D67
LT16NR18UNCB KC5025	D68
LT16NR19W KC5025	D69
LT16NR20ISO KC5010	D63
LT16NR20ISO KC5025	D63
LT16NR20ISOCB KC5025	D64
LT16NR20UN KC5025	D67
LT16NR20UNCB KC5025	D68
LT16NR20W KC5025	D69
LT16NR24UN KC5025	D67
LT16NR25ISO KC5025	D63
LT16NR25ISOCB KC5025	D64
LT16NR28UN KC5025	D67
LT16NR2TR KC5025	D66
LT16NR30ISO KC5010	D63
LT16NR30ISO KC5025	D63
LT16NR32UN KC5025	D67
LT16NR3TR KC5025	D66
LT16NR6STACME KC5025	D66
LT16NR8ACME KC5025	D61
LT16NR8APIRD KC5025	D62
LT16NR8NPT KC5025	D64
LT16NR8RD KC5025	D65
LT16NR8STACME KC5025	D66
LT16NR8UN KC5025	D67
LT16NR8UNCB KC5025	D68
LT16NR8W KC5025	D69
LT16NRA55 KC5025	D60
LT16NRA60 KC5010	D60
LT16NRA60 KC5025	D60
LT16NRAG55 KC5025	D60
LT16NRAG60 KC5010	D60
LT16NRAG60 KC5025	D60
LT16NRAG60CB KC5025	D61
LT16NRAG60K KU25T	D61
LT16NRG55 KC5025	D60
LT16NRG60 KC5010	D60
LT16NRG60 KC5025	D60
LT16NRG60CB KC5025	D61
LT22EL35ISO KC5025	D54
LT22ELN60 KC5025	D51
LT22ER35ISO KC5025	D54
LT22ER40ISO KC5025	D54
LT22ER45ISO KC5025	D54
LT22ER4API382 KC5025	D52
LT22ER4API502 KC5010	D52
LT22ER4API502 KC5025	D52
LT22ER4API503 KC5010	D52
LT22ER4TR KC5025	D57
LT22ER50ISO KC5025	D54
LT22ER5ACME KC5025	D52
LT22ER5API403 KC5010	D52
LT22ER5BUT75 KC5025	D53
LT22ER5STACME KC5025	D56
LT22ER5TR KC5025	D57
LT22ER6ACME KC5025	D52
LT22ER6RD KC5025	D56
LT22ER6W KC5025	D59
LT22ER7W KC5025	D59
LT22ERN55 KC5025	D51
LT22ERN60 KC5025	D51
LT22NLN60 KC5025	D60
LT22NR35ISO KC5025	D63
LT22NR40ISO KC5025	D63
LT22NR45ISO KC5025	D63
LT22NR4API382 KC5025	D62
LT22NR4API502 KC5025	D62
LT22NR4TR KC5025	D66
LT22NR50ISO KC5025	D63
LT22NR5ACME KC5025	D61
LT22NR5API403 KC5025	D62
LT22NR5BUT1 KC5025	D63
LT22NR5BUT75 KC5025	D63
LT22NR5TR KC5025	D66
LT22NR6ACME KC5025	D61
LT22NR6RD KC5025	D65
LT22NR7W KC5025	D69
LT22NRN55 KC5025	D60
LT22NRN60 KC5025	D60
LT27ER4API382 KC5025	D52
LT27ER4API502 KC5025	D52
LT27NR4API382 KC5025	D62
LT27NR4API502 KC5025	D62
M-13-M8-CA.625-3.543 S	V32
M-13-M8-CA.625-4.331 S	V32
M-13-M8-CA.625-5.118 S	V32
M-13-M8-CA.625-6.693 S	V32
M-18-M10-CA.750-4.331 S	V32
M-18-M10-CA.750-5.118 S	V32
M-18-M10-CA.750-6.693 S	V32
M-21-M12-CA1-5.157 S	V32
M-21-M12-CA1-6.142 S	V32
M-21-M12-CA1-7.126 S	V32
M-21-M12-CA1-8.110 S	V32
M-21-M12-CA1-9.094 S	V32
M-29-M16-CA1.25-10.2 S	V32
M-29-M16-CA1.25-12.2 S	V32
M-29-M16-CA1.25-6.3 S	V32
M-29-M16-CA1.25-8.27 S	V32
M10-JIC	C83
M1D050E0702C050L400	T24
M1D050E1001C062L350	T31
M1D062E0703C062L500	T24
M1D062E1002C062L670	T31

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
M1D062E1002C062L670R	T32
M1D062E1002C075L400	T31
M1D062E1002CM08	T29
M1D062E1002W075L100	T30
M1D062E1401W075L150	T49
M1D075E0705C075L600	T24
M1D075E1002C075L450	T31
M1D075E1002C075L670	T31
M1D075E1002CM10	T29
M1D075E1002W075L110	T30
M1D075E1003C075L450	T31
M1D075E1003C075L670	T31
M1D075E1003C075L670R	T32
M1D075E1003CM10	T29
M1D075E1003W075L110	T30
M1D075E1402C075L650	T52
M1D075E1402C075L800	T52
M1D075E1402W075L175	T49
M1D075E1402W075L175DE	T51
M1D088E1003C075L670	T31
M1D088E1402W100L175	T49
M1D097E1403W100L175	T49
M1D097E1802W100L175	T75
M1D100E1003C075L480	T31
M1D100E1003C100L480	T31
M1D100E1003C100L800	T31
M1D100E1003C100L800R	T32
M1D100E1003CM12	T29
M1D100E1003W075L125	T30
M1D100E1003W100L125	T30
M1D100E1004C075L480	T31
M1D100E1004C100L480	T31
M1D100E1004C100L800	T31
M1D100E1004C100L800R	T32
M1D100E1004CM12	T29
M1D100E1004W075L125	T30
M1D100E1004W100L125	T30
M1D100E1402C100L1000	T52
M1D100E1402W100L175	T49
M1D100E1403C100L750	T52
M1D100E1403CV40L300	T54
M1D100E1403W075L175	T50
M1D100E1403W100L175	T49
M1D100E1403W100L175DE	T51
M1D100E1403W100L175R	T50
M1D100E1802BT40L450	T80
M1D100E1802C100L1000	T77
M1D100E1802C100L800	T77
M1D100E1802CV40L250	T79
M1D100E1802CV40L450	T79
M1D100E1802W075L175	T76
M1D100E1802W100L175	T75
M1D100E1802W100L175R	T75
M1D100E1802W100L375	T75
M1D100E1802W100L375R	T75
M1D110E1004C100L800	T31
M1D125E1004C125L520	T31
M1D125E1004C125L800	T31
M1D125E1004W125L160	T30
M1D125E1005C125L520	T31
M1D125E1005C125L800	T31
M1D125E1005C125L800R	T32
M1D125E1005CM16	T29
M1D125E1005W125L160	T30
M1D125E1403C125L1000	T52
M1D125E1403W100L225	T50
M1D125E1404C125L800	T52
M1D125E1404CV40L300	T54
M1D125E1404S050L157	T53
M1D125E1404W100L225	T50
M1D125E1404W125L225	T49
M1D125E1404W125L225R	T50
M1D125E1802C125L1000	T77
M1D125E1802C125L800	T77
M1D125E1802W100L225	T76
M1D125E1803CV40L288	T79
M1D125E1803CV40L488	T79
M1D125E1803W100L225	T76
M1D125E1803W125L225	T75
M1D125E1803W125L225R	T75
M1D125E1803W125L425	T75
M1D125E1803W125L425R	T75
M1D150E1004S075L157	T33
M1D150E1006CM16	T29
M1D150E1006S075L157	T33
M1D150E1403C125L1000	T52
M1D150E1404C125L1000	T52
M1D150E1404W125L225	T50
M1D150E1405C125L800	T52
M1D150E1405CV40L300	T54
M1D150E1405S075L157	T53
M1D150E1405W125L225	T50
M1D150E1405W125L225R	T50
M1D150E1803C125L1000	T77
M1D150E1803C125L1000AL	T77
M1D150E1803C125L800	T77
M1D150E1803W125L225	T76
M1D150E1803W125L425	T76
M1D150E1803W125L425R	T76
M1D150E1804BT40L488	T80
M1D150E1804CV40L288	T79
M1D150E1804CV40L488	T79
M1D150E1804W125L225	T76
M1D150E1804W125L225R	T76
M1D150K2502C125L200	T89
M1D150K2502C125L400	T89
M1D150K2502HSK63L477	T91
M1D150K2502W125L200	T89
M1D200E1005S075L157	T33
M1D200E1008S075L157	T33
M1D200E1403S075L157	T53
M1D200E1405S075L157	T53
M1D200E1406S075L157	T53
M1D200E1803S075L157	T78
M1D200E1803S075L157AL	T78
M1D200E1805S075L157	T78
M1D200E1805W125L225	T76
M1D200K2502S075L200	T90
M1D200K2503C125L200	T89
M1D200K2503CV50L700	T92
M1D250E1006S075L157	T33
M1D250E1009S075L157	T33
M1D250E1405S075L157	T53
M1D250E1407S075L157	T53
M1D250E1804S075L157AL	T78
M1D250E1806S075L157	T78
M1D250K2503S100L225	T90
M1D300E1008S100L175	T33
M1D300E1010S100L175	T33
M1D300E1404S100L175	T53
M1D300E1406S100L175	T53
M1D300E1408S100L175	T53
M1D300E1804S100L175AL	T78
M1D300E1805S100L175	T78
M1D300E1807S100L175	T78
M1D300K2503S100L225	T90
M1D400E1008S150L200	T33
M1D400E1408S150L200	T53
M1D400E1410S150L200	T53
M1D400E1806S150L200	T78
M1D400E1808S150L200	T78
M1D400K2504S125L225	T90
M1D500E1809S150L200	T78
M1D600E1808S150L200	T78
M1D600E1808S200L200	T78
M1D800E1812S250L250	T78
M1HR075ED10C075Z2L110C4	T42
M1HR075ED10W075Z2L140C6	T41
M1HR100ED10C100Z2L110C4	T42
M1HR100ED10W100Z2L180C8	T41
M1HR125E14W125Z2L200C4	T63, T72
M1HR125ED10M16Z2L160C4	T40
M1HR125ED10M16Z3L160C6	T40
M1HR125ED10W125Z2L210C10	T41
M1HR125ED10W125Z3L210C15	T41
M1HR150E14W125Z3L200C6	T63, T72
M1HR150E14W125Z3L250C9	T63, T72
M1HR150E14W125Z3L300C12	T63, T72
M1HR150ED10S075Z3L200C12	T43
M1HR150ED10S075Z5L200C20	T43
M1HR200E14S075Z3L200C6	T64, T72
M1HR200E14S075Z3L250C9	T64, T72
M1HR200E14W150Z3L300C12	T63, T72
M1HR200ED10S075Z3L240C15	T43
M1HR200ED10S075Z5L240C25	T43
M1HR250E14S100Z3L250C9	T64, T72
M1HR250E14S100Z3L300C12	T64, T72
M1HR250E14S100Z4L250C12	T64, T72
M4-11KITD062Z2C062SGEKC725M	T11
M4-11KITD062Z2C062SGEKCPM40	T11
M4-11KITD062Z2W062SGEKC725M	T11
M4-11KITD062Z2W062SGEKCPM40	T11
M4-11KITD075Z2W075SGEKCPM40	T11
M4-11KITD075Z3C075SGEKC725M	T11
M4-11KITD075Z3C075SGEKCPM40	T11
M4-11KITD075Z3W075SGEKC725M	T11
M4-11KITD075Z3W075SGEKCPM40	T11
M4-11KITD100Z3W100SGEKC725M	T11
M4-11KITD100Z3W100SGEKCPM40	T11
M4-11KITD100Z4C100SGEKC725M	T11
M4-11KITD100Z4C100SGEKCPM40	T11
M4-11KITD125Z4W125SGEKC725M	T11
M4-11KITD125Z4W125SGEKCPM40	T11
M4-11KITD125Z5C125SGEKC725M	T11
M4-11KITD125Z5C125SGEKCPM40	T11
M4-11KITD150Z5S050SGEKC725M	T11
M4-11KITD150Z5S050SGEKCPM40	T11
M4-11KITD200Z5S075SGEKC725M	T11
M4-11KITD200Z5S075SGEKCPM40	T11
M4-11KITD200Z7S075SGEKC725M	T11
M4-11KITD200Z7S075SGEKCPM40	T11
M4D062L1102C062L400	T6, T11
M4D062L1102C062L600	T6
M4D062L1102W062L100	T5, T11
M4D075L1102C075L600	T6
M4D075L1102W075L110	T5, T11
M4D075L1103C075L400	T6, T11
M4D075L1103C075L600	T6
M4D075L1103M10L110	T4
M4D075L1103W075L110	T5, T11
M4D100L1103C100L700	T6
M4D100L1103W075L175	T5
M4D100L1103W100L175	T5, T11
M4D100L1104C075L450	T6
M4D100L1104C100L450	T6, T11
M4D100L1104C100L700	T6
M4D100L1104M12L125	T4
M4D100L1502C100L1000	T16
M4D100L1502C100L800	T16
M4D100L1502M12L125	T14
M4D100L1502W075L175	T15
M4D100L1502W100L175	T15
M4D125L1104C125L800	T6
M4D125L1104W125L225	T5, T11
M4D125L1105C100L500	T6
M4D125L1105C125L500	T6, T11
M4D125L1105M16L175	T4
M4D125L1503C125L1000	T16
M4D125L1503C125L800	T16
M4D125L1503M16L175	T14
M4D125L1503W100L225	T15
M4D125L1503W125L225	T15
M4D150L1105S050L157	T7, T11
M4D150L1105W125L225	T5
M4D150L1106S050L157	T7
M4D150L1503W125L225	T15
M4D150L1504C125L1000	T16
M4D150L1504C125L800	T16
M4D150L1504M16L175	T14
M4D150L1504W125L225	T15
M4D150L1505S050L157	T17
M4D200L1105S075L157	T7, T11
M4D200L1107S075L157	T7, T11
M4D200L1504S075L175	T17
M4D200L1505S075L157	T17
M4D200L1506S075L157	T17
M4D250L1107S075L157	T7
M4D250L1107S100L157	T7
M4D250L1505S075L157	T17
M4D250L1506S075L157	T17
M4D250L1507S100L175	T17
M4D300L1108S100L175	T7
M4D300L1108S125L175	T7
M4D300L1505S100L175	T17
M4D300L1507S100L175	T17
M4D300L1508S125L200	T17
M4D300L1509S100L175	T17
M4D400L1506S150L200	T17
M4D400L1508S150L200	T17
M4D400L1511S150L200	T17
M4D500L1507S150L238	T17
M4D500L1509S150L238	T17
M4D500L1512S150L238	T17
M4D600L1508S200L238	T17
M4D600L1510S200L238	T17
M4D600L1512S200L238	T17
M4KITD100Z02C100EGEKC725M	T21
M4KITD100Z02W100SGEKCPM40	T21
M4KITD100Z02W100SGEMKC520M	T21
M4KITD125Z03C125EGEKC725M	T21
M4KITD125Z03W100SGEKCPM40	T21
M4KITD125Z03W100SGEMKC520M	T21
M4KITD150Z04W125SGEKCPM40	T21
M4KITD150Z05S050EGEKC725M	T21
M4KITD150Z05S050SGEKCPM40	T21
M4KITD150Z05S050SGEMKC520M	T21
M4KITD200Z05S075EGEKC725M	T21
M4KITD200Z05S075SGEKCPM40	T21
M4KITD200Z06S075EGEKC725M	T21
M4KITD200Z06S075SGEKCPM40	T21
M4KITD200Z06S075SGEMKC520M	T21
M4KITD250Z06S075EGEKC725M	T21
M4KITD250Z06S075SGEKCPM40	T21
M4KITD250Z07S075SGEMKC520M	T21
M4KITD300Z07S100EGEKC725M	T21
M4KITD300Z07S100SGEKCPM40	T21
M4KITD300Z09S100SGEMKC520M	T21
M4KITD400Z08S150SGEKCPM40	T21
M4KITD400Z11S150SGEMKC520M	T21
M6-JIC	C83
M8-JIC	C83
MB115RBHT12F	K124
MB115RBHT16LF	K124
MB115RBHT16LK	K125
MB24RBHT06F	K124
MB24RBHT06K	K125
MB30RBHT06F	K124
MB30RBHT06K	K125
MB40RBHT09F	K124
MB40RBHT09K	K125
MB50RBHT09F	K124
MB50RBHT09K	K125
MB66RBHT12F	K124
MB66RBHT12K	K125
MB66RBHT12LF	K124
MB66RBHT12LK	K125
MB87RBHT12F	K124
MB87RBHT12K	K125
MB87RBHT16LF	K124
MB87RBHT16LK	K125
MCC080001	V88, V91
MCC0800HP	V88, V91
MCFNL10CA3	B72
MCFNL12CA4	B72
MCFNL164D	B60
MCFNR10CA3	B72
MCFNR124B	B60
MCFNR12CA4	B72
MCFNR164C	B60
MCFNR164D	B60
MCFNR16CA4	B72
MCFNR20CA4	B72
MCGNL124B	B61
MCGNL164C	B61
MCGNL164D	B61
MCGNR124B	B61
MCGNR164C	B61
MCGNR164D	B61
MCHNN164C	B61
MCHNN205D	B61
MCHNN246D	B61
MCKNL124B	B62
MCKNL12CA4	B73
MCKNL164C	B62
MCKNL164D	B62
MCKNL165D	B62
MCKNL204D	B62
MCKNL205D	B62

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
MCKNL206D	B62
MCKNL246D	B62
MCKNR124B	B62
MCKNR12CA4	B73
MCKNR164C	B62
MCKNR164D	B62
MCKNR165D	B62
MCKNR16CA4	B73
MCKNR204D	B62
MCKNR205D	B62
MCKNR206D	B62
MCKNR246D	B62
MCLNL083A	B63
MCLNL103A	B63
MCLNL123B	B63
MCLNL124A	B63
MCLNL124B	B63
MCLNL12CA4	B74
MCLNL164C	B63
MCLNL164D	B63
MCLNL165C	B63
MCLNL165D	B63
MCLNL166C	B63
MCLNL166D	B63
MCLNL16CA4	B74
MCLNL204D	B63
MCLNL20CA4	B74
MCLNL244D	B64
MCLNL245D	B64
MCLNL245E	B64
MCLNL246D	B64
MCLNL246E	B64
MCLNL248E	B64
MCLNL25CA6	B74
MCLNL326F	B64
MCLNL854D	B64
MCLNL866E	B64
MCLNR083A	B63
MCLNR103A	B63
MCLNR123B	B63
MCLNR124A	B63
MCLNR124B	B63
MCLNR12CA4	B74
MCLNR163C	B63
MCLNR163D	B63
MCLNR164C	B63
MCLNR164D	B63
MCLNR165C	B63
MCLNR165D	B63
MCLNR166C	B63
MCLNR166D	B63
MCLNR16CA4	B74
MCLNR204D	B63
MCLNR205D	B63
MCLNR206D	B63
MCLNR20CA4	B74
MCLNR244D	B63
MCLNR245D	B63
MCLNR245E	B63
MCLNR246D	B63
MCLNR246E	B63
MCLNR248E	B63
MCLNR25CA4	B74
MCLNR25CA5	B74
MCLNR25CA6	B74
MCLNR326F	B63
MCLNR854D	B63
MCLNRC164D	B66, B371
MCMNN124B	B64
MCMNN164C	B64
MCMNN164D	B64
MCMNN166D	B64
MCMNN204D	B64
MCMNN206D	B64
MCMNN246D	B64
MCMNN246E	B64
MCRNL124B	B65
MCRNL164C	B65
MCRNL164D	B65
MCRNL165D	B65
MCRNL166D	B65
MCRNL204D	B65
MCRNL205D	B65
MCRNL206D	B65
MCRNL246D	B65
MCRNL246E	B65
MCRNR124B	B65
MCRNR164C	B65
MCRNR164D	B65
MCRNR165D	B65
MCRNR166D	B65
MCRNR204D	B65
MCRNR205D	B65
MCRNR206D	B65
MCRNR246D	B65
MCRNR246E	B65
MDJNL123B	B89
MDJNL124A	B89
MDJNL124B	B89
MDJNL12CA3	B94
MDJNL163C	B89
MDJNL163D	B89
MDJNL164C	B89
MDJNL164D	B89
MDJNL16CA4	B94
MDJNL203D	B89
MDJNL204D	B89
MDJNL205D	B89
MDJNL245D	B89
MDJNL245E	B89
MDJNR123B	B89
MDJNR124A	B89
MDJNR124B	B89
MDJNR12CA3	B94
MDJNR163C	B89
MDJNR163D	B89
MDJNR164C	B89
MDJNR164D	B89
MDJNR165D	B89
MDJNR16CA4	B94
MDJNR203D	B89
MDJNR204D	B89
MDJNR205D	B89
MDJNR20CA4	B94
MDJNR245D	B89
MDJNR245E	B89
MDJNR854D	B89
MDPNN123B	B90
MDPNN163D	B90
MDPNN164D	B90
MDPNN205D	B90
MDPNN245D	B90
MDQNL124B	B90
MDQNL164C	B90
MDQNL164D	B90
MDQNL16CA4	B95
MDQNL204D	B90
MDQNL20CA4	B95
MDQNL244D	B90
MDQNL244E	B90
MDQNR124B	B90
MDQNR164C	B90
MDQNR164D	B90
MDQNR16CA4	B95
MDQNR204D	B90
MDQNR20CA4	B95
MDQNR244D	B90
MDQNR244E	B90
MDRHEC100S5150 KCPM15	P91
MDRHEC250S3025 KCPM15	P91
MDRHEC250S3075 KCPM15	P91
MDRHEC250S4025 KCPM15	P91
MDRHEC250S4075 KCPM15	P91
MDRHEC312S4081 KCPM15	P91
MDRHEC375S4038 KCPM15	P91
MDRHEC375S4088 KCPM15	P91
MDRHEC500S4050 KCPM15	P91
MDRHEC500S4100 KCPM15	P91
MDRHEC625S4063 KCPM15	P91
MDRHEC625S4125 KCPM15	P91
MDRHEC750S4075 KCPM15	P91
MDRHEC750S4150 KCPM15	P91
MEGA45D1000LN863C10	S94
MEGA45D1000LN863M10	S94
MEGA45D1200LN863C10	S94
MEGA45D1200LN863M10	S94
MEGA45D500LN863M6	S94
MEGA45D800LN863M10	S94
MEGA60D1200LN76M10	S98
MEGA60D500LN76M6	S98
MEGA60D600LN76M8	S98
MEGA60D800LN76M10	S98
MEGA90D1000LN76C10	S100
MEGA90D1200LN76C10	S100
MEGA90D1200LN76M10	S100
MEGA90D500LN76M6	S100
MEGA90D600LN76M8	S100
MILL16E1000Z12ON08SC	S32
MILL16E1000Z24ON08W	S30
MILL16E1000Z34ON08W	S30
MILL16E1200Z42ON08WSC	S31
MILL16E1400Z48ON08WSC	S31
MILL16E1600Z56ON08WSC	S31
MILL16E2000Z70ON08WSC	S31
MILL16E200Z04ON08SC	S32
MILL16E200Z05ON08W	S30
MILL16E250Z04ON08SC	S32
MILL16E250Z06ON08W	S30
MILL16E300Z05ON08SC	S32
MILL16E300Z08ON08W	S30
MILL16E300Z10ON08W	S30
MILL16E400Z06ON08SC	S32
MILL16E400Z10ON08W	S30
MILL16E400Z14ON08W	S30
MILL16E500Z08ON08SC	S32
MILL16E500Z14ON08W	S30
MILL16E500Z18ON08W	S30
MILL16E600Z10ON08SC	S32
MILL16E600Z16ON08W	S30
MILL16E600Z22ON08W	S30
MILL16E800Z10ON08SC	S32
MILL16E800Z20ON08W	S30
MILL16E800Z28ON08W	S30
MRGNL164D	B98
MRGNL166D	B98
MRGNL204D	B98
MRGNL206D	B98
MRGNL246D	B98
MRGNL248E	B98
MRGNLC164D	B99, B371
MRGNLC204D	B99, B371
MRGNLC244D	B99, B371
MRGNR123B	B98
MRGNR124B	B98
MRGNR163D	B98
MRGNR164C	B98
MRGNR164D	B98
MRGNR166D	B98
MRGNR204D	B98
MRGNR206D	B98
MRGNR246D	B98
MRGNR248E	B98
MRGNRC164D	B99, B371
MRGNRC204D	B99, B371
MRGNRC244D	B99, B371
MS-1896	K85
MS-2071	T14–17, V75–77
MS1025	C196, D41
MS1027	B209–212, B216
MS1028	B210–211
MS1034	C190
MS1152	B273, B276–278, J25, J27, J29, J31, J33, J35, J37, J39
MS1153	B193–197, B209–215, B217–223, B227–230, B234–237, B243–245, B259–262, B270–279, B282–285, B287, B289–290, B292, K78–80, K85, K89–90
MS1155	B193, B195–198, B212–215, B217, B220, B227–230, B234–235, B237, B245, B254–255, B261–262, B271–279, B282–285, B287, B289–290
MS1156	B193–196, B227–229, B243–244, B259–260, B282, C127–128
MS1157	B198, B249–251
MS1158	B194, B243
MS1160	C34–45, C52–57, C122–129, C134
MS1162	C52–57, C65–73, C143–151, S94, S98, S100, V87–88, V91
MS1163	C65–73, C143–151
MS1200	C183, C185, C188, C192–193, D30
MS1234CG	V62
MS125	B186, B397
MS1273	C52–55, T119–120
MS1276	J91
MS1281	U17–18
MS1282	U17–18
MS1284	U17–18
MS1285	C52–55
MS1294CG	V62
MS1321	B168–169, B386–387
MS1374	T89–92
MS1375	K89–90
MS1438	B290–291
MS1454	B203, K79
MS1488	D31, D33, D39–40
MS1489	D31–33, D39
MS1490	C34–41, C47–48, C50–51, C122–125, C130, D32
MS1571	C135–136
MS1595	C34–41, C46–47, C49–50, C52–55, C122–126, C129, C131–133
MS1861	H100
MS1933	B214–215, B217, B220, B222–223, B271–272
MS1939	B197, B212–215, B287, B289
MS1944	C38–41, C122–125, C127–128
MS1970	C34–41, C46–51, C122–126, C129–133
MS2002	C65–73, C143–151
MS2038	V62
MS2038CG	V62
MS2055	B197
MS2060	S32
MS2066	B197
MS2077	U35–37, V68–70
MS2078	S39, T113, U32–34
MS2085	T120, V81–83
MS2089	C132–133
MS2090	C130–131
MS2091	C34–41, C122–125, C127–128, C130–131
MS2111	C183, C185, C188–189, C192, D30
MS2126	T75–80
MS2148	T63–64, T107–109, U25–29
MS2166	T49–54
MS2167	T49, T51–52
MS2173	B217, B220, B222–223
MS2175	B217–223, B245, B276–278
MS2191C00	T63, T65, V139–140, V142
MS2191C06	T63, T65, V139–140, V142
MS2191C08	T63, T65, V139–142
MS2191C12	T63, T65, V139–142
MS2191C14	T63, T65, V139–140, V142
MS2191C16	T63–65, V139–140, V142
MS2191C18	T63, T65, V139–140, V142
MS2191C20	T63–65, V139–140, V142
MS2197	V139–141
MS2205	T29–33, T40–43
MS2206	U3
MS2207	U3
MS2208	U3
MS2219	V36–38
MS2236	V123
MS2260	V58
MS2263	T4–7
MS364	B74, B115, B119
MS412	C196, D41
MS5006	W12, W19
MS5007	W12–13
MS5008	W12, W18, W25
MS5009	W18, W25
MS9000	W17–19, W24–25
MSDNN083	B111
MSDNN103	B111
MSDNN123	B111
MSDNN124	B111
MSDNN164	B111

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
MSDNN206	B111
MSDNN246	B111
MSDNN854	B111
MSDNN855	B111
MSDNN856	B111
MSKNL12CA4	B115
MSKNL205D	B111
MSKNL206D	B111
MSKNL20CA5	B115
MSKNL246D	B111
MSKNR10CA3	B115
MSKNR124B	B111
MSKNR12CA4	B115
MSKNR164C	B111
MSKNR164D	B111
MSKNR16CA4	B115
MSKNR205D	B111
MSKNR206D	B111
MSKNR20CA5	B115
MSKNR248	B111
MSKNR25CA6	B115
MSRNL124B	B112
MSRNL12CA4	B116
MSRNL164C	B112
MSRNL164D	B112
MSRNL165C	B112
MSRNL16CA4	B116
MSRNL204D	B112
MSRNL205D	B112
MSRNL206D	B112
MSRNL20CA5	B116
MSRNL246D	B112
MSRNL246E	B112
MSRNL854D	B112
MSRNR10CA3	B116
MSRNR124B	B112
MSRNR12CA4	B116
MSRNR164C	B112
MSRNR164D	B112
MSRNR165C	B112
MSRNR16CA4	B116
MSRNR205D	B112
MSRNR206D	B112
MSRNR246D	B112
MSRNR246E	B112
MSRNR248	B112
MSRNR328	B112
MSRNR856D	B112
MSSNL10CA3	B117
MSSNL12CA4	B117
MSSNL164C	B113
MSSNL164D	B113
MSSNL165D	B113
MSSNL205D	B113
MSSNL206D	B113
MSSNL246D	B113
MSSNL854D	B113
MSSNR10CA3	B117
MSSNR123B	B113
MSSNR124B	B113
MSSNR12CA4	B117
MSSNR164C	B113
MSSNR164D	B113
MSSNR165D	B113
MSSNR16CA4	B117
MSSNR205D	B113
MSSNR206D	B113
MSSNR20CA5	B117
MSSNR246D	B113
MSSNR854D	B113
MSTNR10CA3	B118
MSTNR12CA4	B118
MSYNL10CA3	B119
MSYNL12CA4	B119
MSYNL20CA15	B119
MSYNR10CA3	B119
MSYNR12CA4	B119
MSYNR16CA4	B119
MSYNR25CA19	B119
MTANL103B	B132
MTANL123B	B132
MTANL164D	B132
MTANLS123	B133
MTANLS163	B133
MTANLS164	B133
MTANLS205	B133
MTANR082B	B132
MTANR103B	B132
MTANR123B	B132
MTANR164D	B132
MTANRS123	B133
MTANRS163	B133
MTANRS164	B133
MTANRS205	B133
MTCNN083	B133
MTCNN124	B133
MTCNN443	B133
MTCNN644	B133
MTENNS082	B134
MTENNS103	B134
MTENNS123	B134
MTENNS163	B134
MTENNS164	B134
MTENNS205	B134
MTENNS246	B134
MTENNS854	B134
MTFNL123B	B134
MTFNL12CA3	B140
MTFNL164C	B134
MTFNL164D	B134
MTFNL16CA3	B140
MTFNL204D	B134
MTFNL20CA4	B140
MTFNL245D	B134
MTFNL246E	B134
MTFNL854D	B134
MTFNLS164	B135
MTFNR123B	B134
MTFNR12CA3	B140
MTFNR164C	B134
MTFNR164D	B134
MTFNR16CA3	B140
MTFNR204D	B134
MTFNR205D	B134
MTFNR20CA4	B140
MTFNR246E	B134
MTFNRS164	B135
MTGNL103B	B135
MTGNL123B	B135
MTGNL124B	B135
MTGNL12CA3	B141
MTGNL164C	B135
MTGNL164D	B135
MTGNL204D	B135
MTGNL205D	B135
MTGNL20CA4	B141
MTGNR082B	B135
MTGNR103B	B135
MTGNR123B	B135
MTGNR124B	B135
MTGNR12CA3	B141
MTGNR164C	B135
MTGNR164D	B135
MTGNR165C	B135
MTGNR16CA3	B141
MTGNR204D	B135
MTGNR205D	B135
MTJNL082B	B136
MTJNL103B	B136
MTJNL123B	B136
MTJNL163C	B136
MTJNL163D	B136
MTJNL164D	B136
MTJNL204D	B136
MTJNL205D	B136
MTJNLS123	B137
MTJNLS124	B137
MTJNLS163	B137
MTJNLS164	B137
MTJNLS165	B137
MTJNLS204	B137
MTJNLS205	B137
MTJNLS246	B137
MTJNR082B	B136
MTJNR103B	B136
MTJNR123B	B136
MTJNR163C	B136
MTJNR163D	B136
MTJNR164D	B136
MTJNR204D	B136
MTJNR205D	B136
MTJNRS123	B137
MTJNRS124	B137
MTJNRS163	B137
MTJNRS164	B137
MTJNRS165	B137
MTJNRS204	B137
MTJNRS205	B137
MTJNRS246	B137
MTJNRS864	B137
MTRNR164D	B138
MTUNL12CA3	B142
MTUNL16CA3	B142
MTUNR20CA4	B142
MVJNL123A	B152
MVJNL123B	B152
MVJNL163C	B152
MVJNL163D	B152
MVJNL164C	B152
MVJNL164D	B152
MVJNL203D	B152
MVJNL204D	B152
MVJNL244D	B152
MVJNR123A	B152
MVJNR123B	B152
MVJNR124B	B152
MVJNR163C	B152
MVJNR163D	B152
MVJNR164C	B152
MVJNR164D	B152
MVJNR203D	B152
MVJNR204D	B152
MVJNR243D	B152
MVJNR244D	B152
MVUNL204D	B153
MVUNL244D	B153
MVUNR204C	B153
MVUNR204D	B153
MVUNR244D	B153
MVVNN123B	B153
MVVNN163C	B153
MVVNN163D	B153
MVVNN164D	B153
MVVNN203D	B153
MVVNN204D	B153
MVVNN244E	B153
MW25	U28–29, V148–149
MW3	U35–37
NA3L10 KC5025	D11
NA3L10 KCU25	D11
NA3L12 KC5010	D11
NA3L12 KC5025	D11
NA3L16 KCU10	D11
NA3L4 K68	D11
NA3L4 KC5010	D11
NA3L4 KC5025	D11
NA3L4 KCU10	D11
NA3L4 KCU25	D11
NA3L5 KC5010	D11
NA3L5 KC5025	D11
NA3L5 KCU25	D11
NA3L6 KC5010	D11
NA3L6 KC5025	D11
NA3L6 KCU25	D11
NA3L8 KC5010	D11
NA3L8 KC5025	D11
NA3L8 KCU10	D11
NA3L8 KCU25	D11
NA3R10 KC5010	D11
NA3R10 KC5025	D11
NA3R10 KCU10	D11
NA3R10 KCU25	D11
NA3R12 KC5025	D11
NA3R12 KCU10	D11
NA3R16 KCU10	D11
NA3R4 KC5010	D11
NA3R4 KC5025	D11
NA3R4 KCU25	D11
NA3R5 KC5010	D11
NA3R5 KC5025	D11
NA3R5 KCU10	D11
NA3R5 KCU25	D11
NA3R6 KC5010	D11
NA3R6 KC5025	D11
NA3R6 KCU10	D11
NA3R6 KCU25	D11
NA3R8 KC5010	D11
NA3R8 KC5025	D11
NA3R8 KCU10	D11
NA3R8 KCU25	D11
NA4L4 KC5025	D11
NA4L4 KCU10	D11
NA4L5 KC5025	D11
NA4L6 KC5025	D11
NA4L8 KCU25	D11
NA4R4 KC5010	D11
NA4R4 KC5025	D11
NA4R4 KCU25	D11
NA4R5 KC5025	D11
NA4R6 KC5025	D11
NA6L2 KC5010	D11
NA6L2 KC5025	D11
NA6L2 KCU25	D11
NA6L25 KCU25	D11
NA6L3 KC5025	D11
NA6L3 KCU25	D11
NA6R2 KC5010	D11
NA6R2 KC5025	D11
NA6R2 KCU10	D11
NA6R2 KCU25	D11
NA6R25 KC5025	D11
NA6R3 KC5025	D11
NA6R3 KCU25	D11
NAS3L10 KC5025	D12
NAS3L10 KCU10	D12
NAS3L12 KC5025	D12
NAS3L4 KC5025	D12
NAS3L4 KCU25	D12
NAS3L5 KC5025	D12
NAS3L5 KCU10	D12
NAS3L6 KC5010	D12
NAS3L6 KC5025	D12
NAS3L6 KCU10	D12
NAS3L6 KCU25	D12
NAS3L8 KC5010	D12
NAS3L8 KC5025	D12
NAS3L8 KCU10	D12
NAS3L8 KCU25	D12
NAS3R10 KC5010	D12
NAS3R10 KC5025	D12
NAS3R10 KCU10	D12
NAS3R12 KC5025	D12
NAS3R12 KCU25	D12
NAS3R16 KC5025	D12
NAS3R4 KC5025	D12
NAS3R4 KCU25	D12
NAS3R5 KC5025	D12
NAS3R5 KCU10	D12
NAS3R6 KC5010	D12
NAS3R6 KC5025	D12
NAS3R6 KCU10	D12
NAS3R8 KC5010	D12
NAS3R8 KC5025	D12
NAS3R8 KCU10	D12
NAS3R8 KCU25	D12
NASL062D	C185, D25
NASL082D	C185, D25
NASL083D	C185, D25
NASL1010M2Q	C185
NASL102B	C185, D25
NASL103B	C185, D25
NASL1212M2Q	C185
NASL1616K3Q	C185
NASR062D	C185, D25
NASR082D	C185, D25
NASR083D	C185, D25
NASR1010M2Q	C185
NASR102B	C185, D25

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
NASR103B	C185, D25
NASR1212M2Q	C185
NASR1616K3Q	C185
NB2L K313	C176
NB2R K313	C176
NB3L K313	C176
NB3R K313	C176
NB4L K313	C176
NB4R K313	C176
NBD2R K313	C177
NBD3L K313	C177
NBD3R K313	C177
ND3038L KC5025	D12
ND3038R KC5025	D12
ND3040L KCU25	D12
ND3040R KC5025	D12
ND4050R KCU25	D12
NDC3040L3 KC5010	D13
NDC3040R3 KC5025	D13
NDC310RDL75 KC5025	D13
NDC310RDR75 KC5025	D13
NDC3115VL75 KC5010	D14
NDC3115VL75 KCU10	D14
NDC3115VR75 KC5010	D14
NDC3115VR75 KCU10	D14
NDC314VR75 KCU10	D14
NDC327VR75 KCU10	D14
NDC38RDL75 KC5010	D13
NDC38RDL75 KC5025	D13
NDC38RDL75 KCU25	D13
NDC38RDR75 KC5010	D13
NDC38RDR75 KC5025	D13
NDC38RDR75 KCU25	D13
NDC38VL75 KC5010	D14
NDC38VR75 KC5010	D14
NDC4038L2 KC5025	D13
NDC4038R2 KC5025	D13
NDC4040R3 KC5025	D13
NDC4050L2 KC5025	D13
NDC4050R2 KC5025	D13
NDC4050R3 KC5025	D13
NDC68RDR75M KCU10	D13
NDC8115VR75M KCU10	D14
NDC88VL75M KC5010	D14
NDC88VR75M KC5010	D14
NDC88VR75M KCU10	D14
NDLPL164D	E40
NDLPR164D	E40
NDPPN164D	E40
NEL062	C187, D26
NEL082V	C187, D26
NEL102B	C187, D26
NEL122B	C187, D26
NEL123B	C187, D26
NEL12CA2	C196, D41
NEL1616H2	C188
NEL162C	C187, D26
NEL163C	C187, D26
NEL163D	C187, D26
NEL164C	C187, D26
NEL164D	C187, D26
NEL2020K2	C188
NEL203D	C187, D26
NEL204D	C187, D26
NEL205D	C187, D26
NEL206D	C187, D26
NEL243D	C187, D26
NEL244D	C187, D26
NEL2525M2	C188
NEL2525M3	C188
NEL2525M4	C188
NEL25CA3	C196, D41
NEL3225P3	C188
NEL3225P4	C188
NEL3232P4	C188
NEL853D	C187, D26
NER062	C187, D26
NER082V	C187, D26
NER102B	C187, D26
NER122B	C187, D26
NER123B	C187, D26
NER12CA2	C196, D41
NER1616H2	C188
NER162C	C187, D26
NER163C	C187, D26
NER163D	C187, D26
NER164C	C187, D26
NER164D	C187, D26
NER2020K2	C188
NER203D	C187, D26
NER204D	C187, D26
NER205D	C187, D26
NER206D	C187, D26
NER243D	C187, D26
NER244D	C187, D26
NER2525M2	C188
NER2525M3	C188
NER2525M4	C188
NER3225P3	C188
NER3225P4	C188
NER3232P4	C188
NER853D	C187, D26
NF3125L K313	C175
NF3125LK KC5025	C173
NF3125LK KCU25	C173
NF3125R K313	C175
NF3125RK KC5025	C173
NF3125RK KCU25	C173
NF3156LK KCU25	C173
NF3156RK KCU25	C173
NF3188L KCU25	C175
NF3188R KCU25	C175
NF3M200LK KC5025	C173
NF3M200RK KC5025	C173
NF3M300LK KC5025	C173
NF3M300RK KC5025	C173
NFD3125LK KC5025	C174
NFD3125LK KCU25	C174
NFD3125LKI KCU25	C174
NFD3125RK KC5025	C174
NFD3125RK KCU25	C174
NFD3125RKI KC5025	C174
NFD3125RKI KCU25	C174
NFD3189LKI KCU25	C174
NFD3189RKI KCU25	C174
NFD3M300LK KC5025	C174
NFD3M300RK KC5025	C174
NFD4189LK KC5025	C174
NFD4189LK KCU25	C174
NFD4189RK KCU25	C174
NFD4250LK KCU25	C174
NFD4250RK KCU25	C174
NG1031L KCU25	C170
NG1047L KC5025	C170
NG1047L KCU25	C170
NG1062L KC5025	C170
NG1062L KCU25	C170
NG1094L KC5025	C170
NG1094L KCU25	C170
NG2031L K313	C170
NG2031L KC5010	C170
NG2031L KCK20B	C170
NG2031L KCU10	C170
NG2031L KCU25	C170
NG2031LK KC5010	C163
NG2031LK KC5025	C163
NG2031LK KCP10B	C163
NG2031LK KCP25B	C163
NG2031LK KCU10	C163
NG2031LK KCU25	C163
NG2031R K313	C170
NG2031R KC5010	C170
NG2031R KC5025	C170
NG2031R KCK20B	C170
NG2031R KCU10	C170
NG2031R KCU25	C170
NG2031RK KC5010	C162
NG2031RK KC5025	C162
NG2031RK KCP10B	C162
NG2031RK KCP25B	C162
NG2031RK KCU10	C162
NG2031RK KCU25	C162
NG2031RK KT315	C162
NG2041L KC5010	C170
NG2041L KC5025	C170
NG2041L KCK20B	C170
NG2041L KCU25	C170
NG2041R K313	C170
NG2041R KC5010	C170
NG2041R KC5025	C170
NG2041R KCK20B	C170
NG2041R KCU10	C170
NG2041R KCU25	C170
NG2047L KC5010	C170
NG2047L KCU10	C170
NG2047L KCU25	C170
NG2047LK KC5010	C163
NG2047LK KC5025	C163
NG2047LK KCP10B	C163
NG2047LK KCP25B	C163
NG2047LK KCU10	C163
NG2047LK KCU25	C163
NG2047R KC5010	C170
NG2047R KCK20B	C170
NG2047R KCU10	C170
NG2047R KCU25	C170
NG2047RK KC5010	C162
NG2047RK KC5025	C162
NG2047RK KCP10B	C162
NG2047RK KCP25B	C162
NG2047RK KCU10	C162
NG2047RK KCU25	C162
NG2047RK KT315	C162
NG2058L KCU25	C170
NG2058R KC5025	C170
NG2058R KCU25	C170
NG2062L K313	C170
NG2062L KC5010	C170
NG2062L KC5025	C170
NG2062L KCK20B	C170
NG2062L KCU10	C170
NG2062L KCU25	C170
NG2062LK KC5010	C163
NG2062LK KC5025	C163
NG2062LK KCP10B	C163
NG2062LK KCP25B	C163
NG2062LK KCU10	C163
NG2062LK KCU25	C163
NG2062R K313	C170
NG2062R KC5010	C170
NG2062R KC5025	C170
NG2062R KCK20B	C170
NG2062R KCU10	C170
NG2062R KCU25	C170
NG2062RK KC5010	C162
NG2062RK KC5025	C162
NG2062RK KCP10B	C162
NG2062RK KCP25B	C162
NG2062RK KCU10	C162
NG2062RK KCU25	C162
NG2062RK KT315	C162
NG2094L K313	C170
NG2094L KC5010	C170
NG2094L KCK20B	C170
NG2094L KCU10	C170
NG2094L KCU25	C170
NG2094LK KC5010	C163
NG2094LK KC5025	C163
NG2094LK KCP10B	C163
NG2094LK KCP25B	C163
NG2094LK KCU10	C163
NG2094LK KCU25	C163
NG2094R K313	C170
NG2094R KC5010	C170
NG2094R KCK20B	C170
NG2094R KCU10	C170
NG2094R KCU25	C170
NG2094RK KC5010	C162
NG2094RK KC5025	C162
NG2094RK KCP10B	C162
NG2094RK KCP25B	C162
NG2094RK KCU10	C162
NG2094RK KCU25	C162
NG2094RK KT315	C162
NG2125L KC5010	C170
NG2125L KCK20B	C170
NG2125L KCU10	C170
NG2125L KCU25	C170
NG2125LK KC5010	C163
NG2125LK KC5025	C163
NG2125LK KCP10B	C163
NG2125LK KCP25B	C163
NG2125LK KCU10	C163
NG2125LK KCU25	C163
NG2125R KC5010	C170
NG2125R KCU10	C170
NG2125R KCU25	C170
NG2125RK KC5010	C162
NG2125RK KC5025	C162
NG2125RK KCP10B	C162
NG2125RK KCP25B	C162
NG2125RK KCU10	C162
NG2125RK KCU25	C162
NG2125RK KT315	C162
NG2M050LK KC5010	C163
NG2M050LK KCP25B	C163
NG2M050LK KCU10	C163
NG2M050LK KCU25	C163
NG2M050RK KC5010	C162
NG2M050RK KCP25B	C162
NG2M050RK KCU10	C162
NG2M050RK KCU25	C162
NG2M080LK KC5025	C163
NG2M080LK KCP10B	C163
NG2M080LK KCP25B	C163
NG2M080LK KCU10	C163
NG2M080LK KCU25	C163
NG2M080RK KC5025	C162
NG2M080RK KCP10B	C162
NG2M080RK KCP25B	C162
NG2M080RK KCU10	C162
NG2M080RK KCU25	C162
NG2M100LK KC5010	C163
NG2M100LK KC5025	C163
NG2M100LK KCP10B	C163
NG2M100LK KCP25B	C163
NG2M100LK KCU10	C163
NG2M100LK KCU25	C163
NG2M100RK KC5010	C162
NG2M100RK KC5025	C162
NG2M100RK KCP10B	C162
NG2M100RK KCP25B	C162
NG2M100RK KCU10	C162
NG2M100RK KCU25	C162
NG2M120LK KC5010	C163
NG2M120LK KC5025	C163
NG2M120LK KCP10B	C163
NG2M120LK KCP25B	C163
NG2M120LK KCU10	C163
NG2M120LK KCU25	C163
NG2M120RK KC5010	C162
NG2M120RK KC5025	C162
NG2M120RK KCP10B	C162
NG2M120RK KCP25B	C162
NG2M120RK KCU10	C162
NG2M120RK KCU25	C162
NG2M140LK KC5025	C163
NG2M140LK KCP10B	C163
NG2M140LK KCP25B	C163
NG2M140LK KCU10	C163
NG2M140LK KCU25	C163
NG2M140RK KC5010	C162
NG2M140RK KC5025	C162
NG2M140RK KCP10B	C162
NG2M140RK KCP25B	C162
NG2M140RK KCU10	C162
NG2M140RK KCU25	C162
NG2M150LK KC5025	C163
NG2M150LK KCP25B	C163
NG2M150LK KCU25	C163
NG2M150RK KC5025	C162
NG2M150RK KCP25B	C162
NG2M150RK KCU25	C162
NG2M170LK KC5010	C163
NG2M170LK KC5025	C163
NG2M170LK KCP10B	C163
NG2M170LK KCP25B	C163
NG2M170LK KCU25	C163

