



INNOVATIONS
2024 | 01 | METRIC

Drill Fix PRO™

Indexable Drilling



Wiper Geometry on All Outboard Inserts

Optimized Coolant Delivery System

Robust Toolholder Design

Cost-Effective and Versatile
Indexable Drilling

INNOVATIONS

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CAS — Customer Application Support

Get Fast and Reliable Answers to Your Toughest Problems

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



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	Singapore	English	1800 6221031	ap-kmt.techsupport@kennametal.com
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Numbers shown only serve the originating country listed.

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North America	United States	+1 800 446 7738	FtMill.Service@kennametal.com
	Canada	+1 800 446 7738	toronto.service@kennametal.com
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	Indonesia	+65 6265 9222	k-sg.sales@kennametal.com
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	New Zealand	+64 0800 536626	k-nz.service@kennametal.com
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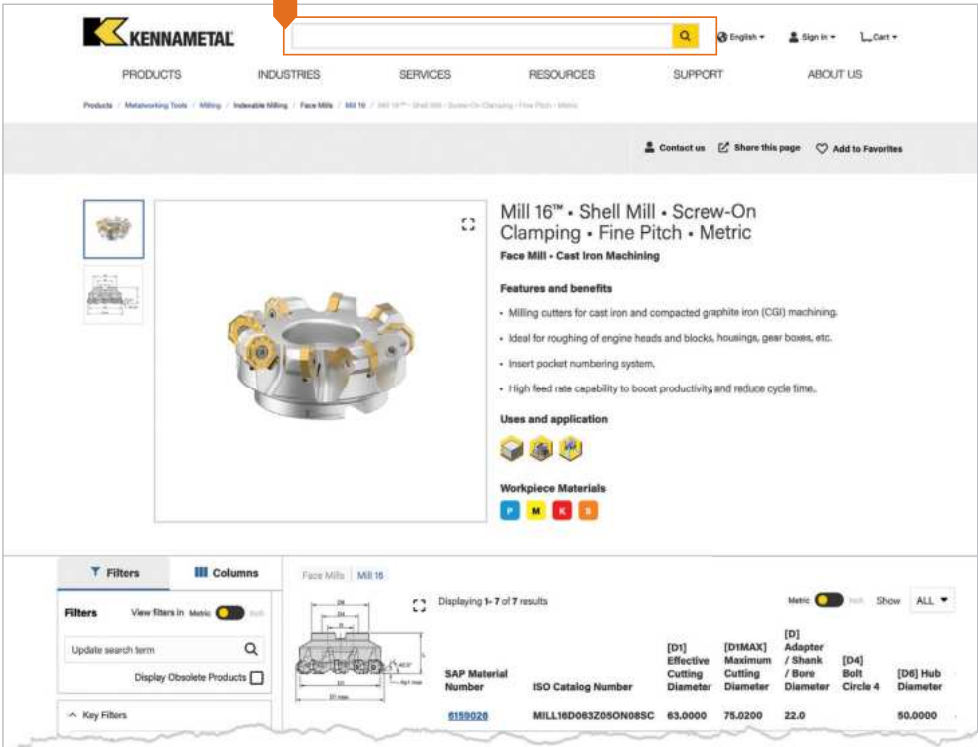


Spare Parts & Accessories Information

Lost a screw? Have to replace worn-out clamping wedges? Need to find and re-order those spare parts?

Are you in need of some accessories, like a torque wrench or coolant shower plate? These tools are at your fingertips! Go to kennametal.com and find what you need in seconds. Enter the catalog number of the corresponding tool, and it will display.

STEP 1 Enter the tool catalog number here



STEP 2 Select the spare parts & accessories

Spare Parts for Mill 16™ • Shell Mill • Screw-On Clamping • Fine Pitch • Metric

SPARE PART	SPARE PART	SPARE PART	SPARE PART
 Spare Part ANTI-SEIZE LUBRICANT Get Price	 WRENCH Get Price	 INSERT SCR M5-0.8 x 14 IP20 Get Price	 SOCKET HEAD SCREW DIN 912 M10X25 Get Price



Digitally access spare parts and accessories information to ensure you keep your operation running.

Visit kennametal.com/novo and log into the web app.
It's free!



Online Catalog

Can't find your paper copy of our catalog anymore?