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
NG2M170RK KC5010	C162
NG2M170RK KC5025	C162
NG2M170RK KCP10B	C162
NG2M170RK KCP25B	C162
NG2M170RK KCU10	C162
NG2M170RK KCU25	C162
NG2M175LK KC5025	C163
NG2M175LK KCP25B	C163
NG2M175LK KCU25	C163
NG2M175RK KCP25B	C162
NG2M175RK KCU25	C162
NG2M195LK KC5010	C163
NG2M195LK KCP10B	C163
NG2M195LK KCP25B	C163
NG2M195LK KCU25	C163
NG2M195RK KC5010	C162
NG2M195RK KC5025	C162
NG2M195RK KCP10B	C162
NG2M195RK KCP25B	C162
NG2M195RK KCU10	C162
NG2M195RK KCU25	C162
NG2M200LK KC5010	C163
NG2M200LK KC5025	C163
NG2M200LK KCP10B	C163
NG2M200LK KCP25B	C163
NG2M200LK KCU10	C163
NG2M200LK KCU25	C163
NG2M200RK KC5010	C162
NG2M200RK KC5025	C162
NG2M200RK KCP10B	C162
NG2M200RK KCP25B	C162
NG2M200RK KCU10	C162
NG2M200RK KCU25	C162
NG2M200RK KT315	C162
NG2M220LK KCP25B	C163
NG2M220LK KCU25	C163
NG2M220RK KC5025	C162
NG2M220RK KCP25B	C162
NG2M220RK KCU25	C162
NG2M225LK KC5025	C163
NG2M225LK KCP10B	C163
NG2M225LK KCP25B	C163
NG2M225LK KCU10	C163
NG2M225LK KCU25	C163
NG2M225RK KC5025	C162
NG2M225RK KCP10B	C162
NG2M225RK KCP25B	C162
NG2M225RK KCU10	C162
NG2M225RK KCU25	C162
NG2M250LK KC5025	C163
NG2M250LK KCP25B	C163
NG2M250LK KCU25	C163
NG2M250RK KC5025	C162
NG2M250RK KCP25B	C162
NG2M250RK KCU25	C162
NG2M275LK KC5010	C163
NG2M275LK KCP25B	C163
NG2M275LK KCU10	C163
NG2M275LK KCU25	C163
NG2M275RK KC5025	C162
NG2M275RK KCP10B	C162
NG2M275RK KCP25B	C162
NG2M275RK KCU10	C162
NG2M275RK KCU25	C162
NG2M300LK KC5010	C163
NG2M300LK KC5025	C163
NG2M300LK KCP10B	C163
NG2M300LK KCP25B	C163
NG2M300LK KCU10	C163
NG2M300LK KCU25	C163
NG2M300RK KC5010	C162
NG2M300RK KC5025	C162
NG2M300RK KCP10B	C162
NG2M300RK KCP25B	C162
NG2M300RK KCU10	C162
NG2M300RK KCU25	C162
NG2M320RK KCP25B	C162
NG2M325LK KCP25B	C163
NG2M325LK KCU25	C163
NG2M325RK KC5025	C162
NG2M325RK KCP25B	C162
NG2M325RK KCU25	C162
NG3047L K313	C170
NG3047L KC5010	C170
NG3047L KCK20B	C170
NG3047L KCU10	C170
NG3047L KCU25	C170
NG3047LK KC5010	C163
NG3047LK KC5025	C163
NG3047LK KCP10B	C163
NG3047LK KCP25B	C163
NG3047LK KCU10	C163
NG3047LK KCU25	C163
NG3047R K313	C170
NG3047R KC5010	C170
NG3047R KC5025	C170
NG3047R KCK20B	C170
NG3047R KCU10	C170
NG3047R KCU25	C170
NG3047RK KC5010	C162
NG3047RK KC5025	C162
NG3047RK KCP10B	C162
NG3047RK KCP25B	C162
NG3047RK KCU10	C162
NG3047RK KCU25	C162
NG3062L K313	C170
NG3062L KC5010	C170
NG3062L KC5025	C170
NG3062L KCK20B	C170
NG3062L KCU10	C170
NG3062L KCU25	C170
NG3062LEST KB1630	C177
NG3062LEST KD1425	C177
NG3062LK KC5010	C163
NG3062LK KC5025	C163
NG3062LK KCU10	C163
NG3062LK KCU25	C163
NG3062R K313	C170
NG3062R KC5010	C170
NG3062R KC5025	C170
NG3062R KCK20B	C170
NG3062R KCU10	C170
NG3062R KCU25	C170
NG3062REST KB1630	C177
NG3062REST KD1425	C177
NG3062RK KC5010	C162
NG3062RK KC5025	C162
NG3062RK KCP10B	C162
NG3062RK KCP25B	C162
NG3062RK KCU10	C162
NG3062RK KCU25	C162
NG3062RK KT315	C162
NG3072L KC5010	C170
NG3072L KCU10	C170
NG3072LK KC5010	C163
NG3072LK KC5025	C163
NG3072LK KCP10B	C163
NG3072LK KCP25B	C163
NG3072LK KCU10	C163
NG3072LK KCU25	C163
NG3072R KC5010	C170
NG3072R KCK20B	C170
NG3072R KCU10	C170
NG3072RK KC5010	C162
NG3072RK KC5025	C162
NG3072RK KCP10B	C162
NG3072RK KCP25B	C162
NG3072RK KCU10	C162
NG3072RK KCU25	C162
NG3078L KCU10	C170
NG3078LK KC5010	C163
NG3078LK KC5025	C163
NG3078LK KCP10B	C163
NG3078LK KCP25B	C163
NG3078LK KCU10	C163
NG3078LK KCU25	C163
NG3078R KC5010	C170
NG3078R KCK20B	C170
NG3078R KCU10	C170
NG3078RK KC5010	C162
NG3078RK KC5025	C162
NG3078RK KCP10B	C162
NG3078RK KCP25B	C162
NG3078RK KCU10	C162
NG3078RK KCU25	C162
NG3088L KC5010	C170
NG3088L KCU10	C170
NG3088L KCU25	C170
NG3088R KC5010	C170
NG3088R KCK20B	C170
NG3088R KCU10	C170
NG3088R KCU25	C170
NG3094L K313	C170
NG3094L KC5010	C170
NG3094L KC5025	C170
NG3094L KCK20B	C170
NG3094L KCU10	C170
NG3094L KCU25	C170
NG3094LEST KB1630	C177
NG3094LEST KD1425	C177
NG3094LK KC5010	C164
NG3094LK KC5025	C164
NG3094LK KCP10B	C164
NG3094LK KCP25B	C164
NG3094LK KCU10	C164
NG3094LK KCU25	C164
NG3094LK KT315	C164
NG3094R K313	C170
NG3094R KC5010	C170
NG3094R KC5025	C170
NG3094R KCK20B	C170
NG3094R KCU10	C170
NG3094R KCU25	C170
NG3094REST KB1630	C177
NG3094REST KD1425	C177
NG3094RK KC5010	C162
NG3094RK KC5025	C162
NG3094RK KCP10B	C162
NG3094RK KCU10	C162
NG3094RK KCU25	C162
NG3094RK KT315	C162
NG3097L KCU10	C171
NG3097L KCU25	C171
NG3097R KC5010	C170
NG3097R KCK20B	C170
NG3097R KCU10	C170
NG3097R KCU25	C170
NG3105L KC5010	C171
NG3105L KCU10	C171
NG3105L KCU25	C171
NG3105R KC5010	C170
NG3105R KC5025	C170
NG3105R KCK20B	C170
NG3105R KCU10	C170
NG3105R KCU25	C170
NG3110L KC5025	C171
NG3110L KCU25	C171
NG3110R KC5025	C170
NG3110R KCU25	C170
NG3122L KCU25	C171
NG3122R KCU25	C170
NG3125L K313	C171
NG3125L KC5010	C171
NG3125L KC5025	C171
NG3125L KCK20B	C171
NG3125L KCU10	C171
NG3125L KCU25	C171
NG3125LEST KB1630	C177
NG3125LK KC5010	C164
NG3125LK KC5025	C164
NG3125LK KCP10B	C164
NG3125LK KCP25B	C164
NG3125LK KCU10	C164
NG3125LK KCU25	C164
NG3125LS0820ST KB1630	C177
NG3125R K313	C170
NG3125R KC5010	C170
NG3125R KC5025	C170
NG3125R KCK20B	C170
NG3125R KCU10	C170
NG3125R KCU25	C170
NG3125REST KB1630	C177
NG3125REST KD1425	C177
NG3125RK KC5010	C162
NG3125RK KC5025	C162
NG3125RK KCP10B	C162
NG3125RK KCP25B	C162
NG3125RK KCU10	C162
NG3125RK KCU25	C162
NG3125RK KT315	C162
NG3125RS0820ST KB1630	C177
NG3125RS0820ST KB5625	C177
NG3142L KCU10	C171
NG3142L KCU25	C171
NG3142R KC5010	C170
NG3142R KCU25	C170
NG3156L KC5025	C171
NG3156L KCU25	C171
NG3156LK KC5010	C164
NG3156LK KC5025	C164
NG3156LK KCP10B	C164
NG3156LK KCP25B	C164
NG3156LK KCU10	C164
NG3156LK KCU25	C164
NG3156R KC5010	C170
NG3156R KC5025	C170
NG3156R KCK20B	C170
NG3156R KCU10	C170
NG3156R KCU25	C170
NG3156RK KC5010	C162
NG3156RK KC5025	C162
NG3156RK KCP10B	C162
NG3156RK KCP25B	C162
NG3156RK KCU10	C162
NG3156RK KCU25	C162
NG3178L KCU25	C171
NG3178R KC5025	C170
NG3185L KC5025	C171
NG3185R KCU25	C170
NG3189L KC5010	C171
NG3189L KC5025	C171
NG3189L KCK20B	C171
NG3189L KCU10	C171
NG3189L KCU25	C171
NG3189LK KC5010	C164
NG3189LK KC5025	C164
NG3189LK KCP10B	C164
NG3189LK KCP25B	C164
NG3189LK KCU10	C164
NG3189LK KCU25	C164
NG3189R K313	C170
NG3189R KC5010	C170
NG3189R KC5025	C170
NG3189R KCK20B	C170
NG3189R KCU10	C170
NG3189R KCU25	C170
NG3189REST KD1425	C177
NG3189RK KC5010	C163
NG3189RK KC5025	C163
NG3189RK KCP10B	C163
NG3189RK KCP25B	C163
NG3189RK KCU10	C163
NG3189RK KCU25	C163
NG3M100LK KC5025	C163
NG3M100LK KCP25B	C163
NG3M100LK KCU25	C163
NG3M100RK KC5025	C162
NG3M100RK KCP25B	C162
NG3M100RK KCU25	C162
NG3M120LK KC5025	C163
NG3M120LK KCP10B	C163
NG3M120LK KCP25B	C163
NG3M120LK KCU10	C163
NG3M120LK KCU25	C163
NG3M120RK KC5025	C162
NG3M120RK KCP10B	C162
NG3M120RK KCP25B	C162
NG3M120RK KCU10	C162
NG3M120RK KCU25	C162
NG3M150LK KC5025	C163
NG3M150LK KCP25B	C163
NG3M150LK KCU25	C163
NG3M150RK KC5025	C162
NG3M150RK KCP25B	C162
NG3M150RK KCU25	C162
NG3M175LK KC5025	C163
NG3M175LK KCP25B	C163
NG3M175LK KCU25	C163

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
NG3M175RK KC5025	C162
NG3M175RK KCP25B	C162
NG3M175RK KCU25	C162
NG3M200LK KC5025	C163
NG3M200LK KCP25B	C163
NG3M200LK KCU25	C163
NG3M200LS02020ST KB5625	C177
NG3M200RK KC5025	C162
NG3M200RK KCP25B	C162
NG3M200RK KCU25	C162
NG3M200RK KT315	C162
NG3M200RS02020ST KB1630	C177
NG3M200RS02020ST KB5625	C177
NG3M220LK KC5025	C164
NG3M220LK KCP25B	C164
NG3M220LK KCU25	C164
NG3M220RK KC5025	C162
NG3M220RK KCP25B	C162
NG3M220RK KCU25	C162
NG3M225LK KCP10B	C164
NG3M225LK KCP25B	C164
NG3M225LK KCU10	C164
NG3M225LK KCU25	C164
NG3M225RK KC5010	C162
NG3M225RK KC5025	C162
NG3M225RK KCP10B	C162
NG3M225RK KCP25B	C162
NG3M225RK KCU10	C162
NG3M225RK KCU25	C162
NG3M250LK KC5025	C164
NG3M250LK KCP25B	C164
NG3M250LK KCU25	C164
NG3M250RK KC5025	C162
NG3M250RK KCP25B	C162
NG3M250RK KCU25	C162
NG3M275LK KC5025	C164
NG3M275LK KCP10B	C164
NG3M275LK KCP25B	C164
NG3M275LK KCU10	C164
NG3M275LK KCU25	C164
NG3M275RK KC5010	C162
NG3M275RK KC5025	C162
NG3M275RK KCP10B	C162
NG3M275RK KCP25B	C162
NG3M275RK KCU10	C162
NG3M275RK KCU25	C162
NG3M300LK KC5010	C164
NG3M300LK KC5025	C164
NG3M300LK KCP10B	C164
NG3M300LK KCP25B	C164
NG3M300LK KCU10	C164
NG3M300LK KCU25	C164
NG3M300RK KC5010	C162
NG3M300RK KC5025	C162
NG3M300RK KCP10B	C162
NG3M300RK KCP25B	C162
NG3M300RK KCU10	C162
NG3M300RK KCU25	C162
NG3M300RS02020ST KB1630	C177
NG3M300RS02020ST KB5625	C177
NG3M320LK KC5025	C164
NG3M320LK KCP25B	C164
NG3M320LK KCU25	C164
NG3M320RK KC5025	C162
NG3M320RK KCP25B	C162
NG3M320RK KCU25	C162
NG3M325LK KC5025	C164
NG3M325LK KCP25B	C164
NG3M325LK KCU25	C164
NG3M325RK KC5025	C162
NG3M325RK KCP25B	C162
NG3M325RK KCU25	C162
NG3M350LK KC5025	C164
NG3M350LK KCP25B	C164
NG3M350LK KCU25	C164
NG3M350RK KC5025	C162
NG3M350RK KCP25B	C162
NG3M350RK KCU25	C162
NG3M400LK KC5025	C164
NG3M400LK KCP10B	C164
NG3M400LK KCP25B	C164
NG3M400LK KCU10	C164
NG3M400LK KCU25	C164
NG3M400RK KC5010	C162
NG3M400RK KC5025	C162
NG3M400RK KCP10B	C162
NG3M400RK KCP25B	C162
NG3M400RK KCU10	C162
NG3M400RK KCU25	C162
NG3M400RS02020ST KB5625	C177
NG3M425LK KCP10B	C164
NG3M425LK KCP25B	C164
NG3M425LK KCU10	C164
NG3M425LK KCU25	C164
NG3M425RK KC5025	C163
NG3M425RK KCP10B	C163
NG3M425RK KCP25B	C163
NG3M425RK KCU10	C163
NG3M425RK KCU25	C163
NG3M450LK KCP25B	C164
NG3M450LK KCU25	C164
NG3M450RK KCP25B	C163
NG3M450RK KCU25	C163
NG4125L K313	C171
NG4125L KCU10	C171
NG4125L KCU25	C171
NG4125LK KCP10B	C164
NG4125LK KCP25B	C164
NG4125LK KCU10	C164
NG4125LK KCU25	C164
NG4125R K313	C170
NG4125R KCK20B	C170
NG4125R KCU10	C170
NG4125R KCU25	C170
NG4125RK KC5010	C163
NG4125RK KCP10B	C163
NG4125RK KCP25B	C163
NG4125RK KCU10	C163
NG4125RK KCU25	C163
NG4189L KC5010	C171
NG4189L KCK20B	C171
NG4189L KCU10	C171
NG4189L KCU25	C171
NG4189LEST KB1630	C171, C177
NG4189LK KC5010	C164
NG4189LK KC5025	C164
NG4189LK KCP10B	C164
NG4189LK KCP25B	C164
NG4189LK KCU10	C164
NG4189LK KCU25	C164
NG4189R K313	C170
NG4189R KC5010	C170
NG4189R KCK20B	C170
NG4189R KCU10	C170
NG4189R KCU25	C170
NG4189REST KB1630	C177
NG4189RK KC5010	C163
NG4189RK KC5025	C163
NG4189RK KCP10B	C163
NG4189RK KCP25B	C163
NG4189RK KCU10	C163
NG4189RK KCU25	C163
NG4213R KCU25	C170
NG4250L KC5010	C171
NG4250L KC5025	C171
NG4250L KCK20B	C171
NG4250L KCU10	C171
NG4250L KCU25	C171
NG4250LK KC5010	C164
NG4250LK KC5025	C164
NG4250LK KCP10B	C164
NG4250LK KCP25B	C164
NG4250LK KCU10	C164
NG4250LK KCU25	C164
NG4250R KC5010	C170
NG4250R KC5025	C170
NG4250R KCK20B	C170
NG4250R KCU10	C170
NG4250R KCU25	C170
NG4250RK KC5010	C163
NG4250RK KC5025	C163
NG4250RK KCP10B	C163
NG4250RK KCP25B	C163
NG4250RK KCU25	C163
NG4M300LK KCP25B	C164
NG4M300LK KCU25	C164
NG4M300RK KCP25B	C163
NG4M300RK KCU25	C163
NG4M320LK KCP25B	C164
NG4M350LK KCP25B	C164
NG4M350LK KCU25	C164
NG4M350RK KCP25B	C163
NG4M350RK KCU25	C163
NG4M400LK KCP10B	C164
NG4M400LK KCP25B	C164
NG4M400LK KCU10	C164
NG4M400LK KCU25	C164
NG4M400RK KC5010	C163
NG4M400RK KC5025	C163
NG4M400RK KCP10B	C163
NG4M400RK KCP25B	C163
NG4M400RK KCU25	C163
NG4M450LK KC5025	C164
NG4M450LK KCP25B	C164
NG4M450LK KCU25	C164
NG4M450RK KCP25B	C163
NG4M450RK KCU25	C163
NG4M500LK KC5010	C164
NG4M500LK KCP10B	C164
NG4M500LK KCP25B	C164
NG4M500LK KCU10	C164
NG4M500LK KCU25	C164
NG4M500RK KCP10B	C163
NG4M500RK KCP25B	C163
NG4M500RK KCU10	C163
NG4M500RK KCU25	C163
NG4M550LK KCP25B	C164
NG4M550RK KCP25B	C163
NG4M600LK KCP25B	C164
NG4M600LK KCU25	C164
NG4M600RK KCP25B	C163
NG4M600RK KCU25	C163
NG5312R KCU25	C170
NG6375R KCU25	C170
NGC2C130L055K KCU25	C168
NGC2C130R055K KCU25	C168
NGC2C185L125K KCU25	C168
NGC2C215L150K KCU25	C168
NGC2C215R150K KCU25	C168
NGD2M150LK KC5025	C165
NGD2M150LK KCU10	C165
NGD2M150LK KCU25	C165
NGD2M150RK KC5010	C165
NGD2M150RK KC5025	C165
NGD2M150RK KCU10	C165
NGD2M150RK KCU25	C165
NGD2M200LK KC5010	C165
NGD2M200LK KC5025	C165
NGD2M200LK KCU10	C165
NGD2M200LK KCU25	C165
NGD2M200RK KC5010	C165
NGD2M200RK KC5025	C165
NGD2M200RK KCU10	C165
NGD2M200RK KCU25	C165
NGD2M250LK KC5010	C165
NGD2M250LK KC5025	C165
NGD2M250LK KCU10	C165
NGD2M250LK KCU25	C165
NGD2M250RK KC5025	C165
NGD2M250RK KCU10	C165
NGD2M250RK KCU25	C165
NGD3062LK KC5010	C165
NGD3062LK KC5025	C165
NGD3062LK KCU10	C165
NGD3062LK KCU25	C165
NGD3062RK K313	C165
NGD3062RK KC5010	C165
NGD3062RK KC5025	C165
NGD3062RK KCU10	C165
NGD3062RK KCU25	C165
NGD3094LK K313	C165
NGD3094LK KC5010	C165
NGD3094LK KC5025	C165
NGD3094LK KCU10	C165
NGD3094LK KCU25	C165
NGD3094RK K313	C165
NGD3094RK KC5010	C165
NGD3094RK KC5025	C165
NGD3094RK KCU10	C165
NGD3094RK KCU25	C165
NGD3125LK K313	C165
NGD3125LK KC5010	C165
NGD3125LK KC5025	C165
NGD3125LK KCU10	C165
NGD3125LK KCU25	C165
NGD3125RK K313	C165
NGD3125RK KC5010	C165
NGD3125RK KC5025	C165
NGD3125RK KCU10	C165
NGD3125RK KCU25	C165
NGD3189L K313	C171
NGD3189L KC5010	C171
NGD3189L KCU10	C171
NGD3189LK KC5010	C165
NGD3189LK KC5025	C165
NGD3189LK KCU10	C165
NGD3189LK KCU25	C165
NGD3189R K313	C171
NGD3189R KCU10	C171
NGD3189RK KC5010	C165
NGD3189RK KC5025	C165
NGD3189RK KCU10	C165
NGD3189RK KCU25	C165
NGD3M200LK KC5025	C165
NGD3M200LK KCU25	C165
NGD3M200RK KC5010	C165
NGD3M200RK KC5025	C165
NGD3M200RK KCU10	C165
NGD3M200RK KCU25	C165
NGD3M250LK KC5025	C165
NGD3M250LK KCU25	C165
NGD3M250RK KC5010	C165
NGD3M250RK KC5025	C165
NGD3M250RK KCU25	C165
NGD3M300LK KC5010	C165
NGD3M300LK KC5025	C165
NGD3M300LK KCU10	C165
NGD3M300LK KCU25	C165
NGD3M300RK KC5010	C165
NGD3M300RK KC5025	C165
NGD3M300RK KCU10	C165
NGD3M300RK KCU25	C165
NGD3M350LK KC5025	C165
NGD3M350LK KCU25	C165
NGD3M400LK KC5025	C165
NGD3M400LK KCU10	C165
NGD3M400LK KCU25	C165
NGD3M400RK KC5010	C165
NGD3M400RK KC5025	C165
NGD3M400RK KCU10	C165
NGD3M400RK KCU25	C165
NGD4125LK KC5010	C165
NGD4125LK KC5025	C165
NGD4125LK KCU10	C165
NGD4125LK KCU25	C165
NGD4125RK KC5010	C165
NGD4125RK KC5025	C165
NGD4125RK KCU10	C165
NGD4125RK KCU25	C165
NGD4189LK KC5010	C165
NGD4189LK KC5025	C165
NGD4189LK KCU10	C165
NGD4189LK KCU25	C165
NGD4189RK KC5010	C165
NGD4189RK KC5025	C165
NGD4189RK KCU10	C165
NGD4189RK KCU25	C165
NGD4250L K313	C171
NGD4250L KC5010	C171
NGD4250L KCU10	C171
NGD4250LK KC5025	C165
NGD4250LK KCU10	C165
NGD4250LK KCU25	C165
NGD4250R K313	C171
NGD4250R KCU10	C171
NGD4250RK KC5010	C165
NGD4250RK KC5025	C165
NGD4250RK KCU10	C165

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
NGD4250RK KCU25	C165
NGD4M400LK KCU25	C165
NGD4M500LK KCU25	C165
NGD4M550RK KCU25	C165
NGP2031L KCU10	C168
NGP2031R KC5010	C168
NGP2031R KCU10	C168
NGP2062L KCU10	C168
NGP2062R KC5010	C168
NGP2062R KCU10	C168
NGP2125L KCU10	C168
NGP2125R KCU10	C168
NGP3088L KCU10	C168
NGP3088R KCU10	C168
NGP3088R KD1425	C168
NGP3125L KC5010	C168
NGP3125R KC5010	C168
NGP3125R KCU10	C168
NGP3125R KD1425	C168
NGP3156R KCU10	C168
NGP4189R KCU10	C168
NGP4250L KCU10	C168
NGP4250R KC5010	C168
NJ3010L16 KC5025	D15
NJ3010R16 K68	D15
NJ3010R16 KC5025	D15
NJ3010R16 KCU25	D15
NJ3014L12 KC5010	D15
NJ3014L12 KC5025	D15
NJ3014R12 KC5010	D15
NJ3014R12 KC5025	D15
NJ3014R12 KCU10	D15
NJ3014R12 KCU25	D15
NJ3020L8 KC5025	D15
NJ3020R8 KC5010	D15
NJ3020R8 KC5025	D15
NJF3005R32 KC5010	D15
NJF3005R32 KCU10	D15
NJF3006R28 KC5010	D15
NJF3006R28 KC5025	D15
NJF3007L24 KC5010	D15
NJF3007R24 KC5010	D15
NJF3007R24 KC5025	D15
NJF3008L20 KC5010	D15
NJF3008R20 KC5010	D15
NJF3008R20 KC5025	D15
NJF3009R18 K68	D15
NJF3009R18 KC5010	D15
NJF3009R18 KC5025	D15
NJF3009R18 KCU25	D15
NJF3010L16 KC5010	D15
NJF3010R16 KC5010	D15
NJF3010R16 KC5025	D15
NJF3012R14 KC5010	D15
NJF3012R14 KC5025	D15
NJF3012R14 KCU25	D15
NJK3005L32 KC5025	D16
NJK3005R32 KC5010	D16
NJK3005R32 KC5025	D16
NJK3006L28 KC5025	D16
NJK3006R28 KC5010	D16
NJK3006R28 KCU25	D16
NJK3007R24 KC5010	D16
NJK3007R24 KC5025	D16
NJK3007R24 KCU25	D16
NJK3008R20 KC5010	D16
NJK3008R20 KC5025	D16
NJK3008R20 KCU10	D16
NJK3008R20 KCU25	D16
NJK3009R18 KC5010	D16
NJK3009R18 KC5025	D16
NJK3010R16 KC5010	D16
NJK3010R16 KC5025	D16
NJK3010R16 KCU25	D16
NJK3012R14 KC5010	D16
NJK3012R14 KC5025	D16
NJP3010L16 KC5025	D16
NJP3010R16 KC5010	D16
NJP3010R16 KC5025	D16
NJP3010R16 KCU10	D16
NJP3014L12 KC5010	D16
NJP3014R12 K68	D16
NJP3014R12 KC5010	D16
NJP3014R12 KC5025	D16
NJP3014R12 KCU10	D16
NJP3014R12 KCU25	D16
NJP3020L8 KC5025	D16
NJP3020R8 KC5010	D16
NJP3020R8 KC5025	D16
NJP3020R8 KCU25	D16
NKLCL0805V	E41
NKLCL1005B	E41
NKLCL1205A	E41
NKLCL1205B	E41
NKLCL1605C	E41
NKLCLF0805D	E42
NKLCR0805V	E41
NKLCR1005B	E41
NKLCR1205A	E41
NKLCR1205B	E41
NKLCR1605C	E41
NKLCRF0805D	E42
NKLCRF1005B	E42
NKLNL121B	E41
NKLNL161C	E41
NKLNR121B	E41
NKLNR161C	E41
NKPCN1205B	E42
NLW-0.375 S	T128, T131
NLW12SP	T131
NP2002RK KC5010	C167
NP2002RK KC5025	C167
NP2002RK KCU10	C167
NP2002RK KCU25	C167
NP2012RK KCU25	C167
NP3002RK KC5010	C167
NP3002RK KCU10	C167
NP3002RK KCU25	C167
NP3012RK KC5025	C167
NP3012RK KCU25	C167
NPD2002RK KC5010	C167
NPD2002RK KCU25	C167
NPD3002RK KCU25	C167
NPD3012RK KC5010	C167
NPD3012RK KCU10	C167
NPD3012RK KCU25	C167
NPGR51L K68	E33
NPGR51L KC5010	E33
NPGR51L KC5025	E33
NPGR51L KCU10	E33
NPGR51L KCU25	E33
NPGR51L KT315	E33
NPGR51LFP KCM25	E33
NPGR51LFP KCP10	E33
NPGR51LFP KCP25	E33
NPGR51LFP KCU25	E33
NPGR51R K68	E33
NPGR51R KC5010	E33
NPGR51R KC5025	E33
NPGR51R KCU10	E33
NPGR51R KCU25	E33
NPGR51R KD1425	E33
NPGR51R KT315	E33
NPGR51RFP KCM25	E33
NPGR51RFP KCP10	E33
NPGR51RFP KCP25	E33
NPGR52L KC5025	E33
NPGR52L KCM15B	E33
NPGR52L KCU10	E33
NPGR52L KCU25	E33
NPGR52L KD1425	E33
NPGR52LFP KCP10	E33
NPGR52LFP KCP25	E33
NPGR52R KCU10	E33
NPGR52R KCU25	E33
NPGR52R KT315	E33
NPGR52RFP KCP10	E33
NPGR52RFP KCU10	E33
NPL131F KC5010	E34
NPL131F KCU25	E34
NPL132F K68	E34
NPL132F KC5010	E34
NPL132F KCU25	E34
NPL13M05N K68	E35
NPL13M05N KCU10	E35
NPL13M10N K68	E35
NPL13M10N KCU10	E35
NPL332F KCU10	E34
NPL505 K313	E35
NPL505 K68	E35
NPL505 KC5010	E35
NPL505 KCU25	E35
NPL505 KD1425	E35
NPL508 K313	E35
NPL508 KCU10	E35
NPL508 KCU25	E35
NPL508 KD1425	E35
NPL51 K313	E35
NPL51 K68	E35
NPL51 KC5010	E35
NPL51 KC5025	E35
NPL51 KCU10	E35
NPL51 KCU25	E35
NPL51 KD1425	E35
NPL52 K313	E35
NPL52 K68	E35
NPL52 KC5010	E35
NPL52 KCU25	E35
NPL5M02 K68	E36
NPL5M02 KC5010	E36
NPL5M02 KCU10	E36
NPL5M05 K68	E36
NPL5M05 KC5010	E36
NPL5M05 KCU10	E36
NPR1305 K68	E34
NPR1305 KCU10	E34
NPR1308 KCU10	E34
NPR131F KC5010	E34
NPR131F KCU25	E34
NPR132F KC5010	E34
NPR132F KCU10	E34
NPR132F KCU25	E34
NPR13M05F KC5010	E35
NPR13M05F KCP25B	E36
NPR13M05F KCU10	E35
NPR13M05N K68	E35
NPR13M05N KCP25B	E35
NPR13M10N K68	E35
NPR13M10N KCU10	E35
NPR331N KCU25	E34
NPR332 KCU10	E34
NPR505 K313	E35
NPR505 K68	E35
NPR505 KC5010	E35
NPR505 KC5025	E35
NPR505 KCU10	E35
NPR505 KD1425	E35
NPR508 K313	E35
NPR508 KC5010	E35
NPR508 KCU10	E35
NPR508 KCU25	E35
NPR508 KD1425	E35
NPR508 KT315	E35
NPR51 K313	E35
NPR51 K68	E35
NPR51 KC5010	E35
NPR51 KC5025	E35
NPR51 KC5410	E35
NPR51 KCU10	E35
NPR51 KCU25	E35
NPR51 KD1425	E35
NPR51 KT315	E35
NPR52 K68	E35
NPR52 KC5010	E35
NPR52 KC5025	E35
NPR52 KCU10	E35
NPR52 KT315	E35
NPR5M02 K68	E36
NPR5M02 KC5010	E36
NPR5M05 K68	E36
NPR5M05 KC5010	E36
NPR5M05 KCP25B	E36
NPR5M05 KCU10	E36
NR2031L KC5010	C172
NR2031L KC5025	C172
NR2031L KCU10	C172
NR2031L KCU25	C172
NR2031R KC5010	C172
NR2031R KC5025	C172
NR2031R KCU10	C172
NR2031R KCU25	C172
NR2047L KCU25	C172
NR2047R KCU25	C172
NR2062L KC5010	C172
NR2062L KCU10	C172
NR2062L KCU25	C172
NR2062R KC5010	C172
NR2062R KCU10	C172
NR2062R KCU25	C172
NR2M050L KC5010	C172
NR2M050L KCU10	C172
NR2M050L KCU25	C172
NR2M050R KC5010	C172
NR2M050R KC5025	C172
NR2M050R KCU10	C172
NR2M050R KCU25	C172
NR2M075R KC5010	C172
NR2M075R KCU10	C172
NR2M100L KC5025	C172
NR2M100R KC5010	C172
NR2M100R KC5025	C172
NR2M100R KCU10	C172
NR2M125R KC5025	C172
NR2M150L KC5025	C172
NR2M150R KC5025	C172
NR2M175R KC5025	C172
NR3031L K313	C172
NR3031L KC5010	C172
NR3031L KC5025	C172
NR3031L KCU10	C172
NR3031L KCU25	C172
NR3031LK KC5010	C166
NR3031LK KC5025	C166
NR3031LK KCU10	C166
NR3031LK KCU25	C166
NR3031R K313	C172
NR3031R KC5010	C172
NR3031R KC5025	C172
NR3031R KCU10	C172
NR3031R KCU25	C172
NR3031RK KC5010	C166
NR3031RK KC5025	C166
NR3031RK KCU10	C166
NR3031RK KCU25	C166
NR3047L K313	C172
NR3047L KC5010	C172
NR3047L KCU10	C172
NR3047L KCU25	C172
NR3047LK KC5010	C166
NR3047LK KC5025	C166
NR3047LK KCU10	C166
NR3047LK KCU25	C166
NR3047R K313	C172
NR3047R KC5010	C172
NR3047R KCU10	C172
NR3047R KCU25	C172
NR3047RK KC5010	C166
NR3047RK KC5025	C166
NR3047RK KCU10	C166
NR3047RK KCU25	C166
NR3062L K313	C172
NR3062L KC5010	C172
NR3062L KC5025	C172
NR3062L KCU10	C172
NR3062L KCU25	C172
NR3062LK KC5010	C166
NR3062LK KC5025	C166
NR3062LK KCU10	C166
NR3062LK KCU25	C166
NR3062R K313	C172
NR3062R KC5010	C172
NR3062R KC5025	C172
NR3062R KCU10	C172
NR3062R KCU25	C172
NR3062RK KC5010	C166
NR3062RK KC5025	C166
NR3062RK KCU10	C166
NR3062RK KCU25	C166

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
NR3078LK KC5010	C166
NR3078LK KC5025	C166
NR3078LK KCU25	C166
NR3078R K313	C172
NR3078RK KC5010	C166
NR3078RK KCU10	C166
NR3078RK KCU25	C166
NR3094L K313	C172
NR3094L KC5010	C172
NR3094L KC5025	C172
NR3094L KCU25	C172
NR3094R KC5010	C172
NR3094R KC5025	C172
NR3094R KCU10	C172
NR3094R KCU25	C172
NR3M100L KC5025	C172
NR3M100R KC5025	C172
NR3M150L KC5010	C172
NR3M150L KC5025	C172
NR3M150L KCU10	C172
NR3M150R KC5025	C172
NR3M200L KC5025	C172
NR3M200R KC5025	C172
NR4062LK KC5010	C166
NR4062LK KCU10	C166
NR4062LK KCU25	C166
NR4062RK KC5010	C166
NR4062RK KCU10	C166
NR4062RK KCU25	C166
NR4094LK KC5010	C166
NR4094LK KC5025	C166
NR4094LK KCU10	C166
NR4094LK KCU25	C166
NR4094R K313	C172
NR4094RK KC5010	C166
NR4094RK KCU10	C166
NR4094RK KCU25	C166
NR4125L KC5010	C172
NR4125L KCU25	C172
NR4125LK KC5010	C166
NR4125LK KCU10	C166
NR4125LK KCU25	C166
NR4125R KC5010	C172
NR4125R KCU10	C172
NR4125R KCU25	C172
NR4125RK KC5010	C166
NR4125RK KC5025	C166
NR4125RK KCU10	C166
NR4125RK KCU25	C166
NRD3031L KC5010	C173
NRD3031L KC5025	C173
NRD3031L KCU10	C173
NRD3031L KCU25	C173
NRD3031R KC5010	C173
NRD3031R KC5025	C173
NRD3031R KCU10	C173
NRD3031R KCU25	C173
NRD3062L KC5010	C173
NRD3062L KC5025	C173
NRD3062L KCU10	C173
NRD3062L KCU25	C173
NRD3062R KC5010	C173
NRD3062R KC5025	C173
NRD3062R KCU10	C173
NRD3062R KCU25	C173
NRD4062L KC5010	C173
NRD4062L KC5025	C173
NRD4062L KCU10	C173
NRD4062L KCU25	C173
NRD4062R KC5010	C173
NRD4062R KCU10	C173
NRD4062R KCU25	C173
NRD4094L KC5010	C173
NRD4094L KCU10	C173
NRD4094L KCU25	C173
NRD4094R KC5010	C173
NRD4094R KCU10	C173
NRD4125L KC5010	C173
NRD4125L KC5025	C173
NRD4125L KCU10	C173
NRD4125L KCU25	C173
NRD4125R KC5010	C173
NRD4125R KCU25	C173
NRL123B	C189
NRL163C	C189
NRL163D	C189
NRL2020K3	C189
NRL203D	C189
NRL2525M3	C189
NRL3225P3	C189
NRP3031L KC5010	C169
NRP3031L KCU10	C169
NRP3031R KC5010	C169
NRP3031R KCU10	C169
NRP3047L KC5010	C169
NRP3047L KCU10	C169
NRP3047R K313	C169
NRP3047R KC5010	C169
NRP3047R KCU10	C169
NRP3062L KC5010	C169
NRP3062R KC5010	C169
NRP3062R KCU10	C169
NRP3094L KC5010	C169
NRP3094L KCU10	C169
NRP3094R KC5010	C169
NRP3094R KCU10	C169
NRR123B	C189
NRR163C	C189
NRR163D	C189
NRR2020K3	C189
NRR203D	C189
NRR243D	C189
NRR2525M3	C189
NRR3225P3	C189
NSL062	C182, D27
NSL082V	C182, D27
NSL1010E2	C183
NSL102B	C182, D27
NSL1212F2	C183
NSL122B	C182, D27
NSL123A	C182, D27
NSL123B	C182, D27
NSL1616H2	C183
NSL162C	C182, D27
NSL163C	C182, D27
NSL163D	C182, D27
NSL164C	C184, D28
NSL164D	C184, D28
NSL166D	C184, D28
NSL2020K2	C183
NSL2020K3	C183
NSL203D	C182, D27
NSL204C	C184, D28
NSL204D	C184, D28
NSL205D	C182, D27
NSL206D	C184, D28
NSL243D	C182, D27
NSL243E	C182, D27
NSL244D	C184, D28
NSL244E	C184, D28
NSL246D	C184, D28
NSL2525M2	C183
NSL2525M3	C183
NSL2525M4	C183
NSL3225P3	C183
NSL3225P4	C183
NSL3232P3	C183
NSL3232P4	C183
NSL853D	C182, D27
NSL854D	C184, D28
NSLDH203D	C186, D29
NSR062	C182, D27
NSR082V	C182, D27
NSR1010E2	C183
NSR102B	C182, D27
NSR1212F2	C183
NSR122B	C182, D27
NSR123A	C182, D27
NSR123B	C182, D27
NSR1616H2	C183
NSR162C	C182, D27
NSR163C	C182, D27
NSR163D	C182, D27
NSR164C	C184, D28
NSR164D	C184, D28
NSR166D	C184, D28
NSR168D	C184, D28
NSR2020K2	C183
NSR2020K3	C183
NSR203D	C182, D27
NSR204C	C184, D28
NSR204D	C184, D28
NSR205D	C182, D27
NSR206D	C184, D28
NSR243D	C182, D27
NSR243E	C182, D27
NSR244D	C184, D28
NSR244E	C184, D28
NSR245D	C182, D27
NSR246D	C184, D28
NSR2525M2	C183
NSR2525M3	C183
NSR2525M4	C183
NSR3225P3	C183
NSR3225P4	C183
NSR3232P3	C183
NSR3232P4	C183
NSR853D	C182, D27
NSR854D	C184, D28
NSR864E	C184, D28
NSRDH122B	C186, D29
NSRDH123A	C186, D29
NSRDH162C	C186, D29
NSRDH163C	C186, D29
NSRDH163D	C186, D29
NSRDH203D	C186, D29
NSRDH204D	C186, D29
NST1	B168–169, B386–387
NST2	B168–169, B386–387
NST3	B168–169, B386–387
NSUL164D	D29
NSUR124C	D29
NSUR164D	D29
NT1L K68	D23
NT1L KC5010	D23
NT1L KC5025	D23
NT1L KCU10	D23
NT1L KCU25	D23
NT2L K313	D17
NT2L K68	D17
NT2L KC5010	D17
NT2L KC5025	D17
NT2L KCU10	D17
NT2L KCU25	D17
NT2LK KC5010	D22
NT2LK KC5025	D22
NT2LK KCU10	D22
NT2LK KCU25	D22
NT2R K313	D17
NT2R K68	D17
NT2R KC5010	D17
NT2R KC5025	D17
NT2R KCU10	D17
NT2R KCU25	D17
NT2RK KC5010	D22
NT2RK KC5025	D22
NT2RK KCU10	D22
NT2RK KCU25	D22
NT3L K68	D17
NT3L KC5010	D17
NT3L KC5025	D17
NT3L KCU10	D17
NT3L KCU25	D17
NT3LCK KC5010	D19
NT3LCK KC5025	D19
NT3LCK KCU10	D19
NT3LCK KCU25	D19
NT3LK KC5010	D22
NT3LK KC5025	D22
NT3LK KCU10	D22
NT3LK KCU25	D22
NT3R K313	D17
NT3R K68	D17
NT3R KC5010	D17
NT3R KC5025	D17
NT3R KCU10	D17
NT3R KCU25	D17
NT3RCK KC5010	D19
NT3RCK KC5025	D19
NT3RCK KCU10	D19
NT3RCK KCU25	D19
NT3RK KC5010	D22
NT3RK KC5025	D22
NT3RK KCU10	D22
NT3RK KCU25	D22
NT4L K68	D17
NT4L KC5010	D17
NT4L KC5025	D17
NT4L KCU10	D17
NT4L KCU25	D17
NT4LCK KC5025	D19
NT4LCK KCU25	D19
NT4LK KC5010	D22
NT4LK KC5025	D22
NT4LK KCU10	D22
NT4LK KCU25	D22
NT4R K68	D17
NT4R KC5010	D17
NT4R KC5025	D17
NT4R KCU10	D17
NT4R KCU25	D17
NT4RCK KC5010	D19
NT4RCK KC5025	D19
NT4RCK KCU25	D19
NT4RK KC5010	D22
NT4RK KC5025	D22
NT4RK KCU10	D22
NT4RK KCU25	D22
NTB2LB KC5010	D18
NTB2LB KCU10	D18
NTB2RA K68	D17
NTB2RB KC5010	D18
NTB3L12B KC5010	D18
NTB3LA K68	D17
NTB3LA KC5010	D17
NTB3LA KC5025	D17
NTB3LB K68	D18
NTB3LB KC5010	D18
NTB3LB KC5025	D18
NTB3LB KCU10	D18
NTB3R12B KC5010	D18
NTB3RA KC5025	D17
NTB3RA KCU10	D17
NTB3RB K68	D18
NTB3RB KC5010	D18
NTB3RB KC5025	D18
NTB3RB KCU10	D18
NTB3RB KCU25	D18
NTB4LB KC5010	D18
NTB4LB KC5025	D18
NTB4RA KCU10	D17
NTB4RB KC5010	D18
NTB4RB KC5025	D18
NTB4RB KCU10	D18
NTC3L10E KCU10	D20
NTC3L10I KC5025	D18
NTC3L12E KCU10	D20
NTC3L12I KC5025	D18
NTC3L14I KC5025	D18
NTC3L16E KCU10	D20
NTC3L16I KC5025	D18
NTC3L8E KC5010	D20
NTC3L8I KC5025	D18
NTC3MR150E KC5010	D19
NTC3MR150E KC5025	D19
NTC3MR150E KCU10	D19
NTC3MR200E KC5010	D19
NTC3R10E KC5010	D20
NTC3R10E KC5025	D20
NTC3R11E KC5025	D20
NTC3R11E KCU10	D20
NTC3R12E KC5010	D20
NTC3R12E KC5025	D20
NTC3R12E KCU25	D20
NTC3R12I KC5025	D18
NTC3R13E KC5010	D20
NTC3R13E KC5025	D20
NTC3R14E KC5010	D20

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
NTC3R14E KC5025	D20
NTC3R16E KC5010	D20
NTC3R16E KC5025	D20
NTC3R18E KC5010	D20
NTC3R18E KC5025	D20
NTC3R18E KCU25	D20
NTC3R20E KC5010	D20
NTC3R20E KC5025	D20
NTC3R20E KCU10	D20
NTC3R24E KC5010	D20
NTC3R24E KC5025	D20
NTC3R28E KC5025	D20
NTC3R32E KC5025	D20
NTC3R32E KCU10	D20
NTC3R7E KC5025	D20
NTC3R8E KC5010	D20
NTC3R8E KC5025	D20
NTC3R8E KCU10	D20
NTC3R9E KCU10	D20
NTF2L K68	D21
NTF2L KC5010	D21
NTF2L KC5025	D21
NTF2L KCU10	D21
NTF2L KCU25	D21
NTF2R K68	D21
NTF2R KC5010	D21
NTF2R KC5025	D21
NTF2R KCU10	D21
NTF2R KCU25	D21
NTF3L K68	D21
NTF3L KC5010	D21
NTF3L KC5025	D21
NTF3L KCU10	D21
NTF3L KCU25	D21
NTF3R K68	D21
NTF3R KC5010	D21
NTF3R KC5025	D21
NTF3R KCU10	D21
NTF3R KCU25	D21
NTF4R KC5025	D21
NTK2L K68	D21
NTK2L KC5010	D21
NTK2L KC5025	D21
NTK2L KCU10	D21
NTK2L KCU25	D21
NTK2R K68	D21
NTK2R KC5010	D21
NTK2R KC5025	D21
NTK2R KCU10	D21
NTK2R KCU25	D21
NTK3L K68	D21
NTK3L KC5010	D21
NTK3L KC5025	D21
NTK3L KCU10	D21
NTK3L KCU25	D21
NTK3R K68	D21
NTK3R KC5010	D21
NTK3R KC5025	D21
NTK3R KCU10	D21
NTK3R KCU25	D21
NTP2L K68	D22
NTP2L KC5010	D22
NTP2L KC5025	D22
NTP2L KCU10	D22
NTP2L KCU25	D22
NTP2R K68	D22
NTP2R KC5010	D22
NTP2R KC5025	D22
NTP2R KCU10	D22
NTP2R KCU25	D22
NTP3L K68	D22
NTP3L KC5010	D22
NTP3L KC5025	D22
NTP3L KCU10	D22
NTP3L KCU25	D22
NTP3R K68	D22
NTP3R KC5010	D22
NTP3R KC5025	D22
NTP3R KC5410	D22
NTP3R KCU10	D22
NTP3R KCU25	D22
NTP4L KC5010	D22
NTP4L KC5025	D22
NTP4R KC5010	D22
NTP4R KC5025	D22
NTP4R KCU10	D22
NTP4R KCU25	D22
NTU4R KC5025	D22
NTU4R KCU25	D22
NU3094L KC5025	C175
NU3094L KCU25	C175
NU3094R KC5025	C175
NU3125L KC5025	C175
NU3125R KCU25	C175
NU3156L KC5025	C175
NUFRL	E64
NUFRR	E64
NUWTC	E65
NV3RJ KCU25	C176
NV4LL KCU25	C176
NV4RL KCU25	C176
NVLCL123B	E43
NVLCL163D	E43
NVLCL203D	E43
NVLCL243D	E43
NVLCR123B	E43
NVLCR163D	E43
NVLCR203D	E43
NVLCR243D	E43
NVVCN163D	E43
NWC3L11I KC5025	D23
NWC3R11E KC5010	D23
NWC3R11E KC5025	D23
NWC3R14E KC5010	D23
NWC3R14E KCU25	D23
ODC1063IEGD KMF	U9
ODC2087IEGD KMF	U9
ODC3125IEGD KMF	U9
ODC4158IEGD KMF	U9
ODG1063ISGB KC735M	U9
ODG1063ISGB KCPK30	U9
ODG1063ISGD KC735M	U9
ODG1063ISGD KCPK30	U9
ODG2087ISGB KC735M	U9
ODG2087ISGB KCPK30	U9
ODG2087ISGD KC735M	U9
ODG2087ISGD KCPK30	U9
ODG3125ISGB KC735M	U9
ODG3125ISGB KCPK30	U9
ODG3125ISGD KC735M	U9
ODG3125ISGD KCPK30	U9
ODG4158ISGB KC735M	U9
ODG4158ISGB KCPK30	U9
ODG4158ISGD KC735M	U9
ODG4158ISGD KCPK30	U9
ODG5197ISGB KC735M	U10
ODG6236ISGB KC735M	U10
ODG6236ISGB KCPK30	U10
OFKT53AFEN4GB KC520M	S47
OFKT53AFEN4GB KC522M	S47
OFKT53AFEN4GB KC725M	S47
OFKT53AFEN4GB KCK15	S47
OFKT53AFEN4GB KCPK30	S47
OFKT53AFEN4GB KCPM40	S47
OFKT53AFEN4GB KCSM40	S47
OFKT53AFEN4LBJ KC422M	S46
OFKT53AFEN6LB KC522M	S47
OFKT53AFEN6LB KC725M	S47
OFKT53AFEN6LB KCK15	S47
OFKT53AFEN6LB KCPK30	S47
OFKT53AFEN6LB KCSM40	S47
OFKT53AFFN4LBJ KC410M	S46
OFKT53AFFN4LNJ KC410M	S46
OFKT53AFSN4HB KC522M	S47
OFKT53AFSN4HB KC725M	S47
OFKT53AFSN4HB KCPK30	S47
OFKT53AFSN4HB KCSM40	S47
OFKT53AFSN6LB KC520M	S47
OFKT53AFSN6LB KC522M	S47
OFKT53AFSN6LB KC725M	S47
OFKT53AFSN6LB KCPK30	S47
OFKT64AFEN6GB KC520M	S52
OFKT64AFEN6GB KC522M	S52
OFKT64AFEN6GB KC725M	S52
OFKT64AFEN6GB KCPK30	S52
OFKT64AFEN6GB KCPM40	S52
OFKT64AFEN6GB KCSM30	S52
OFKT64AFEN6GB KCSM40	S52
OFKT64AFEN6LB KC522M	S51
OFKT64AFEN6LB KC725M	S51
OFKT64AFEN6LB KCPK30	S51
OFKT64AFEN6LB KCSM40	S51
OFKT64AFFN6LNJ KC410M	S51
OFKT64AFSN6HB KC520M	S52
OFKT64AFSN6HB KC522M	S52
OFKT64AFSN6HB KC725M	S52
OFKT64AFSN6HB KCPK30	S52
OFKT64AFSN6HB KCPM40	S52
OFKT64AFSN6HB KCSM40	S52
OFKT64AFSN6LB KC725M	S51
OFKT64AFSN6LB KCPK30	S51
OFPT53AFEN4GB KC520M	S48
OFPT53AFEN4GB KC725M	S48
OFPT53AFEN4GB KCK15	S48
OFPT53AFEN4GB KCPK30	S48
OFPT53AFEN4GB KCPM40	S48
OFPT53AFSN4HB KC520M	S48
OFPT53AFSN4HB KC725M	S48
OFPT53AFSN4HB KCK15	S48
OFPT53AFSN4HB KCPK30	S48
OFPT53AFSN4HB KCSM40	S48
OFPT64AFEN6GB KC520M	S52
OFPT64AFEN6GB KC522M	S52
OFPT64AFEN6GB KC725M	S52
OFPT64AFEN6GB KCK15	S52
OFPT64AFEN6GB KCPK30	S52
OFPT64AFEN6GB KCPM40	S52
OFPT64AFSN6HB KC522M	S52
OFPT64AFSN6HB KC725M	S52
OFPT64AFSN6HB KCK15	S52
OFPT64AFSN6HB KCPK30	S52
OFPT64AFSN6HB KCSM40	S52
ONGX642SNHB KC514M	S34
ONGX642SNHB KCK15	S34
ONGX645ENLE KC514M	S33
ONGX645ENLE KCK15	S33
ONGX645ENLE KCK20	S33
ONGX645SNGP KC514M	S33
ONGX645SNGP KCK15	S33
ONGX645SNGP KCK20	S33
ONGX645SNGP KCPK30	S33
ONGX645SNHB KC514M	S34
ONGX645SNHB KCK15	S34
ONGX645SNHB KCK20	S34
ONGX645SNHB KCPK30	S34
ONGX648SNHB KC514M	S34
ONGX648SNHB KCK15	S34
ONGX648SNHB KCK20	S34
ONGX64ANENLE KC514M	S33
ONGX64ANENLE KCK15	S33
ONGX64ANENLE KCK20	S33
ONGX64ANSNGP KC514M	S33
ONGX64ANSNGP KCK15	S33
ONGX64ANSNGP KCK20	S33
ONPX642SNGP KCK15	S34
ONPX642SNGP KCK20	S34
ONPX642SNGP KCPK30	S34
ONPX645SNHB KCK15	S34
ONPX645SNHB KCK20	S34
ONPX645SNHB KCPK30	S34
PDC251A04763DA KD1415	G106
PDC251A06350DA KD1415	G106
PDC251A07938DA KD1415	G106
PDC251A09525DA KD1415	G106
PDC251A11113DA KD1415	G106
PDC251A12700DA KD1415	G106
PKG-8001	K132–134
PKG0002	K145
PKG0011	K130
PKG1402	K130
PKG1565	K141–143
PKG156502	K143–144
PKG1602	K130
PKG1802	K130
PKG2025	K134, K136
PKG3242	K134, K136
PKG7001	K128
PKG7994	K145
PMT04525	C71, C149
PROON164D	B170, B385
PROON204D	B170, B385
PROON206D	B170, B385
PROON208D	B170, B385
PROON244D	B170, B385
PROON246	B170, B385
PSC40KGMEL50C	C73, C151
PSC40KGMER50C	C73, C151
PSC40KGMSL50C	C72, C150
PSC40KGMSR50C	C72, C150
PSC50KGMEL50C	C73, C151
PSC50KGMEL65C	C73, C151
PSC50KGMER50C	C73, C151
PSC50KGMER65C	C73, C151
PSC50KGMSL50C	C72, C150
PSC50KGMSL65C	C72, C150
PSC50KGMSR50C	C72, C150
PSC50KGMSR65C	C72, C150
PSC63DL10200	052
PSC63DL12200	052
PSC63DL16225	052
PSC63DL20225	052
PSC63DL25238	052
PSC63DL32275	052
PSC63KGMEL50C	C73, C151
PSC63KGMEL65C	C73, C151
PSC63KGMER50C	C73, C151
PSC63KGMER65C	C73, C151
PSC63KGMSL50C	C72, C150
PSC63KGMSL65C	C72, C150
PSC63KGMSR50C	C72, C150
PSC63KGMSR65C	C72, C150
PSC80KGMEL50C	C73, C151
PSC80KGMEL65C	C73, C151
PSC80KGMER50C	C73, C151
PSC80KGMER65C	C73, C151
PSC80KGMSL50C	C72, C150
PSC80KGMSL65C	C72, C150
PSC80KGMSR50C	C72, C150
PSC80KGMSR65C	C72, C150
PT00163	E60
QC21	B265
QTM20 WG	B292
R125FBHS09	K140
R24FBHS06	K140
R24FBHS06LF	K140
R30FBHS06	K140
R31FBHS06	K140
R31FBHS06LF	K140
R38FBHS06	K140
R40FBHS06	K140
R40FBHS06LF	K140
R48FBHS06	K140
R51FBHS06	K140
R51FBHS06LF	K140
R65FBHS06	K140
R67FBHS06	K140
R67FBHS09	K140
R67FBHS09LF	K140
R82154	K78
R85FBHS06	K140
R85FBHS09	K140
RCGH43 KC5010	B238
RCGH43 KCU10	B238
RCGH43MP KCS10	B238
RCGK152FS KCU10	E69
RCGK152HP K313	E69
RCGK152HP KC5010	E69
RCGK152HP KCU10	E69
RCGK23FS KC5010	E69
RCGK23FS KCU10	E69
RCGK23HP KC5010	E69
RCGK23HP KC5410	E69
RCGK23HP KCU10	E69
RCGK35FS KC5010	E69
RCGK35FS KC5025	E69
RCGK35FS KCU10	E69
RCGK35HP KC5410	E69
RCGK35HP KCU10	E69