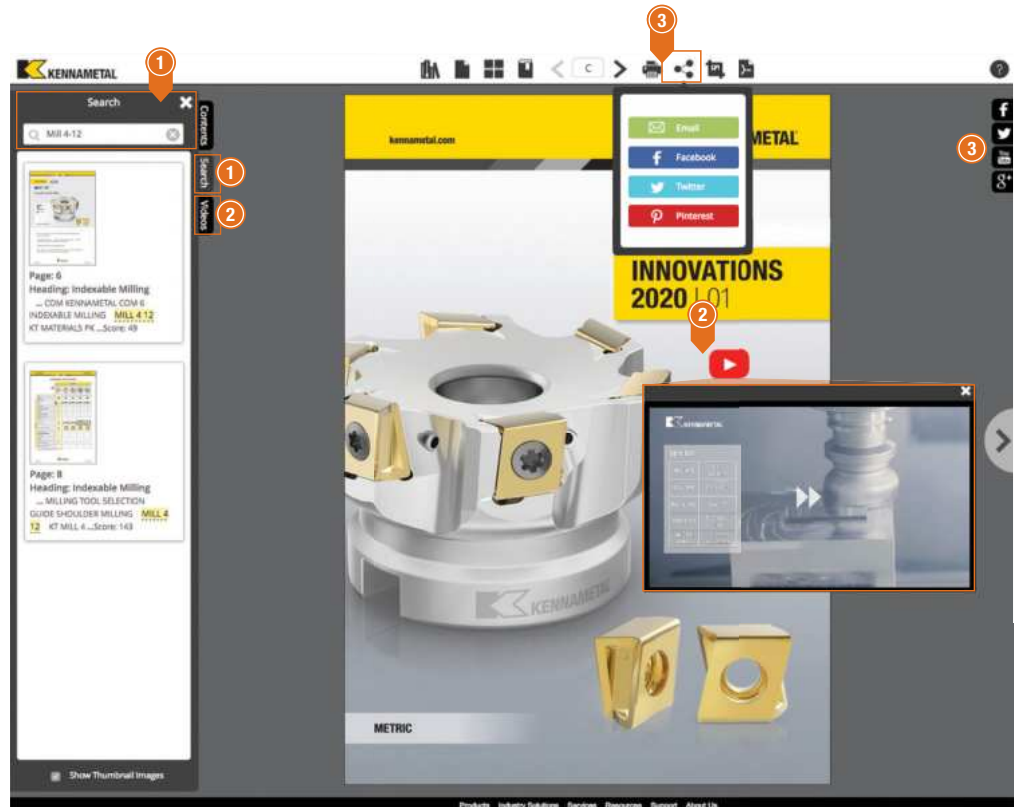
No worries. Go to catalogs.kennametal.com to see what's out there.

Search for what you need, watch a video, and share pages with others, all from one site! Go to catalogs.kennametal.com, and if you want to check it out on your mobile device, just download the FREE app for iOS or Android™.

1 Search for what you need

2 Watch videos

3 Share with others



Check out our new catalog app.
Available in the Google Play™ Store or
the App Store®.



Tool Selection Guide • Indexable Drills • Drill Fix PRO™



	PK	MS	LC	PK	MS	LC						
	NEW!	NEW!	NEW!	NEW!	NEW!	NEW!						
												
Page	14	14	14	15	15	15						
Insert position	Inboard			Outboard								
Workpiece material												
Primary	P	K	M	S	P	P	K	M	S	P		
Secondary			P	N	M	S			P	N	M	S
For long chipping material				✓						✓		
Main operation	          											
Hole tolerance	IT 9–11											
Cutting diameter [D1 min]	12mm											
Cutting diameter [D1 max]	65mm											
Drilling depth L/D1	2–5 x D											
Cutting edges per insert	4											
Coolant												
Connection Style Machine Side (CSMS)	  											

Tool Selection Guide • Indexable Drills • HTS-R



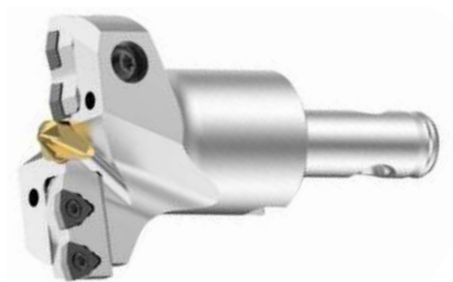
	GD	MD	LD	ST (PCD)
				
Page	kennametal.com	kennametal.com	kennametal.com	kennametal.com
Insert position	Inboard/Outboard			
Workpiece material				
Primary	P K S	P M S	P M K N S	N
Secondary	M N H	K N		
For long chipping material		✓		
Main operation				
Hole tolerance	IT 9–11			
Cutting diameter [D1 min]	40mm			
Cutting diameter [D1 max]	55mm			
Drilling depth L/D1	10 x D			
Cutting edges per insert	2			
Coolant				
Connection Style Machine Side (CSMS)	    			