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
RCGK46FS KCU10	E69
RCGK46HP KC5410	E69
RCGK46HP KCU10	E69
RCGN33T0415 KBK45	B308
RCGT0602M0RP KCP25B	B239
RCGT0803M0HP K313	B238
RCGT0803M0HP K68	B238
RCGT0803M0HP KC5010	B238
RCGT0803M0HP KC5410	B238
RCGT0803M0HP KCU25	B238
RCGT0803M0MS KC5010	B239
RCGT0803M0MS KCU10	B239
RCGT0803M0RP KCP25B	B239
RCGT10T3M0HP K313	B238
RCGT10T3M0HP KC5010	B238
RCGT10T3M0HP KC5025	B238
RCGT10T3M0HP KC5410	B238
RCGT10T3M0HP KCU10	B238
RCGT10T3M0HP KCU25	B238
RCGT1204M0HP K313	B238
RCGT1204M0HP KC5010	B238
RCGT1204M0HP KC5025	B238
RCGT1204M0HP KCU10	B238
RCGT1204M0MS KC5010	B239
RCGT1204M0MS KCU10	B239
RCGT1204M0MS KCU25	B239
RCGT1204M0RP KCP25	B239
RCGT1606M0MS KCU10	B239
RCGT1606M0MS KCU25	B239
RCGT64ELF KC725M	V89
RCGT64ELF KCPK30	V89
RCGT64ELF KCSM40	V89
RCGT64ELFJ KCSM30	V89
RCGT64SGF KC522M	V89
RCGT64SGF KC725M	V89
RCGT64SGFJ KCPM40	V89
RCGT64SHF KC725M	V89
RCGT64SHF KCPK30	V89
RCGT64SHF KCSM40	V89
RCGT64SHFJ KCPM40	V89
RCGT86ELF KC725M	V92
RCGT86ELF KCPK30	V92
RCGT86ELF KCSM40	V92
RCGT86SGF KC522M	V92
RCGT86SGF KC725M	V92
RCGT86SGFJ KCPM40	V92
RCGT86SHF KC725M	V92
RCGT86SHF KCPK30	V92
RCGT86SHF KCSM40	V92
RCGT86SHFJ KCPM40	V92
RCGV23 KC5010	B166
RCGV23 KCU10	B166
RCGV23E KYS25	B351
RCGV23E KYS30	B351
RCGV23MP KCS10	B166
RCGV35 KC5010	B166
RCGV35E KYS25	B351
RCGV35E KYS30	B351
RCGV35T0225 KYS30	B351
RCGV35T0420 KY1615	B335
RCGV35T0420 KYS25	B351
RCGV35T0420 KYS30	B351
RCGV35T0820 KY1615	B335
RCGV35T4015 KY1615	B335
RCGV35T8015 KY1615	B335
RCGV45 K313	B166
RCGV45 KC5010	B166
RCGV45E KYS25	B351
RCGV45E KYS30	B351
RCGV45MP KCS10	B166
RCGV45T0420 KYS25	B351
RCGV45T0420 KYS30	B351
RCGV45T0425 KYS25	B351
RCGV45T0425 KYS30	B351
RCGV45T0820 KY1615	B335
RCGV45T4015 KY1615	B335
RCGV45T8015 KY1615	B335
RCGV88T8015 KY1615	B335
RCGW1204M0T01020 KY1615	B336
RCGX0907-001 KY1615	B336
RCGX151000T20015 KY1615	B335
RCGX191000T20015 KY1615	B335
RCMH2507M0RU KCP25	E66
RCMH2507M0TUPG KCP10B	E66
RCMH2507M0TUPG KCP25B	E66
RCMH3209M0RU KCP25	E66
RCMH3209M0TUPG KCP10B	E66
RCMH3209M0TUPG KCP25B	E66
RCMH64K KCP10B	B239
RCMK152 K313	E69
RCMK152 KC5010	E69
RCMK23 K313	E69
RCMK23 KC5010	E69
RCMK23 KCU10	E69
RCMK23MP KCS10	E69
RCMK35 K313	E69
RCMK35 KC5010	E69
RCMK35MP KCS10	E69
RCMK46 KC5010	E69
RCMK46MP KCS10	E69
RCMT0602M0 K313	B240
RCMT0602M0 K68	B240
RCMT0602M0 KC5010	B240
RCMT0602M0 KCM25	B240
RCMT0602M0 KCP25	B240
RCMT0602M0 KCP30	B240
RCMT0602M0 KCU10	B240
RCMT0803M0 K313	B240
RCMT0803M0 KC5010	B240
RCMT0803M0 KCK20B	B240
RCMT0803M0 KCM25	B240
RCMT0803M0 KCP25	B240
RCMT0803M0MP KCS10	B240
RCMT10T3M0 KC5010	B240
RCMT10T3M0 KCK20B	B240
RCMT10T3M0 KCM25	B240
RCMT10T3M0 KCP25	B240
RCMT10T3M0 KCP30	B240
RCMT10T3M0 KCU10	B240
RCMT10T3M0MP KCS10	B240
RCMT1204M0 K313	B240
RCMT1204M0 KC5010	B240
RCMT1204M0 KCK15B	B240
RCMT1204M0 KCK20	B240
RCMT1204M0 KCK20B	B240
RCMT1204M0 KCM25	B240
RCMT1204M0 KCM25B	B240
RCMT1204M0 KCP30	B240
RCMT1204M0 KCU10	B240
RCMT1204M0MP KCS10	B240
RCMT1204M0RP KCK15	B242
RCMT1204M0RP KCK20	B242
RCMT1204M0RP KCP10	B242
RCMT1204M0RP KCP10B	B242
RCMT1204M0RP KCP25	B242
RCMT1204M0RP KCP25B	B242
RCMT1605M0 K313	B240
RCMT1605M0 KC5010	B240
RCMT1605M0 KCK20	B240
RCMT1605M0 KCM25	B240
RCMT1605M0 KCP25	B240
RCMT1605M0 KCU10	B240
RCMT1606M0MP KCS10	B240
RCMT1606M0RP KCK15	B242
RCMT1606M0RP KCP25	B242
RCMT1606M0RP KCP25B	B242
RCMT1606M0UPG KCK15B	E66
RCMT1606M0UPG KCP10B	E66
RCMT1606M0UPG KCP25B	E66
RCMT1606M0UPG KCPK05	E66
RCMT2006M0 K313	B240
RCMT2006M0 KC5010	B240
RCMT2006M0 KCK20B	B240
RCMT2006M0 KCM25	B240
RCMT2006M0 KCP25	B240
RCMT2006M0 KCU10	B240
RCMT2006M0RH KCP10	B241
RCMT2006M0RH KCP25	B241
RCMT2006M0RM KCP25	B241
RCMT2006M0RP KCK20	B242
RCMT2006M0RP KCK20B	B242
RCMT2006M0RP KCP25	B242
RCMT2006M0UPG KCK15B	E66
RCMT2006M0UPG KCP10B	E66
RCMT2006M0UPG KCP25B	E66
RCMT2006M0UPG KCPK05	E66
RCMT215 KC5010	B240
RCMT215 KCP25	B240
RCMT215 KCU10	B240
RCMT325 K313	B240
RCMT325 KC5010	B240
RCMT325 KCP25	B240
RCMT325 KCU10	B240
RCMT43 KC5010	B240
RCMT43 KCK20	B240
RCMT43 KCM25	B240
RCMT43 KCP10B	B240
RCMT43MP KCS10	B240
RCMX1003M0RP KCP10B	B242
RCMX1003M0RP KCP25B	B242
RCMX2507M076 KCP25B	E59
RCMX2507M0RH KCP10	B241
RCMX2507M0RH KCP25	B241
RCMX2507M0RP KCP25	B242
RCMX2507M0RP KCP30	B242
RCMX2507M0RU KCK20	E67
RCMX2507M0TUPG KCP10B	E67
RCMX2507M0TUPG KCP25B	E67
RCMX3209M0RH KCP25	B241
RCMX3209M0RU KCK20	E67
RCMX3209M0RU KCP10	E67
RCMX3209M0TUPG KCP10B	E67
RCMX3209M0TUPG KCP25B	E67
RHM14000KST115H7HF KT325	K33
RHM14000KST115H7HF KT6215	K33
RHM14000KST115H7SF KT325	K31
RHM14000KST115H7SF KT6215	K31
RHM14288KST115H7HF KT325	K33
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RHM16000KST135H7SF KT325	K31
RHM16000KST135H7SF KT6215	K31
RHM17000KST135H7HF KT325	K33
RHM17000KST135H7HF KT6215	K33
RHM17000KST135H7SF KT325	K31
RHM17000KST135H7SF KT6215	K31
RHM17463KST135H7HF KT325	K33
RHM17463KST135H7HF KT6215	K33
RHM17463KST135H7SF KT325	K31
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RHM18000KST155H7HF KT6215	K33
RHM18000KST155H7SF KT325	K31
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RHM19000KST155H7HF KT6215	K33
RHM19000KST155H7SF KT325	K31
RHM19050KST155H7HF KT325	K33
RHM19050KST155H7HF KT6215	K33
RHM19050KST155H7SF KT6215	K31
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RHM20000KST175H7HF KT6215	K33
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RHM21000KST175H7SF KT325	K31
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RHM22000KST175H7HF KT6215	K33
RHM22000KST175H7SF KT6215	K31
RHM22230KST175H7HF KT325	K33
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RHM22230KST175H7SF KT325	K31
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RHM23000KST200H7SF KT325	K31
RHM23000KST200H7SF KT6215	K31
RHM23810KST200H7HF KT325	K33
RHM23810KST200H7HF KT6215	K33
RHM23810KST200H7SF KT325	K31
RHM23810KST200H7SF KT6215	K31
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RHM24000KST200H7HF KT6215	K33
RHM24000KST200H7SF KT325	K31
RHM24000KST200H7SF KT6215	K31
RHM25000KST200H7HF KT325	K33
RHM25000KST200H7HF KT6215	K33
RHM25000KST200H7SF KT325	K31
RHM25000KST200H7SF KT6215	K31
RHM25400KST200H7HF KT325	K33
RHM25400KST200H7HF KT6215	K33
RHM25400KST200H7SF KT325	K31
RHM25400KST200H7SF KT6215	K31
RHM26000KST200H7HF KT325	K33
RHM26000KST200H7SF KT325	K31
RHM26990KST200H7HF KT325	K33
RHM26990KST200H7HF KT6215	K33
RHM26990KST200H7SF KT325	K31
RHM26990KST200H7SF KT6215	K31
RHM27000KST200H7HF KT325	K33
RHM27000KST200H7HF KT6215	K33
RHM27000KST200H7SF KT325	K31
RHM27000KST200H7SF KT6215	K31
RHM27500KST250H7HF KT325	K33
RHM27500KST250H7HF KT6215	K33
RHM27500KST250H7SF KT325	K32
RHM27500KST250H7SF KT6215	K32
RHM28000KST250H7HF KT325	K34
RHM28000KST250H7HF KT6215	K34
RHM28000KST250H7SF KT325	K32
RHM28000KST250H7SF KT6215	K32
RHM28580KST250H7HF KT325	K34
RHM28580KST250H7SF KT325	K32
RHM28580KST250H7SF KT6215	K32
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RHM29000KST250H7HF KT6215	K34
RHM29000KST250H7SF KT325	K32
RHM29000KST250H7SF KT6215	K32
RHM30000KST250H7HF KT325	K34
RHM30000KST250H7HF KT6215	K34
RHM30000KST250H7SF KT325	K32
RHM30000KST250H7SF KT6215	K32
RHM30160KST250H7HF KT325	K34
RHM30160KST250H7HF KT6215	K34
RHM30160KST250H7SF KT325	K32
RHM31000KST250H7HF KT325	K34
RHM31000KST250H7HF KT6215	K34
RHM31000KST250H7SF KT325	K32
RHM31000KST250H7SF KT6215	K32
RHM31750KST250H7HF KT325	K34
RHM31750KST250H7HF KT6215	K34
RHM31750KST250H7SF KT325	K32
RHM31750KST250H7SF KT6215	K32
RHM32000KST250H7HF KT325	K34
RHM32000KST250H7HF KT6215	K34
RHM32000KST250H7SF KT325	K32
RHM32500KST300H7HF KT325	K34
RHM32500KST300H7HF KT6215	K34
RHM32500KST300H7SF KT325	K32
RHM32500KST300H7SF KT6215	K32
RHM33000KST300H7HF KT325	K34
RHM33000KST300H7HF KT6215	K34
RHM33000KST300H7SF KT325	K32
RHM33000KST300H7SF KT6215	K32
RHM33340KST300H7HF KT325	K34
RHM33340KST300H7HF KT6215	K34
RHM33340KST300H7SF KT325	K32
RHM33340KST300H7SF KT6215	K32
RHM34000KST300H7HF KT6215	K34
RHM34000KST300H7SF KT325	K32
RHM34930KST300H7HF KT325	K34
RHM34930KST300H7HF KT6215	K34

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
RHM34930KST300H7SF KT325	K32
RHM34930KST300H7SF KT6215	K32
RHM35000KST300H7HF KT325	K34
RHM35000KST300H7HF KT6215	K34
RHM35000KST300H7SF KT325	K32
RHM35000KST300H7SF KT6215	K32
RHM36000KST300H7HF KT325	K34
RHM36000KST300H7SF KT325	K32
RHM36000KST300H7SF KT6215	K32
RHM36510KST300H7HF KT325	K34
RHM36510KST300H7HF KT6215	K34
RHM36510KST300H7SF KT325	K32
RHM36510KST300H7SF KT6215	K32
RHM37000KST300H7HF KT325	K34
RHM37000KST300H7HF KT6215	K34
RHM37000KST300H7SF KT325	K32
RHM37500KST350H7HF KT325	K34
RHM37500KST350H7HF KT6215	K34
RHM37500KST350H7SF KT325	K32
RHM37500KST350H7SF KT6215	K32
RHM38000KST350H7SF KT325	K32
RHM38000KST350H7SF KT6215	K32
RHM38100KST350H7HF KT325	K34
RHM38100KST350H7SF KT325	K32
RHM38100KST350H7SF KT6215	K32
RHM39000KST350H7HF KT325	K34
RHM39000KST350H7HF KT6215	K34
RHM39000KST350H7SF KT325	K32
RHM39000KST350H7SF KT6215	K32
RHM39690KST350H7HF KT325	K34
RHM39690KST350H7HF KT6215	K34
RHM39690KST350H7SF KT325	K32
RHM39690KST350H7SF KT6215	K32
RHM40000KST350H7HF KT325	K34
RHM40000KST350H7HF KT6215	K34
RHM40000KST350H7SF KT6215	K32
RHM41000KST350H7HF KT325	K34
RHM41000KST350H7HF KT6215	K34
RHM41000KST350H7SF KT325	K32
RHM41000KST350H7SF KT6215	K32
RHM41280KST350H7HF KT325	K34
RHM41280KST350H7HF KT6215	K34
RHM41280KST350H7SF KT325	K32
RHM41280KST350H7SF KT6215	K32
RHM42000KST350H7HF KT325	K34
RHM42000KST350H7HF KT6215	K34
RHM42000KST350H7SF KT325	K32
RHM42000KST350H7SF KT6215	K32
RHME14000KST115H6HF KC6005	K36
RHME14000KST115H6HF KC6305	K36
RHME14000KST115H6SF KC6005	K35
RHME14000KST115H6SF KC6305	K35
RHME14288KST115H6HF KC6005	K36
RHME14288KST115H6HF KC6305	K36
RHME14288KST115H6SF KC6005	K35
RHME14288KST115H6SF KC6305	K35
RHME15000KST115H6HF KC6005	K36
RHME15000KST115H6HF KC6305	K36
RHME15000KST115H6SF KC6005	K35
RHME15000KST115H6SF KC6305	K35
RHME16000KST135H6HF KC6005	K36
RHME16000KST135H6HF KC6305	K36
RHME16000KST135H6SF KC6005	K35
RHME16000KST135H6SF KC6305	K35
RHME17000KST135H6HF KC6005	K36
RHME17000KST135H6HF KC6305	K36
RHME17000KST135H6SF KC6005	K35
RHME17000KST135H6SF KC6305	K35
RHME17463KST135H6HF KC6005	K36
RHME17463KST135H6HF KC6305	K36
RHME17463KST135H6SF KC6005	K35
RHME17463KST135H6SF KC6305	K35
RHME18000KST155H6HF KC6005	K36
RHME18000KST155H6HF KC6305	K36
RHME18000KST155H6SF KC6005	K35
RHME18000KST155H6SF KC6305	K35
RHME19000KST155H6HF KC6005	K36
RHME19000KST155H6HF KC6305	K36
RHME19000KST155H6SF KC6005	K35
RHME19000KST155H6SF KC6305	K35
RHME19050KST155H6HF KC6005	K36
RHME19050KST155H6HF KC6305	K36
RHME19050KST155H6SF KC6005	K35
RHME19050KST155H6SF KC6305	K35
RHME20000KST175H6HF KC6005	K36
RHME20000KST175H6HF KC6305	K36
RHME20000KST175H6SF KC6005	K35
RHME20000KST175H6SF KC6305	K35
RHME21000KST175H6HF KC6005	K36
RHME21000KST175H6HF KC6305	K36
RHME21000KST175H6SF KC6005	K35
RHME21000KST175H6SF KC6305	K35
RHME22000KST175H6HF KC6005	K36
RHME22000KST175H6HF KC6305	K36
RHME22000KST175H6SF KC6005	K35
RHME22000KST175H6SF KC6305	K35
RHME22225KST175H6HF KC6005	K36
RHME22225KST175H6HF KC6305	K36
RHME22225KST175H6SF KC6005	K35
RHME22225KST175H6SF KC6305	K35
RHME23000KST200H6HF KC6005	K36
RHME23000KST200H6HF KC6305	K36
RHME23000KST200H6SF KC6005	K35
RHME23000KST200H6SF KC6305	K35
RHME23813KST200H6HF KC6005	K36
RHME23813KST200H6HF KC6305	K36
RHME23813KST200H6SF KC6005	K35
RHME23813KST200H6SF KC6305	K35
RHME24000KST200H6HF KC6005	K36
RHME24000KST200H6HF KC6305	K36
RHME24000KST200H6SF KC6005	K35
RHME24000KST200H6SF KC6305	K35
RHME25000KST200H6HF KC6005	K36
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RHME25000KST200H6SF KC6005	K35
RHME25000KST200H6SF KC6305	K35
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RHME25400KST200H6HF KC6305	K36
RHME25400KST200H6SF KC6005	K35
RHME25400KST200H6SF KC6305	K35
RHME26000KST200H6HF KC6005	K36
RHME26000KST200H6HF KC6305	K36
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RHME26000KST200H6SF KC6305	K35
RHME27000KST200H6HF KC6005	K36
RHME27000KST200H6HF KC6305	K36
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RHME27000KST200H6SF KC6305	K35
RHME28000KST250H6HF KC6005	K36
RHME28000KST250H6HF KC6305	K36
RHME28000KST250H6SF KC6005	K35
RHME28000KST250H6SF KC6305	K35
RHME30000KST250H6HF KC6005	K36
RHME30000KST250H6HF KC6305	K36
RHME30000KST250H6SF KC6005	K35
RHME30000KST250H6SF KC6305	K35
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RHME31750KST250H6HF KC6305	K36
RHME31750KST250H6SF KC6005	K35
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RHME34000KST300H6HF KC6005	K36
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RHME40000KST350H6HF KC6305	K36
RHME40000KST350H6SF KC6005	K35
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RHR40000KST350H7SF KCU05	K29
RHR41000KST350H7HF KCU05	K30
RHR41000KST350H7SF KCU05	K29
RHR42000KST350H7HF KCU05	K30
RHR42000KST350H7SF KCU05	K29
RIQ06E1300 KC6005	K58
RIQ06E1300 KC6105	K58
RIQ06E1300 KC6305	K58
RIQ06E1306 KC6005	K58
RIQ06E1306 KC6105	K58
RIQ06E1306 KC6305	K58
RIQ06E1312 KC6005	K58
RIQ06E1312 KC6105	K58
RIQ06E1312 KC6305	K58
RIQ06EDR00 KC6005	K59
RIQ06EDR00 KC6105	K59
RIQ06EDR00 KC6305	K59
RIQ06EDR06 KC6005	K59
RIQ06EDR06 KC6105	K59
RIQ06EDR06 KC6305	K59
RIQ06EDR06 KD1415	K59
RIQ06EDR12 KC6005	K59
RIQ06EDR12 KC6105	K59
RIQ06EDR12 KC6305	K59
RIQ06EGR00 KC6005	K59
RIQ06EGR00 KC6105	K59
RIQ06EGR00 KC6305	K59
RIQ06EGR06 KC6005	K59
RIQ06EGR06 KC6105	K59
RIQ06EGR06 KC6305	K59
RIQ06EGR06 KD1415	K59
RIQ06EGR12 KC6005	K59
RIQ06EGR12 KC6105	K59
RIQ06EGR12 KC6305	K59
RIQ06R0200 KD1415	K57
RIQ06R0400FB KT6225	K58
RIQ06R0400S KB1610	K57
RIQ06R0500FT KT6315	K58
RIQ07C4500S KBHK10	K59
RIQ07C4500S KBHK15	K59
RIQ08C4500S KBHK10	K59
RIQ08C4500S KBHK15	K59
RIQ09C4500S KBHK10	K59
RIQ09C4500S KBHK15	K59
RIQ09E1300 KC6005	K58
RIQ09E1300 KC6105	K58
RIQ09E1300 KC6305	K58
RIQ09E1306 KC6005	K58
RIQ09E1306 KC6105	K58
RIQ09E1306 KC6305	K58
RIQ09E1312 KC6005	K58
RIQ09E1312 KC6105	K58
RIQ09E1312 KC6305	K58
RIQ09EDR00 KC6005	K59
RIQ09EDR00 KC6105	K59
RIQ09EDR00 KC6305	K59
RIQ09EDR06 KC6005	K59
RIQ09EDR06 KC6105	K59
RIQ09EDR06 KC6305	K59
RIQ09EDR06 KD1415	K59
RIQ09EDR12 KC6005	K59
RIQ09EDR12 KC6105	K59
RIQ09EDR12 KC6305	K59
RIQ09EGR00 KC6005	K59
RIQ09EGR00 KC6105	K59
RIQ09EGR00 KC6305	K59
RIQ09EGR06 KC6005	K59
RIQ09EGR06 KC6105	K59
RIQ09EGR06 KC6305	K59
RIQ09EGR06 KD1415	K59
RIQ09EGR12 KC6005	K59
RIQ09EGR12 KC6105	K59
RIQ09EGR12 KC6305	K59
RIQ09R0400FB KT6225	K58
RIQ09R0400S KB1610	K57
RIQ09R0506FT KT6315	K58
RIQB6C4500S KBHK10	K59
RIQB6C4500S KBHK15	K59
RIQB7C4500S KBHK10	K59
RIQB7C4500S KBHK15	K59
RIR01E1306 KC6105	K56
RIR01E1312 KC6105	K56
RIR01EGU00 KC6105	K56
RIR02E1312 KC6105	K56
RIR02E1312 KC6305	K56
RIR03E1312 KC6305	K56
RIR04E1312 KC6005	K56
RIR04E1312 KC6105	K56
RIR04EDS06 KD1415	K56
RIR05EGU00 KC6105	K56
RIRT4C4512 KC6005	K57
RKDF0375Y4CQA KCSM15	035
RKDF0500Y4CQB KCSM15	035
RKDF0625Y4CQB KCSM15	035
RKDF0750Y6CQB KCSM15	035
RKDF1000Y6CQB KCSM15	035
RMB14000H7HF KT6215	K18
RMB14000H7SF KT6215	K17
RMB15000H7HF KT6215	K18
RMB15000H7SF KT6215	K17
RMB16000H7HF KT6215	K18
RMB16000H7SF KT6215	K17
RMB17000H7SF KT6215	K17
RMB18000H7HF KT6215	K18
RMB18000H7SF KT6215	K17
RMB19000H7HF KT6215	K18
RMB19000H7SF KT6215	K17
RMB20000H7HF KT6215	K18
RMB20000H7SF KT6215	K17
RMBE14000H6HF KC6005	K20
RMBE14000H6HF KC6305	K20

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
RMBE14000H6SF KC6005	K19
RMBE14000H6SF KC6305	K19
RMBE15000H6HF KC6005	K20
RMBE15000H6HF KC6305	K20
RMBE15000H6SF KC6005	K19
RMBE15000H6SF KC6305	K19
RMBE16000H6HF KC6005	K20
RMBE16000H6HF KC6305	K20
RMBE16000H6SF KC6005	K19
RMBE16000H6SF KC6305	K19
RMBE17000H6HF KC6005	K20
RMBE17000H6HF KC6305	K20
RMBE17000H6SF KC6005	K19
RMBE17000H6SF KC6305	K19
RMBE18000H6HF KC6005	K20
RMBE18000H6HF KC6305	K20
RMBE18000H6SF KC6005	K19
RMBE18000H6SF KC6305	K19
RMBE19000H6HF KC6005	K20
RMBE19000H6HF KC6305	K20
RMBE19000H6SF KC6005	K19
RMBE19000H6SF KC6305	K19
RMBE20000H6HF KC6005	K20
RMBE20000H6HF KC6305	K20
RMBE20000H6SF KC6005	K19
RMBE20000H6SF KC6305	K19
RMR14000H7HF KCU05	K16
RMR14000H7SF KCU05	K15
RMR15000H7HF KCU05	K16
RMR15000H7SF KCU05	K15
RMR16000H7HF KCU05	K16
RMR16000H7SF KCU05	K15
RMR17000H7HF KCU05	K16
RMR17000H7SF KCU05	K15
RMR18000H7HF KCU05	K16
RMR18000H7SF KCU05	K15
RMR19000H7HF KCU05	K16
RMR19000H7SF KCU05	K15
RMR20000H7HF KCU05	K16
RMR20000H7SF KCU05	K15
RMS05000H7HF K605	K9
RMS05000H7HF KC6305	K9
RMS05000H7SF K605	K8
RMS05000H7SF KC6305	K8
RMS05500H7HF K605	K9
RMS05500H7HF KC6305	K9
RMS05500H7SF K605	K8
RMS05500H7SF KC6305	K8
RMS06000H7HF K605	K9
RMS06000H7HF KC6305	K9
RMS06000H7SF K605	K8
RMS06000H7SF KC6305	K8
RMS06500H7HF K605	K9
RMS06500H7HF KC6305	K9
RMS06500H7SF K605	K8
RMS06500H7SF KC6305	K8
RMS07000H7HF K605	K9
RMS07000H7HF KC6305	K9
RMS07000H7SF K605	K8
RMS07000H7SF KC6305	K8
RMS08000H7HF K605	K9
RMS08000H7HF KC6305	K9
RMS08000H7SF K605	K8
RMS08000H7SF KC6305	K8
RMS09000H7HF K605	K9
RMS09000H7HF KC6305	K9
RMS09000H7SF K605	K8
RMS09000H7SF KC6305	K8
RMS10000H7HF K605	K9
RMS10000H7HF KC6305	K9
RMS10000H7SF K605	K8
RMS10000H7SF KC6305	K8
RMS11000H7HF K605	K9
RMS11000H7HF KC6305	K9
RMS11000H7SF K605	K8
RMS11000H7SF KC6305	K8
RMS12000H7HF K605	K9
RMS12000H7HF KC6305	K9
RMS12000H7SF K605	K8
RMS12000H7SF KC6305	K8
RMS13000H7HF K605	K9
RMS13000H7HF KC6305	K9
RMS13000H7SF K605	K8
RMS13000H7SF KC6305	K8
RMS14000H7HF K605	K9
RMS14000H7HF KC6305	K9
RMS14000H7SF K605	K8
RMS14000H7SF KC6305	K8
RNG32S0815C KB5630	B337
RNG32T0820 KY1615	B336
RNG33T0820 KY1615	B336
RNG42T0820 KY1615	B336
RNG43T0420 KYS30	B352
RNG43T0820 KY1615	B336
RNG43T0820 KY3500	B318
RNG43T0820 KYK10	B318
RNG45T0225 KYS30	B352
RNG45T0420 KYS30	B352
RNG45T0425 KYS25	B352
RNG45T0425 KYS30	B352
RNG45T0820 KY1615	B336
RNG45T0820 KY3500	B318
RNG45T4015 KY1615	B336
RNG45T8015 KY1615	B336
RNG65T0420 KYS30	B352
RNG65T0820 KY1615	B336
RNG65T0820 KY3500	B318
RNGA32T0820 KY1615	B336
RNGA43T0820 KY1615	B336
RNGJ10T3M0ELDJ KC725M	V48
RNGJ10T3M0ELDJ KCSM40	V48
RNGJ10T3M0FLDJ KC422M	V48
RNGJ10T3M0SGDJ KC725M	V49
RNGJ10T3M0SGDJ KCSM30	V49
RNGJ1204M0ELD KC522M	V55
RNGJ1204M0ELD KC725M	V55
RNGJ1204M0ELD KCPK30	V55
RNGJ1204M0ELDJ KCSM30	V55
RNGJ1204M0ENLDJX KC522M	V63
RNGJ1204M0FLDJ KC422M	V55
RNGJ1204M0SGD KC522M	V55
RNGJ1204M0SGD KC725M	V55
RNGJ1204M0SGD KCPK30	V55
RNGJ1204M0SGDJ KCSM40	V55
RNGJ1204M0SHD KC725M	V56
RNGJ1204M0SHD KCPK30	V56
RNGJ1204M0SNGDJX KC725M	V63
RNGJ1605M0ELDJ KC522M	V59
RNGJ1605M0ELDJ KC725M	V59
RNGN33S0820 KBK45	B304
RNGN43EGN KYS30	V150
RNGN43EGN KYSP30	V150
RNGN43S0820 KBK45	B304
RNGN43TGN KYS30	V150
RNGN43TGN KYSP30	V150
RNGX43S0820 KBK45	B307
RNM32S0820 KB1340	B305
RNM42S0820 KB1340	B305
RNM43S0820 KB1340	B305
RNMA43 K68	B97
RNMA54 K68	B97
RNMG32RN KCP25	B97
RNMG32RN KCP25B	B97
RNMG43RN KC5010	B97
RNMG43RN KCP10	B97
RNMG43RN KCP10B	B97
RNMG43RN KCP25B	B97
RNMG43RN KCP30	B97
RNMG43RN KCU10	B97
RNMG43UN KCK15B	B97
RNMG43UN KCK20	B97
RNMG54RN KCP25B	B97
RNMG54RN KCP30	B97
RNMG64 K313	B97
RNMG64 KCP25	B97
RNMG64 KCP40	B97
RNMG64RN KC5010	B97
RNMG64RN KCP25	B97
RNMG64RN KCP25B	B97
RNMG64RN KCP40B	B97
RNMG64RN KCU10	B97
RNMG86RN KCP10	B97
RNMG86RN KCP25	B97
RNPJ10T3M0SGD KC522M	V49
RNPJ10T3M0SGD KCPK30	V49
RNPJ10T3M0SGD KCPM40	V49
RNPJ10T3M0SHD KC725M	V49
RNPJ10T3M0SHD KCK15	V49
RNPJ10T3M0SHD KCPK30	V49
RNPJ10T3M0SHD KCPM40	V49
RNPJ1204M0SGD KC522M	V56
RNPJ1204M0SGD KC725M	V56
RNPJ1204M0SGD KCPK30	V56
RNPJ1204M0SGD KCPM40	V56
RNPJ1204M0SHD KC725M	V56
RNPJ1204M0SHD KCPK30	V56
RNPJ1204M0SHD KCPM40	V56
RNPJ1605M0SGD KC522M	V59
RNPJ1605M0SGD KC725M	V59
RNPJ1605M0SGD KCPK30	V59
RNPJ1605M0SGD KCPM40	V59
RNPJ1605M0SGD KCSM40	V59
RNPJ1605M0SHD KC520M	V59
RNPJ1605M0SHD KC725M	V59
RNPJ1605M0SHD KCK15	V59
RNPJ1605M0SHD KCPK30	V59
RNPJ1605M0SHD KCPM40	V59
RPET1204M0ELE KC725M	V71
RPET1204M0ELE KCPK30	V71
RPET1204M0ELEJ KC422M	V71
RPET1204M0ELEJ KC522M	V71
RPET1204M0ELEJ KC725M	V71
RPET1204M0ELEJ KCSM30	V71
RPET1204M0SGE KCPK30	V72
RPET1204M0SGEJ KC522M	V71
RPET1204M0SGEJ KC725M	V71
RPET1204M0SGEJ KCSM30	V71
RPET1605M0ELE KCPK30	V78
RPET1605M0ELEJ KC725M	V78
RPET1605M0SGE KCPK30	V78
RPET1605M0SGEJ KC522M	V78
RPET1605M0SGEJ KC725M	V78
RPET1605M0SGEJ KCSM30	V78
RPET43SGEJ KC725M	V85
RPEX10T3M0F701X4 GH1	V99
RPEX10T3M0F701X4 SP4019	V99
RPEX1204M0E701X4 X500	V104
RPEX1204M0F701X4 GH1	V104
RPG2150E KYS30	B352, V157
RPG2150E KYSP30	V157
RPG32E KYS30	B352, V157
RPG32E KYSP30	V157
RPG32T0420 KYS30	B352, V157
RPG42 K313	B166
RPG43E KYS30	B352, V157
RPG43E KYSP30	V157
RPG43T0420 KYS30	B352, V157
RPGT23MP KCS10	B245
RPGV23 KC5010	B167
RPGV23MP KCS10	B167
RPGV35 KC5010	B167
RPGV35E KYS25	B352
RPGV35E KYS30	B352
RPGV35MP KCS10	B167
RPGV35T0420 KYS30	B352
RPGV45 KC5010	B167
RPGV45E KYS25	B352
RPGV45E KYS30	B352
RPGV45MP KC5010	B167
RPGV45MP KCS10	B167
RPGV45T0420 KYS30	B352
RPHT10T3M0E421X4 X500	V99
RPHT10T3M0E421X4 X700	V99
RPHT10T3M0E422X4 SP6519	V99
RPHT10T3M0E422X4 X500	V99
RPHT10T3M0E422X4 X700	V99
RPHT10T3M0E422X8 SP6519	V99
RPHT10T3M0E422X8 X500	V99
RPHT10T3M0E422X8 X700	V99
RPHT10T3M0TX4 SP6519	V100
RPHT10T3M0TX4 X500	V100
RPHT1204M0E421X4 X500	V104
RPHT1204M0E421X4 X700	V105
RPHT1204M0E442X4 X500	V105
RPHT1204M0E442X4 X700	V105
RPHT1204M0E442X5 SC6525	V104
RPHT1204M0E442X5 SP6519	V104
RPHT1204M0E442X5 X500	V104
RPHT1204M0E442X5 X700	V104
RPHT1204M0E442X8 SC6525	V105
RPHT1204M0SGDX5 KCM40	V105
RPHT1204M0SGDX8 KCM40	V105
RPHT1204M0TX4 SP6519	V105
RPHT1204M0TX4 X500	V105
RPHT1204M0TX4 X700	V105
RPMT10T3M0E41X4 MP91M	V100
RPMT10T3M0E41X4 SP6519	V100
RPMT10T3M0E41X4 X500	V100
RPMT1204M0E41X4 MP91M	V104
RPMT1204M0E41X4 SP6519	V104
RPMT1204M0E41X4 X500	V104
RPMW10T3M0TX4 X500	V100
RPMW1204M0TX4 MP91M	V105
RPMW1204M0TX4 SP6519	V105
RPMW1204M0TX4 X500	V105
RPPT10T3M0E432X5 SC6525	V100
RPPT10T3M0E432X5 SP6519	V100
RPPT10T3M0E432X5 X500	V100
RPPT10T3M0E432X5 X700	V100
RPPT1204M0E432X4 SC6525	V106
RPPT1204M0E432X4 X500	V106
RPPT1204M0E432X4 X700	V106
RPPT1204M0E432X5 SC6525	V106
RPPT1204M0E432X5 SP6519	V106
RPPT1204M0E432X5 X500	V106
RPPT1204M0E432X5 X700	V106
RPPT1204M0E432X8 SP6519	V106
RPPT1204M0E432X8 X500	V106
RPPT1204M0E432X8 X700	V106
RPPT1204M0SGDX KC725M	V72
RPPT1204M0SGDX KCPM40	V72
RPPT1204M0SGDX4 KCM40	V106
RPPT1204M0SGDX5 KCM40	V106
RPPT1204M0SGDX8 KCM40	V106
RPPT1204M0SGP KC725M	V72
RPPT1204M0SGP KCPK30	V72
RPPT1204M0SGP KCPM40	V72
RPPT1605M0SHP KC725M	V79
RPPT1605M0SHP KCPK30	V79
RPPT1605M0SHP KCPM40	V79
RPPT43EGE KC725M	V84
RPPT43EGE KCPK30	V84
RPPT43SGE KC725M	V84
RPPT43SGE KCPK30	V84
RQBB0375Y4CN KCPM15	O36
RQBB0500Y4CN KCPM15	O36
RQBB0625Y4CN KCPM15	O36
RQBB0750Y4CN KCPM15	O36
RQBB1000Y4CN KCPM15	O36
RQDB0375Y4CV KCPM15	O34
RQDB0500Y4CV KCPM15	O34
RQDB0625Y4CV KCPM15	O34
RQDB0750Y4CV KCPM15	O34
RQDB1000Y5CV KCPM15	O34
RS1605	K129
RS1606	K129
RS1608	K129
RS1610	K129
RS1612	K129
S-2165-C	S56
S0612LSEL2	D74
S0612LSER2	D74
S0812LSEL2	D74
S0812LSER2	D74
S1006PKG	E65
S1012LSEL3	D74
S1012LSER3	D74
S111	B165, B172–173, B179–182, B184, B188, B372–382, B390, B393, C184, D28, D38, E40, E48–49
S112	C184, D28
S1212LSEL3	D74
S1212LSER3	D74
S125	B172–173, B179–184, B188, B375–382, B389–390, B393
S1620LSEL3	D74
S1620LSEL4	D74
S1620LSER3	D74

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
S1620LSER4	D74
S19	B165, B183, B376, B389
S2020LSER3	D74
S2020LSER4	D74
S2043	S39
S2044	S39, U27
S2044CG	T53, T78
S2112	C182, C184–187, C189, C191, C194–195, D25–29, D35, D37–38
S2160	V87, V91
S2162C	S17, S20, S24, S45, S50, V70, V77, V88, V141
S2163C	S10, S14, S58, V77, V88, V91, V141
S2164C	T90, V91
S2165C	S10, S14, S58, T17, T53, T78
S2172CG	V54, V58
S2192C	T17
S304	C190, D36–37
S310	C182, C185–187, C191, C193, D25–27, D29, D35–37
S316	B409
S319PKG	B406–407
S321	B409
S322	B406–407
S325	B409
S327	B406–407, B409
S329	B409
S330	B406–407, B409
S337	B406–407, B409
S340	B406–407, B409
S350	B406–407, B409
S352	C182, C187, C191, D26–27, D35
S353	B406–407, B409
S39	C191, C193, D35–37
S411	B285
S412	B407–408, C184, C187, C193, C195, D26, D28, D36, D38, E43, E47, E49
S415	B407–408
S422	B408, C184, C195, D28, D38, T109, V47, V54
S422CG	T53, V54, V70
S424	S10, S14, S45, T7, V38, V70
S425	B408, S122
S432	B408
S435	B408
S4416W	B406
S4420W	B406
S4424W	B406
S4428W	B406
S4432W	B406
S4440W	B406
S4440W48	B406
S445	S5, S10, S14, S17, S20, S32, S45, S50, S56, S58, S64, S67, S121–123, T7, T33, T109, T113, V38, V47, V54
S445CG	S17, S20, T53, T78, T90, V54, V88, V91, V141
S446	S67, S121–122, V58, V70, V77, V83, V149
S446CG	V70, V77
S447	T64
S449	T64
S458	S5, S10, S14, S17, S20, S24, S32, S45, S50, S56, S58, S64, S67, S121–123, T7, T33, T113, U18, U29, V38, V54, V58
S458CG	S17, S20, S24, T90, V54, V88, V141
S459	V70, V77, V83, V149
S459CG	T90, V70
S464	T64
S467	T7, U27, U37, V54, V58
S518	E44–46
S524	E41–42, E44–46
S532	E40, E48–49
S625	E41, E45
S959	E41–47, E49
S965	D29
SALS25	S104
SALS30	S104
SALS40	S104
SALS50	S104
SALS6150	S104
SB3230	T131
SB3232	T131
SB3413	T128
SB3621	T128
SCACL062D	B193
SCACL083D	B193
SCACL103B	B193
SCACR052D	B193
SCACR062D	B193
SCACR083D	B193
SCACR103B	B193
SCAPL052D	B209
SCAPL083D	B209
SCAPR052D	B209
SCAPR062D	B209
SCAPR083D	B209
SCFCL082	B193
SCFCR082	B193
SCFPL083V	B209
SCFPL08CA06	B217
SCFPR06CA05	B217
SCFPR083V	B209
SCFPR08CA06	B217
SCFPR10CA09	B217
SCG332FW KY3500	B320
SCGCL123	B194
SCGCL163	B194
SCGCR062	B194
SCGCR082	B194
SCGCR102	B194
SCGCR103	B194
SCGCR123	B194
SCGCR163	B194
SCGN332S0415WCB KBK45	B309
SCGN332S0415WCC KBK45	B309
SCGPL062	B210
SCGPL083V	B210
SCGPL123B	B210
SCGPR062	B210
SCGPR083V	B210
SCGPR08CA06	B218
SCGPR123B	B210
SCKPL08CA06	B219
SCKPR08CA06	B219
SCLCL052	B194
SCLCL062	B194
SCLCL082	B194
SCLCL102	B194
SCLCL103	B194
SCLCL123	B194
SCLCL124B	B194
SCLCL12CA12	B198
SCLCL163	B194
SCLCL164D	B194
SCLCLF062D	B195
SCLCLF082D	B195
SCLCLF083D	B195
SCLCLF103B	B195
SCLCR052	B194
SCLCR062	B194
SCLCR082	B194
SCLCR102	B194
SCLCR103	B194
SCLCR123	B194
SCLCR124B	B194
SCLCR12CA12	B198
SCLCR163	B194
SCLCR164D	B194
SCLCR16CA12	B198
SCLCRF062D	B195
SCLCRF082D	B195
SCLCRF083D	B195
SCLCRF103B	B195
SCLCRF523Z	B195
SCLPL062	B210
SCLPL083V	B210
SCLPL08CA06	B220
SCLPL10CA09	B220
SCLPL123B	B210
SCLPLF062D	B211
SCLPLF083D	B211
SCLPR062	B210
SCLPR06CA05	B220
SCLPR083V	B210
SCLPR08CA06	B220
SCLPR10CA09	B220
SCLPR123B	B210
SCLPRF062D	B211
SCLPRF083D	B211
SCMCN062	B195
SCMCN082	B195
SCMCN083	B195
SCMCN103	B195
SCMCN123	B195
SCMCN163	B195
SCMPN062	B211
SCMPN083V	B211
SCMPN123B	B211
SCMT325111 KT315	B246
SCMT3251FP KCM25	B246
SCMT3251FP KCP10	B246
SCMT3251FP KCP25	B246
SCMT3251FP KCU10	B246
SCMT3251FP KCU25	B246
SCMT3251LF KC5010	B246
SCMT3251LF KC5025	B246
SCMT3251LF KCK05	B246
SCMT3251LF KCK15B	B246
SCMT3251LF KCK20	B246
SCMT3251LF KCM25	B246
SCMT3251LF KCP10	B246
SCMT3251LF KCP10B	B246
SCMT3251LF KCP25	B246
SCMT3251LF KCP25B	B246
SCMT3251LF KCP30	B246
SCMT3251LF KT315	B246
SCMT3251MP KCK20	B247
SCMT3251MP KCM15	B247
SCMT3251MP KCM25	B247
SCMT3251MP KCP25	B247
SCMT3251MP KCU10	B247
SCMT325211 KT315	B246
SCMT3252FP KCK20	B246
SCMT3252FP KCM15	B246
SCMT3252FP KCP10	B246
SCMT3252FP KCP25	B246
SCMT3252FP KCP25B	B246
SCMT3252FP KCU10	B246
SCMT3252FP KCU25	B246
SCMT3252FP KTP10	B246
SCMT3252LF KC5010	B246
SCMT3252LF KC5025	B246
SCMT3252LF KCK05	B246
SCMT3252LF KCK05B	B246
SCMT3252LF KCK15	B246
SCMT3252LF KCK15B	B246
SCMT3252LF KCK20	B246
SCMT3252LF KCK20B	B246
SCMT3252LF KCM25	B246
SCMT3252LF KCP10	B246
SCMT3252LF KCP10B	B246
SCMT3252LF KCP25	B246
SCMT3252LF KCP25B	B246
SCMT3252LF KCP30	B246
SCMT3252MF KCK15	B247
SCMT3252MF KCK15B	B247
SCMT3252MF KCK20	B247
SCMT3252MF KCK20B	B247
SCMT3252MF KCM25	B247
SCMT3252MF KCM25B	B247
SCMT3252MF KCP10	B247
SCMT3252MF KCP10B	B247
SCMT3252MF KCP25	B247
SCMT3252MF KCP25B	B247
SCMT3252MP KCK20B	B247
SCMT3252MP KCM15	B247
SCMT3252MP KCM25	B247
SCMT3252MP KCM25B	B247
SCMT3252MP KCP10	B247
SCMT3252MP KCP25	B247
SCMT3252MP KCP25B	B247
SCMT3252MP KCU10	B247
SCMT3252UF KC5010	B247
SCMT3252UF KCP05	B247
SCMT3252UF KCP10	B247
SCMT3253MF KCP25B	B247
SCMT43111 KT315	B246
SCMT431FP KCP25	B246
SCMT431FP KCU10	B246
SCMT431LF KC5010	B246
SCMT431LF KCM25B	B246
SCMT431LF KCP10	B246
SCMT431LF KCP25	B246
SCMT431LF KCP30	B246
SCMT431MP KCM25	B247
SCMT431MP KCU10	B247
SCMT43211 KT315	B246
SCMT432FP KCM25	B246
SCMT432FP KCP25B	B246
SCMT432FP KCU10	B246
SCMT432LF KC5010	B246
SCMT432LF KC5025	B246
SCMT432LF KCK05	B246
SCMT432LF KCK15	B246
SCMT432LF KCK15B	B246
SCMT432LF KCK20	B246
SCMT432LF KCK20B	B246
SCMT432LF KCM15	B246
SCMT432LF KCM25	B246
SCMT432LF KCM25B	B246
SCMT432LF KCP10B	B246
SCMT432LF KCP25	B246
SCMT432LF KCP25B	B246
SCMT432LF KCP30	B246
SCMT432MF KCK15	B247
SCMT432MF KCK15B	B247
SCMT432MF KCK20	B247
SCMT432MF KCK20B	B247
SCMT432MF KCM15	B247
SCMT432MF KCM25	B247
SCMT432MF KCM25B	B247
SCMT432MF KCM35	B247
SCMT432MF KCP10	B247
SCMT432MF KCP25	B247
SCMT432MF KCP25B	B247
SCMT432MF KCP30	B247
SCMT432MP KCK20	B247
SCMT432MP KCK20B	B247
SCMT432MP KCM25	B247
SCMT432MP KCM25B	B247
SCMT432MP KCP10	B247
SCMT432MP KCP25	B247
SCMT432MP KCU10	B247
SCMT433FP KCP25	B246
SCMT433FP KCU10	B246
SCMT433LF KC5010	B246
SCMT433LF KCK20	B246
SCMT433LF KCP10B	B246
SCMT433LF KCP25B	B246
SCMT433MF KCK15	B247
SCMT433MF KCK15B	B247
SCMT433MF KCK20	B247
SCMT433MF KCK20B	B247
SCMT433MF KCP10	B247
SCMT433MF KCP25	B247
SCMT433MF KCP25B	B247
SCMT433MP KCM25	B247
SCMT433MP KCP25	B247
SCMW3251 KCK20	B248
SCMW3252 KCK20	B248
SCMW3252 KCK20B	B248
SCMW432 KCK20	B248
SCMW432 KCK20B	B248
SCMW433 KCK20	B248
SCMW433 KCK20B	B248
SCRCL083	B196
SCRCR083	B196
SCRCR103	B196
SCRPL062	B212
SCRPL083V	B212
SCRPR062	B212
SCRPR083V	B212
SCRPR08CA06	B221
SCSPL06CA05	B222
SCSPL08CA06	B222
SCSPR06CA05	B222
SCSPR08CA06	B222

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
SCTPL08CA06	B223
SCTPR06CA05	B223
SCTPR08CA06	B223
SCW5E	C58
SCW8E	C58
SDACL062D	B227
SDACL082D	B227
SDACL083D	B227
SDACL103B	B227
SDACR062D	B227
SDACR082D	B227
SDACR083D	B227
SDACR103B	B227
SDB115RBHT12F	K126
SDB115RBHT16LF	K126
SDB24RBHT06F	K126
SDB30RBHT06F	K126
SDB40RBHT09F	K126
SDB50RBHT09F	K126
SDB66RBHT12F	K126
SDB66RBHT12LF	K126
SDB87RBHT12F	K126
SDB87RBHT16LF	K126
SDCT4316ENLD2 KC725M	T115, T122, U38
SDCT4316ENLD2 KCSM40	T115, T122, U38
SDCT431PDEL8LD2 KC725M	T115, T122, U38
SDCT431PDER8LD2 KC725M	T115, T122, U38
SDCT431PDFL8LE KC410M	T114, T121, U38, V143
SDCT431PDFR8LE KC410M	T114, T121, U38, V143
SDCT433PDEL8LD2 KC725M	T115, T122, U38
SDCT433PDER8LD2 KC725M	T115, T122, U38
SDCT433PDER8LD2 KCSM40	T115, T122
SDCT433PDFL8LE KC410M	T114, T121, U38, V143
SDCT433PDFR8LE KC410M	T114, T121, U38, V143
SDCT434ENLD2 KC725M	T115, T122, U38
SDCT434ENLD2 KCSM40	T115, T122, U38
SDCT434FNLE KC410M	T114, T121, U38, V143
SDCT435ENLD2 KC725M	T115, T122, U38
SDCT435FNLE KC410M	T114, T121, U38, V143
SDCT436ENLD2 KC725M	T115, T122, U38
SDCT436FNLE KC410M	T114, T121, U38, V143
SDCT438ENLD2 KC522M	T115, T122, U38
SDCT438ENLD2 KC725M	T115, T122, U38
SDCT438ENLD2 KCSM30	T115, T122
SDCT438ENLD2 KCSM40	T115, T122
SDCT438FNLE KC410M	T114, T121, U38, V143
SDCT43PDEL8LD2 KC725M	T115, T122, U38
SDCT43PDER8LD2 KC520M	T115, T122, U38
SDCT43PDER8LD2 KC725M	T115, T122, U38
SDCT43PDER8LD2 KCPM40	T115, T122, U38
SDCT43PDER8LD2 KCSM40	T115, T122, U38
SDCT43PDFL8LE KC410M	T114, T121, U38, V143
SDCT43PDFR8LE KC410M	T114, T121, U38, V143
SDCW433PDSR8GN KY3500	T117, T124
SDCW43EDSR8GN KY3500	T117, T124
SDCW43PDSR8GN KY3500	T117, T124
SDET4312ENGB KC725M	T116, T123, U39
SDET4312ENGB KCSM40	T116, T123, U39
SDET4312SNGB KC725M	T116, T123, U39
SDET4312SNGB KCSM40	T116, T123, U39
SDET4316ENGB KC725M	T116, T123, U39
SDET4316ENGB KCSM40	T116, T123, U39
SDET4316SNGB KC725M	T116, T123, U39
SDET4316SNGB KCPK30	T116, T123, U39
SDET4316SNGB KCSM30	T116, T123, U39
SDET4316SNGB KCSM40	T116, T123, U39
SDET4316SNGB2 KCPK30	T115, T122, U39
SDET433PDEL8GB2 KC520M	T115, T122, U39
SDET433PDEL8GB2 KC725M	T115, T122, U39
SDET433PDEL8GB2 KCK15	T115, T122, U39
SDET433PDENGDZ KC725M	V143
SDET433PDENGDZ KCPK30	V143
SDET433PDENGDZ KCPM40	V143
SDET433PDER8GB KC725M	T116, T123, U39
SDET433PDER8GB KCPM40	T116, T123, U39
SDET433PDER8GB KCSM40	T116, T123, U39
SDET433PDER8GB2 KC520M	T115, T122, U39
SDET433PDER8GB2 KC725M	T115, T122, U39
SDET433PDER8GB2 KCK15	T115, T122, U39
SDET433PDER8GB2 KCPK30	T115, T122, U39
SDET433PDER8GB2 KCPM40	T115, T122, U39
SDET433PDSNGDZ KC522M	V143
SDET433PDSNGDZ KC725M	V143
SDET433PDSNGDZ KCPK30	V143
SDET433PDSNGDZ KCPM40	V143
SDET433PDSR8GB KC725M	T116, T123, U39
SDET433PDSR8GB KCSM40	T116, T123, U39
SDET434ENGB KCSM40	T116, T123, U39
SDET434SNGB KC725M	T116, T123, U39
SDET434SNGB KCSM40	T116, T123, U39
SDET434SNGB2 KC520M	T115, T122, U39
SDET434SNGB2 KC725M	T115, T122, U39
SDET434SNGB2 KCK15	T115, T122, U39
SDET434SNGB2 KCPK30	T115, T122, U39
SDET435SNGB2 KC520M	T115, T122, U39
SDET435SNGB2 KC725M	T115, T122, U39
SDET435SNGB2 KCK15	T115, T122, U39
SDET435SNGB2 KCPK30	T115, T122, U39
SDET435SNGB2 KCPM40	T115, T122, U39
SDET436ENGB KC725M	T116, T123, U39
SDET436ENGB KCSM40	T116, T123, U39
SDET436SNGB KC725M	T116, T123, U39
SDET436SNGB KCSM40	T116, T123, U39
SDET436SNGB2 KC725M	T115, T122, U39
SDET436SNGB2 KCK15	T115, T122, U39
SDET436SNGB2 KCPK30	T115, T122, U39
SDET438ENGB KC725M	T116, T123, U39
SDET438ENGB KCSM40	T116, T123, U39
SDET438SNGB KCSM40	T116, T123, U39
SDET438SNGB2 KC520M	T115, T122, U39
SDET438SNGB2 KC725M	T115, T122, U39
SDET438SNGB2 KCK15	T115, T122, U39
SDET438SNGB2 KCPK30	T115, T122, U39
SDET438XENGB2 KC725M	T115, T122, U39
SDET43PDEL8GB2 KC520M	T115, T122, U39
SDET43PDEL8GB2 KC725M	T115, T122, U39
SDET43PDEL8GB2 KCK15	T115, T122, U39
SDET43PDEL8GB2 KCPK30	T115, T122, U39
SDET43PDER8GB KC520M	T116, T123, U39
SDET43PDER8GB KCSM40	T116, T123, U39
SDET43PDER8GB2 KC520M	T115, T122, U39
SDET43PDER8GB2 KC725M	T115, T122, U39
SDET43PDER8GB2 KCK15	T115, T122, U39
SDET43PDER8GB2 KCPK30	T115, T122, U39
SDET43PDER8GB2 KCPM40	T115, T122, U39
SDET43PDER8GB2 KCSM40	T115, T122, U39
SDET43PDSL8GB2 KC725M	T115, T122, U39
SDET43PDSL8GB2 KCPK30	T115, T122, U39
SDET43PDSR8GB KC725M	T116, T123, U39
SDET43PDSR8GB KCPK30	T116, T123, U39
SDET43PDSR8GB KCPM40	T116, T123, U39
SDET43PDSR8GB KCSM30	T116, T123, U39
SDET43PDSR8GB KCSM40	T116, T123, U39
SDET43PDSR8GB2 KC520M	T115, T122, U39
SDET43PDSR8GB2 KC725M	T115, T122, U39
SDET43PDSR8GB2 KCK15	T115, T122, U39
SDET43PDSR8GB2 KCPK30	T115, T122, U39
SDET43PDSR8GB2 KCPM40	T115, T122, U39
SDHT09T308EN422 KCSM40	T129
SDHT09T308EN422 SP6519	T129
SDHT09T308EN422 X500	T129
SDHT09T308EN423 KCSM40	T129
SDHT09T308EN423 SP6519	T129
SDHT09T308EN423 X500	T129
SDHT09T3AEEN422 SP6519	T129
SDHT120412EN422 KCSM40	T132
SDHT120412EN422 SP6519	T132
SDHT120412EN422 X500	T132
SDHT120412EN423 KCSM40	T132
SDHT120412EN423 SP6519	T132
SDHT120412EN423 X500	T132
SDJCL062	B228
SDJCL082	B228
SDJCL083	B228
SDJCL102	B228
SDJCL103	B228
SDJCL123	B228
SDJCL163	B228
SDJCLF062D	B228
SDJCLF082D	B228
SDJCLF083D	B228
SDJCLF103B	B228
SDJCR062	B228
SDJCR082	B228
SDJCR083	B228
SDJCR102	B228
SDJCR103	B228
SDJCR123	B228
SDJCR163	B228
SDJCRF062D	B228
SDJCRF082D	B228
SDJCRF083D	B228
SDJCRF103B	B228
SDJPL10CA07	B236
SDJPR10CA07	B236
SDMT060304EGG KC730M	U4
SDMT060304EGG KC735M	U4
SDMT080308EGG KC505M	U4
SDMT080308EGG KC730M	U4
SDMT080308EGG KC735M	U4
SDMT09T308EN41 KCSM40	T130
SDMT09T308EN41 MP91M	T130
SDMT09T308EN41 SP6519	T130
SDMT09T308EN41 X500	T130
SDMT120408EGG KC505M	U4
SDMT120408EGG KC730M	U4
SDMT120408EGG KC735M	U4
SDMT120412EN41 KCSM40	T133
SDMT120412EN41 MP91M	T133
SDMT120412EN41 SP6519	T133
SDMT120412EN41 X500	T133
SDMW09T308TN KCSM40	T130
SDMW120412TN KCSM40	T133
SDMW120412TN SP6519	T133
SDPCN062D	B229
SDPCN082D	B229
SDPCN083D	B229
SDPCN103B	B229
SDPT433PDENHPZ KC725M	V143
SDPT433PDENHPZ KCPK30	V143
SDPT433PDENHPZ KCPM40	V143
SDPT433PDSNHPZ KC725M	V143
SDPT433PDSNHPZ KCPK30	V143
SDPT433PDSNHPZ KCPM40	V143
SDPT43PDER8GB2 KC725M	T116, T123, U39
SDPT43PDER8GB2 KCK15	T116, T123, U39
SDPT43PDER8GB2 KCPK30	T116, T123, U39
SDPT43PDER8GB2 KCPM40	T116, T123, U39
SDPT43PDER8GB2 KCSM40	T116, T123, U39
SDPT43PDSR8GB2 KC725M	T116, T123, U39
SDPT43PDSR8GB2 KCK15	T116, T123, U39
SDPT43PDSR8GB2 KCPK30	T116, T123, U39
SDPT43PDSR8GB2 KCPM40	T116, T123, U39
SDPT43PDSR8GB2 KCSM40	T116, T123, U39
SDSW66	V91
SDUCL082	B229
SDUCL083	B229
SDUCL103	B229
SDUCR082	B229
SDUCR083	B229
SDUCR103	B229
SDUPR10CA07	B237
SECT443AEEN7LD2 KC725M	S40
SECT443AEFN7LE KC410M	S40
SECW443AEEN22GNW KC725M	S41
SECW443AESN7GN KY3500	S41
SEF040060RSS075M	I26
SEF060080RSS075M	I26
SEF080100RSS100M	I26
SEF100120RSS125M	I26
SEF120140RSS125M	I26
SEF140160RSS125M	I26
SEF156187RSS075	I25
SEF160180RSS125M	I26
SEF180200RSS125M	I26
SEF218250RSS075	I25
SEF265312RSS075	I25
SEF328375RSS075	I25
SEF390437RSS100	I25
SEF453500RSS100	I25
SEF500562RSS100	I25
SEF562625RSS125	I25
SEF625687RSS125	I25
SEF687750RSS125	I25
SEF750812RSS125	I25
SEF812875RSS150	I25
SEF875937RSS150	I25
SEF9371010RSS150	I25
SEKT443AEEN7GP2 KC520M	S40
SEKT443AEEN7GP2 KC725M	S40
SEKT443AEEN7GP2 KCK15	S40
SEKT443AEEN7GP2 KCPK30	S40
SEKT443AEEN7GP2 KCPM40	S40
SEKT443AESN7GP2 KC520M	S40
SEKT443AESN7GP2 KC725M	S40
SEKT443AESN7GP2 KCK15	S40
SEKT443AESN7GP2 KCPK30	S40
SEKT443AESN7GP2 KCPM40	S40
SEPT443AEEN7GB2 KC725M	S41
SEPT443AEEN7GB2 KCK15	S41
SEPT443AEEN7GB2 KCPK30	S41
SEPT443AESN7GB2 KC725M	S41
SEPT443AESN7GB2 KCK15	S41
SEPT443AESN7GB2 KCPK30	S41
SF075FBHS24	K138
SF075RBHT24	K123
SF100FBH01660	K129
SF100FBHS31	K138
SF100FBHS51	K138
SF100RBHT30	K123
SF100RBHT50	K123
SF125FBHS40	K138
SF125FBHS67	K138
SF125RBHT40	K123
SF125RBHT66	K123
SF150FBH01660	K129
SF150FBHS87	K138
SF150RBHT87	K123
SF200FBHS116	K138
SF200RBHT115	K123
SF300M1LA1RA	K68
SF300M1RS	K68
SF750M1LA1RA	K68
SF750M1RS	K68
SFCPS	K70
SFCR20	K71
SFCR20S	K71
SFCRHSK3263	K71
SFCRHSK63100	K71
SFEBCH	K70
SFEBS	K70
SFMGS	K71
SFRHEC100S3150 KC625M	P131
SFRHEC100S3225 K600	P131
SFRHEC100S3225 KC625M	P131
SFRHEC250S3075 K600	P131
SFRHEC312S3075 KC625M	P131
SFRHEC375S3088 K600	P131
SFRHEC375S3088 KC625M	P131
SFRHEC500S3100 K600	P131
SFRHEC500S3100 KC625M	P131
SFRHEC500S3200 K600	P131
SFRHEC500S3200 KC625M	P131
SFRHEC625S3225 K600	P131
SFRHEC625S3225 KC625M	P131
SFRHEC750S3150 K600	P131
SFRHEC750S3150 KC625M	P131
SFRHEC750S3225 K600	P131
SFRHEC750S3225 KC625M	P131
SFSB450	K70
SFSB900	K70
SFSLLA	K69
SFSLLS	K69
SFSLRA	K69
SFSLRS	K69
SFSLSS	K69
SFVB	K69
SIF100HC12090M	K51
SIF100HC20100M	K51
SIF100HC25100M	K51
SIF70HC12090M	K51
SIF70HC20100M	K51
SIF80HC12090M	K51
SIF80HC20100M	K51
SIF80HC25100M	K51
SKCP343 K9	B193–196
SKCP453 K9	B194
SKDP343 K9	B227–229