Tool Selection Guide • Indexable Drills • HTS



	GD	HP	MD	DS	DFT-ST (PCD)
					
Page	kennametal.com	kennametal.com	kennametal.com	kennametal.com	kennametal.com
Insert position	Inboard/Outboard				
Workpiece material					
Primary	P K	P K	P K	P	N
Secondary	M N S	M N S	M N S	M N S	
For long chipping material				✓	
Main operation					
Hole tolerance	IT 9–11				
Cutting diameter [D1 min]	45mm				
Cutting diameter [D1 max]	270mm				
Drilling depth L/D1	10 x D				
Cutting edges per insert	3–4				
Coolant					
Connection Style Machine Side (CSMS)	    				

Tool Selection Guide • Indexable Drills • HTS



	HP	FP	MD	LP
				
Page	kennametal.com	kennametal.com	kennametal.com	kennametal.com
Insert position	Outboard			
Workpiece material				
Primary	P K	P K	P K	P
Secondary	M N S	M N S	M N S	M N S
For long chipping material				✓
Main operation				
Hole tolerance	IT 9–11			
Cutting diameter [D1 min]	45mm			
Cutting diameter [D1 max]	270mm			
Drilling depth L/D1	10 x D			
Cutting edges per insert	3–4			
Coolant				
Connection Style Machine Side (CSMS)	    			

Drill Fix PRO™ • Bodies • Catalog Numbering System

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.

DFPR	250	R	5	WB	32	M
Series	Cutting Diameter D1	Hand of Tool	Length to Diameter Ratio	Shank Style	Shank Diameter	Unit of Dimensions
DFPR = Drill Fix PRO	Metric = D1 in mm Inch = D1 in decimal inch	R = Right Hand	05 = 5 x D	WB = Weldon® SSF = Flanged Shank with Flats KM = Kennametal Modular	Metric = D1 in mm Inch = D1 in decimal inch	M = Metric Blank = Inch

Drill Fix PRO • Inserts • Catalog Numbering System

DFPR	04	03	04	LC	I
Series	Size	Thickness	Corner Radius	Geometry/ Application	Insert Location
DFPR = Drill Fix PRO	D (mm/inch) Inboard Inserts 04 = 4,57 / 0.180 05 = 5,30 / 0.209 06 = 6,50 / 0.256 08 = 8,04 / 0.317 10 = 9,90 / 0.390 12 = 11,90 / 0.469 14 = 14,45 / 0.569 17 = 17,30 / 0.681 20 = 20,50 / 0.807 D (mm/inch) Outboard Inserts 04 = 4,60 / 0.181 05 = 5,25 / 0.207 06 = 6,20 / 0.244 07 = 7,71 / 0.304 09 = 9,40 / 0.370 11 = 11,30 / 0.445 14 = 13,55 / 0.533 15 = 15,85 / 0.624 18 = 18,70 / 0.736	s (mm/inch) 02 = 2,00 / 0.079 02 = 2,40 / 0.094 03 = 2,60 / 0.102 03 = 2,80 / 0.110 03 = 3,00 / 0.118 04 = 3,60 / 0.142 04 = 4,40 / 0.173 05 = 5,20 / 0.205 06 = 6,20 / 0.244	Re (mm/inch) Inboard Inserts 03 = 0,30 / 0.012 03 = 0,30 / 0.012 04 = 0,40 / 0.016 04 = 0,40 / 0.016 05 = 0,50 / 0.020 05 = 0,50 / 0.020 06 = 0,60 / 0.024 08 = 0,80 / 0.031 08 = 0,80 / 0.031 Re (mm/inch) Outboard Inserts 04 = 0,40 / 0.016 04 = 0,40 / 0.016 04 = 0,40 / 0.016 05 = 0,50 / 0.020 05 = 0,50 / 0.020 06 = 0,60 / 0.024 08 = 0,80 / 0.031 08 = 0,80 / 0.031 10 = 1,00 / 0.039	PK = Steels, Cast Iron MS = Stainless Steel, Steels LC = Long Chipping Materials	I = Inboard O = Outboard

KenShape™ MaPACS/MaxPACS

Piloted PCD-Countersinks for CFRP Composite Materials

KenShape MaPACS and MaxPACS Countersinks deliver maximum performance for manual CFRP countersinking applications and are the perfect fit for our aerospace industry customers focusing on rivet hole drilling in composite and stacked materials.