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
SKSN566K K9	B115–117, B119
SKTP343 K9	B259–260
SKVN343 K9	B282
SL344	B170, B172, B179, B181–182, B372–374, B376, B378, B381–382, B393, C184, D28, E41, E45
SM-906 KC720	S94, S98, S100
SM-906LH KC720	S94, S98, S100
SM119 K9	B179, B181–182, B378, B381–382
SM120 K9	B172, B376
SM216 K9	B375
SM218 K9	B373
SM26 K9	B375
SM271 K9	E41, E45
SM272 K9	E41
SM285 K9	E41–42, E44–46
SM286 K9	E41–42, E44–46
SM36 K9	B172–173, B376–378
SM369 K9	B165, B376, B389
SM37 K9	B179–184, B188, B378–382, B389–390, B393
SM396 K9	B372
SM40 K9	B172–173, B376–378
SM41 K9	B179–184, B188, B378–382, B389–390, B393
SM412 K9	E43, E47, E49
SM414 K9	E40, E48–49
SM416 K9	C184, D28
SM417 K9	B210–211
SM419 K9	C184, D28
SM420 K9	C184, D28
SM427 K9	D38
SM432 K9	B372–373
SM434 K9	B374
SM437 K9	B170, B374, B393
SM449 K9	T113
SM45 K9	B373
SM455 K9	S39
SM46 K9	B373
SM47 K9	B374
SM48 K9	B375
SM837 K9	B186, B397
SMRN42B K9	B170, B385
SMRN63B K9	B170, B385
SMRN84B K9	B170, B385
SMYE3 K9	D71–72, D74–75, D77–79
SMYE4 K9	D71–72, D74, D77–78
SMYE5 K9	D78
SMYI3 K9	D71, D74–79
SMYI4 K9	D71, D74–79
SMYI5 K9	D76, D78–79
SN2TPKG	W40, W42–43
SN3TM	W40, W42
SN3TPKG	D74–75, W40–43
SN5TM	W40–43
SN7T	W40
SNG322T0820 KY1615	B337
SNG322T0820 KY3500	B318
SNG432T0220 KY1615	B337
SNG432T0420 KYS30	B353
SNG432T0820 KY1615	B337
SNG432T0820 KY3500	B318
SNG432T0820 KYK25	B318
SNG433T0420 KYS30	B353
SNG433T0820 KY1615	B337
SNG433T0820 KY3500	B318
SNG433T0820 KYK25	B318
SNG434T0420 KYS25	B353
SNG434T0420 KYS30	B353
SNG434T0820 KY1615	B337
SNG434T0820 KY3500	B318
SNG438T0820 KY3500	B318
SNG451T0820 KY1615	B337
SNG452T0820 KY1615	B337
SNG453T0820 KY1615	B337
SNG453T0820 KYK25	B318
SNG454T0420 KYS30	B353
SNG454T0820 KY1615	B337
SNG454T0820 KY3500	B318
SNG455T0820 KY1615	B337
SNG455T4015 KY1615	B337
SNG455T8015 KY1615	B337
SNG554T0820 KY1615	B337
SNG634T0820 KY3500	B318
SNG644E KYS25	B353
SNG644T0420 KYS30	B353
SNG656E KYS30	B353
SNGA432S0415MT KBH10	B337
SNGA432S0525MT KBH10	B337
SNGA432S0525MT KBH20	B337
SNGA432T0820 KY1615	B337
SNGA432T0820 KY3500	B314
SNGA432T0820 KYK10	B314
SNGA432T0820 KYK25	B314
SNGA433S0525MT KBH10	B337
SNGA433S0525MT KBH20	B337
SNGA433T0420 KYS25	B353
SNGA433T0420 KYS30	B353
SNGA433T0820 KY1615	B337
SNGA433T0820 KY3500	B314
SNGA433T0820 KYK25	B314
SNGA434T0820 KY3500	B314
SNGA543T KY3500	B314
SNGA543T0820 KYK25	B314
SNGA544T KY3500	B314
SNGA643T0820 KY3500	B314
SNGN332S0415WCB KBK45	B306
SNGN332S0415WCC KBK45	B306
SNGN432T0820 KBK45	B305
SNGN433S0820 KBK45	B305
SNGN434S0820 KBK45	B305
SNGP431 KC5010	B100
SNGP432 KC5010	B100
SNGX432T0820 KBK45	B308
SNGX433S0820 KBK45	B308
SNGX434S0820 KB1340	B308
SNGX434S0820 KBK45	B308
SNGX453T0420 KYS30	B353
SNGX453T0820 KY1615	B338
SNGX453T0820 KY3500	B318
SNGX453T0820 KYK10	B318
SNGX453T0820 KYK25	B318
SNGX454T0420 KYS30	B353
SNGX454T0820 KY3500	B318
SNGX454T0820 KYK10	B318
SNGX454T0820 KYK25	B318
SNGX554T0820 KY3500	B318
SNGX556T0820 KY3500	B318
SNHJ31252ENLD KC520M	S57
SNHJ31252ENLD KC725M	S57
SNHJ31252ENLD KCK15	S57
SNHJ31252ENLD KCPK30	S57
SNHJ31253ENLD KC725M	S57
SNHJ31253ENLD KCK15	S57
SNHJ442ENLD KC520M	S59
SNHJ442ENLD KC725M	S59
SNHJ442ENLD KCK15	S59
SNHJ442ENLD KCPK30	S59
SNHJ442SNGD KC520M	S59
SNHJ442SNGD KC522M	S59
SNHJ442SNGD KCK15	S59
SNHJ442SNGD KCPK30	S59
SNHJ442SNGD KCPM40	S59
SNHJ442SNGD KCSM40	S59
SNHJ444ENLD KC520M	S59
SNHJ444ENLD KC725M	S59
SNHJ444ENLD KCK15	S59
SNHJ444ENLD KCPK30	S59
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
SNM322S0820 KB1340	B306
SNM324S0820 KB1340	B306
SNM424S0820 KB1340	B306
SNM434S0820 KB1340	B306
SNMA432 K68	B100
SNMA432 KCK15B	B100
SNMA432 KCK20	B100
SNMA432 KCK20B	B100
SNMA433 KCK15	B100
SNMA433 KCK15B	B100
SNMA433 KCK20	B100
SNMA433 KCK20B	B100
SNMA433S0820 KB1340	B310
SNMA543 KCK15B	B100
SNMA543 KCK20	B100
SNMA643 K68	B100
SNMA643 KCK20	B100
SNMA644 KCK20	B100
SNMG321FF KC5010	B101
SNMG321FF KCU10	B101
SNMG322FF KC5010	B101
SNMG322FF KCP10	B101
SNMG322FF KCU10	B101
SNMG322FF KT315	B101
SNMG322FN KCK05	B101
SNMG322FN KCK15B	B101
SNMG322FN KCP10	B101
SNMG322MN KCP10	B102
SNMG322MN KCP10B	B102
SNMG322MN KCP25	B102
SNMG322MN KCP25B	B102
SNMG322MN KCP30	B102
SNMG323MN KCP10	B102
SNMG323MN KCP25	B102
SNMG333RN KCP10	B105
SNMG431FN KCK05	B101
SNMG431FN KCP05	B101
SNMG431FN KCP10B	B101
SNMG431FP KCM15	B101
SNMG431FP KCU10	B101
SNMG431MN KCP10B	B102
SNMG431MN KCP25B	B102
SNMG432 K313	B100
SNMG432FF KC5010	B101
SNMG432FN KCP10	B101
SNMG432FN KCP10B	B101
SNMG432FN KT315	B101
SNMG432FP KCM15	B101
SNMG432FP KCM25B	B101
SNMG432FP KCU10	B101
SNMG432FW KCP05	B102
SNMG432FW KCP10	B102
SNMG432MN KCP10	B102
SNMG432MN KCP10B	B102
SNMG432MN KCP25	B102
SNMG432MN KCP25B	B102
SNMG432MN KCP30	B102
SNMG432MN KCP30B	B102
SNMG432MN KCP40	B102
SNMG432MN KCP40B	B102
SNMG432MP KC5010	B102
SNMG432MP KCM15	B102
SNMG432MP KCM15B	B102
SNMG432MP KCM25	B102
SNMG432MP KCM25B	B102
SNMG432MP KCM35B	B102
SNMG432MP KCU10	B102
SNMG432MR KCM25B	B103
SNMG432MR KCP25B	B103
SNMG432MR KCU10	B103
SNMG432MS KC5010	B103
SNMG432MS KC5025	B103
SNMG432MS KCU10	B103
SNMG432MS KCU25	B103
SNMG432MW KCP25	B104
SNMG432RN KCP10	B105
SNMG432RN KCP25	B105
SNMG432RN KCP25B	B105
SNMG432RN KCP30B	B105
SNMG432RN KCP40B	B105
SNMG432RP KC5010	B105
SNMG432RP KC5025	B105
SNMG432RP KCK20	B105
SNMG432RP KCK20B	B105
SNMG432RP KCM25	B105
SNMG432RP KCM35	B105
SNMG432RP KCP05	B105
SNMG432RP KCP10	B105
SNMG432RP KCP25	B105
SNMG432RP KCP25B	B105
SNMG432RP KCU10	B105
SNMG432RP KCU25	B105
SNMG432UN KCK15	B106
SNMG432UN KCK15B	B106
SNMG432UN KCK20	B106
SNMG432UN KCK20B	B106
SNMG432UP KC5010	B106
SNMG432UP KCM35	B106
SNMG433 K68	B100
SNMG433FN KCP10	B101
SNMG433FN KCP25	B101
SNMG433FW KCP10	B102
SNMG433FW KT315	B102
SNMG433MN KCP10	B102
SNMG433MN KCP10B	B102
SNMG433MN KCP25	B102
SNMG433MN KCP25B	B102
SNMG433MN KCP30	B102
SNMG433MN KCP40	B102
SNMG433MP KC5010	B102
SNMG433MP KCM15	B102
SNMG433MP KCM25	B102
SNMG433MP KCM25B	B102
SNMG433MP KCM35	B102
SNMG433MP KCU10	B102
SNMG433MP KCU25	B102
SNMG433MR KCM25	B103
SNMG433MR KCP10B	B103
SNMG433MR KCP25B	B103
SNMG433MR KCU10	B103
SNMG433MS KC5010	B103
SNMG433MS KCU10	B103
SNMG433MS KCU25	B103
SNMG433MW KCP10	B104
SNMG433P KCU10	B104
SNMG433RN KCP10	B105
SNMG433RN KCP10B	B105
SNMG433RN KCP25	B105
SNMG433RN KCP25B	B105
SNMG433RN KCP30B	B105
SNMG433RN KCP40	B105
SNMG433RN KCP40B	B105
SNMG433RN KCPK05	B105
SNMG433RP KC5010	B105
SNMG433RP KC5025	B105
SNMG433RP KCK05	B105
SNMG433RP KCK15	B105
SNMG433RP KCK15B	B105
SNMG433RP KCK20	B105
SNMG433RP KCM25	B105
SNMG433RP KCM25B	B105
SNMG433RP KCP05	B105
SNMG433RP KCP10	B105
SNMG433RP KCP10B	B105
SNMG433RP KCP25	B105
SNMG433RP KCP25B	B105
SNMG433RP KCP30	B105
SNMG433RP KCP40	B105
SNMG433RP KCU10	B105
SNMG433RP KCU25	B105
SNMG433UN KCK05B	B106

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
SNMG433UN KCK15B	B106
SNMG433UN KCK20	B106
SNMG433UN KCK20B	B106
SNMG433UP KCM25	B106
SNMG433UP KCM35	B106
SNMG434FN KCP10	B101
SNMG434MG KCP25B	B103
SNMG434MN KCP25	B102
SNMG434MN KCP25B	B102
SNMG434MP KCM25B	B102
SNMG434MP KCM35	B102
SNMG434RN KCP10B	B105
SNMG434RN KCP25	B105
SNMG434RN KCP25B	B105
SNMG434RN KCP40	B105
SNMG434RN KCP40B	B105
SNMG434RP KC5025	B105
SNMG434RP KCP10	B105
SNMG434RP KCU10	B105
SNMG434UN KCK20	B106
SNMG434UN KCK20B	B106
SNMG542MP KCM25B	B102
SNMG542MS KCU25	B103
SNMG542RN KCP10	B105
SNMG542RN KCP25	B105
SNMG543MN KCP10B	B102
SNMG543MN KCP25	B102
SNMG543MN KCP25B	B102
SNMG543MP KC5010	B102
SNMG543MP KCM15	B102
SNMG543MP KCM25	B102
SNMG543MP KCM25B	B102
SNMG543MP KCU10	B102
SNMG543MR KCM15B	B103
SNMG543MR KCPK05	B103
SNMG543MS KCU25	B103
SNMG543RN KCP10B	B105
SNMG543RN KCP25	B105
SNMG543RN KCP25B	B105
SNMG543RN KCP40	B105
SNMG543RN KCP40B	B105
SNMG543RN KCPK05	B105
SNMG543RP KCM35	B105
SNMG543RP KCP10B	B105
SNMG543RP KCP25	B105
SNMG543RP KCP25B	B105
SNMG543RP KCP40	B105
SNMG543RP KCU10	B105
SNMG543RP KCU25	B105
SNMG543UN KCK15B	B106
SNMG543UN KCK20	B106
SNMG543UP KCM15	B106
SNMG543UP KCM25	B106
SNMG543UP KCU10	B106
SNMG544MN KCP25B	B102
SNMG544MP KCM25	B102
SNMG544MP KCU10	B102
SNMG544RN KCP25	B105
SNMG544RN KCP25B	B105
SNMG544RN KCP30B	B105
SNMG544RN KCPK05	B105
SNMG544RP KCM15B	B105
SNMG544RP KCM25B	B105
SNMG544RP KCP10B	B105
SNMG544RP KCP25	B105
SNMG544RP KCU25	B105
SNMG544UN KCK15	B106
SNMG544UN KCK20	B106
SNMG642RN KCP25B	B105
SNMG642RN KCP30	B105
SNMG643 KCU10	B100
SNMG643MN KCP10	B102
SNMG643MN KCP25B	B102
SNMG643MP KCM15	B102
SNMG643MP KCM25	B102
SNMG643MP KCM25B	B102
SNMG643MP KCM35	B102
SNMG643MS KC5025	B103
SNMG643MS KCU25	B103
SNMG643RN KCP10B	B105
SNMG643RN KCP25	B105
SNMG643RN KCP25B	B105
SNMG643RN KCP30B	B105
SNMG643RN KCP40	B105
SNMG643RP KC5010	B105
SNMG643RP KC5025	B105
SNMG643RP KCM25B	B105
SNMG643RP KCM35	B105
SNMG643RP KCP10	B105
SNMG643RP KCP25B	B105
SNMG643RP KCP40B	B105
SNMG643RP KCU10	B105
SNMG643RP KCU25	B105
SNMG643UN KCK15	B106
SNMG643UN KCK20	B106
SNMG644 KCP40	B100
SNMG644MN KCP25	B102
SNMG644MP KC5010	B102
SNMG644RN KCP10	B105
SNMG644RN KCP25	B105
SNMG644RN KCP25B	B105
SNMG644RN KCP30B	B105
SNMG644RN KCP40B	B105
SNMG644RN KCPK05	B105
SNMG644RP KC5025	B105
SNMG644RP KCK20	B105
SNMG644RP KCM25	B105
SNMG644RP KCM25B	B105
SNMG644RP KCP10	B105
SNMG644RP KCP40	B105
SNMG644RP KCPK05	B105
SNMG644RP KCU10	B105
SNMG644RP KCU25	B105
SNMG644UN KCK20	B106
SNMG646RN KCP25	B105
SNMG646RN KCP30	B105
SNMG866 KCP25	B100
SNMG866 KCP40	B100
SNMG866 KCU10	B100
SNMG866RM KC5010	B104
SNMG866RM KCP25	B104
SNMG866RM KCU10	B104
SNMG866RN KCP40B	B105
SNMM432RM KCP25	B107
SNMM432RM KCM35	B107
SNMM432RP KCP25	B107
SNMM433RM KCP25	B107
SNMM433RP KCM25	B107
SNMM433RP KCP25	B107
SNMM543RM KCP10	B107
SNMM543RM KCP25	B107
SNMM543RM KCP25B	B107
SNMM543RP KCP25	B107
SNMM544RM KCP10	B107
SNMM544RM KCP25	B107
SNMM544RM KCP25B	B107
SNMM544RP KCM25	B107
SNMM544RP KCP10	B107
SNMM643RH KCP25B	B106
SNMM643RH KCP30	B106
SNMM643RM KCP10	B107
SNMM643RM KCP25	B107
SNMM643RM KCP25B	B107
SNMM643RM KCP40	B107
SNMM643RP KCP25	B107
SNMM643RP KCP40	B107
SNMM644RH KCP10	B106
SNMM644RH KCP25	B106
SNMM644RH KCP25B	B106
SNMM644RH KCP30	B106
SNMM644RH KCP40	B106
SNMM644RM KCP10	B107
SNMM644RM KCP25	B107
SNMM644RM KCP25B	B107
SNMM644RM KCP40B	B107
SNMM644RP KCM25	B107
SNMM644RP KCM25B	B107
SNMM644RP KCP40	B107
SNMM646RH KCP10	B106
SNMM646RH KCP25	B106
SNMM646RH KCP25B	B106
SNMM646RH KCP30	B106
SNMM646RH KCP40B	B106
SNMM646RM KCP25	B107
SNMM646RM KCP25B	B107
SNMM646RM KCP40B	B107
SNMM646RP KCM25	B107
SNMM646RP KCP25	B107
SNMM646RP KCP25B	B107
SNMM646RW KCP25B	B107
SNMM856RH KCP10	B106
SNMM856RH KCP10B	B106
SNMM856RH KCP25	B106
SNMM856RH KCP25B	B106
SNMM856RH KCP30	B106
SNMM856RH KCP40	B106
SNMM856RH KCP40B	B106
SNMM856RM KCP10	B107
SNMM856RM KCP25	B107
SNMM856RP KCM25	B107
SNMM856RP KCP25	B107
SNMM856RP KCP40	B107
SNMM856RW KCP25B	B107
SNMM866RH KCP10	B106
SNMM866RH KCP10B	B106
SNMM866RH KCP25	B106
SNMM866RH KCP25B	B106
SNMM866RH KCP30	B106
SNMM866RH KCP40	B106
SNMM866RH KCP40B	B106
SNMM866RM KCP25	B107
SNMM866RM KCP30	B107
SNMM866RM KCP40	B107
SNMM866RP KCM25	B107
SNMM866RP KCM25B	B107
SNMM866RP KCP25	B107
SNMP432K KCP25	B108
SNMP643 K313	B108
SNMP643 K68	B108
SNMS432 K68	B108
SNMS643 K68	B108
SNMS643 KC5410	B108
SNMX190640S-WT5 KCP25B	E59
SNMX453T0820 KY3500	B319
SNMX454T0820 KY3500	B319
SNMX554T0820 KY3500	B319
SNPJ31252SNGD KC520M	S57
SNPJ31252SNGD KCK15	S57
SNPJ31252SNGD KCPK30	S57
SNPJ31252SNGD KCPM40	S57
SNPJ31253SNGD KCK15	S57
SNPJ31253SNGD KCPM40	S57
SNPJ442SNGD KC520M	S60
SNPJ442SNGD KCK15	S60
SNPJ442SNGD KCPK30	S60
SNPJ442SNGD KCPM40	S60
SNPJ444SNGD KCK15	S60
SNPJ444SNGD KCPK30	S60
SNPJ444SNGD KCPM40	S60
SNXF433AMSN KY3500	S90
SNXF433ENLD KC514M	S89
SNXF433ENLD KC524M	S89
SNXF433ENLD KCK15	S89
SNXF433ENLD KCK20	S89
SNXF433ENLD KCPK30	S89
SNXF433SNGP KC514M	S89
SNXF433SNGP KC524M	S89
SNXF433SNGP KCK15	S89
SNXF433SNGP KCK20	S89
SNXF433SNGP KCPK30	S89
SNXF433SNHE KC524M	S89
SNXF433SNHE KCK15	S89
SNXF433SNHE KCK20	S89
SNXF433SNHE KCPK30	S89
SNXF43ZNAMSN KY3500	S90
SNXF43ZNENLD KC514M	S89
SNXF43ZNENLD KC524M	S89
SNXF43ZNENLD KCK15	S89
SNXF43ZNENLD KCK20	S89
SNXF43ZNENLD KCPK30	S89
SNXF43ZNSNGP KC514M	S89
SNXF43ZNSNGP KC524M	S89
SNXF43ZNSNGP KCK15	S89
SNXF43ZNSNGP KCK20	S89
SNXF43ZNSNGP KCPK30	S89
SNXF43ZNSNHE KC514M	S89
SNXF43ZNSNHE KCK15	S89
SNXF43ZNSNHE KCK20	S89
SNXF43ZNSNHE KCPK30	S89
SPCT31251PPEL8LD2 KC725M	T111, U30
SPCT31251PPER8LD2 KC725M	T111, U30
SPCT31251PPFL8LE KC410M	T110, U30
SPCT31251PPFR8LE KC410M	T110, U30
SPCT31253PPEL8LD2 KC725M	T111, U30
SPCT31253PPER8LD2 KC725M	T111, U30
SPCT31253PPFR8LE KC410M	T110, U30
SPCT31254ENLD2 KC725M	T111, U30
SPCT31254ENLD2 KCSM30	T111, U30
SPCT31255ENLD2 KC725M	T111, U30
SPCT31255FNLE KC410M	T110, U30
SPCT3125PPEL8LD2 KC725M	T111, U30
SPCT3125PPER8LD2 KC520M	T111, U30
SPCT3125PPER8LD2 KC725M	T111, U30
SPCT3125PPER8LD2 KCPM40	T111, U30
SPCT3125PPFL8LE KC410M	T110, U30
SPCT3125PPFR8LE KC410M	T110, U30
SPET31251PPEL8GB2 KC725M	T111, U31
SPET31251PPEL8GB2 KCK15	T111, U31
SPET31251PPEL8GB2 KCPK30	T111, U31
SPET31251PPER8GB2 KC725M	T111, U31
SPET31251PPER8GB2 KCK15	T111, U31
SPET31251PPER8GB2 KCPK30	T111, U31
SPET3125PPEL8GB2 KC520M	T111, U31
SPET3125PPEL8GB2 KC725M	T111, U31
SPET3125PPEL8GB2 KCK15	T111, U31
SPET3125PPEL8GB2 KCPK30	T111, U31
SPET3125PPER8GB2 KC520M	T111, U31
SPET3125PPER8GB2 KC725M	T111, U31
SPET3125PPER8GB2 KCK15	T111, U31
SPET3125PPER8GB2 KCPK30	T111, U31
SPET3125PPER8GB2 KCPM40	T111, U31
SPET3125PPSL8GB2 KC725M	T111, U31
SPET3125PPSL8GB2 KCPK30	T111, U31
SPET3125PPSR8GB2 KC520M	T111, U31
SPET3125PPSR8GB2 KC725M	T111, U31
SPET3125PPSR8GB2 KCK15	T111, U31
SPET3125PPSR8GB2 KCPK30	T111, U31
SPG321 K68	B171
SPG321 KC5010	B171
SPG322 K68	B171
SPG322 KC5010	B171
SPG322 KCK15	B171
SPG322T0420 KY1615	B338
SPG421 K68	B171
SPG421 KC5010	B171
SPG421 KCU10	B171
SPG422 K313	B171
SPG422 K68	B171
SPG422 KC5010	B171
SPG422 KCU10	B171
SPG422T0420 KY1615	B338
SPG423 K68	B171
SPG424 KC5010	B171
SPG433 KCU10	B171
SPG632 K68	B171
SPG633 K313	B171
SPG633 KCU10	B171
SPGF322 KC5010	B171
SPGF322 KCU10	B171
SPGF422 KCP25B	B171
SPGT3251LF KC5010	B252
SPGT3251LF KC5025	B252
SPGT3251LF KCU10	B252
SPGT3252LF KC5010	B252
SPGT3252LF KC5025	B252
SPGT3252LF KC5410	B252
SPGT3252LF KCU10	B252
SPGX050204HP KC7140	J103
SPGX050204HP KCU25	J103
SPGX050204HP KCU40	J103
SPGX050204LP KCU40	J104
SPGX050204MD KC7140	J103
SPGX050204MD KCU25	J103
SPGX050204MD KCU40	J103
SPGX060304FP KCPK10	J104
SPGX060304FP KCU25	J104
SPGX060304FP KCU40	J104
SPGX060304LP KCU40	J104

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
SPGX060304MD KC7140	J103
SPGX060304MD KCPK10	J103
SPGX060304MD KCU25	J103
SPGX060304MD KCU40	J103
SPGX060304RHP KC7140	J103
SPGX060304RHP KCU25	J103
SPGX060304RHP KCU40	J103
SPGX070304FP KCPK10	J104
SPGX070304FP KCU25	J104
SPGX070304FP KCU40	J104
SPGX070304MD KC7140	J103
SPGX070304MD KCPK10	J103
SPGX070304MD KCU25	J103
SPGX070304MD KCU40	J103
SPGX070304RHP KC7140	J103
SPGX070304RHP KCU25	J103
SPGX070304RHP KCU40	J103
SPGX070308FP KCPK10	J104
SPGX070308FP KCU25	J104
SPGX070308FP KCU40	J104
SPGX070308HP KCPK10	J103
SPGX070308HP KCU25	J103
SPGX070308HP KCU40	J103
SPGX070308MD KCPK10	J103
SPGX070308MD KCU25	J103
SPGX070308MD KCU40	J103
SPHX060202R20 KC7215	J115
SPHX060202R21 KC7215	J116
SPHX060204R20 KC7140	J115
SPHX060204R20 KCU25	J115
SPHX060204R20 KCU40	J115
SPHX060204R21 KCPK10	J116
SPHX060204R21 KCU25	J116
SPHX060204R21 KCU40	J116
SPHX060204R21 KM1	J116
SPHX060204R22 KM1	J117
SPHX060206R20 KC7215	J115
SPHX060206R21 KC7215	J116
SPHX060208R20 KC7215	J115
SPHX060208R21 KC7215	J116
SPHX070302R20 KC7215	J115
SPHX070304R20 KC7140	J115
SPHX070304R20 KCU25	J115
SPHX070304R20 KCU40	J115
SPHX070304R21 KCPK10	J116
SPHX070304R21 KCU25	J116
SPHX070304R21 KCU40	J116
SPHX070304R21 KM1	J116
SPHX070304R22 KM1	J117
SPHX070306R20 KC7215	J115
SPHX070306R21 KC7215	J116
SPHX070308R20 KC7215	J115
SPHX070308R21 KCPK10	J116
SPHX070308R21 KCU40	J116
SPHX070310R20 KC7215	J115
SPHX070310R21 KC7215	J116
SPHX070312R20 KC7215	J115
SPHX090304R20 KC7140	J115
SPHX090304R20 KC7215	J115
SPHX090304R20 KCU25	J115
SPHX090304R20 KCU40	J115
SPHX090304R21 KCPK10	J116
SPHX090304R21 KCU25	J116
SPHX090304R21 KCU40	J116
SPHX090304R21 KM1	J116
SPHX090304R22 KM1	J117
SPHX090308R20 KCU25	J115
SPHX090308R20 KCU40	J115
SPHX090308R21 KCPK10	J116
SPHX090308R21 KCU25	J116
SPHX090308R21 KCU40	J116
SPHX090310R20 KC7215	J115
SPHX090310R21 KC7215	J116
SPHX090312R20 KC7215	J115
SPHX090312R21 KC7215	J116
SPHX090316R20 KC7215	J115
SPHX090316R21 KC7215	J116
SPHX120404R20 KC7140	J115
SPHX120404R20 KCU25	J115
SPHX120404R20 KCU40	J115
SPHX120404R21 KCPK10	J116
SPHX120404R21 KCU25	J116
SPHX120404R21 KCU40	J116
SPHX120404R21 KM1	J116
SPHX120404R22 KM1	J117
SPHX120408R20 KCU25	J115
SPHX120408R20 KCU40	J115
SPHX120408R21 KC7215	J116
SPHX120410R20 KC7215	J115
SPHX120410R21 KC7215	J116
SPHX120412R20 KC7215	J115
SPHX120412R21 KC7215	J116
SPHX120416R20 KC7215	J115
SPHX120416R21 KC7215	J116
SPHX120420R20 KC7215	J115
SPHX120420R21 KC7215	J116
SPHX120508PCSRGP KCK15	S68
SPHX1205PCELGPB KCK15	S68–69
SPHX1205PCER-GP1WB KC520M	S69
SPHX1205PCER-GP1WB KCK15	S69
SPHX1205PCERGN1WB KCPK30	S69
SPHX1205PCERGNT1WB KB1340	S69
SPHX1205PCERGP4SB KC520M	S68
SPHX1205PCERGP4SB KCK15	S68
SPHX1205PCERGPB KC520M	S68
SPHX1205PCERGPB KCK15	S68
SPHX1205PCERGPB KCPK30	S68
SPHX1205PCFLGN1WB KCK15	S69
SPHX1205PCFRGN1WB KC520M	S69
SPHX1205PCFRGN1WB KC725M	S69
SPHX1205PCFRGN1WB KCK15	S69
SPHX1205PCFRGN1WB KTPK20	S69
SPHX1205PCFRGN1WBK KY3500	S69
SPHX1205PCSRGPB KC725M	S68
SPHX1205PCSRGPB KCK15	S68
SPHX1205PCSRGPB KCPK30	S68
SPHX1205PCTLGPBK KY3500	S68
SPHX1205PCTR-GP1WBK KY3500	S69
SPHX1205PCTRGP4SBK KY3500	S68
SPHX1205PCTRGPB KTPK20	S68
SPHX1205PCTRGPBK KY3500	S68
SPHX1205ZCELGP KC520M	S65
SPHX1205ZCELGP KCK15	S65
SPHX1205ZCER-GP1W KC520M	S66
SPHX1205ZCER-GP1W KCK15	S66
SPHX1205ZCERGNT1W KB1340	S66
SPHX1205ZCERGP KC520M	S65
SPHX1205ZCERGP KCK15	S65
SPHX1205ZCERGP KCPK30	S65
SPHX1205ZCERGP4S KCK15	S65
SPHX1205ZCFRGN1W KC520M	S66
SPHX1205ZCFRGN1W KCK15	S66
SPHX1205ZCFRGN1WK KY3500	S66
SPHX1205ZCSRGP KCK15	S65
SPHX1205ZCSRGP KCPK30	S65
SPHX1205ZCTLGPK KY3500	S65
SPHX1205ZCTR-GP1WK KY3500	S66
SPHX1205ZCTRGP KTPK20	S65
SPHX1205ZCTRGP4SK KY3500	S65
SPHX1205ZCTRGPK KY3500	S65
SPHX150504R20 KCU25	J115
SPHX150504R20 KCU40	J115
SPHX150504R21 KM1	J116
SPHX150504R22 KM1	J117
SPHX150508R20 KCU25	J115
SPHX150508R20 KCU40	J115
SPHX150512R20 KC7215	J115
SPHX150516R20 KC7215	J115
SPHX150520R20 KC7215	J115
SPHX15T6ZCERGP KCK15	S71
SPHX15T6ZCERGP KCPK30	S71
SPHX15T6ZCERGP4S KCK15	S71
SPHX15T6ZCFRGN1W KCK15	S72
SPHX15T6ZCSRGP K110M	S71
SPHX15T6ZCSRGP KCPK30	S71
SPHX15T6ZCTRGP4SK KY3500	S71
SPHX15T6ZCTRGPK KY3500	S71
SPMT3251FP KCP25	B252
SPMT3251FP KCU10	B252
SPMT3251FP KCU25	B252
SPMT3251LF KC5010	B252
SPMT3251LF KC5025	B252
SPMT3251LF KCK15B	B252
SPMT3251LF KCK20	B252
SPMT3251LF KCP10	B252
SPMT3251LF KCP25	B252
SPMT3251LF KT315	B252
SPMT3251UF KC5010	B253
SPMT3251UF KCP10B	B253
SPMT3252FP KCU10	B252
SPMT3252LF K68	B252
SPMT3252LF KC5010	B252
SPMT3252LF KC5025	B252
SPMT3252LF KCK15	B252
SPMT3252LF KCK15B	B252
SPMT3252LF KCK20	B252
SPMT3252LF KCK20B	B252
SPMT3252LF KCP10B	B252
SPMT3252LF KCP25	B252
SPMT3252LF KCP25B	B252
SPMT3252MF KCK15	B253
SPMT3252MF KCK15B	B253
SPMT3252MF KCK20	B253
SPMT3252MF KCM25B	B253
SPMT3252MF KCP10	B253
SPMT3252MF KCP25	B253
SPMT3252MF KCP25B	B253
SPMT3252MP KCK20	B253
SPMT3252MP KCM15	B253
SPMT3252MP KCU10	B253
SPMT432MF KCK15	B253
SPMT432MF KCK20	B253
SPMT432MF KCM25	B253
SPMT432MF KCP25	B253
SPMT432MF KCP30	B253
SPMT432MP KCP25	B253
SPMT432MP KCU10	B253
SPPT3125PPER8GB2 KCK15	T112, U31
SPPT3125PPER8GB2 KCPK30	T112, U31
SPPT3125PPSR8GB2 KCK15	T112, U31
SPPT3125PPSR8GB2 KCPK30	T112, U31
SPPT3125PPSR8GB2 KTPK20	T112, U31
SPPX070304LP KCU40	J104
SPPX09T308FP KCPK10	J104
SPPX09T308FP KCU25	J104
SPPX09T308FP KCU40	J104
SPPX09T308LP KCU40	J104
SPPX09T308MD KC7140	J103
SPPX09T308MD KCU25	J103
SPPX09T308MD KCU40	J103
SPPX09T308RHP KC7140	J103
SPPX09T308RHP KCU25	J103
SPPX09T308RHP KCU40	J103
SPPX09T310FP KCPK10	J104
SPPX09T310FP KCU25	J104
SPPX09T310FP KCU40	J104
SPPX09T310HP KCPK10	J103
SPPX09T310HP KCU25	J103
SPPX09T310HP KCU40	J103
SPPX09T310MD KCPK10	J103
SPPX09T310MD KCU25	J103
SPPX09T310MD KCU40	J103
SPPX120408FP KCPK10	J104
SPPX120408FP KCU25	J104
SPPX120408FP KCU40	J104
SPPX120408LP KCU40	J104
SPPX120408MD KC7140	J103
SPPX120408MD KCU25	J103
SPPX120408MD KCU40	J103
SPPX120408RHP KC7140	J103
SPPX120408RHP KCU25	J103
SPPX120408RHP KCU40	J103
SPPX120412FP KCPK10	J104
SPPX120412FP KCU25	J104
SPPX120412FP KCU40	J104
SPPX120412HP KCPK10	J103
SPPX120412HP KCU25	J103
SPPX120412HP KCU40	J103
SPPX120412MD KCPK10	J103
SPPX120412MD KCU25	J103
SPPX120412MD KCU40	J103
SPPX15T508FP KCPK10	J104
SPPX15T508FP KCU25	J104
SPPX15T508FP KCU40	J104
SPPX15T508MD KC7140	J103
SPPX15T508MD KCU25	J103
SPPX15T508MD KCU40	J103
SPPX15T508RHP KC7140	J103
SPPX15T508RHP KCU25	J103
SPPX15T508RHP KCU40	J103
SPPX15T512FP KCPK10	J104
SPPX15T512FP KCU25	J104
SPPX15T512FP KCU40	J104
SPPX15T512HP KCPK10	J103
SPPX15T512HP KCU25	J103
SPPX15T512HP KCU40	J103
SPPX15T512MD KCPK10	J103
SPPX15T512MD KCU25	J103
SPPX15T512MD KCU40	J103
SPU421 K68	B171
SPU421 KCP25B	B171
SPU422 K68	B171
SPU422 KCP25B	B171
SPU422T0220 KY1615	B338
SPU423 KCP25B	B171
SR3 KWH	B243–244
SR4	B243
SRACL162D	B243
SRACL164D	B243
SRACL202D	B243
SRACL203D	B243
SRACL204D	B243
SRACL244D	B243
SRACR162D	B243
SRACR163D	B243
SRACR164D	B243
SRACR202D	B243
SRACR203D	B243
SRACR204D	B243
SRACR244D	B243
SRCCL162D	B243
SRCCL163D	B243
SRCCL203D	B243
SRCCR122B	B243
SRCCR123B	B243
SRCCR162D	B243
SRCCR163D	B243
SRCCR203D	B243
SRGCL162	B244
SRGCL203	B244
SRGCR08CA06	B245
SRGCR122	B244
SRGCR12CA10	B245
SRGCR162	B244
SRGCR163	B244
SRGCR203	B244
SROCN102	B244
SROCN122	B244
SROCN123	B244
SROCN162	B244
SROCN163	B244
SROCN203	B244
SRS3	B193–196, B227–229, B259–260, B282, S39, T113
SRS4	B194
SS038DL100375	055
SS038SLDL100225	054
SS050DL100500	055
SS050DL120500	055
SS050SLDL100250	054
SS050SLDL120250	054
SS062DL100625	055
SS062DL120625	055
SS062DL160625	055
SS062SLDL100350	054
SS062SLDL120325	054
SS062SLDL160275	054
SS075DL100750	055
SS075DL120750	055
SS075DL160750	055
SS075DL200750	055
SS075SLDL100450	054
SS075SLDL120425	054
SS075SLDL160325	054
SS075SLDL200300	054
SS100DL161000	055
SS100DL201000	055
SS100DL251000	055

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
SS100SLDL160450	054
SS100SLDL200375	054
SS100SLDL250350	054
SS125DL251000	055
SS125DL321000	055
SS125SLDL250425	054
SS125SLDL320400	054
SS150DL321000	055
SS150SLDL320550	054
SS16KST115AR3M	K42
SS16KST115AR5M	K42
SS200DL321000	055
SS200SLDL320750	054
SS20FBHS24	K139
SS20KST135AR3M	K42
SS20KST135AR5M	K42
SS20KST155AR3M	K42
SS20KST155AR5M	K42
SS20KST175AR3M	K42
SS20KST175AR5M	K42
SS20KST175RR3M	K43
SS20KST175RR5M	K43
SS20KST200AR3M	K42
SS20KST200AR5M	K42
SS20KST200RR3M	K43
SS20KST200RR5M	K43
SS20RBHT24	K124
SS25FBHS31	K139
SS25KST250AR3M	K42
SS25KST250AR5M	K42
SS25KST250RR3M	K43
SS25KST250RR5M	K43
SS25RBHT30	K124
SS32KST300AR3M	K42
SS32KST300AR5M	K42
SS32KST300RR3M	K43
SS32KST300RR5M	K43
SS32KST350AR3M	K42
SS32KST350AR5M	K42
SS32KST350RR3M	K43
SS32KST350RR5M	K43
SSA3T	D71–72, D74–79
SSA4T	D71–72, D74–79
SSA5T	D76, D78–79
SSE075FBHS24	K139
SSE100FBHS31	K139
SSE125FBHS40	K139
SSF150FDS280299	H128
SSF150FDS280502	H128
SSF150FDS280746	H129
SSF150FDS281112	H129
SSF150FDS281356	H129
SSF150FDS320323	H128
SSF150FDS320573	H128
SSF150FDS320850	H129
SSF150FDS321263	H129
SSF150FDS321539	H129
SSF150FDS360362	H128
SSF150FDS360652	H128
SSF150FDS360960	H129
SSF150FDS361421	H129
SSF150FDS361728	H129
SSF150HTS130239	J89
SSF150HTS130450	J89
SSF150HTS130664	J89
SSF150HTS131114	J89
SSF150HTS131764	J89
SSF200FDS400394	H128
SSF200FDS400721	H128
SSF200FDS401066	H129
SSF200FDS401586	H129
SSF200FDS401933	H129
SSF200FDS450441	H128
SSF200FDS450809	H128
SSF200FDS451196	H129
SSF200FDS451775	H129
SSF200FDS452161	H129
SSF200FDS500480	H128
SSF200FDS500896	H128
SSF200FDS501330	H129
SSF200FDS501980	H129
SSF200FDS502413	H129
SSF200FDS560551	H128
SSF200FDS561020	H128
SSF200FDS561507	H129
SSF200FDS562240	H129
SSF200FDS562783	H129
SSF200FDS630606	H128
SSF200FDS631138	H128
SSF200FDS631688	H129
SSF200FDS632515	H129
SSF200FDS633066	H129
SSF200FDS710677	H128
SSF200FDS711150	H128
SSF200FDS711780	H129
SSF200FDS800756	H128
SSF200FDS801287	H128
SSF200FDS801996	H129
SSF200FDS900835	H128
SSF200FDS901425	H128
SSF200FDS902213	H129
SSF200HTS130239	J89
SSF200HTS130450	J89
SSF200HTS130664	J89
SSF200HTS131114	J89
SSF200HTS131764	J89
SSF200HTS160239	J89
SSF200HTS160450	J89
SSF200HTS160714	J89
SSF200HTS161214	J89
SSF200HTS161964	J89
SSF200HTS220297	J89
SSF200HTS220550	J89
SSF200HTS220922	J89
SSF200HTS221572	J89
SSF200HTS222572	J89
SSF200HTS270297	J89
SSF200HTS270550	J89
SSF200HTS271122	J89
SSF200HTS271922	J89
SSF200HTS273122	J89
SSF200HTS320305	J89
SSF200HTS320550	J89
SSF200HTS320805	J89
SSF200HTS321305	J89
SSF200HTS321805	J89
SSF250HTS400355	J89
SSF250HTS400650	J89
SSF250HTS401055	J89
SSF250HTS401555	J89
SSF250HTS402555	J89
SSF300HTS500413	J89
SSF300HTS500700	J89
SSF300HTS501313	J89
SSF300HTS502113	J89
SSF300HTS503113	J89
SSKCL12CA12	B249
SSKCR12CA12	B249
SSKCR16CA12	B249
SSKPR10CA09	B254
SSN2T	D74–75
SSP025016M	B58–60, B67–68, B87–88, B91–92, B98, B109–110, B113, B131, B138, B150–151, B154, B163
SSP025018M	B67–68
SSP8	S104
SSRCL12CA12	B250
SSRCR12CA12	B250
SSRPR10CA09	B254
SSSCL12CA12	B251
SSSCR12CA12	B251
SSSPL10CA09	B255
SSSPR10CA09	B255
SSY3T	D71–72, D74–79
SSY4T	D71–72, D74–79
SSY5T K9	D76, D78–79
STACR062D	B259
STACR082D	B259
STACR103B	B259
STC11	B71, B165, B180, B183–185, B372–373, B379–380, B389–390, B392
STC19	B63–64, B98, B111–112, B172, B376
STC20	B60–64, B66, B69–71, B75–76, B89–90, B92, B96, B98–99, B120, B155, B163, B371–372, B374
STC26	B165, B389
STC27	B183–185, B388–390, B392
STC4	B61–65, B69, B71, B75–76, B89–90, B93, B96, B98, B111–114, B120, B132–139, B143, B152–155, B165, B172–173, B179–184, B188, B373–382, B389–390, B393
STC5	B63, B71, B89–90, B93, B96, B98, B111, B113, B132–137, B163, B172, B179, B373, B376, B378
STC8	B165, B172–173, B179–184, B188, B376–382, B389–390, B393
STC9	B69, B76, B132–133, B135–136, B139, B143, B165, B170, B179, B181–185, B376, B378, B381–382, B388–390, B392–393
STCM11	U28–29, U35–36
STCM20	B74
STCM25	V148–149
STCM32	U28
STCM37	B140–142
STCM38	B72–74, B94, B115–119, B140–142, B174–176, B186–187, B394–398
STCM40	B74, B94, B115–117, B119
STCM8	B74, B115, B119, B186, B397
STCM9	B72–74, B94–95, B115–117, B119, B140–142
STFCL062	B259
STFCR062	B259
STFCR163	B259
STFPL08CA09	B276
STFPL10CA11	B276
STFPL12CA16	B276
STFPR062	B270
STFPR08CA09	B276
STFPR10CA11	B276
STFPR12CA16	B276
STGCL062	B260
STGCL082	B260
STGCL103	B260
STGCL123	B260
STGCL163	B260
STGCR062	B260
STGCR082	B260
STGCR103	B260
STGCR123	B260
STGCR163	B260
STGPL062	B270
STGPL082V	B270
STGPL08CA09	B277
STGPL10CA11	B277
STGPR062	B270
STGPR082V	B270
STGPR10CA11	B277
STGPR12CA16	B277
STJCRF062D	B261
STJCRF082D	B261
STJCRF102B	B261
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	B278
STTPR10CA11	B278
STTPR12CA16	B278
STWPR10CA11	B279
STWPR12CA16	B279
SU3	E65
SUWTCL	E64
SUWTCR	E64
SVABL062D	B282
SVABL082D	B282
SVABL103B	B282
SVABR062D	B282
SVABR082D	B282
SVABR103B	B282
SVJBL062	B282
SVJBL082	B282
SVJBL102	B282
SVJBL123	B282
SVJBL163	B282
SVJBLF062D	B283
SVJBLF082D	B283
SVJBLF103B	B283
SVJBR062	B282
SVJBR082	B282
SVJBR102	B282
SVJBR123	B282
SVJBR163	B282
SVJBRF062D	B283
SVJBRF082D	B283
SVJBRF103B	B283
SVUBL082	B283
SVUBL102	B283
SVUBR082	B283
SVUBR102	B283
SWLCRF082D	B287
SWSM515	S104
SYB115RBHT16LF	K125
SYB24RBHT06F	K125
SYB30RBHT06F	K125
SYB40RBHT09F	K125
SYB50RBHT09F	K125
SYB66RBHT12F	K125
SYB66RBHT12LF	K125
SYB87RBHT12F	K125
SYB87RBHT16LF	K125
T15 S	T127–128, V9–12, V17–19, V102–103, V111–112
T20 S	T131, V111–112
T320M060X100R6HX KC7542	M4
T320M080X125R6HX KC7542	M4
T320M100X150R6HX KC7542	M4
T320M120X175R6HX KC7542	M4
T320M160X200R6HX KC7542	M4
T320MF140X150R6HX KC7542	M4
T320NC03750-16R3BX KC7542	M4

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
T320NC04375-14R3BX KC7542	M4
T320NC05000-13R3BX KC7542	M4
T321M100X150R6HX KC7542	M5
T321M120X175R6HX KC7542	M5
T321M140X200R6HX KC7542	M5
T321M160X200R6HX KC7542	M5
T321MF120X150R6HX KC7542	M5
T321MF140X150R6HX KC7542	M5
T331M060X100R6HX KC7542	M45
T331M080X125R6HX KC7542	M45
T331M100X150R6HX KC7542	M45
T331M120X175R6HX KC7542	M45
T331M140X200R6HX KC7542	M45
T331M160X200R6HX KC7542	M45
T331MF120X150R6HX KC7542	M45
T331MF140X150R6HX KC7542	M45
T331NC2500-20R3BX KC7542	M44
T331NC3125-18R3BX KC7542	M44
T331NC3750-16R3BX KC7542	M44
T331NC4375-14R3BX KC7542	M44
T331NC5000-13R3BX KC7542	M44
T331NF2500-28R3BX KC7542	M44
T340M040X070R6HX KCK17	M109
T340M050X080R6HX KCK17	M109
T340M060X100R6HX KCK17	M109
T340M080X125R6HX KCK17	M109
T340M100X150R6HX KCK17	M109
T340M120X175R6HX KCK17	M109
T340M140X200R6HX KCK17	M109
T340M160X200R6HX KCK17	M109
T340M200X250R6HX KCK17	M109
T340MF100X100R6HX KCK17	M109
T340MF120X150R6HX KCK17	M109
T340MF140X150R6HX KCK17	M109
T340NC#10-24R3BX KCK17	M108
T340NC#6-32R3BX KCK17	M108
T340NC#8-32R3BX KCK17	M108
T340NC02500-20R3BX KCK17	M108
T340NC03125-18R3BX KCK17	M108
T340NC03750-16R3BX KCK17	M108
T340NC05000-13R3BX KCK17	M108
T340NF#10-32R3BX KCK17	M108
T340NF03750-24R3BX KCK17	M108
T340NF05000-20R3BX KCK17	M108
T340NF05625-18R3BX KCK17	M108
T351M040X070R6HX KCK17	M111
T351M050X080R6HX KCK17	M111
T351M060X100R6HX KCK17	M111
T351M060X100R6HX-D1 KCK17	M112
T351M070X100R6HX-D1 KCK17	M112
T351M080X125R6HX KCK17	M111
T351M080X125R6HX-D1 KCK17	M112
T351M090X125R6HX-D1 KCK17	M112
T351M100X150R6HX KCK17	M111
T351M100X150R6HX-D1 KCK17	M112
T351M120X175R6HX KCK17	M111
T351M120X175R6HX-D6 KCK17	M112
T351M140X200R6HX-D6 KCK17	M112
T351M140X200R6HX KCK17	M111
T351M160X200R6HX KCK17	M111
T351MF100X100R6HX KCK17	M111
T351MF100X100R6HX-D4 KCK17	M112
T351MF100X125R6HX-D4 KCK17	M112
T351MF120X125R6HX-D4 KCK17	M112
T351MF120X150R6HX KCK17	M111
T351MF120X150R6HX-D4 KCK17	M112
T351MF140X125R6HX-D4 KCK17	M112
T351MF140X150R6HX KCK17	M111
T351MF140X150R6HX-D4 KCK17	M112
T351NC#6-32R3BX KCK17	M110
T351NC#8-32R3BX KCK17	M110
T351NC02500-20R3BX KCK17	M110
T351NC03125-18R3BX KCK17	M110
T351NC03750-16R3BX KCK17	M110
T351NC04375-14R3BX KCK17	M110
T351NC05000-13R3BX KCK17	M110
T351NC06250-11R3BX KCK17	M110
T351NC07500-10R3BX KCK17	M110
T351NF#10-32R3BX KCK17	M110
T353M040X070R6HX-D1 KCK17	M113
T353M050X080R6HX-D1 KCK17	M113
T353M060X100R6HX-D1 KCK17	M113

Catalog No.	Page(s)
T353M080X125R6HX-D1 KCK17	M113
T353M100X150R6HX-D1 KCK17	M113
T353M120X175R6HX-D6 KCK17	M113
T353M140X200R6HX-D6 KCK17	M113
T410M030X050R6HX-D1 KCU36	M116
T410M040X070R6HX-D1 KCU36	M116
T410M050X080R6HX-D1 KCU36	M116
T410M060X100R6HX-D1 KCU36	M116
T410M080X125R6HX-D1 KCU36	M116
T410M100X150R6HX-D1 KCU36	M116
T410M120X175R6HX-D6 KCU36	M116
T410M140X200R6HX-D6 KCU36	M116
T410MF080X100R6HX-D4 KCU36	M116
T410MF100X100R6HX-D4 KCU36	M116
T410MF120X150R6HX-D4 KCU36	M116
T410MF140X150R6HX-D4 KCU36	M116
T410MF160X150R6HX-D4 KCU36	M116
T471M060X100R6HX KCN14	M114
T471M060X100R6HX-D1 KCN14	M115
T471M080X125R6HX KCN14	M114
T471M080X125R6HX-D1 KCN14	M115
T471M100X150R6HX KCN14	M114
T471M100X150R6HX-D1 KCN14	M115
T471M120X175R6HX KCN14	M114
T471M140X200R6HX KCN14	M114
T491M050X080R6HX KCN14	M138
T491M060X100R6HX KCN14	M138
T491M060X100R6HX-D74 KCN14	M138
T491M080X125R6HX KCN14	M138
T491M080X125R6HX-D74 KCN14	M138
T491M100X150R6HX KCN14	M138
T491M100X150R6HX-D74 KCN14	M138
T491M120X175R6HX KCN14	M138
T600M030X050R6HX-D1 KSP21	M22
T600M040X070R6HX-D1 KSP21	M22
T600M050X080R6HX-D1 KSP21	M22
T600M060X100R6HX-D1 KSP21	M22
T600M080X125R6HX-D1 KSP21	M22
T600M100X150R6HX-D1 KSP21	M22
T600M120X175R6HX-D6 KSP21	M22
T600M140X200R6HX-D6 KSP21	M22
T600M160X200R6HX-D6 KSP21	M22
T600M180X250R6HX-D6 KSP21	M22
T600M200X250R6HX-D6 KSP21	M22
T600MF080X100R6HX-D4 KSP21	M22
T600MF100X100R6HX-D4 KSP21	M22
T600MF100X125R6HX-D4 KSP21	M22
T600MF120X125R6HX-D4 KSP21	M22
T600MF120X150R6HX-D4 KSP21	M22
T600MF140X150R6HX-D4 KSP21	M22
T600MF160X150R6HX-D4 KSP21	M22
T604M030X050R6H-D1 KSH26	M73
T604M040X070R6H-D1 KSH26	M73
T604M050X080R6H-D1 KSH26	M73
T604M060X100R6H-D1 KSH26	M73
T604M080X125R6H-D1 KSH26	M73
T604M100X150R6H-D1 KSH26	M73
T604M120X175R6H-D6 KSH26	M73
T604M140X200R6H-D6 KSH26	M73
T604M160X200R6H-D6 KSH26	M73
T604M180X250R6H-D6 KSH26	M73
T604M200X250R6H-D6 KSH26	M73
T604MF080X100R6H-D4 KSH26	M73
T604MF100X100R6H-D4 KSH26	M73
T604MF100X125R6H-D4 KSH26	M73
T604MF120X125R6H-D4 KSH26	M73
T604MF120X150R6H-D4 KSH26	M73
T604MF140X150R6H-D4 KSH26	M73
T604MF160X150R6H-D4 KSH26	M73
T620M030X050R6HX-A KM6515	M10
T620M030X050R6HX-A KP6525	M10
T620M030X050R6HX-D1 KM6515	M11
T620M030X050R6HX-D1 KP6525	M11
T620M040X070R6HX-A KM6515	M10
T620M040X070R6HX-A KP6525	M10
T620M040X070R6HX-D1 KM6515	M11
T620M040X070R6HX-D1 KP6525	M11
T620M050X080R6HX-A KM6515	M10
T620M050X080R6HX-A KP6525	M10
T620M050X080R6HX-D1 KM6515	M11
T620M050X080R6HX-D1 KP6525	M11
T620M060X100R6HX-A KM6515	M10

Catalog No.	Page(s)
T620M060X100R6HX-A KP6525	M10
T620M060X100R6HX-D1 KM6515	M11
T620M060X100R6HX-D1 KP6525	M11
T620M080X100R6HX-A KP6525	M10
T620M080X125R6HX-A KM6515	M10
T620M080X125R6HX-A KP6525	M10
T620M080X125R6HX-D1 KM6515	M11
T620M080X125R6HX-D1 KP6525	M11
T620M100X150R6HX-A KM6515	M10
T620M100X150R6HX-A KP6525	M10
T620M100X150R6HX-D1 KM6515	M11
T620M100X150R6HX-D1 KP6525	M11
T620M120X175R6HX-A KM6515	M10
T620M120X175R6HX-A KP6525	M10
T620M120X175R6HX-D6 KM6515	M11
T620M120X175R6HX-D6 KP6525	M11
T620M140X200R6HX-D6 KM6515	M11
T620M140X200R6HX-D6 KP6525	M11
T620M160X200R6HX-D6 KM6515	M11
T620M160X200R6HX-D6 KP6525	M11
T620M200X250R6HX-D6 KM6515	M11
T620M200X250R6HX-D6 KP6525	M11
T620M240X300R6H-XL KP6525	M14
T620M240X300R6HX-D6 KP6525	M13
T620M300X350R6H-XL KP6525	M14
T620M300X350R6HX-D6 KP6525	M13
T620M330X350R6H-XL KP6525	M14
T620M330X350R6HX-D6 KP6525	M13
T620M360X400R6H-XL KP6525	M14
T620M360X400R6HX-D6 KP6525	M13
T620M420X450R6H-XL KP6525	M14
T620M420X450R6HX-D6 KP6525	M13
T620MF080X100R6HX-A KM6515	M10
T620MF080X100R6HX-D4 KM6515	M11
T620MF080X100R6HX-D4 KP6525	M11
T620MF100X100R6HX-D4 KM6515	M11
T620MF100X100R6HX-D4 KP6525	M11
T620MF100X125R6HX-D4 KP6525	M11
T620MF120X150R6HX-D4 KM6515	M11
T620MF120X150R6HX-D4 KP6525	M11
T620MF140X150R6HX-D4 KM6515	M11
T620MF140X150R6HX-D4 KP6525	M11
T620MF160X150R6HX-D4 KM6515	M11
T620MF160X150R6HX-D4 KP6525	M11
T620MF180X150R6HX-D4 KM6515	M11
T620MF180X150R6HX-D4 KP6525	M11
T620NC#02-56R2BX-A KM6515	M6
T620NC#02-56R2BX-A KP6525	M6
T620NC#02-56R3BX-A KM6515	M6
T620NC#02-56R3BX-A KP6525	M6
T620NC#04-40R2BX-A KM6515	M6
T620NC#04-40R2BX-A KP6525	M6
T620NC#04-40R3BX-A KM6515	M6
T620NC#04-40R3BX-A KP6525	M6
T620NC#05-40R3BX-A KM6515	M6
T620NC#05-40R3BX-A KP6525	M6
T620NC#06-32R2BX-A KM6515	M6
T620NC#06-32R2BX-A KP6525	M6
T620NC#06-32R2BX-D1 KP6525	M8
T620NC#06-32R3BX-A KM6515	M6
T620NC#06-32R3BX-A KP6525	M6
T620NC#08-32R2BX-A KM6515	M6
T620NC#08-32R2BX-A KP6525	M6
T620NC#08-32R2BX-D1 KP6525	M8
T620NC#08-32R3BX-A KM6515	M6
T620NC#08-32R3BX-A KP6525	M6
T620NC#10-24R2BX-D1 KP6525	M8
T620NC#10-24R3BX-A KM6515	M6
T620NC#10-24R3BX-A KP6525	M6
T620NC#12-24R3BX-A KM6515	M6
T620NC#12-24R3BX-A KP6525	M6
T620NC02500-20R2BX-A KM6515	M6
T620NC02500-20R2BX-A KP6525	M6
T620NC02500-20R3BX-A KM6515	M6
T620NC02500-20R3BX-A KP6525	M6
T620NC02500-20R3BX-D1 KP6525	M8
T620NC03125-18R2BX-A KM6515	M6
T620NC03125-18R2BX-A KP6525	M6
T620NC03125-18R3BX-A KM6515	M6
T620NC03125-18R3BX-A KP6525	M6
T620NC03125-18R3BX-D1 KP6525	M8
T620NC03750-16R2BX-A KM6515	M6

Catalog No.	Page(s)
T620NC03750-16R2BX-A KP6525	M6
T620NC03750-16R3BX-A KM6515	M6
T620NC03750-16R3BX-A KP6525	M6
T620NC03750-16R3BX-D1 KP6525	M8
T620NC04375-14R3BX-A KM6515	M7
T620NC04375-14R3BX-A KP6525	M7
T620NC04375-14R3BX-D6 KP6525	M8
T620NC05000-13R3BX-A KM6515	M7
T620NC05000-13R3BX-A KP6525	M7
T620NC05000-13R3BX-D6 KP6525	M8
T620NC06250-11R3BX-A KM6515	M7
T620NC06250-11R3BX-A KP6525	M7
T620NC07500-10R3BX-A KM6515	M7
T620NC07500-10R3BX-A KP6525	M7
T620NF#06-40R2BX-D1 KP6525	M8
T620NF#08-36R3BX-A KM6515	M6
T620NF#08-36R3BX-A KP6525	M6
T620NF#10-32R2BX-A KM6515	M6
T620NF#10-32R2BX-A KP6525	M6
T620NF#10-32R2BX-D1 KP6525	M8
T620NF#10-32R3BX-A KM6515	M6
T620NF#10-32R3BX-A KP6525	M6
T620NF02500-28R2BX-A KM6515	M6
T620NF02500-28R2BX-A KP6525	M6
T620NF02500-28R3BX-A KM6515	M6
T620NF02500-28R3BX-A KP6525	M6
T620NF02500-28R3BX-D1 KP6525	M8
T620NF03125-24R3BX-A KM6515	M6
T620NF03125-24R3BX-A KP6525	M6
T620NF03125-24R3BX-D1 KP6525	M8
T620NF03750-24R3BX-A KM6515	M6
T620NF03750-24R3BX-A KP6525	M6
T620NF03750-24R3BX-D1 KP6525	M8
T620NF04375-20R3BX-A KM6515	M7
T620NF04375-20R3BX-A KP6525	M7
T620NF04375-20R3BX-D6 KP6525	M8
T620NF05000-20R3BX-A KM6515	M7
T620NF05000-20R3BX-A KP6525	M7
T620NF05000-20R3BX-D6 KP6525	M8
T621M050X080R6HX-D1 KM6515	M12
T621M050X080R6HX-D1 KP6525	M12
T621M060X100R6HX-D1 KM6515	M12
T621M060X100R6HX-D1 KP6525	M12
T621M080X125R6HX-D1 KM6515	M12
T621M080X125R6HX-D1 KP6525	M12
T621M100X150R6HX-D1 KM6515	M12
T621M100X150R6HX-D1 KP6525	M12
T621M120X175R6HX-D6 KM6515	M12
T621M120X175R6HX-D6 KP6525	M12
T621M140X200R6HX-D6 KM6515	M12
T621M140X200R6HX-D6 KP6525	M12
T621M160X200R6HX-D6 KM6515	M12
T621M160X200R6HX-D6 KP6525	M12
T621M180X250R6HX-D6 KM6515	M12
T621M180X250R6HX-D6 KP6525	M12
T621MF080X100R6HX-D4 KM6515	M12
T621MF080X100R6HX-D4 KP6525	M12
T621MF100X100R6HX-D4 KM6515	M12
T621MF100X100R6HX-D4 KP6525	M12
T621MF100X125R6HX-D4 KM6515	M12
T621MF100X125R6HX-D4 KP6525	M12
T621MF120X125R6HX-D4 KP6525	M12
T621MF120X150R6HX-D4 KM6515	M12
T621MF120X150R6HX-D4 KP6525	M12
T621MF140X125R6HX-D4 KP6525	M12
T621MF140X150R6HX-D4 KM6515	M12
T621MF140X150R6HX-D4 KP6525	M12
T621MF160X150R6HX-D4 KM6515	M12
T621MF160X150R6HX-D4 KP6525	M12
T621MF180X150R6HX-D4 KM6515	M12
T621MF180X150R6HX-D4 KP6525	M12
T621NC02500-20R3BX-D1 KP6525	M9
T621NC03125-18R3BX-D1 KP6525	M9
T621NC03750-16R3BX-D1 KP6525	M9
T621NC04375-14R3BX-D6 KP6525	M9
T621NC05000-13R3BX-D6 KP6525	M9
T621NF02500-28R3BX-D1 KP6525	M9
T621NF03125-24R3BX-D1 KP6525	M9
T621NF03750-24R3BX-D1 KP6525	M9
T621NF04375-20R3BX-D6 KP6525	M9
T621NF05000-20R3BX-D6 KP6525	M9
T622M030X050R6HX-D74 KSN28	M139

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
T622M030X050R6HX-D74 KSP21	M139
T622M040X070R6HX-D74 KSN28	M139
T622M040X070R6HX-D74 KSP21	M139
T622M050X080R6HX-D74 KSN28	M139
T622M050X080R6HX-D74 KSP21	M139
T622M060X100R6HX-D74 KSN28	M139
T622M060X100R6HX-D74 KSP21	M139
T622M080X125R6HX-D74 KSN28	M139
T622M080X125R6HX-D74 KSP21	M139
T622M100X150R6HX-D74 KSN28	M139
T622M100X150R6HX-D74 KSP21	M139
T622M120X175R6HX-D74 KSN28	M139
T622M120X175R6HX-D74 KSP21	M139
T622M160X200R6HX-D74 KSN28	M139
T622M160X200R6HX-D74 KSP21	M139
T622MF080X100R6HX-D74 KSN28	M139
T622MF080X100R6HX-D74 KSP21	M139
T622MF100X100R6HX-D74 KSN28	M139
T622MF100X100R6HX-D74 KSP21	M139
T622MF100X125R6HX-D74 KSN28	M139
T622MF100X125R6HX-D74 KSP21	M139
T622MF120X125R6HX-D74 KSN28	M139
T622MF120X125R6HX-D74 KSP21	M139
T622MF120X150R6HX-D74 KSN28	M139
T622MF120X150R6HX-D74 KSP21	M139
T622MF140X150R6HX-D74 KSN28	M139
T622MF140X150R6HX-D74 KSP21	M139
T622MF160X150R6HX-D74 KSN28	M139
T622MF160X150R6HX-D74 KSP21	M139
T623M050X080R6HX-D74 KSN28	M140
T623M050X080R6HX-D74 KSP21	M140
T623M060X100R6HX-D74 KSN28	M140
T623M060X100R6HX-D74 KSP21	M140
T623M080X125R6HX-D74 KSN28	M140
T623M080X125R6HX-D74 KSP21	M140
T623M100X150R6HX-D74 KSN28	M140
T623M100X150R6HX-D74 KSP21	M140
T623M120X175R6HX-D74 KSN28	M140
T623M120X175R6HX-D74 KSP21	M140
T623M160X200R6HX-D74 KSN28	M140
T623M160X200R6HX-D74 KSP21	M140
T623MF080X100R6HX-D74 KSN28	M140
T623MF080X100R6HX-D74 KSP21	M140
T623MF100X100R6HX-D74 KSN28	M140
T623MF100X100R6HX-D74 KSP21	M140
T623MF120X150R6HX-D74 KSN28	M140
T623MF120X150R6HX-D74 KSP21	M140
T623MF140X150R6HX-D74 KSN28	M140
T623MF140X150R6HX-D74 KSP21	M140
T623MF160X150R6HX-D74 KSN28	M140
T623MF160X150R6HX-D74 KSP21	M140
T624M030X050RD5-DA KSP27	M145
T624M040X070RD6-DA KSP27	M145
T624M060X100RD8-DA KSP27	M145
T624M080X125RD9-DA KSP27	M145
T624M100X150RD10-DA KSP27	M145
T624M120X175RD11-DA KSP27	M145
T624M140X200RD12-DA KSP27	M145
T624M160X200RD12-DA KSP27	M145
T624MF100X125RD9-DA KSP27	M145
T624MF120X125RD9-DA KSP27	M145
T624MF120X150RD9-DA KSP27	M145
T624MF140X150RD11-DA KSP27	M145
T624MF160X150RD11-DA KSP27	M145
T624NC#06-32RH3-DA KSP27	M141
T624NC#06-32RH5-DA KSP27	M141
T624NC#08-32RH3-DA KSP27	M141
T624NC#08-32RH5-DA KSP27	M141
T624NC#10-24RH4-DA KSP27	M141
T624NC#10-24RH6-DA KSP27	M141
T624NC02500-20RH4-DA KSP27	M141
T624NC02500-20RH6-DA KSP27	M141
T624NC03125-18RH5-DA KSP27	M141
T624NC03125-18RH7-DA KSP27	M141
T624NC03750-16RH5-DA KSP27	M141
T624NC03750-16RH7-DA KSP27	M141
T624NC05000-13RH5-DA KSP27	M141
T624NC05000-13RH7-DA KSP27	M141
T624NC06250-11RH10-DA KSP27	M141
T624NC06250-11RH7-DA KSP27	M141
T624NC07500-10RH10-DA KSP27	M141
T624NC07500-10RH7-DA KSP27	M141
T624NF#10-32RH4-DA KSP27	M141
T624NF#10-32RH6-DA KSP27	M141
T624NF02500-28RH4-DA KSP27	M141
T624NF02500-28RH6-DA KSP27	M141
T624NF03125-24RH5-DA KSP27	M141
T624NF03125-24RH7-DA KSP27	M141
T624NF03750-24RH5-DA KSP27	M141
T624NF03750-24RH7-DA KSP27	M141
T624NF05000-20RH5-DA KSP27	M141
T624NF05000-20RH7-DA KSP27	M141
T624NF06250-18RH10-DA KSP27	M141
T624NF06250-18RH7-DA KSP27	M141
T624NF07500-16RH10-DA KSP27	M141
T624NF07500-16RH7-DA KSP27	M141
T625M060X100RD8-DA KSP27	M146
T625M080X125RD9-DA KSP27	M146
T625M100X150RD10-DA KSP27	M146
T625M120X175RD11-DA KSP27	M146
T625M140X200RD12-DA KSP27	M146
T625M160X200RD12-DA KSP27	M146
T625MF100X125RD9-DA KSP27	M146
T625MF120X125RD9-DA KSP27	M146
T625MF120X150RD9-DA KSP27	M146
T625MF140X150RD11-DA KSP27	M146
T625MF160X150RD11-DA KSP27	M146
T625NC02500-20RH4-DA KSP27	M142
T625NC02500-20RH6-DA KSP27	M142
T625NC03125-18RH5-DA KSP27	M142
T625NC03125-18RH7-DA KSP27	M142
T625NC03750-16RH5-DA KSP27	M142
T625NC03750-16RH7-DA KSP27	M142
T625NC05000-13RH5-DA KSP27	M142
T625NC05000-13RH7-DA KSP27	M142
T625NC06250-11RH10-DA KSP27	M142
T625NC06250-11RH7-DA KSP27	M142
T625NC07500-10RH10-DA KSP27	M142
T625NC07500-10RH7-DA KSP27	M142
T625NF02500-28RH4-DA KSP27	M142
T625NF02500-28RH6-DA KSP27	M142
T625NF03125-24RH5-DA KSP27	M142
T625NF03125-24RH7-DA KSP27	M142
T625NF03750-24RH5-DA KSP27	M142
T625NF03750-24RH7-DA KSP27	M142
T625NF05000-20RH5-DA KSP27	M142
T625NF05000-20RH7-DA KSP27	M142
T625NF06250-18RH10-DA KSP27	M142
T625NF06250-18RH7-DA KSP27	M142
T625NF07500-16RH10-DA KSP27	M142
T625NF07500-16RH7-DA KSP27	M142
T626M030X050RD5-DA KSP27	M147
T626M035X060RD6-DA KSP27	M147
T626M040X070RD6-DA KSP27	M147
T626M050X080RD7-DA KSP27	M147
T626M060X100RD8-DA KSP27	M147
T626M080X125RD9-DA KSP27	M147
T626M100X150RD10-DA KSP27	M147
T626M120X175RD11-DA KSP27	M147
T626M140X200RD12-DA KSP27	M147
T626M160X200RD12-DA KSP27	M147
T626MF100X125RD9-DA KSP27	M147
T626MF120X125RD9-DA KSP27	M147
T626MF120X150RD9-DA KSP27	M147
T626MF140X150RD11-DA KSP27	M147
T626MF160X150RD11-DA KSP27	M147
T626NC#02-56RH3-DA KSP27	M143
T626NC#03-48RH3-DA KSP27	M143
T626NC#04-40RH3-DA KSP27	M143
T626NC#04-40RH5-DA KSP27	M143
T626NC#06-32RH3-DA KSP27	M143
T626NC#06-32RH5-DA KSP27	M143
T626NC#08-32RH3-DA KSP27	M143
T626NC#08-32RH5-DA KSP27	M143
T626NC#10-24RH4-DA KSP27	M143
T626NC#10-24RH6-DA KSP27	M143
T626NC02500-20RH4-DA KSP27	M143
T626NC02500-20RH6-DA KSP27	M143
T626NC03125-18RH5-DA KSP27	M143
T626NC03125-18RH7-DA KSP27	M143
T626NC03750-16RH5-DA KSP27	M143
T626NC03750-16RH7-DA KSP27	M143
T626NC05000-13RH5-DA KSP27	M143
T626NC05000-13RH7-DA KSP27	M143
T626NC06250-11RH10-DA KSP27	M143
T626NC06250-11RH7-DA KSP27	M143
T626NC07500-10RH10-DA KSP27	M143
T626NC07500-10RH7-DA KSP27	M143
T626NF#10-32RH4-DA KSP27	M143
T626NF#10-32RH6-DA KSP27	M143
T626NF02500-28RH4-DA KSP27	M143
T626NF02500-28RH6-DA KSP27	M143
T626NF03125-24RH5-DA KSP27	M143
T626NF03125-24RH7-DA KSP27	M143
T626NF03750-24RH5-DA KSP27	M143
T626NF03750-24RH7-DA KSP27	M143
T626NF05000-20RH5-DA KSP27	M143
T626NF05000-20RH7-DA KSP27	M143
T626NF06250-18RH10-DA KSP27	M143
T626NF06250-18RH7-DA KSP27	M143
T626NF07500-16RH10-DA KSP27	M143
T626NF07500-16RH7-DA KSP27	M143
T627M060X100RD8-DA KSP27	M148
T627M080X125RD9-DA KSP27	M148
T627M100X150RD10-DA KSP27	M148
T627M120X175RD11-DA KSP27	M148
T627M140X200RD12-DA KSP27	M148
T627M160X200RD12-DA KSP27	M148
T627MF100X125RD9-DA KSP27	M148
T627MF120X125RD9-DA KSP27	M148
T627MF120X150RD9-DA KSP27	M148
T627MF140X150RD11-DA KSP27	M148
T627MF160X150RD11-DA KSP27	M148
T627NC02500-20RH4-DA KSP27	M144
T627NC02500-20RH6-DA KSP27	M144
T627NC03125-18RH5-DA KSP27	M144
T627NC03125-18RH7-DA KSP27	M144
T627NC03750-16RH5-DA KSP27	M144
T627NC03750-16RH7-DA KSP27	M144
T627NC05000-13RH5-DA KSP27	M144
T627NC05000-13RH7-DA KSP27	M144
T627NC06250-11RH10-DA KSP27	M144
T627NC06250-11RH7-DA KSP27	M144
T627NC07500-10RH10-DA KSP27	M144
T627NC07500-10RH7-DA KSP27	M144
T627NF02500-28RH4-DA KSP27	M144
T627NF02500-28RH6-DA KSP27	M144
T627NF03125-24RH5-DA KSP27	M144
T627NF03125-24RH7-DA KSP27	M144
T627NF03750-24RH5-DA KSP27	M144
T627NF03750-24RH7-DA KSP27	M144
T627NF05000-20RH5-DA KSP27	M144
T627NF05000-20RH7-DA KSP27	M144
T627NF06250-18RH10-DA KSP27	M144
T627NF06250-18RH7-DA KSP27	M144
T627NF07500-16RH10-DA KSP27	M144
T627NF07500-16RH7-DA KSP27	M144
T630M030X050R6HX-A KM6515	M49
T630M030X050R6HX-A KP6525	M49
T630M030X050R6HX-D1 KM6515	M50
T630M030X050R6HX-D1 KP6525	M50
T630M040X070R6HX-A KM6515	M49
T630M040X070R6HX-A KP6525	M49
T630M040X070R6HX-D1 KM6515	M50
T630M040X070R6HX-D1 KP6525	M50
T630M050X080R6HX-A KM6515	M49
T630M050X080R6HX-A KP6525	M49
T630M050X080R6HX-D1 KM6515	M50
T630M050X080R6HX-D1 KP6525	M50
T630M060X100R6HX-A KM6515	M49
T630M060X100R6HX-A KP6525	M49
T630M060X100R6HX-D1 KM6515	M50
T630M060X100R6HX-D1 KP6525	M50
T630M080X125R6HX-A KM6515	M49
T630M080X125R6HX-A KP6525	M49
T630M080X125R6HX-D1 KM6515	M50
T630M080X125R6HX-D1 KP6525	M50
T630M100X150R6HX-A KM6515	M49
T630M100X150R6HX-A KP6525	M49
T630M100X150R6HX-D1 KM6515	M50
T630M100X150R6HX-D1 KP6525	M50
T630M120X175R6HX-A KM6515	M49
T630M120X175R6HX-A KP6525	M49
T630M120X175R6HX-D6 KM6515	M50
T630M120X175R6HX-D6 KP6525	M50
T630M140X200R6HX-A KM6515	M49
T630M140X200R6HX-A KP6525	M49
T630M140X200R6HX-D6 KM6515	M50
T630M140X200R6HX-D6 KP6525	M50
T630M160X200R6HX-A KM6515	M49
T630M160X200R6HX-A KP6525	M49
T630M160X200R6HX-D6 KM6515	M50
T630M160X200R6HX-D6 KP6525	M50
T630M180X250R6HX-D6 KM6515	M50
T630M180X250R6HX-D6 KP6525	M50
T630M240X300R6HX-D6 KP6525	M54
T630M240X300R6HX-XL KP6525	M56
T630M300X350R6HX-D6 KP6525	M54
T630M300X350R6HX-XL KP6525	M56
T630M330X350R6HX-D6 KP6525	M54
T630M330X350R6HX-XL KP6525	M56
T630M360X400R6HX-D6 KP6525	M54
T630M360X400R6HX-XL KP6525	M56
T630M420X450R6HX-D6 KP6525	M54
T630M420X450R6HX-XL KP6525	M56
T630MF080X100R6HX-D4 KM6515	M50
T630MF080X100R6HX-D4 KP6525	M50
T630MF100X100R6HX-D4 KM6515	M50
T630MF100X100R6HX-D4 KP6525	M50
T630MF100X125R6HX-D4 KM6515	M50
T630MF100X125R6HX-D4 KP6525	M50
T630MF120X150R6HX-D4 KM6515	M50
T630MF120X150R6HX-D4 KP6525	M50
T630MF140X150R6HX-D4 KM6515	M50
T630MF140X150R6HX-D4 KP6525	M50
T630MF160X150R6HX-D4 KM6515	M50
T630MF160X150R6HX-D4 KP6525	M50
T630MF180X150R6HX-D4 KM6515	M50
T630MF180X150R6HX-D4 KP6525	M50
T630NC#02-56R3BX-A KM6515	M46
T630NC#02-56R3BX-A KP6525	M46
T630NC#04-40R2BX-A KM6515	M46
T630NC#04-40R2BX-A KP6525	M46
T630NC#04-40R3BX-A KM6515	M46
T630NC#04-40R3BX-A KP6525	M46
T630NC#06-32R2BX-A KM6515	M46
T630NC#06-32R2BX-A KP6525	M46
T630NC#06-32R2BX-D1 KP6525	M47
T630NC#06-32R3BX-A KM6515	M46
T630NC#06-32R3BX-A KP6525	M46
T630NC#08-32R2BX-D1 KP6525	M47
T630NC#08-32R3BX-A KM6515	M46
T630NC#08-32R3BX-A KP6525	M46
T630NC#10-24R2BX-D1 KP6525	M47
T630NC#10-24R3BX-A KM6515	M46
T630NC#10-24R3BX-A KP6525	M46
T630NC02500-20R2BX-A KM6515	M46
T630NC02500-20R2BX-A KP6525	M46
T630NC02500-20R3BX-A KM6515	M46
T630NC02500-20R3BX-A KP6525	M46
T630NC02500-20R3BX-D1 KP6525	M47
T630NC03125-18R2BX-A KM6515	M46
T630NC03125-18R2BX-A KP6525	M46
T630NC03125-18R3BX-A KM6515	M46
T630NC03125-18R3BX-A KP6525	M46
T630NC03125-18R3BX-D1 KP6525	M47
T630NC03750-16R2BX-A KM6515	M46
T630NC03750-16R2BX-A KP6525	M46
T630NC03750-16R3BX-A KM6515	M46
T630NC03750-16R3BX-A KP6525	M46
T630NC03750-16R3BX-D1 KP6525	M47
T630NC04375-14R3BX-A KM6515	M46
T630NC04375-14R3BX-A KP6525	M46
T630NC04375-14R3BX-D6 KP6525	M47
T630NC05000-13R2BX-A KM6515	M46
T630NC05000-13R2BX-A KP6525	M46
T630NC05000-13R3BX-A KM6515	M46
T630NC05000-13R3BX-A KP6525	M46
T630NC05000-13R3BX-D6 KP6525	M47
T630NC06250-11R2BX-A KM6515	M46
T630NC06250-11R2BX-A KP6525	M46
T630NC06250-11R3BX-A KM6515	M46
T630NC06250-11R3BX-A KP6525	M46
T630NC07500-10R2BX-A KM6515	M46
T630NC07500-10R2BX-A KP6525	M46
T630NC07500-10R3BX-A KM6515	M46
T630NC07500-10R3BX-A KP6525	M46
T630NC10000-08R3BX-A KM6515	M46

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
T630NC10000-08R3BX-A KP6525	M46
T630NF#06-40R2BX-D1 KP6525	M47
T630NF#10-32R2BX-A KM6515	M46
T630NF#10-32R2BX-A KP6525	M46
T630NF#10-32R2BX-D1 KP6525	M47
T630NF#10-32R3BX-A KM6515	M46
T630NF#10-32R3BX-A KP6525	M46
T630NF02500-28R2BX-A KM6515	M46
T630NF02500-28R2BX-A KP6525	M46
T630NF02500-28R3BX-A KM6515	M46
T630NF02500-28R3BX-A KP6525	M46
T630NF02500-28R3BX-D1 KP6525	M47
T630NF03125-24R2BX-A KM6515	M46
T630NF03125-24R2BX-A KP6525	M46
T630NF03125-24R3BX-A KM6515	M46
T630NF03125-24R3BX-A KP6525	M46
T630NF03125-24R3BX-D1 KP6525	M47
T630NF03750-24R3BX-A KM6515	M46
T630NF03750-24R3BX-A KP6525	M46
T630NF03750-24R3BX-D1 KP6525	M47
T630NF04375-20R3BX-A KM6515	M46
T630NF04375-20R3BX-A KP6525	M46
T630NF04375-20R3BX-D6 KP6525	M47
T630NF05000-20R3BX-A KM6515	M46
T630NF05000-20R3BX-A KP6525	M46
T630NF05000-20R3BX-D6 KP6525	M47
T631M050X080R6HX-D1 KM6515	M51
T631M050X080R6HX-D1 KP6525	M51
T631M060X100R6HX-D1 KM6515	M51
T631M060X100R6HX-D1 KP6525	M51
T631M080X125R6HX-D1 KM6515	M51
T631M080X125R6HX-D1 KP6525	M51
T631M100X150R6HX-D1 KM6515	M51
T631M100X150R6HX-D1 KP6525	M51
T631M120X175R6HX-D6 KM6515	M51
T631M120X175R6HX-D6 KP6525	M51
T631M140X200R6HX-D6 KM6515	M51
T631M140X200R6HX-D6 KP6525	M51
T631M160X200R6HX-D6 KM6515	M51
T631M160X200R6HX-D6 KP6525	M51
T631M180X250R6HX-D6 KM6515	M51
T631M180X250R6HX-D6 KP6525	M51
T631M240X300R6HX-D6 KP6525	M55
T631M240X300R6HX-XL KP6525	M57
T631M300X350R6HX-D6 KP6525	M55
T631M300X350R6HX-XL KP6525	M57
T631M330X350R6HX-D6 KP6525	M55
T631M330X350R6HX-XL KP6525	M57
T631M360X400R6HX-D6 KP6525	M55
T631M360X400R6HX-XL KP6525	M57
T631M420X450R6HX-D6 KP6525	M55
T631M420X450R6HX-XL KP6525	M57
T631MF080X100R6HX-D4 KM6515	M51
T631MF080X100R6HX-D4 KP6525	M51
T631MF100X100R6HX-D4 KM6515	M51
T631MF100X100R6HX-D4 KP6525	M51
T631MF100X125R6HX-D4 KM6515	M51
T631MF100X125R6HX-D4 KP6525	M51
T631MF120X125R6HX-D4 KM6515	M51
T631MF120X125R6HX-D4 KP6525	M51
T631MF120X150R6HX-D4 KM6515	M51
T631MF120X150R6HX-D4 KP6525	M51
T631MF140X125R6HX-D4 KM6515	M51
T631MF140X125R6HX-D4 KP6525	M51
T631MF140X150R6HX-D4 KM6515	M51
T631MF140X150R6HX-D4 KP6525	M51
T631MF160X150R6HX-D4 KM6515	M51
T631MF160X150R6HX-D4 KP6525	M51
T631MF180X150R6HX-D4 KM6515	M51
T631MF180X150R6HX-D4 KP6525	M51
T631NC02500-20R3BX-D1 KP6525	M48
T631NC03125-18R3BX-D1 KP6525	M48
T631NC03750-16R3BX-D1 KP6525	M48
T631NC04375-14R3BX-D6 KP6525	M48
T631NC05000-13R3BX-D6 KP6525	M48
T631NF02500-28R3BX-D1 KP6525	M48
T631NF03125-24R3BX-D1 KP6525	M48
T631NF03750-24R3BX-D1 KP6525	M48
T631NF04375-20R3BX-D6 KP6525	M48
T631NF05000-20R3BX-D6 KP6525	M48
T632M050X080R6HX-D1 KP6525	M52
T632M060X100R6HX-D1 KP6525	M52
T632M080X125R6HX-D1 KP6525	M52
T632M100X150R6HX-D1 KP6525	M52
T632M120X175R6HX-D6 KP6525	M52
T632M140X200R6HX-D6 KP6525	M52
T632MF120X150R6HX-D4 KP6525	M52
T632MF140X150R6HX-D4 KP6525	M52
T632MF160X150R6HX-D4 KP6525	M52
T633M050X080R6HX-D1 KP6525	M53
T633M060X100R6HX-D1 KP6525	M53
T633M080X125R6HX-D1 KP6525	M53
T633M100X150R6HX-D1 KP6525	M53
T633M120X175R6HX-D6 KP6525	M53
T633M140X200R6HX-D6 KP6525	M53
T633MF120X150R6HX-D4 KP6525	M53
T633MF140X150R6HX-D4 KP6525	M53
T633MF160X150R6HX-D4 KP6525	M53
T640M040X070R6HX-D1 KP6525	M120
T640M050X080R6HX-D1 KP6525	M120
T640M060X100R6HX-D1 KP6525	M120
T640M080X125R6HX-D1 KP6525	M120
T640M100X150R6HX-D1 KP6525	M120
T640M120X175R6HX-D6 KP6525	M120
T640M140X200R6HX-D6 KP6525	M120
T640M160X200R6HX-D6 KP6525	M120
T640M180X250R6HX-D6 KP6525	M120
T640M200X250R6HX-D6 KP6525	M120
T640M220X250R6HX-D6 KP6525	M120
T640NC#06-32R2BX-D1 KP6525	M118
T640NC#08-32R2BX-D1 KP6525	M118
T640NC#10-24R2BX-D1 KP6525	M118
T640NC#10-24R3BX-A KP6525	M117
T640NC02500-20R2BX-A KP6525	M117
T640NC02500-20R3BX-A KP6525	M117
T640NC02500-20R3BX-D1 KP6525	M118
T640NC03125-18R2BX-A KP6525	M117
T640NC03125-18R3BX-A KP6525	M117
T640NC03125-18R3BX-D1 KP6525	M118
T640NC03750-16R2BX-A KP6525	M117
T640NC03750-16R3BX-A KP6525	M117
T640NC03750-16R3BX-D1 KP6525	M118
T640NC04375-14R3BX-A KP6525	M117
T640NC04375-14R3BX-D6 KP6525	M118
T640NC05000-13R3BX-A KP6525	M117
T640NC05000-13R3BX-D6 KP6525	M118
T640NC06250-11R3BX-A KP6525	M117
T640NC07500-10R3BX-A KP6525	M117
T640NF#06-40R2BX-D1 KP6525	M118
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T640NF02500-28R3BX-A KP6525	M117
T640NF02500-28R3BX-D1 KP6525	M118
T640NF03125-24R3BX-A KP6525	M117
T640NF03125-24R3BX-D1 KP6525	M118
T640NF03750-24R3BX-A KP6525	M117
T640NF03750-24R3BX-D1 KP6525	M118
T640NF04375-20R3BX-A KP6525	M117
T640NF04375-20R3BX-D6 KP6525	M118
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T640NF05000-20R3BX-D6 KP6525	M118
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T641M200X250R6HX-D6 KP6525	M121
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T641NC03750-16R3BX-D1 KP6525	M119
T641NC04375-14R3BX-D6 KP6525	M119
T641NC05000-13R3BX-D6 KP6525	M119
T641NF02500-28R3BX-D1 KP6525	M119
T641NF03125-24R3BX-D1 KP6525	M119
T641NF03750-24R3BX-D1 KP6525	M119
T641NF04375-20R3BX-D6 KP6525	M119
T641NF05000-20R3BX-D6 KP6525	M119
T642M050X080R6HX-D1 KP6525	M122
T642M060X100R6HX-D1 KP6525	M122
T642M080X125R6HX-D1 KP6525	M122
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T650M240X300R6HX-XL KP6525	M60
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T650M420X450R6HX-XL KP6525	M60
T651M240X300R6HX-D6 KP6525	M59
T651M240X300R6HX-XL KP6525	M61
T651M300X350R6HX-D6 KP6525	M59
T651M300X350R6HX-XL KP6525	M61
T651M330X350R6HX-D6 KP6525	M59
T651M330X350R6HX-XL KP6525	M61
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T651M420X450R6HX-D6 KP6525	M59
T651M420X450R6HX-XL KP6525	M61
T660M025X045RD3-A KSS20	M19
T660M025X045RD3-A KSSM24	M19
T660M030X050RD3-A KSS20	M19
T660M030X050RD3-A KSSM24	M19
T660M040X070RD4-A KSS20	M19
T660M040X070RD4-A KSSM24	M19
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T660M070X100RD5-A KSSM24	M19
T660M080X125RD5-A KSS20	M19
T660M080X125RD5-A KSSM24	M19
T660M100X150RD6-A KSS20	M19
T660M100X150RD6-A KSSM24	M19
T660M120X175RD6-A KSS20	M19
T660M120X175RD6-A KSSM24	M19
T660MF100X125RD5-A KSS20	M19
T660MF100X125RD5-A KSSM24	M19
T660NC#02-56RH2-A KSS20	M18
T660NC#02-56RH2-A KSSM24	M18
T660NC#04-40RH2-A KSS20	M18
T660NC#04-40RH2-A KSSM24	M18
T660NC#06-32RH2-A KSS20	M18
T660NC#06-32RH2-A KSSM24	M18
T660NC#06-32RH3-A KSS20	M18
T660NC#06-32RH3-A KSSM24	M18
T660NC#08-32RH2-A KSS20	M18
T660NC#08-32RH2-A KSSM24	M18
T660NC#08-32RH3-A KSS20	M18
T660NC#08-32RH3-A KSSM24	M18
T660NC#10-24RH3-A KSS20	M18
T660NC#10-24RH3-A KSSM24	M18
T660NC02500-20RH3-A KSS20	M18
T660NC02500-20RH3-A KSSM24	M18
T660NC02500-20RH5-A KSS20	M18
T660NC02500-20RH5-A KSSM24	M18
T660NC03125-18RH3-A KSS20	M18
T660NC03125-18RH3-A KSSM24	M18
T660NC03125-18RH5-A KSS20	M18
T660NC03125-18RH5-A KSSM24	M18
T660NC03750-16RH3-A KSS20	M18
T660NC03750-16RH3-A KSSM24	M18
T660NC03750-16RH5-A KSS20	M18
T660NC03750-16RH5-A KSSM24	M18
T660NC04375-14RH3-A KSS20	M18
T660NC04375-14RH3-A KSSM24	M18
T660NC05000-13RH3-A KSS20	M18
T660NC05000-13RH3-A KSSM24	M18
T660NC06250-11RH3-A KSSM24	M18
T660NC07500-10RH5-A KSSM24	M18
T660NC10000-08RH5-A KSSM24	M18
T660NF#06-40RH2-A KSS20	M18
T660NF#06-40RH2-A KSSM24	M18
T660NF#08-36RH2-A KSS20	M18
T660NF#08-36RH2-A KSSM24	M18
T660NF#10-32RH2-A KSS20	M18
T660NF#10-32RH2-A KSSM24	M18
T660NF#10-32RH3-A KSS20	M18
T660NF#10-32RH3-A KSSM24	M18
T660NF02500-28RH3-A KSS20	M18
T660NF02500-28RH3-A KSSM24	M18
T660NF02500-28RH4-A KSS20	M18
T660NF02500-28RH4-A KSSM24	M18
T660NF03125-24RH3-A KSS20	M18
T660NF03125-24RH3-A KSSM24	M18
T660NF03125-24RH4-A KSS20	M18
T660NF03125-24RH4-A KSSM24	M18
T660NF03750-24RH3-A KSS20	M18
T660NF03750-24RH3-A KSSM24	M18
T660NF03750-24RH4-A KSS20	M18
T660NF03750-24RH4-A KSSM24	M18
T660NF04375-20RH3-A KSS20	M18
T660NF04375-20RH3-A KSSM24	M18
T660NF05000-20RH3-A KSS20	M18
T660NF05000-20RH3-A KSSM24	M18
T660NF05625-18RH3-A KSSM24	M18
T660NF05625-18RH5-A KSSM24	M18
T660NF06250-18RH3-A KSSM24	M18
T660NF06250-18RH5-A KSSM24	M18
T660NF07500-16RH3-A KSSM24	M18
T660NF07500-16RH5-A KSSM24	M18
T662M025X045RD3-A KSS20	M68
T662M025X045RD3-A KSSM24	M68
T662M030X050RD3-A KSS20	M68
T662M030X050RD3-A KSSM24	M68
T662M040X070RD4-A KSS20	M68
T662M040X070RD4-A KSSM24	M68
T662M050X080RD4-A KSS20	M68
T662M050X080RD4-A KSSM24	M68
T662M060X100RD5-A KSS20	M68
T662M060X100RD5-A KSSM24	M68
T662M070X100RD5-A KSS20	M68
T662M070X100RD5-A KSSM24	M68
T662M080X125RD5-A KSS20	M68
T662M080X125RD5-A KSSM24	M68
T662M100X150RD6-A KSS20	M68
T662M100X150RD6-A KSSM24	M68
T662M120X175RD6-A KSS20	M68
T662M120X175RD6-A KSSM24	M68
T662MF100X125RD5-A KSS20	M68
T662MF100X125RD5-A KSSM24	M68
T662NC#02-56RH2-A KSS20	M66
T662NC#02-56RH2-A KSSM24	M66
T662NC#04-40RH2-A KSS20	M66
T662NC#04-40RH2-A KSSM24	M66
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T662NC#06-32RH2-A KSSM24	M66
T662NC#06-32RH3-A KSS20	M66
T662NC#06-32RH3-A KSSM24	M66
T662NC#08-32RH2-A KSS20	M66
T662NC#08-32RH2-A KSSM24	M66
T662NC#08-32RH3-A KSS20	M66
T662NC#08-32RH3-A KSSM24	M66
T662NC#10-24RH3-A KSS20	M66
T662NC#10-24RH3-A KSSM24	M66
T662NC02500-20RH3-A KSS20	M66
T662NC02500-20RH3-A KSSM24	M66
T662NC02500-20RH5-A KSS20	M66
T662NC02500-20RH5-A KSSM24	M66
T662NC03125-18RH3-A KSS20	M66
T662NC03125-18RH3-A KSSM24	M66
T662NC03125-18RH5-A KSS20	M66
T662NC03125-18RH5-A KSSM24	M66
T662NC03750-16RH3-A KSS20	M66
T662NC03750-16RH3-A KSSM24	M66
T662NC03750-16RH5-A KSS20	M66
T662NC03750-16RH5-A KSSM24	M66