Both, MaPACS and MaxPACS, are designed with one cutting edge to minimize the effort required by the operator. These piloted countersinks deliver excellent hole quality and tool life at a competitive cost per hole. The unique indexable version offers a highly economical solution for customers that don't want to maintain reconditioning infrastructure or prefer a screw-on design.

MaPACS/MaxPACS

- One brazed high-quality PCD cutting edge means lower thrust force and longer tool life.
- Lower your cost per hole with a design allowing up to three regrinds.
- Complementary to tooling platforms in aerospace and CFRP for rivet hole drilling.

MaxPACS

- Easily interchangeable PCD inserts deliver cost effectiveness with no reconditioning.



Drill Fix PRO™

Indexable Drilling

Materials



Applications



Drilling



Drilling:
Inclined Entry



Drilling:
Inclined Exit



Drilling:
Convex



Drilling:
X Offset



Drilling:
Stacked Plate



Drilling:
Blind



Drilling:
Chain Drilling



Drilling:
Cross Hole



Drilling:
Half Cylinder



Drilling:
Corner Drilling



NEW!



Designed for extended tool life and smooth drilling at high metal removal rates.

Our Drill Fix PRO indexable drill comes with a wiper included in every outboard insert and features larger coolant channels for high-volume coolant flow.

Other platform advancements include the versatility of the four-time indexable cutting edges, which offer customers extended application range and cost effectiveness.



Cost-Effective & Versatile Indexable Drilling: Drill Fix PRO™ offers an economic drilling platform that covers a broad spectrum of materials and applications.

Wiper Geometry on All Outboard Inserts:
Creating superior surface finish and hole quality.

Robust Toolholder Design:
Extreme rigidity resulting in less deviations, vibrations, and noise.

Optimized Coolant Delivery System:
Large twin coolant channels provide enhanced coolant flow, resulting in superior chip evacuation and increased tool life.

Indexable Drilling of Stainless Steel and High-Temp Alloys with Advanced High-PIMS Grades KCMS35 & KCMS40

- Providing high process reliability with the longest tool life on stainless steels and high-temp alloys.
- Smooth coating surface prevents build up on cutting edges for a consistent machining process.
- Combination of optimum layer adhesion and high depth-of-cut notching resistance enhances tool longevity.
- Lower cost per hole: Up to 100% longer insert life when compared to competitor grades.

MS Geometry

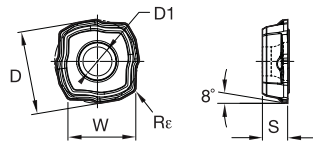


Inboard Insert
in KCMS40



Outboard Insert
in KCMS35

Drill Fix PRO™ • Carbide Insert • Inboard • PK Geometry

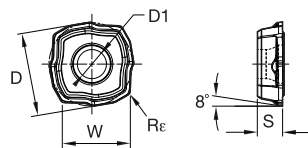
NEW!

- first choice
○ alternate choice

P	●
M	●
K	●
N	●
S	●
H	●

ISO catalogue number	D1	D	R _ε	W	S	KC7140
DFPR040203PKI	2,13	4,57	0,30	3,81	2,0	●
DFPR050203PKI	2,43	5,30	0,30	4,42	2,4	●
DFPR060304PKI	2,54	6,50	0,40	5,37	2,6	●
DFPR080304PKI	2,84	8,04	0,40	6,58	2,8	●
DFPR100305PKI	3,45	9,90	0,50	8,09	3,0	●
DFPR120405PKI	4,85	11,90	0,50	9,83	3,6	●
DFPR140406PKI	5,55	14,45	0,60	12,00	4,4	●
DFPR170508PKI	6,05	17,30	0,80	14,35	5,2	●
DFPR200608PKI	7,55	20,50	0,80	17,08	6,2	●

Drill Fix PRO • Carbide Insert • Inboard • MS Geometry

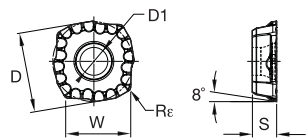
NEW!

- first choice
○ alternate choice

P	○
M	○
K	○
N	○
S	○
H	○

ISO catalogue number	D1	D	R _ε	W	S	KC7140	KCMS40
DFPR040203MSI	2,13	4,57	0,30	3,81	2,0	●	●
DFPR050203MSI	2,43	5,30	0,30	4,42	2,4	●	●
DFPR060304MSI	2,54	6,50	0,40	5,37	2,6	●	●
DFPR080304MSI	2,84	8,04	0,40	6,58	2,8	●	●
DFPR100305MSI	3,45	9,90	0,50	8,09	3,0	●	●
DFPR120405MSI	4,85	11,90	0,50	9,83	3,6	●	●
DFPR140406MSI	5,55	14,45	0,60	12,00	4,4	●	●
DFPR170508MSI	6,05	17,30	0,80	14,35	5,2	●	●
DFPR200608MSI	7,55	20,50	0,80	17,08	6,2	●	●

Drill Fix PRO • Carbide Insert • Inboard • LC Geometry

NEW!

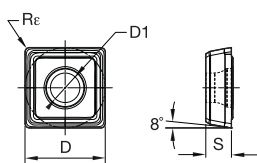
- first choice
○ alternate choice

P	○
M	○
K	○
N	○
S	○
H	○

ISO catalogue number	D1	D	R _ε	W	S	KC7140	KCMS40
DFPR040203LCI	2,13	4,57	0,30	3,81	2,0	●	●
DFPR050203LCI	2,43	5,30	0,30	4,42	2,4	●	●
DFPR060304LCI	2,54	6,50	0,40	5,37	2,6	●	●
DFPR080304LCI	2,84	8,04	0,40	6,58	2,8	●	●
DFPR100305LCI	3,45	9,90	0,50	8,09	3,0	●	●
DFPR120405LCI	4,85	11,90	0,50	9,83	3,6	●	●
DFPR140406LCI	5,55	14,45	0,60	12,00	4,4	●	●
DFPR170508LCI	6,05	17,30	0,80	14,35	5,2	●	●
DFPR200608LCI	7,55	20,50	0,80	17,08	6,2	●	●

Drill Fix PRO™ • Carbide Insert • Outboard • PK Geometry

NEW!



● first choice

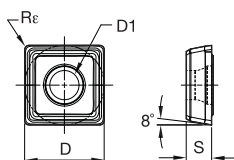
○ alternate choice

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

ISO catalogue number	D1	D	Re	S	KCPK10	KCU25	KCU40	KC7140
DFPR040204PKO	2,13	4,60	0,40	2,00	●	●	●	●
DFPR050204PKO	2,43	5,25	0,40	2,40	●	●	●	●
DFPR060304PKO	2,54	6,20	0,40	2,60	●	●	●	●
DFPR070305PKO	2,84	7,71	0,50	2,80	●	●	●	●
DFPR090305PKO	3,45	9,40	0,50	3,00	●	●	●	●
DFPR110406PKO	4,85	11,30	0,60	3,60	●	●	●	●
DFPR140408PKO	5,55	13,55	0,80	4,40	●	●	●	●
DFPR150508PKO	6,05	15,85	0,80	5,20	●	●	●	●
DFPR180610PKO	7,55	18,70	1,00	6,20	●	●	●	●

Drill Fix PRO • Carbide Insert • Outboard • MS Geometry

NEW!



● first choice

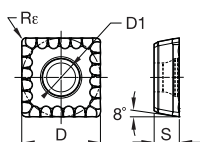
○ alternate choice

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

ISO catalogue number	D1	D	Re	S	KCU40	KCMS35	KC7140	KCMS40
DFPR040204MSO	2,13	4,60	0,40	2,00	●	●	●	●
DFPR050204MSO	2,43	5,25	0,40	2,40	●	●	●	●
DFPR060304MSO	2,54	6,20	0,40	2,60	●	●	●	●
DFPR070305MSO	2,84	7,71	0,50	2,80	●	●	●	●
DFPR090305MSO	3,45	9,40	0,50	3,00	●	●	●	●
DFPR110406MSO	4,85	11,30	0,60	3,60	●	●	●	●
DFPR140408MSO	5,55	13,55	0,80	4,40	●	●	●	●
DFPR150508MSO	6,05	15,85	0,80	5,20	●	●	●	●
DFPR180610MSO	7,55	18,70	1,00	6,20	●	●	●	●

Drill Fix PRO • Carbide Insert • Outboard • LC Geometry

NEW!