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
T662NC04375-14RH3-A KSS20	M66
T662NC04375-14RH3-A KSSM24	M66
T662NC04375-14RH5-A KSS20	M66
T662NC04375-14RH5-A KSSM24	M66
T662NC05000-13RH3-A KSS20	M67
T662NC05000-13RH3-A KSSM24	M67
T662NC05000-13RH5-A KSS20	M67
T662NC05000-13RH5-A KSSM24	M67
T662NC06250-11RH3-A KSSM24	M67
T662NC07500-10RH5-A KSSM24	M67
T662NC10000-08RH5-A KSSM24	M67
T662NF#06-40RH2-A KSS20	M66
T662NF#06-40RH2-A KSSM24	M66
T662NF#08-36RH2-A KSS20	M66
T662NF#08-36RH2-A KSSM24	M66
T662NF#10-32RH2-A KSS20	M66
T662NF#10-32RH2-A KSSM24	M66
T662NF#10-32RH3-A KSS20	M66
T662NF#10-32RH3-A KSSM24	M66
T662NF02500-28RH3-A KSS20	M66
T662NF02500-28RH3-A KSSM24	M66
T662NF02500-28RH4-A KSS20	M66
T662NF02500-28RH4-A KSSM24	M66
T662NF02500-28RH5-A KSS20	M66
T662NF02500-28RH5-A KSSM24	M66
T662NF03125-24RH3-A KSS20	M66
T662NF03125-24RH3-A KSSM24	M66
T662NF03125-24RH4-A KSS20	M66
T662NF03125-24RH4-A KSSM24	M66
T662NF03750-24RH3-A KSS20	M66
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T662NF03750-24RH4-A KSS20	M66
T662NF03750-24RH4-A KSSM24	M66
T662NF04375-20RH3-A KSS20	M66
T662NF04375-20RH3-A KSSM24	M66
T662NF04375-20RH5-A KSS20	M66
T662NF04375-20RH5-A KSSM24	M66
T662NF05000-20RH3-A KSS20	M67
T662NF05000-20RH3-A KSSM24	M67
T662NF05000-20RH5-A KSS20	M67
T662NF05000-20RH5-A KSSM24	M67
T662NF05625-18RH3-A KSSM24	M67
T662NF05625-18RH5-A KSSM24	M67
T662NF06250-18RH3-A KSSM24	M67
T662NF06250-18RH5-A KSSM24	M67
T662NF07500-16RH3-A KSSM24	M67
T662NF07500-16RH5-A KSSM24	M67
T672M030X050R6H-DA KSMN34	M21
T672M035X060R6H-DA KSMN34	M21
T672M040X070R6H-DA KSMN34	M21
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T672MF120X150R6H-DA KSMN34	M21
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T672NC#04-40R3B-DA KSMN34	M20
T672NC#05-40R3B-DA KSMN34	M20
T672NC#06-32R2B-DA KSMN34	M20
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T672NC02500-20R3B-DA KSMN34	M20
T672NC03125-18R2B-DA KSMN34	M20
T672NC03125-18R3B-DA KSMN34	M20
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T672NF03125-24R3B-DA KSMN34	M20
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T682NC03125-18R3B-DA KSMN34	M69
T682NC03750-16R2B-DA KSMN34	M69
T682NC03750-16R3B-DA KSMN34	M69
T682NC04375-14R2B-DA KSMN34	M69
T682NC04375-14R3B-DA KSMN34	M69
T682NC05000-13R2B-DA KSMN34	M69
T682NC05000-13R3B-DA KSMN34	M69
T682NF#10-32R2B-DA KSMN34	M69
T682NF02500-28R2B-DA KSMN34	M69
T682NF02500-28R3B-DA KSMN34	M69
T682NF03125-24R2B-DA KSMN34	M69
T682NF03125-24R3B-DA KSMN34	M69
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T682NF04375-20R2B-DA KSMN34	M69
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T682NF05000-20R3B-DA KSMN34	M69
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T686M080X125R6H-DA KSMN34	M72
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T686NC03125-18R3B-DA KSMN34	M71
T686NC03750-16R3B-DA KSMN34	M71
T686NC04375-14R3B-DA KSMN34	M71
T686NC05000-13R3B-DA KSMN34	M71
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T686NF04375-20R3B-DA KSMN34	M71
T686NF05000-20R3B-DA KSMN34	M71
T690M025X045RD3-A KSP27	M17
T690M025X045RD3-A KSS29	M17
T690M030X050RD3-A KSP27	M17
T690M030X050RD3-A KSS29	M17
T690M035X060RD4-A KSP27	M17
T690M035X060RD4-A KSS29	M17
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T690M040X070RD4-A KSS29	M17
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T690M060X100RD5-A KSS29	M17
T690M080X125RD5-A KSP27	M17
T690M080X125RD5-A KSS29	M17
T690M100X150RD6-A KSP27	M17
T690M100X150RD6-A KSS29	M17
T690M120X175RD6-A KSP27	M17
T690M120X175RD6-A KSS29	M17
T690MF080X100RD5-A KSP27	M17
T690MF080X100RD5-A KSS29	M17
T690NC#02-56RH2-A KSP27	M15
T690NC#02-56RH2-A KSS29	M15
T690NC#04-40RH2-A KSP27	M15
T690NC#04-40RH2-A KSS29	M15
T690NC#04-40RH3-A KSP27	M15
T690NC#04-40RH3-A KSS29	M15
T690NC#04-40RH4-A KSS29	M15
T690NC#05-40RH2-A KSP27	M15
T690NC#05-40RH2-A KSS29	M15
T690NC#06-32RH3-A KSP27	M15
T690NC#06-32RH3-A KSS29	M15
T690NC#06-32RH5-A KSP27	M15
T690NC#06-32RH5-A KSS29	M15
T690NC#08-32RH3-A KSP27	M15
T690NC#08-32RH3-A KSS29	M15
T690NC#08-32RH4-A KSP27	M15
T690NC#08-32RH4-A KSS29	M15
T690NC#08-32RH5-A KSS29	M15
T690NC#08-32RH6-A KSS29	M15
T690NC#10-24RH3-A KSP27	M15
T690NC#10-24RH3-A KSS29	M15
T690NC#10-24RH5-A KSS29	M15
T690NC02500-20RH3-A KSP27	M15
T690NC02500-20RH3-A KSS29	M15
T690NC02500-20RH5-A KSP27	M15
T690NC02500-20RH5-A KSS29	M15
T690NC03125-18RH3-A KSP27	M15
T690NC03125-18RH3-A KSS29	M15
T690NC03125-18RH5-A KSP27	M15
T690NC03125-18RH5-A KSS29	M15
T690NC03125-18RH7-A KSS29	M15
T690NC03750-16RH3-A KSP27	M16
T690NC03750-16RH3-A KSS29	M16
T690NC03750-16RH5-A KSP27	M16
T690NC03750-16RH5-A KSS29	M16
T690NC03750-16RH7-A KSS29	M16
T690NC04375-14RH3-A KSP27	M16
T690NC04375-14RH3-A KSS29	M16
T690NC05000-13RH3-A KSP27	M16
T690NC05000-13RH3-A KSS29	M16
T690NC05000-13RH5-A KSS29	M16
T690NC05000-13RH7-A KSS29	M16
T690NC06250-11RH3-A KSP27	M16
T690NC06250-11RH3-A KSS29	M16
T690NC07500-10RH3-A KSS29	M16
T690NF#04-48RH2-A KSP27	M15
T690NF#04-48RH2-A KSS29	M15
T690NF#06-40RH2-A KSS29	M15
T690NF#10-32RH2-A KSP27	M15
T690NF#10-32RH2-A KSS29	M15
T690NF#10-32RH3-A KSP27	M15
T690NF#10-32RH3-A KSS29	M15
T690NF#10-32RH4-A KSP27	M15
T690NF#10-32RH4-A KSS29	M15
T690NF#10-32RH5-A KSP27	M15
T690NF#10-32RH5-A KSS29	M15
T690NF#10-32RH6-A KSP27	M15
T690NF#10-32RH6-A KSS29	M15
T690NF02500-28RH3-A KSP27	M15
T690NF02500-28RH3-A KSS29	M15
T690NF02500-28RH4-A KSP27	M15
T690NF02500-28RH4-A KSS29	M15
T690NF02500-28RH5-A KSP27	M15
T690NF02500-28RH5-A KSS29	M15
T690NF02500-28RH6-A KSP27	M15
T690NF02500-28RH6-A KSS29	M15
T690NF02500-28RH7-A KSS29	M15
T690NF03125-24RH3-A KSP27	M15
T690NF03125-24RH3-A KSS29	M15
T690NF03125-24RH4-A KSS29	M15
T690NF03125-24RH5-A KSS29	M16
T690NF03125-24RH6-A KSS29	M16
T690NF03125-24RH7-A KSS29	M16
T690NF03750-24RH3-A KSP27	M16
T690NF03750-24RH3-A KSS29	M16
T690NF03750-24RH4-A KSS29	M16
T690NF03750-24RH5-A KSS29	M16
T690NF03750-24RH6-A KSS29	M16
T690NF03750-24RH7-A KSS29	M16
T690NF04375-20RH3-A KSP27	M16
T690NF04375-20RH3-A KSS29	M16
T690NF04375-20RH5-A KSP27	M16
T690NF04375-20RH5-A KSS29	M16
T690NF05000-20RH3-A KSP27	M16
T690NF05000-20RH3-A KSS29	M16
T690NF05000-20RH5-A KSS29	M16
T690NF05000-20RH7-A KSS29	M16
T690NF06250-18RH3-A KSP27	M16
T690NF06250-18RH3-A KSS29	M16
T690NF07500-16RH3-A KSS29	M16
T692M025X045RD3-A KSP27	M64
T692M025X045RD3-A KSS29	M64
T692M030X050RD3-A KSP27	M64
T692M030X050RD3-A KSS29	M64
T692M040X070RD4-A KSP27	M64
T692M040X070RD4-A KSS29	M64
T692M050X080RD4-A KSP27	M64
T692M050X080RD4-A KSS29	M64
T692M060X100RD5-A KSP27	M64
T692M060X100RD5-A KSS29	M64
T692M080X125RD5-A KSP27	M64
T692M080X125RD5-A KSS29	M64
T692M100X150RD6-A KSP27	M64
T692M100X150RD6-A KSS29	M64
T692M120X175RD6-A KSP27	M64
T692M120X175RD6-A KSS29	M64
T692MF080X100RD5-A KSP27	M64
T692MF080X100RD5-A KSS29	M64
T692MF100X125RD5-A KSP27	M64
T692MF100X125RD5-A KSS29	M64
T692NC#02-56RH2-A KSP27	M62
T692NC#02-56RH2-A KSS29	M62
T692NC#03-48RH2-A KSS29	M62
T692NC#04-40RH2-A KSP27	M62
T692NC#04-40RH2-A KSS29	M62
T692NC#04-40RH3-A KSP27	M62
T692NC#04-40RH3-A KSS29	M62
T692NC#05-40RH2-A KSS29	M62
T692NC#06-32RH2-A KSS29	M62
T692NC#06-32RH3-A KSP27	M62
T692NC#06-32RH3-A KSS29	M62
T692NC#06-32RH5-A KSS29	M62
T692NC#06-32RH7-A KSP27	M62
T692NC#06-32RH7-A KSS29	M62
T692NC#08-32RH2-A KSS29	M62
T692NC#08-32RH3-A KSP27	M62
T692NC#08-32RH3-A KSS29	M62
T692NC#08-32RH4-A KSP27	M62
T692NC#08-32RH4-A KSS29	M62
T692NC#08-32RH5-A KSP27	M62
T692NC#08-32RH5-A KSS29	M62
T692NC#08-32RH6-A KSS29	M62
T692NC#10-24RH3-A KSS29	M62
T692NC#10-24RH5-A KSP27	M62
T692NC#10-24RH5-A KSS29	M62
T692NC02500-20RH3-A KSP27	M62
T692NC02500-20RH3-A KSS29	M62
T692NC02500-20RH5-A KSS29	M62
T692NC03125-18RH3-A KSP27	M62
T692NC03125-18RH3-A KSS29	M62
T692NC03125-18RH5-A KSP27	M62
T692NC03125-18RH5-A KSS29	M62
T692NC03125-18RH7-A KSS29	M62
T692NC03750-16RH3-A KSP27	M63
T692NC03750-16RH3-A KSS29	M63
T692NC03750-16RH5-A KSP27	M63
T692NC03750-16RH5-A KSS29	M63
T692NC04375-14RH3-A KSS29	M63
T692NC04375-14RH5-A KSS29	M63
T692NC05000-13RH3-A KSP27	M63
T692NC05000-13RH3-A KSS29	M63
T692NC05000-13RH5-A KSP27	M63
T692NC05000-13RH5-A KSS29	M63
T692NC06250-11RH3-A KSP27	M63
T692NC06250-11RH3-A KSS29	M63
T692NC06250-11RH5-A KSS29	M63
T692NC06250-11RH7-A KSS29	M63
T692NC07500-10RH3-A KSS29	M63

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
T692NC07500-10RH5-A KSS29	M63
T692NF#04-40RH5-A KSS29	M62
T692NF#06-40RH2-A KSS29	M62
T692NF#10-32RH2-A KSP27	M62
T692NF#10-32RH2-A KSS29	M62
T692NF#10-32RH3-A KSP27	M62
T692NF#10-32RH3-A KSS29	M62
T692NF#10-32RH5-A KSS29	M62
T692NF#10-32RH7-A KSS29	M62
T692NF02500-28RH3-A KSP27	M62
T692NF02500-28RH3-A KSS29	M62
T692NF02500-28RH5-A KSS29	M62
T692NF02500-28RH6-A KSS29	M62
T692NF02500-28RH7-A KSS29	M62
T692NF03125-24RH3-A KSP27	M62
T692NF03125-24RH3-A KSS29	M62
T692NF03125-24RH4-A KSS29	M63
T692NF03125-24RH5-A KSS29	M63
T692NF03125-24RH6-A KSS29	M63
T692NF03125-24RH7-A KSS29	M63
T692NF03750-24RH3-A KSP27	M63
T692NF03750-24RH3-A KSS29	M63
T692NF03750-24RH4-A KSP27	M63
T692NF03750-24RH4-A KSS29	M63
T692NF03750-24RH5-A KSP27	M63
T692NF03750-24RH5-A KSS29	M63
T692NF03750-24RH6-A KSS29	M63
T692NF04375-20RH3-A KSP27	M63
T692NF04375-20RH3-A KSS29	M63
T692NF04375-20RH5-A KSS29	M63
T692NF05000-20RH3-A KSP27	M63
T692NF05000-20RH3-A KSS29	M63
T692NF05000-20RH5-A KSP27	M63
T692NF05000-20RH5-A KSS29	M63
T692NF05000-20RH7-A KSS29	M63
T692NF06250-18RH3-A KSS29	M63
T692NF07500-16RH3-A KSS29	M63
T692NF07500-16RH5-A KSS29	M63
T694NC#04-40RH2-A KSP27	M65
T694NC#04-40RH2-A KSS29	M65
T694NC#04-40RH3-A KSS29	M65
T694NC#05-40RH2-A KSS29	M65
T694NC#06-32RH3-A KSP27	M65
T694NC#06-32RH3-A KSS29	M65
T694NC#06-32RH5-A KSS29	M65
T694NC#08-32RH3-A KSP27	M65
T694NC#08-32RH3-A KSS29	M65
T694NC#10-24RH3-A KSP27	M65
T694NC#10-24RH3-A KSS29	M65
T694NC02500-20RH3-A KSP27	M65
T694NC02500-20RH3-A KSS29	M65
T694NC02500-20RH5-A KSS29	M65
T694NC03125-18RH3-A KSP27	M65
T694NC03125-18RH3-A KSS29	M65
T694NC03750-16RH3-A KSP27	M65
T694NC03750-16RH3-A KSS29	M65
T694NC03750-16RH5-A KSS29	M65
T694NC04375-14RH5-A KSS29	M65
T694NC05000-13RH5-A KSS29	M65
T694NC06250-11RH3-A KSP27	M65
T694NC06250-11RH3-A KSS29	M65
T694NF#06-40RH2-A KSS29	M65
T694NF#10-32RH3-A KSP27	M65
T694NF#10-32RH3-A KSS29	M65
T694NF02500-28RH3-A KSP27	M65
T694NF02500-28RH3-A KSS29	M65
T694NF02500-28RH4-A KSS29	M65
T694NF03125-24RH3-A KSP27	M65
T694NF03125-24RH3-A KSS29	M65
T694NF03125-24RH4-A KSS29	M65
T694NF03750-24RH3-A KSP27	M65
T694NF03750-24RH3-A KSS29	M65
T694NF03750-24RH4-A KSS29	M65
T694NF04375-20RH3-A KSP27	M65
T694NF04375-20RH3-A KSS29	M65
T694NF04375-20RH5-A KSS29	M65
T694NF05000-20RH5-A KSS29	M65
T694NF06250-18RH3-A KSP27	M65
T694NF06250-18RH3-A KSS29	M65
T820M020X040R6G-D1 KSP39	M31
T820M020X040R6H-D1 KSP32	M31
T820M020X040R6H-D1 KSP39	M31
T820M025X045R6G-D1 KSP39	M31
T820M025X045R6H-D1 KSP39	M31
T820M030X050R6G-D1 KSP39	M31
T820M030X050R6H-D1 KSP32	M31
T820M030X050R6H-D1 KSP39	M31
T820M030X050R6H-J KSU30	M33
T820M030X050R6H-J KSU31	M33
T820M030X050RD3-A KSMN34	M29
T820M030X050RD3-A KSP32	M29
T820M030X050RD3-A KSP39	M29
T820M035X060R6H-D1 KSP39	M31
T820M035X060RD4-A KSP39	M29
T820M040X070R6G-D1 KSP39	M31
T820M040X070R6H-D1 KSP32	M31
T820M040X070R6H-D1 KSP39	M31
T820M040X070R6H-J KSU30	M33
T820M040X070R6H-J KSU31	M33
T820M040X070RD4-A KSMN34	M29
T820M040X070RD4-A KSP32	M29
T820M040X070RD4-A KSP39	M29
T820M050X080R6G-D1 KSP39	M31
T820M050X080R6H-D1 KSP32	M31
T820M050X080R6H-D1 KSP39	M31
T820M050X080R6H-J KSU30	M33
T820M050X080R6H-J KSU31	M33
T820M050X080RD4-A KSMN34	M29
T820M050X080RD4-A KSP32	M29
T820M050X080RD4-A KSP39	M29
T820M060X100R6G-D1 KSP39	M31
T820M060X100R6H-D1 KSP32	M31
T820M060X100R6H-D1 KSP39	M31
T820M060X100R6H-D6 KSP39	M31
T820M060X100R6H-J KSU30	M33
T820M060X100R6H-J KSU31	M33
T820M060X100RD5-A KSMN34	M29
T820M060X100RD5-A KSP32	M29
T820M060X100RD5-A KSP39	M29
T820M070X100R6G-D1 KSP39	M31
T820M070X100R6H-D1 KSP32	M31
T820M070X100R6H-D1 KSP39	M31
T820M070X100RD5-A KSP39	M29
T820M080X125R6G-D1 KSP39	M31
T820M080X125R6H-D1 KSP32	M31
T820M080X125R6H-D1 KSP39	M31
T820M080X125R6H-D6 KSP39	M31
T820M080X125R6H-J KSU30	M33
T820M080X125R6H-J KSU31	M33
T820M080X125RD5-A KSMN34	M29
T820M080X125RD5-A KSP32	M29
T820M080X125RD5-A KSP39	M29
T820M100X150R6G-D1 KSP39	M32
T820M100X150R6H-D1 KSP32	M31
T820M100X150R6H-D1 KSP39	M31
T820M100X150R6H-D6 KSP39	M31
T820M100X150R6H-J KSU30	M33
T820M100X150R6H-J KSU31	M33
T820M100X150RD6-A KSMN34	M29
T820M100X150RD6-A KSP32	M29
T820M100X150RD6-A KSP39	M29
T820M120X175R6G-D6 KSP39	M32
T820M120X175R6H-D6 KSP32	M32
T820M120X175R6H-D6 KSP39	M32
T820M120X175R6H-J KSU30	M33
T820M120X175RD6-A KSMN34	M29
T820M120X175RD6-A KSP32	M29
T820M120X175RD6-A KSP39	M29
T820M140X200R6G-D6 KSP39	M32
T820M140X200R6H-D6 KSP32	M32
T820M140X200R6H-D6 KSP39	M32
T820M140X200R6H-J KSU30	M33
T820M140X200RD7-A KSP39	M29
T820M160X200R6G-D6 KSP39	M32
T820M160X200R6H-D6 KSP32	M32
T820M160X200R6H-D6 KSP39	M32
T820M160X200R6H-J KSU30	M33
T820M160X200RD7-A KSMN34	M29
T820M160X200RD7-A KSP32	M29
T820M160X200RD7-A KSP39	M29
T820M180X250R6H-D6 KSP32	M32
T820M180X250R6H-D6 KSP39	M32
T820M180X250R6H-J KSU30	M33
T820M200X250R6H-D6 KSP32	M32
T820M200X250R6H-D6 KSP39	M32
T820M200X250R6H-J KSU30	M33
T820M220X250R6H-D6 KSP39	M32
T820M240X300R6H-D6 KSP39	M32
T820M270X300R6H-D6 KSP39	M32
T820M300X350R6H-D6 KSP39	M32
T820M330X350R6H-D6 KSP39	M32
T820M360X400R6H-D6 KSP39	M32
T820MF040X050R6H-D4 KSP39	M31
T820MF050X050R6H-D4 KSP39	M31
T820MF060X050R6H-D4 KSP39	M31
T820MF060X075R6H-D4 KSP39	M31
T820MF080X100R6H-D4 KSP39	M31
T820MF080X100RD5-A KSP39	M29
T820MF100X100R6H-D4 KSP39	M31
T820MF100X125R6H-D4 KSP39	M31
T820MF100X125RD5-A KSP39	M29
T820MF120X100R6H-D4 KSP39	M32
T820MF120X125R6H-D4 KSP39	M32
T820MF120X125R6H-J KSU30	M33
T820MF120X125RD6-A KSP39	M29
T820MF120X150R6H-D4 KSP39	M32
T820MF120X150R6H-J KSU30	M33
T820MF120X150RD6-A KSP39	M29
T820MF140X100R6H-D4 KSP39	M32
T820MF140X125R6H-D4 KSP39	M32
T820MF140X150R6H-D4 KSP39	M32
T820MF140X150R6H-J KSU30	M33
T820MF140X150RD6-A KSP39	M29
T820MF160X100R6H-D4 KSP39	M32
T820MF160X150R6H-D4 KSP39	M32
T820MF160X150R6H-J KSU30	M33
T820MF160X150RD6-A KSMN34	M29
T820MF160X150RD6-A KSP39	M29
T820MF180X150R6H-D4 KSP39	M32
T820MF180X200R6H-D4 KSP39	M32
T820MF200X150R6H-D4 KSP39	M32
T820MF200X200R6H-D4 KSP39	M32
T820MF220X150R6H-D4 KSP39	M32
T820MF220X200R6H-D4 KSP39	M32
T820MF240X150R6H-D4 KSP39	M32
T820NC#02-56RH2-A KSP39	M23
T820NC#02-56RH3-A KSP39	M23
T820NC#02-56RH4-A KSP39	M23
T820NC#03-48RH2-A KSP39	M23
T820NC#04-40R2B-D1 KSP39	M26
T820NC#04-40R3B-D1 KSP39	M27
T820NC#04-40RH2-A KSMN34	M23
T820NC#04-40RH2-A KSP32	M23
T820NC#04-40RH2-A KSP39	M23
T820NC#04-40RH2-XL4 KSP39	M34
T820NC#04-40RH2-XL6 KSP39	M35
T820NC#04-40RH3-A KSP39	M23
T820NC#04-40RH4-A KSP39	M23
T820NC#04-40RH5-A KSP32	M23
T820NC#04-40RH5-A KSP39	M23
T820NC#04-40RH6-A KSP39	M23
T820NC#05-40R2B-D1 KSP39	M26
T820NC#05-40RH2-A KSP39	M23
T820NC#06-32R2B-D1 KSP39	M26
T820NC#06-32R3B-D1 KSP39	M27
T820NC#06-32RH2-A KSP39	M23
T820NC#06-32RH3-A KSMN34	M23
T820NC#06-32RH3-A KSP32	M23
T820NC#06-32RH3-A KSP39	M23
T820NC#06-32RH3-XL4 KSP39	M34
T820NC#06-32RH3-XL6 KSP39	M35
T820NC#06-32RH4-A KSP39	M23
T820NC#06-32RH5-A KSP39	M23
T820NC#06-32RH6-A KSP39	M23
T820NC#06-32RH7-A KSP39	M23
T820NC#08-32R2B-D1 KSP39	M26
T820NC#08-32R3B-D1 KSP39	M27
T820NC#08-32RH2-A KSP39	M23
T820NC#08-32RH3-A KSMN34	M23
T820NC#08-32RH3-A KSP32	M23
T820NC#08-32RH3-A KSP39	M23
T820NC#08-32RH3-XL4 KSP39	M34
T820NC#08-32RH3-XL6 KSP39	M35
T820NC#08-32RH4-A KSP32	M23
T820NC#08-32RH5-A KSP39	M23
T820NC#08-32RH6-A KSP39	M23
T820NC#08-32RH7-A KSP39	M23
T820NC#10-24R2B-D1 KSP39	M26
T820NC#10-24RH3-A KSMN34	M24
T820NC#10-24RH3-A KSP32	M24
T820NC#10-24RH3-A KSP39	M24
T820NC#10-24RH3-XL6 KSP39	M35
T820NC#10-24RH4-XL4 KSP39	M34
T820NC#10-24RH5-A KSP39	M24
T820NC#10-24RH7-A KSP39	M24
T820NC02500-20R2B-D1 KSP39	M26
T820NC02500-20RH2-A KSP39	M24
T820NC02500-20RH3-A KSMN34	M24
T820NC02500-20RH3-A KSP32	M24
T820NC02500-20RH3-A KSP39	M24
T820NC02500-20RH3-XL4 KSP39	M34
T820NC02500-20RH3-XL6 KSP39	M35
T820NC02500-20RH5-A KSP39	M24
T820NC02500-20RH7-A KSP39	M24
T820NC03125-18R2B-D1 KSP39	M26
T820NC03125-18RH3-A KSMN34	M24
T820NC03125-18RH3-A KSP32	M24
T820NC03125-18RH3-A KSP39	M24
T820NC03125-18RH3-XL6 KSP39	M35
T820NC03125-18RH5-A KSP39	M24
T820NC03125-18RH7-A KSP39	M24
T820NC03750-16R2B-D1 KSP39	M26
T820NC03750-16RH3-A KSMN34	M24
T820NC03750-16RH3-A KSP32	M24
T820NC03750-16RH3-A KSP39	M24
T820NC03750-16RH3-XL6 KSP39	M35
T820NC03750-16RH5-A KSP39	M24
T820NC03750-16RH7-A KSP39	M24
T820NC04375-14R2B-D6 KSP39	M26
T820NC04375-14RH3-A KSMN34	M24
T820NC04375-14RH3-A KSP39	M24
T820NC04375-14RH3-XL6 KSP39	M35
T820NC04375-14RH5-A KSP39	M24
T820NC05000-13R2B-D6 KSP39	M26
T820NC05000-13RH3-A KSMN34	M24
T820NC05000-13RH3-A KSP32	M24
T820NC05000-13RH3-A KSP39	M24
T820NC05000-13RH3-XL6 KSP39	M35
T820NC05000-13RH5-A KSP39	M24
T820NC05000-13RH7-A KSP39	M24
T820NC05625-12R2B-D6 KSP39	M26
T820NC05625-12RH3-A KSP32	M24
T820NC05625-12RH3-A KSP39	M24
T820NC06250-11R2B-D6 KSP39	M26
T820NC06250-11RH3-A KSMN34	M24
T820NC06250-11RH3-A KSP32	M24
T820NC06250-11RH3-A KSP39	M24
T820NC06250-11RH3-XL6 KSP39	M35
T820NC06250-11RH5-A KSP39	M24
T820NC06250-11RH7-A KSP39	M24
T820NC07500-10R2B-D6 KSP39	M26
T820NC07500-10RH3-A KSMN34	M24
T820NC07500-10RH3-A KSP32	M24
T820NC07500-10RH3-A KSP39	M24
T820NC08750-9R2B-D6 KSP39	M26
T820NC08750-9RH4-A KSMN34	M25
T820NC08750-9RH4-A KSP32	M25
T820NC10000-8R2B-D6 KSP39	M26
T820NC10000-8RH5-A KSMN34	M25
T820NC10000-8RH5-A KSP32	M25
T820NC10000-8RH5-A KSP39	M25
T820NC11250-7RH6-A KSP39	M25
T820NC12500-7RH6-A KSP39	M25
T820NF#04-48RH2-A KSP39	M23
T820NF#04-48RH4-A KSP39	M23
T820NF#06-40R2B-D1 KSP39	M26
T820NF#06-40RH2-A KSP39	M23
T820NF#06-40RH3-A KSP39	M23
T820NF#08-36RH2-A KSP39	M23
T820NF#10-32R2B-D1 KSP39	M26
T820NF#10-32R3B-D1 KSP39	M27
T820NF#10-32RH3-A KSMN34	M23
T820NF#10-32RH3-A KSP32	M23
T820NF#10-32RH3-A KSP39	M23
T820NF#10-32RH3-XL4 KSP39	M34
T820NF#10-32RH3-XL6 KSP39	M35
T820NF#10-32RH4-A KSP39	M23
T820NF#10-32RH5-A KSP39	M23

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
T820NF#10-32RH6-A KSP39	M23
T820NF#10-32RH7-A KSP39	M23
T820NF#12-28RH3-A KSP39	M24
T820NF02500-28R2B-D1 KSP39	M26
T820NF02500-28R3B-D1 KSP39	M27
T820NF02500-28RH2-A KSP39	M24
T820NF02500-28RH3-A KSMN34	M24
T820NF02500-28RH3-A KSP32	M24
T820NF02500-28RH3-A KSP39	M24
T820NF02500-28RH3-XL6 KSP39	M35
T820NF02500-28RH4-A KSP39	M24
T820NF02500-28RH5-A KSP39	M24
T820NF02500-28RH6-A KSP39	M24
T820NF02500-28RH7-A KSP39	M24
T820NF03125-24R2B-D1 KSP39	M26
T820NF03125-24R3B-D1 KSP39	M27
T820NF03125-24RH3-A KSMN34	M24
T820NF03125-24RH3-A KSP32	M24
T820NF03125-24RH3-A KSP39	M24
T820NF03125-24RH3-XL6 KSP39	M35
T820NF03125-24RH4-A KSP39	M24
T820NF03125-24RH5-A KSP39	M24
T820NF03125-24RH6-A KSP39	M24
T820NF03125-24RH7-A KSP39	M24
T820NF03750-24R2B-D1 KSP39	M26
T820NF03750-24R3B-D1 KSP39	M27
T820NF03750-24RH3-A KSMN34	M24
T820NF03750-24RH3-A KSP32	M24
T820NF03750-24RH3-A KSP39	M24
T820NF03750-24RH3-XL6 KSP39	M35
T820NF03750-24RH4-A KSP39	M24
T820NF03750-24RH5-A KSP39	M24
T820NF03750-24RH6-A KSP39	M24
T820NF03750-24RH7-A KSP39	M24
T820NF04375-20R2B-D6 KSP39	M26
T820NF04375-20R3B-D6 KSP39	M27
T820NF04375-20RH3-A KSMN34	M24
T820NF04375-20RH3-A KSP39	M24
T820NF04375-20RH3-XL6 KSP39	M35
T820NF04375-20RH5-A KSP39	M24
T820NF04375-20RH6-A KSP39	M24
T820NF04375-20RH7-A KSP39	M24
T820NF05000-20R2B-D6 KSP39	M26
T820NF05000-20R3B-D6 KSP39	M27
T820NF05000-20RH3-A KSMN34	M24
T820NF05000-20RH3-A KSP32	M24
T820NF05000-20RH3-A KSP39	M24
T820NF05000-20RH3-XL6 KSP39	M35
T820NF05000-20RH5-A KSP39	M24
T820NF05000-20RH6-A KSP39	M24
T820NF05000-20RH7-A KSP39	M24
T820NF05625-18R2B-D6 KSP39	M26
T820NF05625-18RH3-A KSMN34	M24
T820NF05625-18RH3-A KSP39	M24
T820NF06250-18R2B-D6 KSP39	M26
T820NF06250-18RH3-A KSP32	M24
T820NF06250-18RH3-A KSP39	M24
T820NF06250-18RH5-A KSP32	M24
T820NF06250-18RH5-A KSP39	M24
T820NF06250-18RH6-A KSP39	M24
T820NF07500-16R2B-D6 KSP39	M26
T820NF07500-16RH3-A KSMN34	M25
T820NF07500-16RH3-A KSP32	M25
T820NF07500-16RH3-A KSP39	M25
T820NF08750-14R2B-D6 KSP39	M26
T820NF08750-14RH4-A KSP39	M25
T820NF10000-12R2B-D6 KSP39	M26
T820NF10000-12RH4-A KSP39	M25
T820NF11250-12RH5-A KSP39	M25
T822M030X050RD3-A KSMN34	M30
T822M030X050RD3-A KSP32	M30
T822M030X050RD3-A KSP39	M30
T822M035X060RD4-A KSP39	M30
T822M040X070RD4-A KSMN34	M30
T822M040X070RD4-A KSP32	M30
T822M040X070RD4-A KSP39	M30
T822M050X080RD4-A KSMN34	M30
T822M050X080RD4-A KSP32	M30
T822M050X080RD4-A KSP39	M30
T822NC#05-40RH2-A KSP39	M28
T822NC#06-32RH2-A KSP39	M28
T822NC#06-32RH3-A KSMN34	M28
T822NC#06-32RH3-A KSP32	M28
T822NC#06-32RH3-A KSP39	M28
T822NC#06-32RH4-A KSP39	M28
T822NC#06-32RH5-A KSP39	M28
T822NC#06-32RH6-A KSP39	M28
T822NC#06-32RH7-A KSP39	M28
T822NC#08-32RH2-A KSP39	M28
T822NC#08-32RH3-A KSMN34	M28
T822NC#08-32RH3-A KSP32	M28
T822NC#08-32RH3-A KSP39	M28
T822NC#08-32RH4-A KSP32	M28
T822NC#08-32RH5-A KSP39	M28
T822NC#08-32RH6-A KSP39	M28
T822NC#08-32RH7-A KSP39	M28
T822NC#10-24RH3-A KSMN34	M28
T822NC#10-24RH3-A KSP32	M28
T822NC#10-24RH3-A KSP39	M28
T822NC#10-24RH5-A KSP39	M28
T822NC#10-24RH7-A KSP39	M28
T822NF#06-40RH2-A KSP39	M28
T822NF#06-40RH3-A KSP39	M28
T822NF#08-36RH2-A KSP39	M28
T822NF#10-32RH3-A KSMN34	M28
T822NF#10-32RH3-A KSP32	M28
T822NF#10-32RH3-A KSP39	M28
T822NF#10-32RH4-A KSP39	M28
T822NF#10-32RH5-A KSP39	M28
T822NF#10-32RH6-A KSP39	M28
T822NF#10-32RH7-A KSP39	M28
T822NF#12-28RH3-A KSP39	M28
T830M020X040R6G-D1 KSP39	M92
T830M020X040R6H-D1 KSP39	M92
T830M025X045R6G-D1 KSP39	M92
T830M025X045R6H-D1 KSP39	M92
T830M030X050R6G-D1 KSP39	M92
T830M030X050R6H-D1 KSP32	M92
T830M030X050R6H-D1 KSP39	M92
T830M030X050R6H-J KSU30	M98
T830M030X050R6H-J KSU31	M98
T830M030X050RD3-A KSP32	M88
T830M030X050RD3-A KSP39	M88
T830M035X060R6H-D1 KSP39	M92
T830M035X060RD4-A KSP39	M88
T830M040X070R6G-D1 KSP39	M92
T830M040X070R6H-D1 KSP32	M92
T830M040X070R6H-D1 KSP39	M92
T830M040X070R6H-J KSU30	M98
T830M040X070R6H-J KSU31	M98
T830M040X070RD4-A KSP32	M88
T830M040X070RD4-A KSP39	M88
T830M050X080R6G-D1 KSP39	M92
T830M050X080R6H-D1 KSP32	M92
T830M050X080R6H-D1 KSP39	M92
T830M050X080R6H-J KSU30	M98
T830M050X080R6H-J KSU31	M98
T830M050X080RD4-A KSMN34	M88
T830M050X080RD4-A KSP32	M88
T830M050X080RD4-A KSP39	M88
T830M060X100R6G-D1 KSP39	M92
T830M060X100R6H-D1 KSP32	M92
T830M060X100R6H-D1 KSP39	M92
T830M060X100R6H-D6 KSP39	M92
T830M060X100R6H-J KSU30	M98
T830M060X100R6H-J KSU31	M98
T830M060X100RD5-A KSMN34	M88
T830M060X100RD5-A KSP32	M88
T830M060X100RD5-A KSP39	M88
T830M070X100R6H-D1 KSP39	M92
T830M070X100RD5-A KSP39	M88
T830M080X125R6G-D1 KSP39	M92
T830M080X125R6H-D1 KSP32	M92
T830M080X125R6H-D1 KSP39	M92
T830M080X125R6H-D6 KSP39	M92
T830M080X125R6H-J KSU30	M98
T830M080X125R6H-J KSU31	M98
T830M080X125RD5-A KSMN34	M88
T830M080X125RD5-A KSP32	M88
T830M080X125RD5-A KSP39	M88
T830M100X150R6G-D1 KSP39	M92
T830M100X150R6H-D1 KSP32	M92
T830M100X150R6H-D1 KSP39	M92
T830M100X150R6H-D6 KSP39	M92
T830M100X150R6H-J KSU30	M98
T830M100X150R6H-J KSU31	M98
T830M100X150RD6-A KSMN34	M88
T830M100X150RD6-A KSP32	M88
T830M100X150RD6-A KSP39	M88
T830M120X175R6G-D6 KSP39	M93
T830M120X175R6H-D6 KSP32	M93
T830M120X175R6H-D6 KSP39	M93
T830M120X175R6H-J KSU30	M98
T830M120X175RD6-A KSMN34	M88
T830M120X175RD6-A KSP32	M88
T830M120X175RD6-A KSP39	M88
T830M140X200R6G-D6 KSP39	M93
T830M140X200R6H-D6 KSP32	M93
T830M140X200R6H-D6 KSP39	M93
T830M140X200R6H-J KSU30	M98
T830M140X200RD7-A KSP39	M88
T830M160X200R6G-D6 KSP39	M93
T830M160X200R6H-D6 KSP39	M93
T830M160X200R6H-J KSU30	M98
T830M160X200RD7-A KSP39	M88
T830M180X250R6H-D6 KSP39	M93
T830M180X250R6H-J KSU30	M98
T830M180X250RD7-A KSP39	M88
T830M200X250R6H-D6 KSP39	M93
T830M200X250R6H-J KSU30	M98
T830M220X250R6H-D6 KSP39	M93
T830M240X300R6H-D6 KSP39	M93
T830M270X300R6H-D6 KSP39	M93
T830M300X350R6H-D6 KSP39	M93
T830M330X350R6H-D6 KSP39	M93
T830M360X400R6H-D6 KSP39	M93
T830MF080X100R6H-D4 KSP32	M92
T830MF080X100R6H-D4 KSP39	M92
T830MF080X100RD5-A KSP39	M88
T830MF100X125R6H-D4 KSP32	M92
T830MF100X125R6H-D4 KSP39	M92
T830MF100X125RD5-A KSP39	M88
T830MF120X125R6H-D4 KSP39	M93
T830MF120X125R6H-J KSU30	M98
T830MF120X125RD5-A KSP39	M88
T830MF120X150R6H-D4 KSP32	M93
T830MF120X150R6H-D4 KSP39	M93
T830MF120X150R6H-J KSU30	M98
T830MF120X150RD5-A KSP39	M88
T830MF140X150R6H-D4 KSP32	M93
T830MF140X150R6H-D4 KSP39	M93
T830MF140X150R6H-J KSU30	M98
T830MF140X150RD6-A KSP39	M88
T830MF160X150R6H-D4 KSP39	M93
T830MF160X150R6H-J KSU30	M98
T830MF160X150RD6-A KSP39	M88
T830MF180X150R6H-D4 KSP39	M93
T830MF180X150RD6-A KSP39	M88
T830NC#02-56RH2-A KSP39	M74
T830NC#03-48RH2-A KSP39	M74
T830NC#04-40R2B-D1 KSP39	M84
T830NC#04-40R3B-D1 KSP39	M87
T830NC#04-40RH2-A KSMN34	M74
T830NC#04-40RH2-A KSP32	M74
T830NC#04-40RH2-A KSP39	M74
T830NC#04-40RH2-XL4 KSP39	M99
T830NC#04-40RH2-XL6 KSP39	M100
T830NC#04-40RH3-A KSP39	M74
T830NC#04-40RH4-A KSP39	M74
T830NC#04-40RH5-A KSP39	M74
T830NC#05-40R2B-D1 KSP39	M84
T830NC#05-40RH2-A KSP39	M74
T830NC#06-32R2B-D1 KSP39	M84
T830NC#06-32R3B-D1 KSP39	M87
T830NC#06-32RH2-A KSP39	M74
T830NC#06-32RH3-A KSMN34	M74
T830NC#06-32RH3-A KSP32	M74
T830NC#06-32RH3-A KSP39	M74
T830NC#06-32RH3-XL4 KSP39	M99
T830NC#06-32RH3-XL6 KSP39	M100
T830NC#06-32RH4-A KSP39	M74
T830NC#06-32RH5-A KSP39	M74
T830NC#06-32RH6-A KSP39	M74
T830NC#06-32RH7-A KSP39	M74
T830NC#08-32R2B-D1 KSP39	M84
T830NC#08-32R3B-D1 KSP39	M87
T830NC#08-32RH2-A KSP39	M74
T830NC#08-32RH3-A KSMN34	M74
T830NC#08-32RH3-A KSP32	M74
T830NC#08-32RH3-A KSP39	M74
T830NC#08-32RH3-XL4 KSP39	M99
T830NC#08-32RH3-XL6 KSP39	M100
T830NC#08-32RH4-A KSP39	M74
T830NC#08-32RH5-A KSP39	M74
T830NC#08-32RH6-A KSP39	M74
T830NC#08-32RH7-A KSP39	M74
T830NC#10-24R2B-D1 KSP39	M84
T830NC#10-24RH2-A KSP39	M74
T830NC#10-24RH3-A KSMN34	M74
T830NC#10-24RH3-A KSP32	M74
T830NC#10-24RH3-A KSP39	M74
T830NC#10-24RH3-XL6 KSP39	M100
T830NC#10-24RH4-A KSP39	M74
T830NC#10-24RH5-A KSP39	M75
T830NC#10-24RH7-A KSP39	M75
T830NC#12-24RH3-A KSP39	M75
T830NC02500-20R2B-D1 KSP39	M84
T830NC02500-20RH2-A KSP39	M75
T830NC02500-20RH3-A KSMN34	M75
T830NC02500-20RH3-A KSP32	M75
T830NC02500-20RH3-A KSP39	M75
T830NC02500-20RH3-XL4 KSP39	M99
T830NC02500-20RH3-XL6 KSP39	M100
T830NC02500-20RH5-A KSP39	M75
T830NC02500-20RH7-A KSP39	M75
T830NC03125-18R2B-D1 KSP39	M84
T830NC03125-18RH3-A KSMN34	M75
T830NC03125-18RH3-A KSP32	M75
T830NC03125-18RH3-A KSP39	M75
T830NC03125-18RH3-XL6 KSP39	M100
T830NC03125-18RH5-A KSP39	M75
T830NC03125-18RH7-A KSP39	M75
T830NC03750-16R2B-D1 KSP39	M84
T830NC03750-16RH3-A KSMN34	M75
T830NC03750-16RH3-A KSP32	M75
T830NC03750-16RH3-A KSP39	M75
T830NC03750-16RH3-XL6 KSP39	M100
T830NC03750-16RH5-A KSP39	M75
T830NC03750-16RH7-A KSP39	M75
T830NC04375-14R2B-D6 KSP39	M84
T830NC04375-14RH3-A KSMN34	M75
T830NC04375-14RH3-A KSP32	M75
T830NC04375-14RH3-A KSP39	M75
T830NC04375-14RH3-XL6 KSP39	M100
T830NC04375-14RH5-A KSP39	M75
T830NC04375-14RH7-A KSP39	M75
T830NC05000-13R2B-D6 KSP39	M84
T830NC05000-13RH3-A KSMN34	M75
T830NC05000-13RH3-A KSP32	M75
T830NC05000-13RH3-A KSP39	M75
T830NC05000-13RH3-XL6 KSP39	M100
T830NC05000-13RH5-A KSP39	M75
T830NC05000-13RH7-A KSP39	M75
T830NC05625-12R2B-D6 KSP39	M84
T830NC05625-12RH3-A KSMN34	M75
T830NC05625-12RH3-A KSP32	M75
T830NC05625-12RH3-A KSP39	M75
T830NC05625-12RH5-A KSP39	M76
T830NC06250-11R2B-D6 KSP39	M84
T830NC06250-11RH3-A KSMN34	M76
T830NC06250-11RH3-A KSP32	M76
T830NC06250-11RH3-A KSP39	M76
T830NC06250-11RH3-XL6 KSP39	M100
T830NC06250-11RH5-A KSP39	M76
T830NC06250-11RH7-A KSP39	M76
T830NC07500-10R2B-D6 KSP39	M84
T830NC07500-10RH3-A KSMN34	M76
T830NC07500-10RH3-A KSP32	M76
T830NC07500-10RH3-A KSP39	M76
T830NC07500-10RH5-A KSP39	M76
T830NC08750-9RH4-A KSMN34	M76
T830NC08750-9RH4-A KSP39	M76
T830NC10000-8R2B-D6 KSP39	M84
T830NC10000-8RH4-A KSMN34	M76
T830NC10000-8RH5-A KSP32	M76
T830NC10000-8RH5-A KSP39	M76
T830NC11250-7RH6-A KSP39	M76
T830NF#04-48RH2-A KSP39	M74
T830NF#06-40R2B-D1 KSP39	M84

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
T830NF#06-40RH2-A KSP39	M74
T830NF#06-40RH3-A KSP39	M74
T830NF#10-32R2B-D1 KSP39	M84
T830NF#10-32R3B-D1 KSP39	M87
T830NF#10-32RH2-A KSP39	M75
T830NF#10-32RH3-A KSMN34	M75
T830NF#10-32RH3-A KSP32	M75
T830NF#10-32RH3-A KSP39	M75
T830NF#10-32RH3-XL4 KSP39	M99
T830NF#10-32RH3-XL6 KSP39	M100
T830NF#10-32RH4-A KSP39	M75
T830NF#10-32RH5-A KSP39	M75
T830NF#10-32RH6-A KSP39	M75
T830NF#10-32RH7-A KSP39	M75
T830NF#12-28RH3-A KSP39	M75
T830NF02500-28R2B-D1 KSP39	M84
T830NF02500-28R3B-D1 KSP39	M87
T830NF02500-28RH2-A KSP39	M75
T830NF02500-28RH3-A KSMN34	M75
T830NF02500-28RH3-A KSP32	M75
T830NF02500-28RH3-A KSP39	M75
T830NF02500-28RH4-A KSP39	M75
T830NF02500-28RH5-A KSP39	M75
T830NF02500-28RH6-A KSP39	M75
T830NF02500-28RH7-A KSP39	M75
T830NF03125-24R2B-D1 KSP39	M84
T830NF03125-24R3B-D1 KSP39	M87
T830NF03125-24RH3-A KSMN34	M75
T830NF03125-24RH3-A KSP32	M75
T830NF03125-24RH3-A KSP39	M75
T830NF03125-24RH3-XL6 KSP39	M100
T830NF03125-24RH5-A KSP39	M75
T830NF03125-24RH7-A KSP39	M75
T830NF03750-24R2B-D1 KSP39	M84
T830NF03750-24R3B-D1 KSP39	M87
T830NF03750-24RH3-A KSMN34	M75
T830NF03750-24RH3-A KSP32	M75
T830NF03750-24RH3-A KSP39	M75
T830NF03750-24RH3-XL6 KSP39	M100
T830NF03750-24RH4-A KSP39	M75
T830NF03750-24RH5-A KSP39	M75
T830NF03750-24RH6-A KSP39	M75
T830NF04375-20R2B-D6 KSP39	M84
T830NF04375-20R3B-D6 KSP39	M87
T830NF04375-20RH3-A KSMN34	M75
T830NF04375-20RH3-A KSP32	M75
T830NF04375-20RH3-A KSP39	M75
T830NF04375-20RH3-XL6 KSP39	M100
T830NF04375-20RH5-A KSP39	M75
T830NF04375-20RH6-A KSP39	M75
T830NF04375-20RH7-A KSP39	M75
T830NF05000-20R2B-D6 KSP39	M84
T830NF05000-20R3B-D6 KSP39	M87
T830NF05000-20RH3-A KSMN34	M75
T830NF05000-20RH3-A KSP32	M75
T830NF05000-20RH3-A KSP39	M75
T830NF05000-20RH3-XL6 KSP39	M100
T830NF05000-20RH5-A KSP39	M75
T830NF05000-20RH6-A KSP39	M75
T830NF05000-20RH7-A KSP39	M75
T830NF05625-18R2B-D6 KSP39	M84
T830NF05625-18RH3-A KSMN34	M76
T830NF05625-18RH3-A KSP39	M76
T830NF05625-18RH5-A KSP39	M76
T830NF06250-18R2B-D6 KSP39	M84
T830NF06250-18RH3-A KSMN34	M76
T830NF06250-18RH3-A KSP32	M76
T830NF06250-18RH3-A KSP39	M76
T830NF06250-18RH5-A KSP39	M76
T830NF06250-18RH6-A KSP39	M76
T830NF06250-18RH7-A KSP39	M76
T830NF07500-16R2B-D6 KSP39	M84
T830NF07500-16RH3-A KSMN34	M76
T830NF07500-16RH3-A KSP32	M76
T830NF07500-16RH3-A KSP39	M76
T830NF07500-16RH5-A KSP39	M76
T830NF08750-14R2B-D6 KSP39	M84
T830NF08750-14RH4-A KSMN34	M76
T830NF08750-14RH4-A KSP39	M76
T830NF08750-9R2B-D6 KSP39	M84
T830NF1000-12RH4-A KSP39	M76
T830NF10000-12R2B-D6 KSP39	M84
T832M030X050R6H-D1 KSP32	M94
T832M030X050R6H-D1 KSP39	M94
T832M030X050RD3-A KSP39	M89
T832M035X060RD4-A KSP39	M89
T832M040X070R6H-D1 KSP32	M94
T832M040X070R6H-D1 KSP39	M94
T832M040X070RD4-A KSP39	M89
T832M050X080R6H-D1 KSP32	M94
T832M050X080R6H-D1 KSP39	M94
T832M050X080RD4-A KSP39	M89
T832M060X100R6H-D1 KSP32	M94
T832M060X100R6H-D1 KSP39	M94
T832M060X100RD5-A KSP39	M89
T832M070X100RD5-A KSP39	M89
T832M080X125R6H-D1 KSP32	M94
T832M080X125R6H-D1 KSP39	M94
T832M080X125RD5-A KSP39	M89
T832M100X150R6H-D1 KSP32	M94
T832M100X150R6H-D1 KSP39	M94
T832M100X150RD6-A KSP39	M89
T832M120X175R6H-D6 KSP32	M94
T832M120X175R6H-D6 KSP39	M94
T832M120X175RD6-A KSP39	M89
T832M140X200R6H-D6 KSP32	M94
T832M140X200R6H-D6 KSP39	M94
T832M140X200RD7-A KSP39	M89
T832M160X200R6H-D6 KSP39	M94
T832M160X200RD7-A KSP39	M89
T832M180X250R6H-D6 KSP32	M94
T832M180X250R6H-D6 KSP39	M94
T832M200X250R6H-D6 KSP32	M94
T832M200X250R6H-D6 KSP39	M94
T832MF080X100R6H-D4 KSP32	M94
T832MF080X100R6H-D4 KSP39	M94
T832MF080X100RD5-A KSP39	M89
T832MF100X125R6H-D4 KSP32	M94
T832MF100X125R6H-D4 KSP39	M94
T832MF100X125RD5-A KSP39	M89
T832MF120X125RD5-A KSP39	M89
T832MF120X150R6H-D4 KSP32	M94
T832MF120X150R6H-D4 KSP39	M94
T832MF120X150RD5-A KSP39	M89
T832MF140X150R6H-D4 KSP32	M94
T832MF140X150R6H-D4 KSP39	M94
T832MF140X150RD6-A KSP39	M89
T832MF160X150RD6-A KSP39	M89
T832MF180X150RD6-A KSP39	M89
T832NC#04-40RH2-A KSP39	M77
T832NC#04-40RH2-XL6 KSP39	M101
T832NC#04-40RH3-A KSP39	M77
T832NC#04-40RH5-A KSP39	M77
T832NC#05-40RH2-A KSP39	M77
T832NC#06-32RH2-A KSP39	M77
T832NC#06-32RH3-A KSP39	M77
T832NC#06-32RH3-XL6 KSP39	M101
T832NC#06-32RH5-A KSP39	M77
T832NC#08-32RH2-A KSP39	M77
T832NC#08-32RH3-A KSP39	M77
T832NC#08-32RH3-XL6 KSP39	M101
T832NC#08-32RH5-A KSP39	M77
T832NC#10-24RH3-A KSP39	M77
T832NC#10-24RH5-A KSP39	M77
T832NC02500-20RH3-A KSP39	M77
T832NC02500-20RH3-XL6 KSP39	M101
T832NC02500-20RH5-A KSP39	M77
T832NC03125-18RH3-A KSP39	M77
T832NC03125-18RH3-XL6 KSP39	M101
T832NC03125-18RH5-A KSP39	M77
T832NC03750-16RH3-A KSP39	M77
T832NC03750-16RH3-XL6 KSP39	M101
T832NC03750-16RH5-A KSP39	M77
T832NC04375-14RH3-A KSP39	M78
T832NC04375-14RH3-XL6 KSP39	M101
T832NC04375-14RH5-A KSP39	M78
T832NC05000-13RH3-A KSP39	M78
T832NC05000-13RH5-A KSP39	M78
T832NC05625-12RH3-A KSP39	M78
T832NC05625-12RH5-A KSP39	M78
T832NC06250-11RH3-A KSP39	M78
T832NC06250-11RH5-A KSP39	M78
T832NC07500-10RH3-A KSP39	M78
T832NF#06-40RH2-A KSP39	M77
T832NF#06-40RH3-A KSP39	M77
T832NF#10-32RH3-A KSP39	M77
T832NF#10-32RH3-XL6 KSP39	M101
T832NF#10-32RH5-A KSP39	M77
T832NF02500-28RH3-A KSP39	M77
T832NF02500-28RH3-XL6 KSP39	M101
T832NF02500-28RH5-A KSP39	M77
T832NF03125-24RH3-A KSP39	M77
T832NF03125-24RH5-A KSP39	M77
T832NF03750-24RH3-A KSP39	M77
T832NF03750-24RH3-XL6 KSP39	M101
T832NF03750-24RH4-A KSP39	M77
T832NF03750-24RH5-A KSP39	M78
T832NF04375-20RH3-A KSP39	M78
T832NF04375-20RH5-A KSP39	M78
T832NF05000-20RH3-A KSP39	M78
T832NF05625-18RH3-A KSP39	M78
T832NF06250-18RH3-A KSP39	M78
T832NF06250-18RH5-A KSP39	M78
T832NF07500-16RH3-A KSP39	M78
T834M030X050RD3-A KSP32	M88
T834M030X050RD3-A KSP39	M88
T834M035X060RD4-A KSP39	M88
T834NC#05-40RH2-A KSP39	M74
T834NC#06-32RH2-A KSP39	M74
T834NC#06-32RH3-A KSMN34	M74
T834NC#06-32RH3-A KSP32	M74
T834NC#06-32RH3-A KSP39	M74
T834NC#06-32RH4-A KSP39	M74
T834NC#06-32RH5-A KSP39	M74
T834NC#06-32RH7-A KSP39	M74
T834NF#06-40RH2-A KSP39	M74
T834NF#06-40RH3-A KSP39	M74
T838M020X040R6H-D1 KSP39	M95
T838M020X040R6H-D1 KSU31	M95
T838M030X050R6H-D1 KSP39	M95
T838M030X050R6H-D1 KSU31	M95
T838M030X050RD3-A KSP32	M90
T838M030X050RD3-A KSP39	M90
T838M035X060RD4-A KSP39	M90
T838M040X070R6H-D1 KSP39	M95
T838M040X070R6H-D1 KSU31	M95
T838M040X070RD4-A KSP32	M90
T838M040X070RD4-A KSP39	M90
T838M050X080R6H-D1 KSP39	M95
T838M050X080R6H-D1 KSU31	M95
T838M050X080R6H-D6 KSP39	M95
T838M050X080R6H-D6 KSU31	M95
T838M050X080RD4-A KSP32	M90
T838M050X080RD4-A KSP39	M90
T838M060X100R6H-D1 KSP39	M95
T838M060X100R6H-D1 KSU31	M95
T838M060X100R6H-D6 KSP39	M95
T838M060X100R6H-D6 KSU31	M95
T838M060X100RD5-A KSP32	M90
T838M060X100RD5-A KSP39	M90
T838M070X100RD5-A KSP39	M90
T838M080X125R6H-D1 KSP39	M95
T838M080X125R6H-D1 KSU31	M95
T838M080X125R6H-D6 KSP39	M95
T838M080X125R6H-D6 KSU31	M95
T838M080X125RD5-A KSP32	M90
T838M080X125RD5-A KSP39	M90
T838M100X150R6H-D1 KSP39	M95
T838M100X150R6H-D1 KSU31	M95
T838M100X150R6H-D6 KSP39	M95
T838M100X150R6H-D6 KSU31	M95
T838M100X150RD6-A KSP32	M90
T838M100X150RD6-A KSP39	M90
T838M120X175R6H-D6 KSP39	M95
T838M120X175R6H-D6 KSU31	M95
T838M120X175RD6-A KSP32	M90
T838M120X175RD6-A KSP39	M90
T838M140X200R6H-D6 KSP39	M95
T838M140X200R6H-D6 KSU31	M95
T838M140X200RD7-A KSP39	M90
T838M160X200R6H-D6 KSP39	M95
T838M160X200R6H-D6 KSU31	M95
T838M160X200RD7-A KSP39	M90
T838M180X250R6H-D6 KSP39	M96
T838M180X250R6H-D6 KSU31	M96
T838M180X250RD7-A KSP39	M90
T838M200X250R6H-D6 KSP39	M96
T838M200X250R6H-D6 KSU31	M96
T838M220X250R6H-D6 KSP39	M96
T838M220X250R6H-D6 KSU31	M96
T838M240X300R6H-D6 KSP39	M96
T838M240X300R6H-D6 KSU31	M96
T838M270X300R6H-D6 KSP39	M96
T838M270X300R6H-D6 KSU31	M96
T838M300X350R6H-D6 KSP39	M96
T838M300X350R6H-D6 KSU31	M96
T838M330X350R6H-D6 KSP39	M96
T838M330X350R6H-D6 KSU31	M96
T838M360X400R6H-D6 KSP39	M96
T838M360X400R6H-D6 KSU31	M96
T838M390X400R6H-D6 KSP39	M96
T838M390X400R6H-D6 KSU31	M96
T838M420X450R6H-D6 KSP39	M96
T838M420X450R6H-D6 KSU31	M96
T838M450X450R6H-D6 KSP39	M96
T838M450X450R6H-D6 KSU31	M96
T838M480X500R6H-D6 KSP39	M96
T838M480X500R6H-D6 KSU31	M96
T838M520X500R6H-D6 KSP39	M96
T838M520X500R6H-D6 KSU31	M96
T838MF060X075R6H-D4 KSP39	M95
T838MF060X075R6H-D4 KSU31	M95
T838MF080X075R6H-D4 KSP39	M95
T838MF080X075R6H-D4 KSU31	M95
T838MF080X100R6H-D4 KSP39	M95
T838MF080X100R6H-D4 KSU31	M95
T838MF080X100RD5-A KSP39	M90
T838MF100X075R6H-D4 KSP39	M95
T838MF100X075R6H-D4 KSU31	M95
T838MF100X100R6H-D4 KSP39	M95
T838MF100X100R6H-D4 KSU31	M95
T838MF100X125R6H-D4 KSP39	M95
T838MF100X125R6H-D4 KSU31	M95
T838MF100X125RD5-A KSP39	M90
T838MF120X100R6H-D4 KSP39	M95
T838MF120X100R6H-D4 KSU31	M95
T838MF120X125R6H-D4 KSP39	M95
T838MF120X125R6H-D4 KSU31	M95
T838MF120X125RD5-A KSP39	M90
T838MF120X150R6H-D4 KSP39	M95
T838MF120X150R6H-D4 KSU31	M95
T838MF120X150RD5-A KSP39	M90
T838MF140X100R6H-D4 KSP39	M95
T838MF140X100R6H-D4 KSU31	M95
T838MF140X125R6H-D4 KSP39	M95
T838MF140X125R6H-D4 KSU31	M95
T838MF140X150R6H-D4 KSP39	M95
T838MF140X150R6H-D4 KSU31	M95
T838MF140X150RD6-A KSP39	M90
T838MF160X150R6H-D4 KSP39	M95
T838MF160X150R6H-D4 KSU31	M95
T838MF160X150RD6-A KSP39	M90
T838MF180X150R6H-D4 KSP39	M95
T838MF180X150R6H-D4 KSU31	M95
T838MF180X150RD6-A KSP39	M90
T838MF180X200R6H-D4 KSP39	M96
T838MF180X200R6H-D4 KSU31	M96
T838MF200X150R6H-D4 KSP39	M96
T838MF200X150R6H-D4 KSU31	M96
T838MF200X200R6H-D4 KSP39	M96
T838MF200X200R6H-D4 KSU31	M96
T838MF220X150R6H-D4 KSP39	M96
T838MF220X150R6H-D4 KSU31	M96
T838MF220X200R6H-D4 KSP39	M96
T838MF220X200R6H-D4 KSU31	M96
T838MF240X150R6H-D4 KSP39	M96
T838MF240X150R6H-D4 KSU31	M96
T838MF240X200R6H-D4 KSP39	M96
T838MF240X200R6H-D4 KSU31	M96
T838MF270X150R6H-D4 KSP39	M96
T838MF270X150R6H-D4 KSU31	M96
T838MF300X150R6H-D4 KSP39	M96
T838MF300X150R6H-D4 KSU31	M96
T838MF300X200R6H-D4 KSP39	M96
T838MF300X200R6H-D4 KSU31	M96
T838NC#02-56RH2-A KSP39	M79
T838NC#03-48RH2-A KSP39	M79
T838NC#04-40RH2-A KSP32	M79

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
T838NC#04-40RH2-A KSP39	M79
T838NC#04-40RH3-A KSP39	M79
T838NC#04-40RH4-A KSP39	M79
T838NC#04-40RH5-A KSP39	M79
T838NC#05-40RH2-A KSP39	M79
T838NC#06-32R2B-D1 KSP39	M85
T838NC#06-32R2B-D1 KSU31	M85
T838NC#06-32RH2-A KSP39	M79
T838NC#06-32RH3-A KSP32	M79
T838NC#06-32RH3-A KSP39	M79
T838NC#06-32RH4-A KSP39	M79
T838NC#06-32RH5-A KSP39	M79
T838NC#06-32RH7-A KSP39	M79
T838NC#08-32R2B-D1 KSP39	M85
T838NC#08-32R2B-D1 KSU31	M85
T838NC#08-32RH2-A KSP39	M79
T838NC#08-32RH3-A KSP32	M79
T838NC#08-32RH3-A KSP39	M79
T838NC#08-32RH4-A KSP39	M79
T838NC#08-32RH5-A KSP39	M79
T838NC#08-32RH6-A KSP39	M79
T838NC#08-32RH7-A KSP39	M79
T838NC#10-24R2B-D1 KSP39	M85
T838NC#10-24R2B-D1 KSU31	M85
T838NC#10-24RH2-A KSP39	M79
T838NC#10-24RH3-A KSP32	M79
T838NC#10-24RH3-A KSP39	M79
T838NC#10-24RH4-A KSP39	M79
T838NC#10-24RH5-A KSP39	M79
T838NC#10-24RH7-A KSP39	M79
T838NC#12-24R2B-D1 KSP39	M85
T838NC#12-24R2B-D1 KSU31	M85
T838NC#12-24RH3-A KSP39	M80
T838NC02500-20R2B-D1 KSP39	M85
T838NC02500-20R2B-D1 KSU31	M85
T838NC02500-20R2B-D6 KSP39	M85
T838NC02500-20R2B-D6 KSU31	M85
T838NC02500-20RH2-A KSP39	M80
T838NC02500-20RH3-A KSP32	M80
T838NC02500-20RH3-A KSP39	M80
T838NC02500-20RH5-A KSP39	M80
T838NC02500-20RH7-A KSP39	M80
T838NC03125-18R2B-D1 KSP39	M85
T838NC03125-18R2B-D1 KSU31	M85
T838NC03125-18R2B-D6 KSP39	M85
T838NC03125-18R2B-D6 KSU31	M85
T838NC03125-18RH3-A KSP32	M80
T838NC03125-18RH3-A KSP39	M80
T838NC03125-18RH5-A KSP39	M80
T838NC03125-18RH7-A KSP39	M80
T838NC03750-16R2B-D1 KSP39	M85
T838NC03750-16R2B-D1 KSU31	M85
T838NC03750-16R2B-D6 KSP39	M85
T838NC03750-16R2B-D6 KSU31	M85
T838NC03750-16RH3-A KSP32	M80
T838NC03750-16RH3-A KSP39	M80
T838NC03750-16RH5-A KSP39	M80
T838NC03750-16RH7-A KSP39	M80
T838NC04375-14R2B-D6 KSP39	M85
T838NC04375-14R2B-D6 KSU31	M85
T838NC04375-14RH3-A KSP32	M80
T838NC04375-14RH3-A KSP39	M80
T838NC04375-14RH5-A KSP39	M80
T838NC04375-14RH7-A KSP39	M80
T838NC05000-13R2B-D6 KSP39	M85
T838NC05000-13R2B-D6 KSU31	M85
T838NC05000-13RH3-A KSP32	M80
T838NC05000-13RH3-A KSP39	M80
T838NC05000-13RH5-A KSP39	M80
T838NC05000-13RH7-A KSP39	M80
T838NC05625-12R2B-D6 KSP39	M85
T838NC05625-12R2B-D6 KSU31	M85
T838NC05625-12RH3-A KSP32	M80
T838NC05625-12RH3-A KSP39	M80
T838NC05625-12RH5-A KSP39	M80
T838NC06250-11R2B-D6 KSP39	M85
T838NC06250-11R2B-D6 KSU31	M85
T838NC06250-11RH3-A KSP32	M80
T838NC06250-11RH3-A KSP39	M80
T838NC06250-11RH5-A KSP39	M80
T838NC06250-11RH7-A KSP39	M80
T838NC07500-10R2B-D6 KSP39	M85
T838NC07500-10R2B-D6 KSU31	M85
T838NC07500-10RH3-A KSP32	M81
T838NC07500-10RH3-A KSP39	M81
T838NC07500-10RH5-A KSP39	M81
T838NC08750-9R2B-D6 KSP39	M86
T838NC08750-9R2B-D6 KSU31	M86
T838NC08750-9RH4-A KSP39	M81
T838NC10000-8R2B-D6 KSP39	M86
T838NC10000-8R2B-D6 KSU31	M86
T838NC10000-8RH5-A KSP32	M81
T838NC10000-8RH5-A KSP39	M81
T838NC11250-7R2B-D6 KSP39	M86
T838NC11250-7R2B-D6 KSU31	M86
T838NC11250-7RH6-A KSP39	M81
T838NC12500-7R2B-D6 KSP39	M86
T838NC12500-7R2B-D6 KSU31	M86
T838NC13750-6R2B-D6 KSP39	M86
T838NC13750-6R2B-D6 KSU31	M86
T838NC15000-6R2B-D6 KSP39	M86
T838NC15000-6R2B-D6 KSU31	M86
T838NC17500-5R2B-D6 KSP39	M86
T838NC17500-5R2B-D6 KSU31	M86
T838NC20000-4,5R2B-D6 KSP39	M86
T838NC20000-4,5R2B-D6 KSU31	M86
T838NF#04-48RH2-A KSP39	M79
T838NF#06-40R2B-D1 KSP39	M85
T838NF#06-40R2B-D1 KSU31	M85
T838NF#06-40RH2-A KSP39	M79
T838NF#06-40RH3-A KSP39	M79
T838NF#08-36R2B-D1 KSP39	M85
T838NF#08-36R2B-D1 KSU31	M85
T838NF#10-32R2B-D1 KSP39	M85
T838NF#10-32R2B-D1 KSU31	M85
T838NF#10-32RH2-A KSP39	M79
T838NF#10-32RH3-A KSP32	M79
T838NF#10-32RH3-A KSP39	M79
T838NF#10-32RH4-A KSP39	M80
T838NF#10-32RH5-A KSP39	M80
T838NF#10-32RH6-A KSP39	M80
T838NF#10-32RH7-A KSP39	M80
T838NF#12-28R2B-D1 KSP39	M85
T838NF#12-28R2B-D1 KSU31	M85
T838NF#12-28RH3-A KSP39	M80
T838NF02500-28R2B-D1 KSP39	M85
T838NF02500-28R2B-D1 KSU31	M85
T838NF02500-28R2B-D4 KSP39	M85
T838NF02500-28R2B-D4 KSU31	M85
T838NF02500-28RH2-A KSP39	M80
T838NF02500-28RH3-A KSP32	M80
T838NF02500-28RH3-A KSP39	M80
T838NF02500-28RH4-A KSP39	M80
T838NF02500-28RH5-A KSP39	M80
T838NF02500-28RH6-A KSP39	M80
T838NF02500-28RH7-A KSP39	M80
T838NF03125-24R2B-D4 KSP39	M85
T838NF03125-24R2B-D4 KSU31	M85
T838NF03125-24RH3-A KSP32	M80
T838NF03125-24RH3-A KSP39	M80
T838NF03125-24RH5-A KSP39	M80
T838NF03125-24RH7-A KSP39	M80
T838NF03750-24R2B-D4 KSP39	M85
T838NF03750-24R2B-D4 KSU31	M85
T838NF03750-24RH3-A KSP32	M80
T838NF03750-24RH3-A KSP39	M80
T838NF03750-24RH4-A KSP39	M80
T838NF03750-24RH5-A KSP39	M80
T838NF03750-24RH6-A KSP39	M80
T838NF04375-20R2B-D4 KSP39	M85
T838NF04375-20R2B-D4 KSU31	M85
T838NF04375-20RH3-A KSP32	M80
T838NF04375-20RH3-A KSP39	M80
T838NF04375-20RH5-A KSP39	M80
T838NF04375-20RH6-A KSP39	M80
T838NF04375-20RH7-A KSP39	M80
T838NF05000-20R2B-D4 KSP39	M85
T838NF05000-20R2B-D4 KSU31	M85
T838NF05000-20RH3-A KSP32	M80
T838NF05000-20RH3-A KSP39	M80
T838NF05000-20RH5-A KSP39	M80
T838NF05000-20RH6-A KSP39	M80
T838NF05000-20RH7-A KSP39	M80
T838NF05625-18R2B-D4 KSP39	M85
T838NF05625-18R2B-D4 KSU31	M85
T838NF05625-18RH3-A KSP39	M80
T838NF05625-18RH5-A KSP39	M80
T838NF06250-18R2B-D4 KSP39	M85
T838NF06250-18R2B-D4 KSU31	M85
T838NF06250-18RH3-A KSP32	M80
T838NF06250-18RH3-A KSP39	M80
T838NF06250-18RH5-A KSP39	M80
T838NF06250-18RH6-A KSP39	M81
T838NF06250-18RH7-A KSP39	M81
T838NF07500-16R2B-D4 KSP39	M85
T838NF07500-16R2B-D4 KSU31	M85
T838NF07500-16RH3-A KSP32	M81
T838NF07500-16RH3-A KSP39	M81
T838NF07500-16RH5-A KSP39	M81
T838NF08750-14R2B-D4 KSP39	M86
T838NF08750-14R2B-D4 KSU31	M86
T838NF08750-14RH4-A KSP39	M81
T838NF1000-12RH4-A KSP39	M81
T838NF10000-12R2B-D4 KSP39	M86
T838NF10000-12R2B-D4 KSU31	M86
T838NF11250-12R2B-D4 KSP39	M86
T838NF11250-12R2B-D4 KSU31	M86
T838NF12500-12R2B-D4 KSP39	M86
T838NF12500-12R2B-D4 KSU31	M86
T838NF13750-12R2B-D4 KSP39	M86
T838NF13750-12R2B-D4 KSU31	M86
T838NF15000-12R2B-D4 KSP39	M86
T838NF15000-12R2B-D4 KSU31	M86
T839M030X050R6H-D1 KSP39	M97
T839M030X050R6H-D1 KSU31	M97
T839M030X050RD3-A KSP39	M91
T839M035X060RD4-A KSP39	M91
T839M040X070R6H-D1 KSP39	M97
T839M040X070R6H-D1 KSU31	M97
T839M040X070RD4-A KSP39	M91
T839M050X080R6H-D1 KSP39	M97
T839M050X080R6H-D1 KSU31	M97
T839M050X080RD4-A KSP39	M91
T839M060X100R6H-D1 KSP39	M97
T839M060X100R6H-D1 KSU31	M97
T839M060X100RD5-A KSP39	M91
T839M070X100RD5-A KSP39	M91
T839M080X125R6H-D1 KSP39	M97
T839M080X125R6H-D1 KSU31	M97
T839M080X125RD5-A KSP39	M91
T839M100X150R6H-D1 KSP39	M97
T839M100X150R6H-D1 KSU31	M97
T839M100X150RD6-A KSP39	M91
T839M120X175R6H-D6 KSP39	M97
T839M120X175R6H-D6 KSU31	M97
T839M120X175RD6-A KSP39	M91
T839M140X200R6H-D6 KSP39	M97
T839M140X200R6H-D6 KSU31	M97
T839M140X200RD7-A KSP39	M91
T839M160X200R6H-D6 KSP39	M97
T839M160X200R6H-D6 KSU31	M97
T839M160X200RD7-A KSP39	M91
T839M180X250R6H-D6 KSP39	M97
T839M180X250R6H-D6 KSU31	M97
T839M200X250R6H-D6 KSP39	M97
T839M200X250R6H-D6 KSU31	M97
T839MF080X100RD5-A KSP39	M91
T839MF100X125RD5-A KSP39	M91
T839MF120X125RD5-A KSP39	M91
T839MF120X150RD5-A KSP39	M91
T839MF140X150RD6-A KSP39	M91
T839MF160X150RD6-A KSP39	M91
T839MF180X150RD6-A KSP39	M91
T839NC#04-40RH2-A KSP39	M82
T839NC#04-40RH3-A KSP39	M82
T839NC#04-40RH5-A KSP39	M82
T839NC#05-40RH2-A KSP39	M82
T839NC#06-32RH2-A KSP39	M82
T839NC#06-32RH3-A KSP39	M82
T839NC#06-32RH5-A KSP39	M82
T839NC#08-32RH2-A KSP39	M82
T839NC#08-32RH3-A KSP39	M82
T839NC#08-32RH5-A KSP39	M82
T839NC#10-24RH3-A KSP39	M82
T839NC#10-24RH5-A KSP39	M82
T839NC02500-20RH3-A KSP39	M82
T839NC02500-20RH5-A KSP39	M82
T839NC03125-18RH3-A KSP39	M82
T839NC03125-18RH5-A KSP39	M82
T839NC03750-16RH3-A KSP39	M82
T839NC03750-16RH5-A KSP39	M82
T839NC04375-14RH3-A KSP39	M83
T839NC04375-14RH5-A KSP39	M83
T839NC05000-13RH3-A KSP39	M83
T839NC05000-13RH5-A KSP39	M83
T839NC05625-12RH3-A KSP39	M83
T839NC05625-12RH5-A KSP39	M83
T839NC06250-11RH3-A KSP39	M83
T839NC06250-11RH5-A KSP39	M83
T839NC07500-10RH3-A KSP39	M83
T839NF#06-40RH2-A KSP39	M82
T839NF#06-40RH3-A KSP39	M82
T839NF#10-32RH3-A KSP39	M82
T839NF#10-32RH5-A KSP39	M82
T839NF02500-28RH3-A KSP39	M82
T839NF02500-28RH5-A KSP39	M82
T839NF03125-24RH3-A KSP39	M82
T839NF03125-24RH5-A KSP39	M82
T839NF03750-24RH3-A KSP39	M82
T839NF03750-24RH4-A KSP39	M82
T839NF03750-24RH5-A KSP39	M83
T839NF04375-20RH3-A KSP39	M83
T839NF04375-20RH5-A KSP39	M83
T839NF05000-20RH3-A KSP39	M83
T839NF05625-18RH3-A KSP39	M83
T839NF06250-18RH3-A KSP39	M83
T839NF06250-18RH5-A KSP39	M83
T839NF07500-16RH3-A KSP39	M83
T846NPT01250-27R-AS KSU30	M153
T846NPT02500-18R-A KSU30	M153
T846NPT03750-18R-A KSU30	M153
T846NPT05000-14R-A KSU30	M153
T846NPT07500-14R-A KSU30	M153
T848NPT00625-27R-D55 KSU30	M156
T848NPT01250-27R-D55 KSU30	M156
T848NPT02500-18R-D55 KSU30	M156
T848NPT03750-18R-D55 KSU30	M156
T848NPT05000-14R-D55 KSU30	M156
T848NPT07500-14R-D55 KSU30	M156
T848NPT10000-11,5R-D55 KSU30	M156
T848NPTF00625-27R-D55 KSU30	M156
T848NPTF01250-27R-D55 KSU30	M156
T848NPTF02500-18R-D55 KSU30	M156
T848NPTF03750-18R-D55 KSU30	M156
T848NPTF05000-14R-D55 KSU30	M156
T848NPTF07500-14R-D55 KSU30	M156
T848NPTF10000-11,5R-D55 KSU30	M156
T854NPT00625-27R-A KSP39	M152
T854NPT00625-27R-A KSU31	M152
T854NPT01250-27R-A KSP39	M152
T854NPT01250-27R-A KSU31	M152
T854NPT01250-27R-AS KSP39	M152
T854NPT01250-27R-AS KSU31	M152
T854NPT02500-18R-A KSP39	M152
T854NPT02500-18R-A KSU31	M152
T854NPT03750-18R-A KSP39	M152
T854NPT03750-18R-A KSU31	M152
T854NPT05000-14R-A KSP39	M152
T854NPT05000-14R-A KSU31	M152
T854NPT07500-14R-A KSP39	M152
T854NPT07500-14R-A KSU31	M152
T854NPT10000-11.5R-A KSP39	M152
T854NPT10000-11.5R-A KSU31	M152
T854NPTF00625-27R-A KSP39	M152
T854NPTF01250-27R-A KSP39	M152
T854NPTF01250-27R-A KSU31	M152
T854NPTF01250-27R-AS KSP39	M152
T854NPTF01250-27R-AS KSU31	M152
T854NPTF02500-18R-A KSP39	M152
T854NPTF02500-18R-A KSU31	M152
T854NPTF03750-18R-A KSP39	M152
T854NPTF03750-18R-A KSU31	M152
T854NPTF05000-14R-A KSP39	M152
T854NPTF05000-14R-A KSU31	M152
T854NPTF07500-14R-A KSP39	M152
T854NPTF10000-11.5R-A KSP39	M152
T857G01250-28R-D56 KSP39	M155
T857G01250-28R-D56 KSU31	M155

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
T857G02500-19R-D56 KSP39	M155
T857G02500-19R-D56 KSU31	M155
T857G03750-19R-D56 KSP39	M155
T857G03750-19R-D56 KSU31	M155
T857G05000-14R-D56 KSP39	M155
T857G05000-14R-D56 KSU31	M155
T857G06250-14R-D56 KSP39	M155
T857G06250-14R-D56 KSU31	M155
T857G07500-14R-D56 KSP39	M155
T857G07500-14R-D56 KSU31	M155
T857G08750-14R-D56 KSP39	M155
T857G08750-14R-D56 KSU31	M155
T857G10000-11R-D56 KSP39	M155
T857G10000-11R-D56 KSU31	M155
T860NF02500-28RH3-XL6 KSP39	M100
T877G01250-28R-D56 KSP39	M154
T877G01250-28R-D56 KSU31	M154
T877G02500-19R-D56 KSP39	M154
T877G02500-19R-D56 KSU31	M154
T877G03750-19R-D56 KSP39	M154
T877G03750-19R-D56 KSU31	M154
T877G05000-14R-D56 KSP39	M154
T877G05000-14R-D56 KSU31	M154
T877G06250-14R-D56 KSP39	M154
T877G06250-14R-D56 KSU31	M154
T877G07500-14R-D56 KSP39	M154
T877G07500-14R-D56 KSU31	M154
T877G08750-14R-D56 KSP39	M154
T877G08750-14R-D56 KSU31	M154
T877G10000-11R-D56 KSP39	M154
T877G10000-11R-D56 KSU31	M154
T9 S	T127–128, T131
TB15	V12, V19, V97–98, V102–103
TB20	V26
TCGT21505HP KC5010	B256
TCGT21505HP KC5410	B256
TCGT21505HP KCU25	B256
TCGT2150LF KC5025	B256
TCGT2150LF KCU10	B256
TCGT2151HP K313	B256
TCGT2151HP KC5010	B256
TCGT2151HP KC5025	B256
TCGT2151HP KC5410	B256
TCGT2151HP KCU10	B256
TCGT2151HP KCU25	B256
TCGT2151LF KC5010	B256
TCGT2151LF KC5025	B256
TCGT2151LF KCU10	B256
TCGT2152HP KC5010	B256
TCGT32505HP KC5010	B256
TCGT32505HP KCU25	B256
TCGT32505LF KC5010	B256
TCGT3250LF KCU10	B256
TCGT3251HP K313	B256
TCGT3251HP KC5010	B256
TCGT3251HP KC5025	B256
TCGT3251HP KC5410	B256
TCGT3251HP KCU10	B256
TCGT3251LF KC5010	B256
TCGT3251LF KCU10	B256
TCGT3252HP K313	B256
TCGT3252HP KC5010	B256
TCGT3252HP KC5025	B256
TCGT3252HP KC5410	B256
TCGT3252HP KCU10	B256
TCGT3252LF KC5010	B256
TCGT3252LF KCU10	B256
TCGW181505S0415MT KBH20	B338
TCGW18151S0415MT KBH20	B338
TCGW21505S0415MT KBH10	B338
TCGW21505S0415MT KBH20	B338
TCGW2151FST KD1400	B366
TCGW2151FST KD1425	B366
TCGW2151S0415MT KBH10	B338
TCGW2151S0415MT KBH20	B338
TCGW2151S0525MT KBH10	B338
TCGW2152S0415MT KBH10	B338
TCGW2152S0415MT KBH20	B338
TCGW2152S0525MT KBH10	B338
TCGW3251FST KD1400	B366
TCMT18151FP KCP25B	B257
TCMT18151FP KCU10	B257
TCMT18151FP KCU25	B257
TCMT18152FP KCU10	B257
TCMT18152FP KCU25	B257
TCMT21505FP KCU25	B257
TCMT21505FP KTP10	B257
TCMT21505LF KC5010	B257
TCMT21505LF KC5025	B257
TCMT215111 KT315	B256
TCMT2151FP KCK20B	B257
TCMT2151FP KCM25	B257
TCMT2151FP KCP10	B257
TCMT2151FP KCP25	B257
TCMT2151FP KCU10	B257
TCMT2151FP KCU25	B257
TCMT2151FP KTP10	B257
TCMT2151LF KC5010	B257
TCMT2151LF KC5025	B257
TCMT2151LF KCK05	B257
TCMT2151LF KCK15	B257
TCMT2151LF KCK15B	B257
TCMT2151LF KCK20	B257
TCMT2151LF KCK20B	B257
TCMT2151LF KCM15	B257
TCMT2151LF KCM15B	B257
TCMT2151LF KCM25B	B257
TCMT2151LF KCM35	B257
TCMT2151LF KCP10	B257
TCMT2151LF KCP10B	B257
TCMT2151LF KCP25	B257
TCMT2151LF KCP25B	B257
TCMT2151LF KCP30	B257
TCMT2151LF KT315	B257
TCMT2151UF KC5010	B258
TCMT2151UF KCP25	B258
TCMT2152FP KCM15	B257
TCMT2152FP KCP25	B257
TCMT2152FP KCU10	B257
TCMT2152FP KCU25	B257
TCMT2152LF KC5010	B257
TCMT2152LF KC5025	B257
TCMT2152LF KCK05	B257
TCMT2152LF KCK15	B257
TCMT2152LF KCK15B	B257
TCMT2152LF KCK20	B257
TCMT2152LF KCK20B	B257
TCMT2152LF KCM15	B257
TCMT2152LF KCM25B	B257
TCMT2152LF KCP10	B257
TCMT2152LF KCP25	B257
TCMT2152LF KCP25B	B257
TCMT2152LF KCP30	B257
TCMT2152LF KT315	B257
TCMT2152MF KCK15	B258
TCMT2152MF KCK20	B258
TCMT2152MF KCK20B	B258
TCMT2152MF KCM25B	B258
TCMT2152MF KCP25	B258
TCMT2152MF KCP25B	B258
TCMT2152MP KCK20B	B258
TCMT2152MP KCP25	B258
TCMT2152MP KCU10	B258
TCMT2152UF KC5010	B258
TCMT221FP KCP10B	B257
TCMT221FP KCU10	B257
TCMT221FP KCU25	B257
TCMT222FP KCP05	B257
TCMT222FP KCU10	B257
TCMT222FP KCU25	B257
TCMT223FP KCP05	B257
TCMT223FP KCU10	B257
TCMT32505LF KC5010	B257
TCMT32505LF KC5025	B257
TCMT325111 KT315	B256
TCMT3251FP KCP10	B257
TCMT3251FP KCP25	B257
TCMT3251FP KCU10	B257
TCMT3251FP KCU25	B257
TCMT3251LF KC5010	B257
TCMT3251LF KC5025	B257
TCMT3251LF KCK05	B257
TCMT3251LF KCK15	B257
TCMT3251LF KCK20	B257
TCMT3251LF KCK20B	B257
TCMT3251LF KCM15	B257
TCMT3251LF KCM25B	B257
TCMT3251LF KCM35	B257
TCMT3251LF KCP10	B257
TCMT3251LF KCP10B	B257
TCMT3251LF KCP25	B257
TCMT3251LF KCP25B	B257
TCMT3251LF KT315	B257
TCMT3251MP KCK20B	B258
TCMT3251MP KCM25	B258
TCMT3251MP KCM25B	B258
TCMT3251MP KCP25	B258
TCMT3251MP KCU10	B258
TCMT325211 KT315	B256
TCMT3252FP KCM25	B257
TCMT3252FP KCP10	B257
TCMT3252FP KCP25	B257
TCMT3252FP KCU10	B257
TCMT3252FP KCU25	B257
TCMT3252FP KTP10	B257
TCMT3252LF KC5010	B257
TCMT3252LF KC5025	B257
TCMT3252LF KCK05B	B257
TCMT3252LF KCK15	B257
TCMT3252LF KCK15B	B257
TCMT3252LF KCK20	B257
TCMT3252LF KCK20B	B257
TCMT3252LF KCM25	B257
TCMT3252LF KCM25B	B257
TCMT3252LF KCM35	B257
TCMT3252LF KCP10	B257
TCMT3252LF KCP10B	B257
TCMT3252LF KCP25	B257
TCMT3252LF KCP25B	B257
TCMT3252LF KCP30	B257
TCMT3252LF KT315	B257
TCMT3252MF KCK15	B258
TCMT3252MF KCK15B	B258
TCMT3252MF KCK20	B258
TCMT3252MF KCK20B	B258
TCMT3252MF KCM25	B258
TCMT3252MF KCM25B	B258
TCMT3252MF KCM35	B258
TCMT3252MF KCP10	B258
TCMT3252MF KCP25	B258
TCMT3252MF KCP25B	B258
TCMT3252MF KCP30	B258
TCMT3252MP KCK20B	B258
TCMT3252MP KCM15	B258
TCMT3252MP KCM25	B258
TCMT3252MP KCM25B	B258
TCMT3252MP KCP10	B258
TCMT3252MP KCP25	B258
TCMT3252MP KCU10	B258
TCMT3252UF KC5010	B258
TCMT3252UF KCP25	B258
TCMT3253FP KCP10	B257
TCMT3253FP KCU10	B257
TCMT3253FP KCU25	B257
TCMT3253LF KC5010	B257
TCMT3253LF KCK15	B257
TCMT3253LF KCK20	B257
TCMT3253LF KCK20B	B257
TCMT3253LF KCM25	B257
TCMT3253LF KCP10B	B257
TCMT3253LF KCP25	B257
TCMT3253MF KCK20	B258
TCMT3253MF KCK20B	B258
TCMT3253MF KCM25B	B258
TCMT3253MF KCP10	B258
TCMT3253MF KCP25B	B258
TCMT3253MP KCP25	B258
TCMT432FP KCM25	B257
TCMT432FP KCP05	B257
TCMT432FP KCP25	B257
TCMT432FP KCU10	B257
TCMT432FP KCU25	B257
TCMT432LF KC5010	B257
TCMT432LF KC5025	B257
TCMT432LF KCK15B	B257
TCMT432LF KCK20B	B257
TCMT432LF KCP10B	B257
TCMT432LF KCP25	B257
TCMT432LF KCP25B	B257
TCMW3251 KCK20B	B258
TCMW3252 KCK20B	B258
TD6P K68	B266
TD6P05 KC5010	B266
TD6P1 KC5010	B266
TD6P2 KC5010	B266
TDHB12807501 KC5010	B263
TDHB12807501 KCU25	B263
TDHB12807501 KT315	B263
TDHB12807505 KC5010	B263
TDHB12807505 KC5025	B263
TDHB12807505 KCU10	B263
TDHB12807505 KCU25	B263
TDHB1280751 KC5010	B263
TDHB1280751 KC5025	B263
TDHB1280751 KCU10	B263
TDHB1280751 KCU25	B263
TDHB1280751 KT315	B263
TDHB1280752 KC5025	B263
TDHH12807505L KC5010	B263
TDHH12807505L KCU10	B263
TDHH12807505L KCU25	B263
TDHH12807505R KCU10	B263
TDHH1280751L KC5010	B263
TDHH1280751L KCU10	B263
TDHH1280751L KCU25	B263
TDHH1280751R KCU10	B263
THW2M	T63, T65, V77, V139–142
THW3M	U28–29, U35–37
TK01338D	E60
TK01339D	E60
TM24D053L102Z1	W4
TM24D059L118Z1	W4
TM24D063L110Z2	W4
TM24D063L142Z1	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

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
TM24N32UN KC610M	W6
TM24N32UN KC635M	W6
TM25BLANK	W15
TM25D17L26Z2	W10
TM25D17L36Z2	W10
TM25D20L37Z3	W10
TM25D20L44Z3	W10
TM25D22L43Z3	W10
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
TM40D087L169Z3	W17
TM40D087L256Z3	W17
TM40D118L215Z4	W17
TM40D118L315Z3	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
TM41D083L177Z1	W24
TM41D097L169Z2	W24
TM41D118L256Z3	W24
TM41D142L169Z5	W24
TM41D142L256Z4	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	M165
TM711M040X070R2DHA KCU33	M165
TM711M050X080R2DHA KCU33	M165
TM711M060X100R2DHA KCU33	M165
TM711M080X125R2DHA KCU33	M165
TM711M100X150R2DHA KCU33	M165
TM711M120X175R2DHA KCU33	M165
TM711M140X200R2DHA KCU33	M165
TM711M160X200R2DHA KCU33	M165
TM711M180X250R2DHA KCU33	M165
TM711M200X250R2DHA KCU33	M165
TM711MF040X050R2DHA KCU33	M165
TM711MF050X050R2DHA KCU33	M165
TM711MF060X075R2DHA KCU33	M165
TM711MF080X075R2DHA KCU33	M165
TM711MF080X100R2DHA KCU33	M165
TM711MF100X100R2DHA KCU33	M165
TM711MF120X100R2DHA KCU33	M165
TM711MF120X150R2DHA KCU33	M165
TM711MF140X150R2DHA KCU33	M165
TM711MF160X150R2DHA KCU33	M165
TM711MF180X150R2DHA KCU33	M165
TM711MF200X150R2DHA KCU33	M165
TM721M060X100R2DHA KCU32	M166
TM721M080X125R2DHA KCU32	M166
TM721M100X150R2DHA KCU32	M166
TM721M120X175R2DHA KCU32	M166
TM721M140X200R2DHA KCU32	M166
TM721M160X200R2DHA KCU32	M166
TM721MF080X100R2DHA KCU32	M166
TM721MF120X125R2DHA KCU32	M166
TM721MF140X150R2DHA KCU32	M166
TM721NC0500-13R2DHA KCU32	M166
TM721NC0625-11R2DHA KCU32	M166
TM721NC2500-20R2DHA KCU32	M166
TM721NC3125-18R2DHA KCU32	M166
TM721NC3750-16R2DHA KCU32	M166
TM721NC4375-14R2DHA KCU32	M166
TM721NC5625-12R2DHA KCU32	M166
TM731M040X070R2DHA KCU32	M167
TM731M050X080R2DHA KCU32	M167
TM731M060X100R2DHA KCU32	M167
TM731M080X125R2DHA KCU32	M167
TM731M100X150R2DHA KCU32	M167
TM731M120X175R2DHA KCU32	M167
TM731M160X200R2DHA KCU32	M167
TM731MF080X100R2DHA KCU32	M167
TM741M060X100R2DHA KCU36	M169
TM741M080X125R2DHA KCU36	M169
TM741M100X150R2DHA KCU36	M169
TM741M120X175R2DHA KCU36	M169
TM741M140X200R2DHA KCU36	M169
TM741M160X200R2DHA KCU36	M169
TM741M180X250R2DHA KCU36	M169
TM741M200X250R2DHA KCU36	M169
TM741MF080X100R2DHA KCU36	M169
TM741MF100X100R2DHA KCU36	M169
TM741MF100X125R2DHA KCU36	M169
TM741MF120X150R2DHA KCU36	M169
TM741NC0500-13R2DHA KCU36	M168
TM741NC0750-10R2DHA KCU36	M168
TM741NC0750-16R2DHA KCU36	M168
TM741NC2500-20R2DHA KCU36	M168
TM741NC3125-18R2DHA KCU36	M168
TM741NC3750-16R2DHA KCU36	M168
TM741NF0500-20R2DHA KCU36	M168
TM741NF0625-18R2DHA KCU36	M168
TM741NF2500-28R2DHA KCU36	M168
TM741NF3125-24R2DHA KCU36	M168
TM741NF3750-24R2DHA KCU36	M168
TMC25D30L80Z4	W10
TMS25D154L126Z5	W12
TMS25D193L138Z7	W12
TMS25D232L158Z9	W12
TMS25D36L34Z5	W10
TMS25D44L38Z6	W10
TMS25D52L40Z8	W10
TMS40D193L197Z7	W18
TMS40D232L200Z9	W18
TMS41D210L200Z5	W25
TMS41D250L200Z6	W25
TMST25D154L126Z5	W13
TMST40D193L197Z7	W19
TMT24D055L102Z1	W5
TMT25D067L110Z2	W11
TMT25D087L170Z3	W11
TMT25D110L170Z4	W11
TMT25D17L26Z2	W11
TMT25D22L43Z3	W11
TMT25D28L43Z4	W11
TNG222T0820 KY1615	B339
TNG331T0820 KY1615	B339
TNG332T0820 KY1615	B319, B339
TNG332T0820 KY3500	B319
TNG333T0820 KY1615	B339
TNG334T0820 KY1615	B339
TNG352T0820 KY1615	B339
TNG353T0820 KY1615	B339
TNG432T0820 KY1615	B339
TNG433T0420 KYS25	B354
TNG434T0420 KYS25	B354
TNG434T0820 KY3500	B319
TNGA331S0415MT KBH10	B339
TNGA331S0415MT KBH20	B339
TNGA331S0525MT KBH20	B339
TNGA331S0735MT KBH20	B339
TNGA332S0415MT KBH10	B339
TNGA332S0415MT KBH20	B339
TNGA332S0525MT KBH10	B339
TNGA332S0525MT KBH20	B339
TNGA332S0735MT KBH10	B339
TNGA332S0735MT KBH20	B339
TNGA332T0820 KY1615	B339
TNGA332T0820 KY3500	B314
TNGA332T0820 KYK10	B314
TNGA333S0415MT KBH10	B339
TNGA333S0415MT KBH20	B339
TNGA333S0525MT KBH10	B339
TNGA333S0525MT KBH20	B339
TNGA333S0735MT KBH10	B339
TNGA333S0735MT KBH20	B339
TNGA333T0820 KY1615	B339
TNGA333T0820 KY3500	B314
TNGA334T0820 KY3500	B314
TNGA432T0820 KY1615	B339
TNGA433T0820 KY1615	B339
TNGG3305FS KC5025	B121
TNGG3305LF KC5010	B121
TNGG3305LF KCU10	B121
TNGG331FS KC5010	B121
TNGG331FS KC5025	B121
TNGG331FS KCU10	B121
TNGG331LF KC5010	B121
TNGG332LF KC5010	B121
TNGG432FS KCU10	B121
TNGM332S0525MTCB1 KBH20	B340
TNGN234S0820 KBK45	B306
TNGN334S0820 KBK45	B306
TNGP3305 KC5010	B121
TNGP3305 KCU10	B121
TNGP331 KC5010	B121
TNGP331 KC5410	B121
TNGP331 KCU10	B121
TNGP332 KC5010	B121
TNGP332 KC5410	B121
TNGP332 KCU10	B121
TNGX334S0820 KBK45	B308
TNMA332 K68	B122
TNMA332 KCK15	B122
TNMA332 KCK15B	B122
TNMA332 KCK20	B122
TNMA332 KCK20B	B122
TNMA333 KCK15	B122
TNMA333 KCK20	B122
TNMA334 KCK15	B122
TNMA334 KCK20	B122
TNMA432 K68	B122
TNMA432 KCK05	B122
TNMA432 KCK20B	B122
TNMA433 KCK15B	B122
TNMA433 KCK20B	B122
TNMA544 KCK15	B122
TNMG221FF KCU10	B123
TNMG221FN KCP25	B123
TNMG222FF KC5010	B123
TNMG222FN KCP10	B123
TNMG222FN KCP25	B123
TNMG3305MS KC5010	B125
TNMG3305MS KC5025	B125
TNMG3305MS KCU10	B125
TNMG3305MS KCU25	B125
TNMG331FF KC5010	B123
TNMG331FF KCM15B	B123
TNMG331FF KCP10	B123
TNMG331FF KCU10	B123
TNMG331FF KT315	B123
TNMG331FN KCK05	B123
TNMG331FN KCK15B	B123
TNMG331FN KCP05	B123
TNMG331FN KCP10	B123
TNMG331FN KCP10B	B123
TNMG331FN KCP25	B123
TNMG331FN KCP25B	B123
TNMG331FN KT315	B123
TNMG331FP KC5010	B123
TNMG331FP KCM15	B123
TNMG331FP KCU10	B123
TNMG331FP KT315	B123
TNMG331FW KC5010	B124
TNMG331FW KCP05	B124
TNMG331FW KCP10	B124
TNMG331FW KCU10	B124
TNMG331FW KT315	B124
TNMG331MN KCP10	B124
TNMG331MN KCP10B	B124
TNMG331MN KCP25	B124
TNMG331MN KCP25B	B124
TNMG331MN KCP30	B124
TNMG331MP KC5010	B124
TNMG331MP KCM15	B124
TNMG331MP KCM15B	B124
TNMG331MP KCM25	B124
TNMG331MP KCM25B	B124
TNMG331MP KCM35B	B124
TNMG331MP KCU10	B124
TNMG331MS KC5010	B125
TNMG331MS KC5025	B125

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
TNMG331MS KCU10	B125
TNMG331MS KCU25	B125
TNMG331P KC5010	B126
TNMG331P KCU10	B126
TNMG331UP KCM25	B128
TNMG332CT KCPK05	B122
TNMG332FF KC5010	B123
TNMG332FF KCP05	B123
TNMG332FF KCP10B	B123
TNMG332FF KCU10	B123
TNMG332FF KT315	B123
TNMG332FN KCK05	B123
TNMG332FN KCK15B	B123
TNMG332FN KCP05B	B123
TNMG332FN KCP10	B123
TNMG332FN KCP10B	B123
TNMG332FN KCP25	B123
TNMG332FN KCP25B	B123
TNMG332FN KT315	B123
TNMG332FP KC5010	B123
TNMG332FP KCM15	B123
TNMG332FP KCP10	B123
TNMG332FP KCU10	B123
TNMG332FP KT315	B123
TNMG332FW KCP05	B124
TNMG332FW KCP10B	B124
TNMG332FW KT315	B124
TNMG332MG KCP10B	B125
TNMG332MN KCP05	B124
TNMG332MN KCP10	B124
TNMG332MN KCP10B	B124
TNMG332MN KCP25	B124
TNMG332MN KCP25B	B124
TNMG332MN KCP30	B124
TNMG332MN KCP30B	B124
TNMG332MP KC5010	B124
TNMG332MP KCM15	B124
TNMG332MP KCM15B	B124
TNMG332MP KCM25	B124
TNMG332MP KCM25B	B124
TNMG332MP KCM35	B124
TNMG332MP KCM35B	B124
TNMG332MP KCP25	B124
TNMG332MP KCP25B	B124
TNMG332MP KCU10	B124
TNMG332MR KCM25	B125
TNMG332MR KCM25B	B125
TNMG332MR KCP10B	B125
TNMG332MR KCP25B	B125
TNMG332MS KC5010	B125
TNMG332MS KC5025	B125
TNMG332MS KCU10	B125
TNMG332MS KCU25	B125
TNMG332MW KCP05	B126
TNMG332MW KCP10	B126
TNMG332MW KCP25	B126
TNMG332MW KCP25B	B126
TNMG332P KCU10	B126
TNMG332RN KCP10	B126
TNMG332RN KCP10B	B126
TNMG332RN KCP25	B126
TNMG332RN KCP25B	B126
TNMG332RN KCP30	B126
TNMG332RP KC5010	B127
TNMG332RP KC5025	B127
TNMG332RP KCK05	B127
TNMG332RP KCK20	B127
TNMG332RP KCM15	B127
TNMG332RP KCM25	B127
TNMG332RP KCP05	B127
TNMG332RP KCP10	B127
TNMG332RP KCP10B	B127
TNMG332RP KCP25	B127
TNMG332RP KCP25B	B127
TNMG332RP KCP30	B127
TNMG332RP KCU10	B127
TNMG332RP KCU25	B127
TNMG332UN KCK05	B127
TNMG332UN KCK15	B127
TNMG332UN KCK15B	B127
TNMG332UN KCK20	B127
TNMG332UN KCK20B	B127
TNMG332UP KCM15	B128
TNMG332UP KCM25	B128
TNMG333FN KCK05	B123
TNMG333FN KCP05	B123
TNMG333FN KCP10B	B123
TNMG333FN KCP25	B123
TNMG333FN KT315	B123
TNMG333FP KC5010	B123
TNMG333FP KCM15	B123
TNMG333FP KCU10	B123
TNMG333FW KCP05	B124
TNMG333FW KCP10B	B124
TNMG333FW KT315	B124
TNMG333MN KCP10B	B124
TNMG333MN KCP25	B124
TNMG333MN KCP25B	B124
TNMG333MN KCP40	B124
TNMG333MP KC5010	B124
TNMG333MP KCM15B	B124
TNMG333MP KCM25	B124
TNMG333MP KCM25B	B124
TNMG333MR KCK15B	B125
TNMG333MR KCP10B	B125
TNMG333MR KCP25B	B125
TNMG333MW KCP10	B126
TNMG333MW KCP10B	B126
TNMG333MW KCP25	B126
TNMG333RN KCP10B	B126
TNMG333RN KCP25	B126
TNMG333RN KCP25B	B126
TNMG333RN KCP30	B126
TNMG333RP KC5025	B127
TNMG333RP KCK20	B127
TNMG333RP KCM25	B127
TNMG333RP KCM35	B127
TNMG333RP KCP05	B127
TNMG333RP KCP10	B127
TNMG333RP KCP10B	B127
TNMG333RP KCP25	B127
TNMG333RP KCP25B	B127
TNMG333RP KCU25	B127
TNMG333UN KCK05	B127
TNMG333UN KCK05B	B127
TNMG333UN KCK15B	B127
TNMG333UN KCK20	B127
TNMG333UN KCK20B	B127
TNMG334RP KCP10	B127
TNMG334UN KCK20	B127
TNMG431FN KCP25	B123
TNMG431FP KC5010	B123
TNMG431FP KCM15	B123
TNMG431FP KCM25B	B123
TNMG431FP KCU10	B123
TNMG431MN KCP10	B124
TNMG431MN KCP25	B124
TNMG431MN KCP25B	B124
TNMG431MN KCP30	B124
TNMG431MS KC5010	B125
TNMG431MS KC5025	B125
TNMG431MS KCU10	B125
TNMG431MS KCU25	B125
TNMG431P KCU10	B126
TNMG432FN KCP10B	B123
TNMG432FN KCP25	B123
TNMG432FP KCM15	B123
TNMG432FP KCU10	B123
TNMG432MN KCP10	B124
TNMG432MN KCP10B	B124
TNMG432MN KCP25	B124
TNMG432MN KCP25B	B124
TNMG432MN KCP40	B124
TNMG432MP KC5010	B124
TNMG432MP KCM15B	B124
TNMG432MP KCM25	B124
TNMG432MP KCM25B	B124
TNMG432MP KCP10B	B124
TNMG432MP KCU10	B124
TNMG432MR KCM25	B125
TNMG432MR KCP25B	B125
TNMG432MS K313	B125
TNMG432MS KC5010	B125
TNMG432MS KC5025	B125
TNMG432MS KCU10	B125
TNMG432MS KCU25	B125
TNMG432P KCU10	B126
TNMG432RN KCP10B	B126
TNMG432RN KCP25	B126
TNMG432RN KCP25B	B126
TNMG432RN KCP30	B126
TNMG432RN KCP30B	B126
TNMG432RN KCP40	B126
TNMG432RN KCP40B	B126
TNMG432RP KC5010	B127
TNMG432RP KC5025	B127
TNMG432RP KCK20B	B127
TNMG432RP KCM25	B127
TNMG432RP KCM25B	B127
TNMG432RP KCP10B	B127
TNMG432RP KCP25	B127
TNMG432RP KCP25B	B127
TNMG432RP KCP40B	B127
TNMG432RP KCU10	B127
TNMG432RP KCU25	B127
TNMG432UN KCK20	B127
TNMG432UP KCM25	B128
TNMG432UP KCM35	B128
TNMG433 K68	B122
TNMG433FN KCP10B	B123
TNMG433FN KCP25	B123
TNMG433MN KCP10B	B124
TNMG433MN KCP25	B124
TNMG433MN KCP25B	B124
TNMG433MN KCP30	B124
TNMG433MN KCP40B	B124
TNMG433MP KC5010	B124
TNMG433MP KCM25	B124
TNMG433MP KCM25B	B124
TNMG433MR KCM25B	B125
TNMG433MS KCU10	B125
TNMG433MS KCU25	B125
TNMG433P KCU10	B126
TNMG433RN KCP10	B126
TNMG433RN KCP10B	B126
TNMG433RN KCP25	B126
TNMG433RN KCP25B	B126
TNMG433RN KCP30B	B126
TNMG433RN KCP40B	B126
TNMG433RP KCM25	B127
TNMG433RP KCM25B	B127
TNMG433RP KCP10	B127
TNMG433RP KCP25B	B127
TNMG433RP KCP40	B127
TNMG433RP KCU10	B127
TNMG433RP KCU25	B127
TNMG433UN KCK15	B127
TNMG433UN KCK20	B127
TNMG434MP KC5010	B124
TNMG434RN KCP25	B126
TNMG434RN KCP25B	B126
TNMG434RP KCK15	B127
TNMG434RP KCM25	B127
TNMG434RP KCP10	B127
TNMG434RP KCP25B	B127
TNMG434RP KCU25	B127
TNMG434UN KCK20	B127
TNMG438RP KC5010	B127
TNMG438RP KCK20	B127
TNMG438RP KCP10B	B127
TNMG438RP KCP25B	B127
TNMG438RP KCP30	B127
TNMG542MS KC5025	B125
TNMG542MS KCU25	B125
TNMG542RN KCP10	B126
TNMG542RN KCP25	B126
TNMG542RN KCP25B	B126
TNMG542RN KCP30	B126
TNMG543MR KCP25B	B125
TNMG543RN KCP10	B126
TNMG543RN KCP10B	B126
TNMG543RN KCP25	B126
TNMG543RN KCP30B	B126
TNMG543RN KCP40	B126
TNMG543RP KC5010	B127
TNMG543RP KCM15	B127
TNMG543RP KCM25B	B127
TNMG543RP KCM35	B127
TNMG543RP KCP10	B127
TNMG543RP KCP25	B127
TNMG543RP KCU10	B127
TNMG543RP KCU25	B127
TNMG544MS K313	B125
TNMG544RN KCP10	B126
TNMG544RN KCP25	B126
TNMG544RN KCP25B	B126
TNMG544RN KCP30B	B126
TNMG544RN KCP40B	B126
TNMG544RP KCM25	B127
TNMG544RP KCP25B	B127
TNMG544RP KCU10	B127
TNMG666 KCP25	B122
TNMG666 KCP40	B122
TNMG666RN KCP10B	B126
TNMG666RN KCP25	B126
TNMG666RN KCP25B	B126
TNMG666RN KCP30B	B126
TNMG666RN KCP40B	B126
TNMG666RP KCM25	B127
TNMG666RP KCP25	B127
TNMG666RP KCP40	B127
TNMG666RP KCP40B	B127
TNMG666RP KCU10	B127
TNMM332RM KCP25	B128
TNMM332RM KCP25B	B128
TNMM332RM KCP30	B128
TNMM333RM KCP25	B128
TNMM432RM KCP25B	B128
TNMM432RP KCP10	B129
TNMM432RP KCP10B	B129
TNMM433RM KCP25	B128
TNMM433RM KCP25B	B128
TNMM433RM KCP30	B128
TNMM433RP KCM25B	B129
TNMM433RP KCP25	B129
TNMM434RM KCP25B	B128
TNMM434RP KCP10	B129
TNMM543RM KCP25	B128
TNMM543RM KCP30	B128
TNMM544RM KCP25	B128
TNMM666MR KCP25B	B128
TNMP331 K313	B129
TNMP331K KCP25B	B129
TNMP332 K313	B129
TNMP332K KCP10	B129
TNMP332K KCP25	B129
TNMP332K KCP25B	B129
TNMP432K KCP25	B129
TNMP432K KCP25B	B129
TNMP434 K68	B129
TNMS331 K68	B130
TNMS331FST KD1400	B366
TNMS331FST KD1425	B366
TNMS332 K68	B130
TNMS332FST KD1400	B366
TNMS332FST KD1425	B366
TNMS432 K68	B130
TNMS432 KC5410	B130
TP15	V114
TP20	T96–99, V25–26
TP7	V4–5
TP8	V111, V113–114
TPCB2205 KC5010	B266
TPCG2205L KC5010	B266
TPCG221L KC5010	B266
TPCG222L KC5010	B266
TPCH2205 KC5010	B266
TPCH221 KC5010	B266
TPG221 K313	B177
TPG221 K68	B177
TPG221 KC5010	B177
TPG221 KCU10	B177
TPG221F KD1425	B367
TPG221T0420 KY1615	B340
TPG222 K68	B177
TPG222 KC5010	B177
TPG222 KCU10	B177
TPG222T0420 KY1615	B340

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
TPG223T0420 KY1615	B340
TPG3205 K313	B177
TPG3205 K68	B177
TPG3205 KC5010	B177
TPG321 K313	B177
TPG321 K68	B177
TPG321 KC5010	B177
TPG321 KCU10	B177
TPG321F KD1425	B367
TPG321T0220 KY1615	B340
TPG321T0420 KY1615	B340
TPG322 K313	B177
TPG322 K68	B177
TPG322 KC5010	B177
TPG322 KCU10	B177
TPG322F KD1425	B367
TPG322T0220 KY1615	B340
TPG322T0420 KY1615	B340
TPG322T0820 KY3500	B320
TPG323 K313	B177
TPG323 KC5010	B177
TPG323T0420 KY1615	B340
TPG323T0820 KY3500	B320
TPG323T0820 KYK10	B320
TPG324 K68	B177
TPG324 KC5010	B177
TPG431 K313	B177
TPG431 K68	B177
TPG431 KC5010	B177
TPG431 KCU10	B177
TPG432 K313	B177
TPG432 K68	B177
TPG432 KC5010	B177
TPG432 KCP25B	B177
TPG432 KCU10	B177
TPG432F KD1425	B367
TPG432T0820 KY3500	B320
TPG433 K68	B177
TPG433 KC5010	B177
TPG433 KCU10	B177
TPG433T0820 KY3500	B320
TPG434 K68	B177
TPG434 KC5010	B177
TPGF221 KC5010	B177
TPGF222 KCU10	B177
TPGF321 KC5010	B177
TPGF321 KCU10	B177
TPGF322 KC5010	B177
TPGF322 KCP25B	B177
TPGF322 KCU10	B177
TPGF431 KCU10	B177
TPGF432 KCU10	B177
TPGH321 KCU10	B266
TPGH321 KCU25	B266
TPGH322 KC5010	B266
TPGT181505LF KC5010	B267
TPGT181505LF KCU10	B267
TPGT18151LF KC5010	B267
TPGT18151LF KC5025	B267
TPGT18151LF KC5410	B267
TPGT18151LF KCU10	B267
TPGT21505HP KC5010	B267
TPGT21505HP KC5025	B267
TPGT21505HP KCU10	B267
TPGT21505LF KC5010	B267
TPGT21505LF KC5025	B267
TPGT21505LF KCU10	B267
TPGT2150LF KCU10	B267
TPGT2151HP KC5010	B267
TPGT2151HP KC5025	B267
TPGT2151HP KC5410	B267
TPGT2151HP KCU25	B267
TPGT2151LF KC5010	B267
TPGT2151LF KC5025	B267
TPGT2151LF KC5410	B267
TPGT2151LF KCU10	B267
TPGT2152HP KC5010	B267
TPGT2152HP KC5410	B267
TPGT2152LF KC5010	B267
TPGT2152LF KCU10	B267
TPGT32505HP KC5010	B267
TPGT32505HP KCU10	B267
TPGT3251HP KC5010	B267
TPGT3251HP KC5025	B267
TPGT3251HP KC5410	B267
TPGT3251HP KCU10	B267
TPGT3251HP KCU25	B267
TPGT3251LF KC5010	B267
TPGT3251LF KC5025	B267
TPGT3252HP KC5010	B267
TPGT3252HP KC5410	B267
TPGT3252HP KCU10	B267
TPGT3252HP KCU25	B267
TPGT3252LF KC5010	B267
TPGT3252LF KC5410	B267
TPGT3252LF KCU10	B267
TPGW21505S0415MT KBH20	B341
TPGW2151EC KB1345	B312
TPGW2151FST KD1400	B367
TPGW2151FST KD1425	B367
TPGW2151S0415MT KBH20	B341
TPGW2152FST KD1400	B367
TPGW2152S0415C KB5630	B312, B340
TPGW2152S0415MT KBH20	B341
TPGW221S0415MT KBH10	B341
TPGW221S0525MT KBH10	B341
TPGW222S0525MT KBH10	B341
TPGW3251FST KD1425	B367
TPGW3251S0415MT KBH20	B341
TPGW3252FST KD1400	B367
TPGW3252FST KD1425	B367
TPGW3252S0415MT KBH20	B341
TPGW3252S0525MT KBH20	B341
TPGW331S0415MT KBH10	B341
TPGW331S0525MT KBH10	B341
TPGW332S0415MT KBH10	B341
TPGW332S0525MT KBH10	B341
TPGX0902ZPRGD KC7015	H85
TPGX0902ZPRGD KC7140	H85
TPGX0902ZPRGD KC7315	H85
TPGX1102ZPRGD KC7015	H85
TPGX1102ZPRGD KC7140	H85
TPGX1102ZPRGD KC7315	H85
TPGX1303ZPRGD KC7015	H85
TPGX1303ZPRGD KC7140	H85
TPGX1303ZPRGD KC7315	H85
TPGX1603ZPRGD KC7015	H85
TPGX1603ZPRGD KC7140	H85
TPGX1603ZPRGD KC7315	H85
TPMR221 KCK15B	B177
TPMR221 KCP25B	B177
TPMR222 KCP25B	B177
TPMR321 KCK15B	B177
TPMR321 KCP25B	B177
TPMR322 KCK15B	B177
TPMR322 KCP25B	B177
TPMR432 KCP25B	B177
TPMT181505LF KC5010	B268
TPMT18151FP KCU10	B267
TPMT18151LF KC5010	B268
TPMT18151LF KC5025	B268
TPMT18151LF KCK05	B268
TPMT18151LF KCK15	B268
TPMT18151LF KCM15B	B268
TPMT18151LF KCP10B	B268
TPMT18151LF KCP25	B268
TPMT18151LF KCP25B	B268
TPMT18151LF KT315	B268
TPMT18152FP KCP25	B267
TPMT18152FP KCU10	B267
TPMT18152FP KCU25	B267
TPMT21505FP KCU10	B267
TPMT21505LF KC5010	B268
TPMT21505UF KCP05	B269
TPMT2151FP KCP10	B267
TPMT2151FP KCP25	B267
TPMT2151FP KCU10	B267
TPMT2151FP KCU25	B267
TPMT2151LF K313	B268
TPMT2151LF KC5010	B268
TPMT2151LF KC5025	B268
TPMT2151LF KCK15B	B268
TPMT2151LF KCK20	B268
TPMT2151LF KCM15	B268
TPMT2151LF KCM25B	B268
TPMT2151LF KCP10	B268
TPMT2151LF KCP10B	B268
TPMT2151LF KCP25	B268
TPMT2151LF KCP25B	B268
TPMT2151LF KT315	B268
TPMT2151UF KC5010	B269
TPMT2151UF KCP05	B269
TPMT2152FP KCU10	B267
TPMT2152LF KC5010	B268
TPMT2152LF KC5025	B268
TPMT2152LF KCM25	B268
TPMT2152LF KCP10B	B268
TPMT2152LF KCP25	B268
TPMT2152LF KCP25B	B268
TPMT2152LF KT315	B268
TPMT2152MF KCK15	B268
TPMT2152MF KCK20	B268
TPMT2152MF KCM25	B268
TPMT2152MF KCP25	B268
TPMT2152MF KCP25B	B268
TPMT2152MP KCP25	B269
TPMT221FP KCP10B	B267
TPMT221FP KCU10	B267
TPMT221FP KCU25	B267
TPMT222FP KCU10	B267
TPMT3251FP KCK20	B267
TPMT3251FP KCM25	B267
TPMT3251FP KCP10	B267
TPMT3251FP KCP25	B267
TPMT3251FP KCU10	B267
TPMT3251FP KCU25	B267
TPMT3251LF KC5010	B268
TPMT3251LF KC5025	B268
TPMT3251LF KCK05	B268
TPMT3251LF KCK15	B268
TPMT3251LF KCM15	B268
TPMT3251LF KCM25B	B268
TPMT3251LF KCP10	B268
TPMT3251LF KCP10B	B268
TPMT3251LF KCP25	B268
TPMT3251LF KCP25B	B268
TPMT3251LF KT315	B268
TPMT3252FP KCP10	B267
TPMT3252FP KCP25	B267
TPMT3252FP KCU25	B267
TPMT3252LF KC5010	B268
TPMT3252LF KC5025	B268
TPMT3252LF KCK05	B268
TPMT3252LF KCK15	B268
TPMT3252LF KCK15B	B268
TPMT3252LF KCK20	B268
TPMT3252LF KCK20B	B268
TPMT3252LF KCM25	B268
TPMT3252LF KCP10B	B268
TPMT3252LF KCP25	B268
TPMT3252LF KCP25B	B268
TPMT3252LF KT315	B268
TPMT3252MF KCK15	B268
TPMT3252MF KCK20	B268
TPMT3252MF KCM15	B268
TPMT3252MF KCM25B	B268
TPMT3252MF KCP10	B268
TPMT3252MF KCP25	B268
TPMT3252MF KCP30	B268
TPMT3252MP KCK20B	B269
TPMT3252MP KCP25	B269
TPMT3252UF KCP10	B269
TPMT3253MF KCK15	B268
TPMT3253MF KCK20	B268
TPMT3253MF KCK20B	B268
TPMT3253MF KCP25	B268
TPMT3253MP KCP25	B269
TPMT432LF KC5010	B268
TPMT432LF KC5025	B268
TPMT432LF KCK20	B268
TPU221 K68	B178
TPU221 KCK15B	B178
TPU221T0220 KY1615	B341
TPU222 K68	B178
TPU222 KCK15B	B178
TPU222T0220 KY1615	B341
TPU321 K68	B178
TPU321 KCK15B	B178
TPU321 KCP25B	B178
TPU321T0220 KY1615	B341
TPU322 K68	B178
TPU322 KCK15B	B178
TPU322 KCP25B	B178
TPU322T0220 KY1615	B341
TPU323T0220 KY1615	B341
TPU432 K68	B178
TPU432 KCK15B	B178
TPU432 KCP25B	B178
TPU433 K68	B178
TPU433 KCK15B	B178
TPU433 KCP25B	B178
TRAOL1615D	E70
TRAOL162D	E70
TRAOL163D	E70
TRAOL164D	E70
TRAOL2015D	E70
TRAOL202D	E70
TRAOL203D	E70
TRAOL204D	E70
TRAOL2415E	E70
TRAOL242E	E70
TRAOL243E	E70
TRAOL244E	E70
TRAOR1615D	E70
TRAOR162D	E70
TRAOR163D	E70
TRAOR164D	E70
TRAOR2015D	E70
TRAOR202D	E70
TRAOR203D	E70
TRAOR204D	E70
TRAOR2415E	E70
TRAOR242E	E70
TRAOR243E	E70
TRAOR244E	E70
TRHOR1615D	E70
TRHOR162D	E70
TRHOR2015D	E70
TRM50L0432M	E71
TRM50L0620M	E71
TRM50L0632M	E71
TRM50L0640M	E71
TRM50L0920M	E71
TRM50L0932M	E71
TRM50L0950M	E71
TRM50R0432M	E71
TRM50R0620M	E71
TRM50R0632M	E71
TRM50R0640M	E71
TRM50R0720M	E71
TRM50R0920M	E71
TRM50R0932M	E71
TRM50R0940M	E71
TRM50R0950M	E71
TRTOR1615D	E71
TRTOR162D	E71
TRTOR2015D	E71
TRTOR202D	E71
TT15	K42–43, T119–120, U17–18
TT25	K42–43, V87–88, V91, W40–43
TT30	K42–43, W41
TTP15	S44–45, T120, U35–37
TTP20	S32, S50, V155–156
TTP25	S24
TTP9	U28–29
TWDL10TM	056
TWDL12TM	056
TWDL16TM	056
TWDL20TM	056
TWDL25TM	056
TWDL32TM	056
TWDLTM	056
TWTMBC	056
TWTMEXT	056
TWTMINSERTDL10	056
TWTMINSERTDL10W	056
TWTMINSERTDL12	056
TWTMINSERTDL12W	056

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
TWTMINSERTDL16	056
TWTMINSERTDL20	056
TWTMINSERTDL25	056
TWTMINSERTDL32	056
UADE0250J4AQA KCPM15	P21
UADE0250J4AQB KCPM15	P21
UADE0375J4AQA KCPM15	P21
UADE0375J4AQB KCPM15	P21
UADE0500J4AQB KCPM15	P21
UADE0625J4AQB KCPM15	P21
UADE0750J4AQB KCPM15	P21
UADE0750J4BQB KCPM15	P21
UADE1000J4ARA KC643M	P19
UADE1000J4ARB KC643M	P19
UADE1000J4ARC KC643M	P19
UADE1000J4ARD KC643M	P19
UADE1000J4ARF KC643M	P19
UADE1000J4BQB KCPM15	P21
UADE250J4ARA KC643M	P16
UADE250J4ARC KC643M	P17
UADE375J4ARA KC643M	P17
UADE375J4ARB KC643M	P17
UADE375J4ARC KC643M	P18
UADE375J4BRA KC643M	P18
UADE375J4BRB KC643M	P18
UADE500J4ARA KC643M	P18
UADE500J4ARB KC643M	P18
UADE500J4ARC KC643M	P18
UADE500J4ARE KC643M	P18
UADE500J4BRA KC643M	P18
UADE500J4BRB KC643M	P18
UADE500J4BRC KC643M	P18
UADE500J4BRD KC643M	P18
UADE500J4BRE KC643M	P18
UADE500J4CRA KC643M	P18
UADE500J4CRB KC643M	P18
UADE500J4CRC KC643M	P18
UADE500J4CRD KC643M	P18
UADE500J4CRE KC643M	P18
UADE625J4ARB KC643M	P19
UADE625J4ARC KC643M	P19
UADE750J4ARB KC643M	P19
UADE750J4ARE KC643M	P19
UADE750J4BRA KC643M	P19
UADE750J4BRB KC643M	P19
UADE750J4BRC KC643M	P19
UADE750J4BRE KC643M	P19
UBDE0500N4AQA KCSM15	P21
UBDE0500N4AQB KCSM15	P21
UBDE0625N4AQB KCSM15	P21
UBDE0625N4AQC KCSM15	P21
UBDE0750N4AQB KCSM15	P21
UBDE0750N4AQC KCSM15	P21
UBDE0750N4AQD KCSM15	P21
UBDE0750N4AQE KCSM15	P21
UBDE0750N4BQB KCSM15	P21
UBDE0750N4BQC KCSM15	P21
UBDE0750N4BQD KCSM15	P21
UBDE0750N4BQE KCSM15	P21
UBDE1000N4BQB KCSM15	P21
UBDE1000N4BQC KCSM15	P21
UBDE1000N4BQE KCSM15	P21
UCDE1000J5BRA KC643M	P31
UCDE1000J5BRB KC643M	P31
UCDE1000J5BRB KCPM15	P31
UCDE1000J5BRD KC643M	P31
UCDE1000J5BRD KCPM15	P31
UCDE1000J5BRE KC643M	P31
UCDE1000J5BRE KCPM15	P31
UCDE1000J5BRF KC643M	P31
UCDE1000J5BRF KCPM15	P31
UCDE1000J5BS KC643M	P31
UCDE1000J5BS KCPM15	P31
UCDE1000K5ARB KC643M	P32
UCDE1000K5ARB KCPM15	P32
UCDE1000K5BRB KC643M	P31
UCDE1000K5BRB KCPM15	P31
UCDE1000K5BRF KC643M	P31
UCDE1000K5BRF KCPM15	P31
UCDE1000K5BS KC643M	P31
UCDE1000K5BS KCPM15	P31
UCDE188J5BRA KC643M	P30
UCDE188J5BRA KCPM15	P30
UCDE188J5BRB KC643M	P30
UCDE188J5BRB KCPM15	P30
UCDE188J5BS KC643M	P30
UCDE188J5BS KCPM15	P30
UCDE219J5BS KC643M	P30
UCDE250J5ARA KC643M	P32
UCDE250J5ARA KCPM15	P32
UCDE250J5BRA KC643M	P30
UCDE250J5BRA KCPM15	P30
UCDE250J5BRB KC643M	P30
UCDE250J5BRB KCPM15	P30
UCDE250J5BS KC643M	P30
UCDE250J5BS KCPM15	P30
UCDE281J5BS KC643M	P30
UCDE312J5BRA KC643M	P30
UCDE312J5BRA KCPM15	P30
UCDE312J5BRB KC643M	P30
UCDE312J5BRB KCPM15	P30
UCDE312J5BS KC643M	P30
UCDE312J5BS KCPM15	P30
UCDE344J5BS KC643M	P30
UCDE375J5ARA KC643M	P32
UCDE375J5ARA KCPM15	P32
UCDE375J5BRA KC643M	P30
UCDE375J5BRA KCPM15	P30
UCDE375J5BRB KC643M	P30
UCDE375J5BRB KCPM15	P30
UCDE375J5BS KC643M	P30
UCDE375J5BS KCPM15	P30
UCDE375J5CRA KC643M	P30
UCDE375J5CRB KC643M	P30
UCDE438J5BS KC643M	P30
UCDE500J5BRA KC643M	P30
UCDE500J5BRA KCPM15	P30
UCDE500J5BRB KC643M	P30
UCDE500J5BRB KCPM15	P30
UCDE500J5BRD KC643M	P30
UCDE500J5BRF KC643M	P30
UCDE500J5BRF KCPM15	P30
UCDE500J5BS KC643M	P30
UCDE500J5BS KCPM15	P30
UCDE500K5ARB KC643M	P32
UCDE500K5ARB KCPM15	P32
UCDE500K5BRA KC643M	P30
UCDE500K5BRA KCPM15	P30
UCDE500K5BRB KC643M	P30
UCDE500K5BRB KCPM15	P30
UCDE500K5BRF KC643M	P30
UCDE500K5BRF KCPM15	P30
UCDE500K5BS KC643M	P30
UCDE500K5BS KCPM15	P30
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UEBD0094J2A KC643M	P168
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UEDE0500J3AS KC643M	P166
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UGDE1000J5BRB KC643M	P39
UGDE1000J5BRC KC643M	P39
UGDE1000J5BRD KC643M	P39
UJBE0125J6BP KCSM15	P74

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
UJBE0125J6CP KCSM15	P74
UJBE0188J6BP KCSM15	P74
UJBE0188J6CP KCSM15	P74
UJBE0250J6BP KCSM15	P74
UJBE0250J6CP KCSM15	P74
UJBE0312J6BP KCSM15	P74
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UJBE0375J6AL KCSM15	P53
UJBE0375J6B KCSM15	P52
UJBE0375J6BP KCSM15	P74
UJBE0375J6CP KCSM15	P74
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UJBE0500J6B KCSM15	P52
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UJDE1500N6DBL KCSM15	P65
UJDE1500N6FBB KCSM15	P64
UJDE1500N6FBC KCSM15	P64

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
UJDE1500N6FBD KCSM15	P64
UJDE1500N6FBE KCSM15	P64
UJDE1500N6FBF KCSM15	P64
UJDE1500N6FBH KCSM15	P64
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VBMT332LF KCK05	B281
VBMT332LF KCK15	B281
VBMT332LF KCK15B	B281
VBMT332LF KCK20	B281
VBMT332LF KCM15	B281

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
VBMT332LF KCM15B	B281
VBMT332LF KCM25	B281
VBMT332LF KCM25B	B281
VBMT332LF KCM35	B281
VBMT332LF KCP05	B281
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VDIB4M402544C	C76
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VDIB5M402544C	C77
VDIB6M302040C	C77
VDIB6M402544C	C77
VDIC1M302070C	C78
VDIC1M402585C	C78
VDIC2M302070C	C78
VDIC2M402585C	C78
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VNMG332FP KT315	B146
VNMG332LF KCP25B	B145
VNMG332MN KCP05	B146
VNMG332MN KCP05B	B146
VNMG332MN KCP10	B146
VNMG332MN KCP10B	B146
VNMG332MN KCP25	B146
VNMG332MN KCP25B	B146
VNMG332MN KCP30	B146
VNMG332MP KC5010	B147
VNMG332MP KCM15	B147
VNMG332MP KCM15B	B147
VNMG332MP KCM25	B147
VNMG332MP KCM25B	B147
VNMG332MP KCM35	B147
VNMG332MP KCU10	B147
VNMG332MR KCM15B	B147
VNMG332MS K313	B147
VNMG332MS KC5010	B147
VNMG332MS KC5025	B147
VNMG332MS KCU10	B147
VNMG332MS KCU25	B147
VNMG332P K313	B147
VNMG332P KC5010	B147
VNMG332P KCU10	B147
VNMG332RN KCP10	B148
VNMG332RN KCP10B	B148
VNMG332RN KCP25	B148
VNMG332RN KCP25B	B148
VNMG332RP KC5010	B148
VNMG332RP KC5025	B148
VNMG332RP KCK15	B148
VNMG332RP KCK20B	B148
VNMG332RP KCM15	B148
VNMG332RP KCP10	B148
VNMG332RP KCP25	B148
VNMG332RP KCU10	B148
VNMG332RP KCU25	B148
VNMG332UN KCK05B	B148
VNMG332UN KCK15	B148
VNMG332UN KCK15B	B148
VNMG332UN KCK20	B148
VNMG332UP KC5010	B148
VNMG332UP KCM15	B148
VNMG332UP KCM25	B148
VNMG332UP KCU10	B148
VNMG333 K68	B145
VNMG333MN KCP10	B146
VNMG333MN KCP25	B146
VNMG333MN KCP25B	B146
VNMG333MN KCP30	B146
VNMG333MP KC5010	B147
VNMG333MP KCM15B	B147
VNMG333MP KCU10	B147
VNMG333MR KCM15	B147
VNMG333RN KCP10	B148
VNMG333RN KCP25	B148
VNMG333RN KCP25B	B148
VNMG333RP KCK15	B148
VNMG333RP KCK15B	B148
VNMG333RP KCK20	B148
VNMG333RP KCM25	B148
VNMG333RP KCP10	B148
VNMG333RP KCP25	B148
VNMG333RP KCU10	B148
VNMG333RP KCU25	B148
VNMG333UP KCM15	B148
VNMG431LF KCP25B	B145
VNMG431MS KC5010	B147
VNMG431MS KCU10	B147
VNMG431MS KCU25	B147
VNMG432 K68	B145
VNMG432LF KCP25B	B145
VNMG432MS KC5010	B147
VNMG432MS KC5025	B147
VNMG432MS KCU10	B147
VNMG432MS KCU25	B147
VNMG432RN KCP10	B148
VNMG432RN KCP10B	B148
VNMG432RN KCP25	B148
VNMG432RN KCP25B	B148
VNMG432RN KCP30	B148
VNMG432RN KCP40	B148
VNMG433 K68	B145
VNMG433RN KCP10	B148
VNMG433RN KCP25	B148
VNMG433RN KCP30	B148
VNMP331 K313	B149
VNMP331 K68	B149
VNMP331K K68	B149
VNMP331K KCP10B	B149
VNMP331K KCP25	B149
VNMP332 K313	B149
VNMP332 K68	B149
VNMP332K K68	B149
VNMP332K KCP10	B149
VNMP332K KCP10B	B149
VNMP332K KCP25	B149
VNMS331 K68	B149
VNMS331 KC5410	B149
VNMS331E KD1405	B368
VNMS331FST KD1400	B368
VNMS331FST KD1425	B368
VNMS332 K68	B149
VNMS332 KC5410	B149
VNMS332E KD1405	B368
VNMS332FST KD1400	B368
VNMS332FST KD1425	B368
VPGN331 KD1425	B369, E38
VPGN332 KD1425	B369, E38
VPGP443K KC5410	B145
VPGR3305 K68	E38
VPGR3305 KC5010	E38
VPGR3305 KC5025	E38
VPGR3305 KC5410	E38
VPGR3305 KCU10	E38
VPGR3305 KCU25	E38
VPGR3305FP KCP10	E39
VPGR331 K313	B369, E38
VPGR331 K68	E38
VPGR331 KC5010	E38
VPGR331 KC5025	E38

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
VPGR331 KC5410	E38
VPGR331 KCP25	E38
VPGR331 KCU10	E38
VPGR331 KCU25	E38
VPGR331 KD1425	B369, E38
VPGR331 KT315	E38
VPGR331FP KCM25	E39
VPGR331FP KCP10	E39
VPGR331FP KCP25	E39
VPGR331FP KCU10	E39
VPGR331HP K313	E39
VPGR332 K313	B369, E38
VPGR332 K68	E38
VPGR332 KC5010	E38
VPGR332 KC5025	E38
VPGR332 KC5410	E38
VPGR332 KCP25B	E38
VPGR332 KCU10	E38
VPGR332 KCU25	E38
VPGR332 KD1425	B369, E38
VPGR332 KT315	E38
VPGR332FP KCK05	E39
VPGR332FP KCM25	E39
VPGR332FP KCP10	E39
VPGR332FP KCP25	E39
VPGR333 K68	B369, E38
VPGR333 KC5010	E38
VPGR333 KCU10	E38
VPGR333 KCU25	E38
VPGR333 KD1425	B369, E38
VPGR333FP KCK05	E39
VPGR333FP KCP10	E39
VPGR333FP KCP25	E39
VPGR334 KC5010	E38
VPGR334 KCU10	E38
VPGR334FP KCP25	E39
WCMT2151FP KCU10	B286
WCMT2151FP KCU25	B286
WCMT2151LF KC5010	B286
WCMT3252FP KCP25	B286
WCMT3252FP KCU10	B286
WCMT3252LF KC5010	B286
WCMT3252LF KC5025	B286
WD32FDS28076M	H126
WD32FDS28128M	H126
WD32FDS28190M	H127
WD32FDS28283M	H127
WD32FDS28345M	H127
WD32FDS32082M	H126
WD32FDS32146M	H126
WD32FDS32216M	H127
WD32FDS32321M	H127
WD32FDS32391M	H127
WD32FDS36092M	H126
WD32FDS36166M	H126
WD32FDS36244M	H127
WD32FDS36361M	H127
WD32FDS36439M	H127
WD50FDS40100M	H126
WD50FDS40183M	H126
WD50FDS40271M	H127
WD50FDS40403M	H127
WD50FDS40491M	H127
WD50FDS45112M	H126
WD50FDS45206M	H126
WD50FDS45304M	H127
WD50FDS45451M	H127
WD50FDS45549M	H127
WD50FDS50122M	H126
WD50FDS50228M	H126
WD50FDS50338M	H127
WD50FDS50503M	H127
WD50FDS50613M	H127
WD50FDS56140M	H126
WD50FDS56259M	H126
WD50FDS56383M	H127
WD50FDS56569M	H127
WD50FDS56693M	H127
WD50FDS63154M	H126
WD50FDS63289M	H126
WD50FDS63429M	H127
WD50FDS63639M	H127
WD50FDS63779M	H127
WD50FDS71172M	H126
WD50FDS71292M	H126
WD50FDS71452M	H127
WD50FDS80192M	H126
WD50FDS80327M	H126
WD50FDS80507M	H127
WD50FDS90212M	H126
WD50FDS90362M	H126
WD50FDS90562M	H127
WLFNL32CA19S	E61
WLFNR32CA19S	E61
WLJNL32CA19S	E55
WLJNL32CA30S	E55
WLJNR32CA19S	E55
WLJNR32CA30S	E55
WLLNL32CA19S	E61
WLLNL32CA30S	E61
WLLNR32CA19S	E61
WLLNR32CA30S	E61
WNGA431S0415MT KBH20	B343
WNGA432FST KD1425	B369
WNGA432S0415FWHBMT KBH20	B343
WNGA432S0415FWMT KBH20	B343
WNGA432S0415MT KBH10	B343
WNGA432S0415MT KBH20	B343
WNGA432S0525MT KBH10	B343
WNGA432S0525MT KBH20	B343
WNGA432S0735MT KBH20	B343
WNGA432T0420 KYS30	B354
WNGA432T0420FW KY3500	B315
WNGA432T0820 KY3500	B315
WNGA432T0820 KYK25	B315
WNGA433T0820 KY3500	B315
WNGA433T0820 KYK25	B315
WNGA434T0420 KYS30	B354
WNGA434T0820 KY3500	B315
WNGG4305LF KC5010	B156
WNGG4305LF KCU10	B156
WNGG430LF KC5010	B156
WNGG431FS KCU10	B156
WNGG431LF KC5010	B156
WNGG431LF KCU10	B156
WNGG432FS KCU10	B156
WNGG432LF KC5010	B156
WNGP432K KC5010	B156
WNGP432K KC5410	B156
WNGX453T0820 KY3500	B319
WNGX453T0820 KYK10	B319
WNMA332 KCK15	B157
WNMA333 KCK20	B157
WNMA333 KCK20B	B157
WNMA432 KCK05	B157
WNMA432 KCK15	B157
WNMA432 KCK20	B157
WNMA432 KCK20B	B157
WNMA433 KCK15	B157
WNMA433 KCK15B	B157
WNMA433 KCK20	B157
WNMA434 KCK20	B157
WNMG331FF KCP10	B157
WNMG331FF KCU10	B157
WNMG331FN KCK05	B157
WNMG331FN KCP10	B157
WNMG331FN KT315	B157
WNMG331FP KC5010	B158
WNMG331FP KCM15	B158
WNMG331FP KCU10	B158
WNMG331FW KCP05	B158
WNMG331FW KCP05B	B158
WNMG331FW KCU10	B158
WNMG331FW KT315	B158
WNMG331MN KCP10	B159
WNMG331MN KCP25	B159
WNMG331MP KC5010	B159
WNMG331MP KCM15	B159
WNMG331MP KCM25B	B159
WNMG331MP KCU10	B159
WNMG332FF KC5010	B157
WNMG332FF KT315	B157
WNMG332FN KCK15B	B157
WNMG332FN KCP10	B157
WNMG332FN KCP25	B157
WNMG332FN KT315	B157
WNMG332FP KC5010	B158
WNMG332FP KCM15	B158
WNMG332FP KCP10	B158
WNMG332FW KC5010	B158
WNMG332FW KCP05	B158
WNMG332FW KCP10	B158
WNMG332FW KCU10	B158
WNMG332FW KT315	B158
WNMG332MN KCP10	B159
WNMG332MN KCP10B	B159
WNMG332MN KCP25	B159
WNMG332MN KCP25B	B159
WNMG332MN KCP30	B159
WNMG332MP KC5010	B159
WNMG332MP KCM15	B159
WNMG332MP KCM25	B159
WNMG332MP KCM25B	B159
WNMG332MP KCM35B	B159
WNMG332MP KCP25	B159
WNMG332MP KCU10	B159
WNMG332MR KCM15B	B159
WNMG332MR KCP25B	B159
WNMG332MS K313	B160
WNMG332MS KC5010	B160
WNMG332MS KC5025	B160
WNMG332MS KCU10	B160
WNMG332MS KCU25	B160
WNMG332MW KCP10	B159
WNMG332MW KCP25	B159
WNMG332RN KCP10B	B161
WNMG332RN KCP25	B161
WNMG332RN KCP25B	B161
WNMG332RP KC5010	B161
WNMG332RP KCM15	B161
WNMG332RP KCM25	B161
WNMG332RP KCP10	B161
WNMG332RP KCP10B	B161
WNMG332RP KCP25	B161
WNMG332RP KCU10	B161
WNMG332RP KCU25	B161
WNMG332UN KCK15	B162
WNMG332UN KCK20B	B162
WNMG332UP KCM25B	B162
WNMG333FW KCP10	B158
WNMG333MN KCP10	B159
WNMG333MN KCP25	B159
WNMG333MN KCP30B	B159
WNMG333MP KCM25	B159
WNMG333RN KCP25	B161
WNMG333RP KCP10	B161
WNMG333RP KCP25	B161
WNMG4305MS KC5010	B160
WNMG4305MS KCU10	B160
WNMG4305MS KCU25	B160
WNMG430MS KCU10	B160
WNMG431FF KC5010	B157
WNMG431FF KCP10	B157
WNMG431FF KCU10	B157
WNMG431FN KCK05	B157
WNMG431FN KCK05B	B157
WNMG431FN KCP05	B157
WNMG431FN KCP10	B157
WNMG431FN KCP10B	B157
WNMG431FN KCP25B	B157
WNMG431FN KT315	B157
WNMG431FP KC5010	B158
WNMG431FP KCM15	B158
WNMG431FP KCP10	B158
WNMG431FP KCP25	B158
WNMG431FP KCU10	B158
WNMG431FW KCM15B	B158
WNMG431FW KCP05	B158
WNMG431FW KCP10	B158
WNMG431FW KCU10	B158
WNMG431FW KT315	B158
WNMG431MS K313	B160
WNMG431MS KC5010	B160
WNMG431MS KC5025	B160
WNMG431MS KCU10	B160
WNMG431MS KCU25	B160
WNMG431P KC5010	B160
WNMG431P KCM15B	B160
WNMG431P KCU10	B160
WNMG431UN KCK15	B162
WNMG431UN KCK20	B162
WNMG432FF KC5010	B157
WNMG432FF KCP10	B157
WNMG432FN KCK05	B157
WNMG432FN KCK15B	B157
WNMG432FN KCP05	B157
WNMG432FN KCP10	B157
WNMG432FN KCP10B	B157
WNMG432FN KCP25	B157
WNMG432FN KCP25B	B157
WNMG432FN KT315	B157
WNMG432FP KC5010	B158
WNMG432FP KCM15	B158
WNMG432FP KCM15B	B158
WNMG432FP KCP10	B158
WNMG432FP KCP25	B158
WNMG432FP KCU10	B158
WNMG432FW KC5010	B158
WNMG432FW KCP05	B158
WNMG432FW KCP10	B158
WNMG432FW KCP10B	B158
WNMG432FW KCU10	B158
WNMG432FW KT315	B158
WNMG432MG KCP10B	B158
WNMG432MG KCP25B	B158
WNMG432MN KCP05	B159
WNMG432MN KCP10	B159
WNMG432MN KCP10B	B159
WNMG432MN KCP25	B159
WNMG432MN KCP25B	B159
WNMG432MN KCP30	B159
WNMG432MN KCP30B	B159
WNMG432MN KCP40	B159
WNMG432MP KC5010	B159
WNMG432MP KCM15	B159
WNMG432MP KCM15B	B159
WNMG432MP KCM25	B159
WNMG432MP KCM25B	B159
WNMG432MP KCM35	B159
WNMG432MP KCM35B	B159
WNMG432MP KCP10	B159
WNMG432MP KCP25	B159
WNMG432MP KCP25B	B159
WNMG432MP KCU10	B159
WNMG432MR KCK15B	B159
WNMG432MR KCM15B	B159
WNMG432MR KCM25	B159
WNMG432MR KCM25B	B159
WNMG432MR KCM35	B159
WNMG432MR KCP10B	B159
WNMG432MR KCP25B	B159
WNMG432MR KCPK05	B159
WNMG432MR KCU10	B159
WNMG432MS K313	B160
WNMG432MS KC5010	B160
WNMG432MS KC5025	B160
WNMG432MS KCU10	B160
WNMG432MS KCU25	B160
WNMG432MW KCK15B	B160
WNMG432MW KCP05	B160
WNMG432MW KCP10	B160
WNMG432MW KCP10B	B160
WNMG432MW KCP25	B160
WNMG432MW KCP25B	B160
WNMG432MW KCPK05	B160
WNMG432P KC5010	B160
WNMG432P KCM15B	B160
WNMG432P KCU10	B160
WNMG432RN KCP10	B161
WNMG432RN KCP10B	B161
WNMG432RN KCP25	B161
WNMG432RN KCP25B	B161
WNMG432RN KCP30	B161
WNMG432RN KCP30B	B161
WNMG432RN KCP40	B161
WNMG432RP KC5010	B161
WNMG432RP KC5025	B161

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

Catalog No.	Page(s)
WNMG432RP KCK05	B161
WNMG432RP KCK05B	B161
WNMG432RP KCK15	B161
WNMG432RP KCK15B	B161
WNMG432RP KCK20	B161
WNMG432RP KCK20B	B161
WNMG432RP KCM15	B161
WNMG432RP KCM15B	B161
WNMG432RP KCM25	B161
WNMG432RP KCM25B	B161
WNMG432RP KCM35	B161
WNMG432RP KCM35B	B161
WNMG432RP KCP05	B161
WNMG432RP KCP10	B161
WNMG432RP KCP10B	B161
WNMG432RP KCP25	B161
WNMG432RP KCP25B	B161
WNMG432RP KCP30B	B161
WNMG432RP KCP40B	B161
WNMG432RP KCPK05	B161
WNMG432RP KCU10	B161
WNMG432RP KCU25	B161
WNMG432UN KCK05B	B162
WNMG432UN KCK15	B162
WNMG432UN KCK15B	B162
WNMG432UN KCK20	B162
WNMG432UN KCK20B	B162
WNMG432UP KC5010	B162
WNMG432UP KCM15	B162
WNMG432UP KCM25	B162
WNMG432UP KCM25B	B162
WNMG432UP KCU10	B162
WNMG433FP KC5010	B158
WNMG433FP KCM15	B158
WNMG433FW KCP05	B158
WNMG433FW KCP10	B158
WNMG433FW KCP10B	B158
WNMG433MN KCP10	B159
WNMG433MN KCP10B	B159
WNMG433MN KCP25	B159
WNMG433MN KCP25B	B159
WNMG433MN KCP40B	B159
WNMG433MP KC5010	B159
WNMG433MP KCM15	B159
WNMG433MP KCM25	B159
WNMG433MP KCM25B	B159
WNMG433MP KCM35	B159
WNMG433MP KCP10	B159
WNMG433MP KCP25B	B159
WNMG433MP KCU10	B159
WNMG433MR KCM15B	B159
WNMG433MR KCM25B	B159
WNMG433MR KCM35	B159
WNMG433MR KCP10B	B159
WNMG433MR KCP25B	B159
WNMG433MR KCPK05	B159
WNMG433MW KCM15B	B160
WNMG433MW KCP05	B160
WNMG433MW KCP10	B160
WNMG433MW KCP10B	B160
WNMG433MW KCP25	B160
WNMG433MW KCP25B	B160
WNMG433RN KCP05	B161
WNMG433RN KCP10	B161
WNMG433RN KCP10B	B161
WNMG433RN KCP25	B161
WNMG433RN KCP25B	B161
WNMG433RN KCP30	B161
WNMG433RN KCP30B	B161
WNMG433RN KCP40B	B161
WNMG433RN KCPK05	B161
WNMG433RP KC5010	B161
WNMG433RP KCK05	B161
WNMG433RP KCK15	B161
WNMG433RP KCK15B	B161
WNMG433RP KCK20	B161
WNMG433RP KCK20B	B161
WNMG433RP KCM15	B161
WNMG433RP KCM25	B161
WNMG433RP KCM25B	B161
WNMG433RP KCM35	B161
WNMG433RP KCM35B	B161
WNMG433RP KCP05	B161
WNMG433RP KCP10	B161
WNMG433RP KCP10B	B161
WNMG433RP KCP25	B161
WNMG433RP KCP25B	B161
WNMG433RP KCP30	B161
WNMG433RP KCPK05	B161
WNMG433RP KCU10	B161
WNMG433RP KCU25	B161
WNMG433UN KCK05	B162
WNMG433UN KCK15	B162
WNMG433UN KCK15B	B162
WNMG433UN KCK20	B162
WNMG433UN KCK20B	B162
WNMG433UP KC5010	B162
WNMG433UP KCM25	B162
WNMG433UP KCM35	B162
WNMG433UP KCU10	B162
WNMG434MN KCP25	B159
WNMG434MN KCP25B	B159
WNMG434MR KCP10B	B159
WNMG434MR KCP25B	B159
WNMG434RN KCP10	B161
WNMG434RN KCP10B	B161
WNMG434RN KCP25	B161
WNMG434RN KCP25B	B161
WNMG434RP KCP10	B161
WNMG434RP KCP25	B161
WNMG434RP KCP25B	B161
WNMG434RP KCU25	B161
WNMG434UN KCK15B	B162
WNMG434UN KCK20	B162
WOEJ090512SRGD KC522M	V39
WOEJ090512SRGD KC725M	V39
WOEJ090512SRGD KCPK30	V39
WOEJ090512SRGD KCPM40	V39
WOEJ090512SRGD KCSM30	V39
WOEJ090512SRHD KC522M	V39
WOEJ090512SRHD KC725M	V39
WOEJ090512SRHD KCPK30	V39
WOEJ090512SRHD KCPM40	V39
WPGT15105UF KC5010	B288
WPGT15105UF KCU10	B288
WPGT1510UF KC5010	B288
WPGT1510UF KCU10	B288
WPGT21505UF KCU10	B288
WPMT15121FP KCP25	B288
WPMT15121FP KCU10	B288
WPMT15121LF KC5025	B288
WPMT2151FP KCM25	B288
WPMT2151FP KCP25	B288
WPMT2151FP KCU10	B288
WPMT2151LF KC5010	B288
WPMT2151LF KC5025	B288
WPMT2151LF KCK20	B288
WPMT2151LF KCP10	B288
WPMT3251FP KCU10	B288
WPMT3251LF KC5010	B288
WPMT3251LF KCM15B	B288
WPMT3251LF KCP25	B288
WPMT3252FP KCU10	B288
WPMT3252LF KC5010	B288
WPMT3252LF KCK05	B288
WPMT3252LF KCM15	B288
WPMT3252LF KCP25B	B288
WXXNL4455X-FL	E60
WXXNR4455X-FL	E60
XADA0375Y4CU45 KCPM15	048
XADA0375Y4CU60 KCPM15	048
XADA0500Y5CU45 KCPM15	048
XADA0500Y5CU60 KCPM15	048
XADA0625Y6CU45 KCPM15	048
XADA0625Y6CU60 KCPM15	048
XDLT090408ERD41 SC6525	V14
XDLT090408ERD41 SP6519	V14
XDLT090408ERD41 X500	V14
XDLT090408ERD721 GH2	V14
XDLT090412ERD411 SP6519	V15
XDLT090412ERD411 X500	V15
XDLT120508ERD41 SC6525	V21
XDLT120508ERD41 SP6519	V21
XDLT120508ERD41 X500	V21
XDLT120508ERD721 GH2	V21
XDLT120512ERD411 SP6519	V22
XDLT120512ERD411 X500	V22
XDLW090408SRD SC3025	V16
XDLW090408SRD SC6525	V16
XDLW090408SRD X400	V16
XDLW090408SRD X500	V16
XDLW120508SRD SC3025	V23
XDLW120508SRD X400	V23
XDLW120508SRD X500	V23
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	V22
XDPT120508ERD41 SC6525	V22
XDPT120508ERD41 SP6519	V22
XDPT120508ERD41 X500	V22
XDPT120512ERD411 KCSM40	V22
XDPT120515SRGP KC522M	V23
XDPT120515SRGP KC725M	V23
XDPT120515SRGP KCPK30	V23
XDPT120515SRGP KCPM40	V23
XDPW090412SRD KC510M	V15
XDPW090412SRD KC522M	V15
XDPW090412SRD KCK15	V15
XDPW090412SRD KCPK30	V15
XDPW090412SRD KCPM40	V15
XDPW120515SRD KC510M	V23
XDPW120515SRD KC522M	V23
XDPW120515SRD KCK15	V23
XDPW120515SRD KCPK30	V23
XDPW120515SRD KCPM40	V23
XELT160512ERD41 SC6525	V28
XELT160512ERD41 SP6519	V28
XELT160512ERD41 X500	V28
XELW160512SRD SC3025	V28
XELW160512SRD X400	V28
XEPT160512ERD41 KCSM40	V28
XEPT160516ERD41 KC522M	V28
XEPT160516ERD41 KCPK30	V28
XEPT160516ERD41 KCPM40	V28
XEPW160520SRD KC522M	V28
XEPW160520SRD KCK15	V28
XEPW160520SRD KCPK30	V28
XEPW160520SRD KCPM40	V28
XNGJ43ANENLD3W KC510M	S12
XNGJ43ANENLD3W KC522M	S12
XNGJ43ANENLD3W KC725M	S12
XNGJ43ANENLD3W KCPM40	S12
XNGJ43ANENLD3W KCSM40	S12
XNGJ43ANFNLDJ3W KC410M	S11
XNGJ535ANFNLDJ3W KC410M	S21
XNGJ535ANSNGD3W KC725M	S21
XNGJ535ANSNGD3W KCK15	S21
XNGJ535ANSNGD3W KCPK30	S21
XNGJ535ANSNGD3W KCSM40	S21
XNXF43ZNENLDW KCK15	S90
XNXF43ZNENW KY3500	S90
XPLT060308ERD41 SC6525	V7
XPLT060308ERD41 SP6519	V7
XPLT060308ERD41 X400	V7
XPLT060308ERD41 X500	V7
XPNT050522RF SP6519	V115
XPNT06062515RF SP6519	V115
XPNT080832RF SP6519	V115
XPNT101043RF SP6519	V115
XPNT121254RF SP6519	V115
XPNT161654RF SP6519	V115
XPPT060308ERD41 KCSM40	V7
XPPW060310SRD KC510M	V7
XPPW060310SRD KC522M	V7
XPPW060310SRD KCPK30	V7
XPPW060310SRD KCPM40	V7
XRDA0375Y4CUC KCPM15	049
XRDA0375Y4CUE KCPM15	049
XRDA0500Y5CUB KCPM15	049
XRDA0500Y5CUC KCPM15	049
XRDA0500Y5CUE KCPM15	049
XRDA0625Y6CUC KCPM15	049
XRDA0625Y6CUE KCPM15	049
ZDET16M504FR721 GH1	T100
ZDET16M508FR721 GH1	T100
ZDET16M512FR721 GH1	T100
ZDET16M516FR721 GH1	T100
ZDET16M520FR721 GH1	T100
ZDET16M525ER721 GH1	T100
ZDET16M525FR721 GH1	T100
ZDET16M530ER721 GH1	T100
ZDET16M530FR721 GH1	T100
ZDET16M532FR721 GH1	T100
ZDET16M540ER721 GH1	T100
ZDET16M540FR721 GH1	T100
ZDET16M550FR721 GH1	T100
ZDET16M560FR721 GH1	T100
ZDET16M5PDFR721 GH1	T100

Index

For page references A–E, please see Volume I • Turning Tools Catalog.

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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 2°	Shank: Cylindrical with Flat	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
Tapping: Pipe Thread	Threading: Through Hole	HSS: High-Speed Steel	HSS-E: High-Speed Steel with Cobalt Alloy for Materials with Higher Hardness	HSS-E-PM: High-Speed Steel with Cobalt Alloy for Materials with Higher Hardness (PM = Powder Metal Steel)
HM: (Carbide)	Drilling Depth: 2 x D	Chamfer Form (3–4)	Chamfer Form B (3.5–5.5)	Chamfer Form C (2–3)
Chamfer Form D (3.5–5)	Chamfer Form E (1.5–2)	Chamfer Form (3–5)	Chamfer Form (2.5–3.5)	Chamfer Form (1–2)
Tapping Helix Angle: 0°	Tapping Helix Angle: 10°	Tapping Helix Angle: 15°	Tapping Helix Angle: L15°	Tapping Helix Angle: 25°
Tapping Helix Angle: 42°	Tapping Helix Angle: 45°	Multipurpose Taps: Spiral Point	Tension/ Compression	DIN Number 371
DIN Number 374	DIN Number 376	DIN Number 5156	DIN Number 2174	DIN ANSI
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	American National Standards Institute	American Standard Straight Pipe Thread	American Standard Straight Pipe Thread Dryseal
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	 Plunge Milling	 Plunge Milling: Ball Nose	 Ramping: Blank	 Ramping: Up to 2°
 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	 Corner Style: Taper Ball Nose	 Shank: Cylindrical Plain
 Shank: Cylindrical Weldon®	 Shank: SK BT JIS B 6339	 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: 37°
Helix Angle: 38°	Helix Angle: 40°	Helix Angle: 45°	Helix Angle: 50°	Helix Angle: 43°
Helix Angle: 36°	Helix Angle: 35°/38°	Helix Angle: 37°/39°	Balance (G 2.5/25,000)	Through Coolant

(continued)

(Solid End Milling Icons — continued)

Through Coolant: Axial: Solid End Mill	Tool Dimensions: Flute Configuration: X (Variable)	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: 12	ISO 26622	

Indexable Milling Icons

Counterboring	Spiral Circular	Drilling	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	SK Shank: R8
Shank: SK BT JIS B 6339	Shank: SK CAT(CV) ANSI B5.50	Shank: HSK DIN 69893	Shell Mill Shank	Milling: Through Coolant
Axial: Nozzle	Through Coolant: Pressurized Air Coolant: Radial: Indexable Milling			

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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	–	A36, 1008, 1010, 1018 through 1029; 1108, 1117
P1	Low-Carbon Steels, Short Chipping, Free Machining	C <0,25%	<530	<125	–	10L18, 1200 Series, 1213, 12L14
P2	Medium- and High-Carbon Steels	C >0,25%	>530	<220	<25	1035, 1045, 10L45, 1050, 10L50, 1080, 1137, 1144, 11L44, 1525, 1545, 1572
P3	Alloy Steels and Tool Steels	C >0,25%	600–850	<330	<35	1300, 2000, 3000, 4000, 5000, 8000, P20, SAE: A, D, H, O, S, M, T
P4	Alloy Steels and Tool Steels	C >0,25%	850–1400	340–450	35–48	1300, 2000, 3000, 4000, 5000, 8000, P20, SAE: A, D, H, O, S, M, T
P5	Ferritic, Martensitic, and PH Stainless Steels	–	600–900	<330	<35	15–5 PH, 13–8 PH, 17–4 PH, 400 and 500 Series
P6	High-Strength Ferritic, Martensitic, and PH Stainless Steels	–	900–1350	350–450	35–48	15–5 PH, 13–8 PH, 17–4 PH, 400 and 500 Series
M1	Austenitic Stainless Steel	–	<600	130–200	–	200 Series, 301, 302, 304, 304L, 309
M2	High-Strength Austenitic Stainless and Cast Stainless Steels	–	600–800	150–230	<25	310, 316, 316L, 321, 347, 384 ASTM Cast XM-1, XM-5, XM-7, XM-21
M3	Duplex Stainless Steel	–	<800	135–275	<30	323, 329, F55, 2205, S329000
K1	Gray Cast Iron	–	125–500	120–290	<32	class 20, 25, 30, 35, 40, 45, 50, 55, 60, G1800, G3000, G3500, G4000
K2	Low- and Medium-Strength Ductile Irons (Nodular Irons) and Compacted Graphite Irons (CGI)	–	<600	130–260	<28	60-40-18, 65-45-12, 80-55-06; SAE J434: D4018, D4512, D5506; ASTM A47: Grade 32510, 35018; SAE J158: Grade M3210, M4504, M5003, M5503, M7002; ASTMA842: Grade 250, 300, 350, 400, 450
K3	High-Strength Ductile Irons and Austempered Ductile Iron (ADI)	–	>600	180–350	<43	ASTM A536:100-70-03, 120-90-02, SAE J434: D7003, SAE J158: Grade M8501AST A897: 125-80-10, 150-100-7, 175-125-4, 200-150-1, 230-185
N1	Wrought Aluminum	–	–	–	–	2025, 5050, 7050, 1000, 2017
N2	Low-Silicon Aluminum Alloys and Magnesium Alloys	Si <12,2%	–	–	–	2024, 6061, 7075
N3	High-Silicon Aluminum Alloys and Magnesium Alloys	Si >12,2%	–	–	–	–
N4	Copper-, Brass-, Zinc-Based on Machinability Index Range of 70–100	–	–	–	–	C81500
N5	Nylon, Plastics, Rubbers, Phenolics, Resins, Fiberglass	–	–	–	–	–
N6	Carbon, Graphite Composites, CFRP	–	–	–	–	Graphite, CFK, CFRP
N7	Metal Matrix Composites (MMC)	–	–	–	–	C63000
S1	Iron-Based, Heat-Resistant Alloys	–	500–1200	160–260	25–48	A-286, INCOLOY® 800 Series, A608, A567, Discaloy™, INVAR®, N-155, 16-25-6, 19-9 DL; Cast: ASTM A-297, A-351, A-567, A-608
S2	Cobalt-Based, Heat-Resistant Alloys	–	1000–1450	250–450	25–48	Haynes® 25 (L605), Haynes 188, J-1570, Stellite, AiResist 213; Cast: AiResist 13, Haynes 21, MAR-M302, MAR-M509, NASA Co-W-Re, WI-52
S3	Nickel-Based, Heat-Resistant Alloys	–	600–1700	160–450	<48	Astroloy™, Hastelloy® B/C/ C-276 /X, INCONEL® 600 and 700 Series, IN102, INCOLOY 900 Series, Rene 41, Waspalloy, Monel®, K-500, MAR-M20, NIMONIC®, UDIMET®
S4	Titanium and Titanium Alloys	–	900–1600	300–400	33–48	Pure: Ti 98.8, Ti 98.9,Ti 99.9; Alloyed: Ti 5Al-2.5Sn, Ti6Al-4V, Ti6Al-2Sn-4Zr-2Mo, Ti-3Al-8V-6Cr-4Mo-4Zr, Ti-10V-2Fe-3Al, Ti-13V-11Cr-3Al
H1	Hardened Materials	–	–	–	44–48	Tool Steel H10, H11, H13, D2, D3, 4340, P20
H2	Hardened Materials	–	–	–	48–55	Tool Steel H10, H11, H13, D2, D3, 4340, P20
H3	Hardened Materials	–	–	–	56–60	Tool Steel H10, H11, H13, D2, D3, 4340, P20
H4	Hardened Materials	–	–	–	>60	Tool Steel H10, H11, H13, D2, D3, 4340, P20
C1	CFRP, CFRP/CFRP	–	–	–	–	–
C2	CFRP/Non-Ferrous	–	–	–	–	–
C3	CFRP/High-Temp	–	–	–	–	–
C4	CFRP/Stainless Steel	–	–	–	–	–
C5	CFRP/Non-Ferrous/High-Temp	–	–	–	–	–

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

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	Gray 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 Aluminum	–	–	–	–	AlMg1, Al99.5, AlCuMg1, AlCuBiPb, AlMgSi1, ALMgSiPb
N2	Low-Silicon Aluminum Alloys and Magnesium Alloys	Si <12,2%	–	–	–	GAlSiCu4, GDAlSi10Mg
N3	High-Silicon Aluminum 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, Fiberglass	–	–	–	–	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 J0 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 Y237.

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 Y237.

(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 Y237.

(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 II/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 Y237.

(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	–	–	–	1.115	–
–	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	–	–	–	1.553	–
–	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 Y237.

(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	–	–	–	1.885	–
–	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 Y237.

(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 Y237.

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 Y237.

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 Gray 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 Y237.

N1 Workpiece Materials Listing • Non-Ferrous Metals • N1

N1 Wrought Aluminum

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 Aluminum 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 Aluminum 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 Aluminum 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 Y237.

(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	–	–	–	–	2.1090	–
–	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, Fiberglass

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 Y237.

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 Y237.

(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 Y237.

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 Organization for Standardization
AMS — Aerospace Material Specifications
ASTM — American Society of Mechanical Engineers
BS — British Standards
DIN — German Institute for Standardization
EN — European Standards
JIS — Japanese Industrial Standards
SAE — Society of Automotive Engineers
SIS — Swedish Standards Institute
UNI — Italian Organization for Standardization
UNS — Unified Numbering System

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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.

METALCUTTING SAFETY

IMPORTANT SAFETY INSTRUCTIONS

Read before using the tools in this catalog!

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 catalog 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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