● first choice

○ alternate choice

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

ISO catalogue number	D1	D	Re	S	KCU40	KCMS35
DFPR040204LCO	2,13	4,60	0,40	2,00	●	●
DFPR050204LCO	2,43	5,25	0,40	2,40	●	●
DFPR060304LCO	2,54	6,20	0,40	2,60	●	●
DFPR070305LCO	2,84	7,71	0,50	2,80	●	●
DFPR090305LCO	3,45	9,40	0,50	3,00	●	●
DFPR110406LCO	4,85	11,30	0,60	3,60	●	●
DFPR140408LCO	5,55	13,55	0,80	4,40	●	●
DFPR150508LCO	6,05	15,85	0,80	5,20	●	●
DFPR180610LCO	7,55	18,70	1,00	6,20	●	●

Drill Fix PRO™ Tool Diameter Tolerance Table

L/D	Tolerance • Metric			
	2 L/D	3 L/D	4 L/D	5 L/D
Dia., mm	Hole tolerance, mm			
12,00–23,99	+0,00 / +0,15	+0,00 / +0,20	+0,00 / +0,25	+0,00 / +0,30
24,00–39,99	+0,00 / +0,20	+0,00 / +0,25	+0,00 / +0,30	+0,00 / +0,35
40,00–65,00	+0,00 / +0,25	+0,00 / +0,30	+0,00 / +0,35	+0,00 / +0,40

Drill Fix PRO • Application Data • Speed Vc in m/min and Feed fz in mm/rev

MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 12–13,99mm			Ø 14–16,49mm			Ø 16,5–19,99mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
P0																
	S	O	LC	KCMS35	310	335	360	0,05	0,08	0,10	0,05	0,09	0,12	0,05	0,09	0,13
	S	I	LC	KCMS40	310	335	360	0,05	0,08	0,10	0,05	0,09	0,12	0,05	0,09	0,13
	U	O	LC	KCMS35	200	220	240	0,04	0,06	0,07	0,04	0,07	0,08	0,04	0,07	0,09
	U	I	LC	KCMS40	200	220	240	0,04	0,06	0,07	0,04	0,07	0,08	0,04	0,07	0,09
	I	O	LC	KCMS35	125	135	145	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,06	0,08
	I	I	LC	KCMS40	125	135	145	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,06	0,08
P1																
	S	O	PK	KCPK10	310	335	360	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	S	I	PK	KC7140	310	335	360	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	U	O	PK	KCU25	200	220	240	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	U	I	PK	KC7140	200	220	240	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	I	O	PK	KCU40	125	135	145	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	PK	KC7140	125	135	145	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
P2																
	S	O	PK	KCPK10	310	335	360	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	S	I	PK	KC7140	310	335	360	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	U	O	PK	KCU25	200	220	240	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	U	I	PK	KC7140	200	220	240	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	I	O	PK	KCU40	125	135	145	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	PK	KC7140	125	135	145	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
P3																
	S	O	PK	KCPK10	260	290	320	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	S	I	PK	KC7140	260	290	320	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	U	O	PK	KCU25	170	190	210	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	U	I	PK	KC7140	170	190	210	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	I	O	PK	KCU40	105	120	135	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	PK	KC7140	105	120	135	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
P4																
	S	O	PK	KCPK10	220	260	300	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	S	I	PK	KC7140	220	260	300	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	U	O	PK	KCU25	145	170	195	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	U	I	PK	KC7140	145	170	195	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	I	O	PK	KCU40	90	105	120	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	PK	KC7140	90	105	120	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
P5																
	S	O	PK	KCU25	180	200	220	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	S	I	PK	KC7140	180	200	220	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	U	O	PK	KCU40	115	130	145	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	U	I	PK	KC7140	115	130	145	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	I	O	PK	KC7140	70	80	90	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	PK	KC7140	70	80	90	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
P6																
	S	O	PK	KCU25	180	200	220	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	S	I	PK	KC7140	180	200	220	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	U	O	PK	KCU40	115	130	145	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	U	I	PK	KC7140	115	130	145	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	I	O	PK	KC7140	70	80	90	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	PK	KC7140	70	80	90	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12

Drill Fix PRO™ • Application Data • Speed Vc in m/min and Feed fz in mm/rev

MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 20–24,49mm			Ø 25–30,49mm			Ø 30,5–37,49mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
P0																
S	O	LC	KCMS35	310	335	360	0,05	0,1	0,14	0,06	0,11	0,16	0,07	0,13	0,18	
	I	LC	KCMS40	310	335	360	0,05	0,1	0,14	0,06	0,11	0,16	0,07	0,13	0,18	
	O	LC	KCMS35	200	220	240	0,04	0,07	0,10	0,05	0,08	0,11	0,06	0,10	0,13	
	I	LC	KCMS40	200	220	240	0,04	0,07	0,10	0,05	0,08	0,11	0,06	0,10	0,13	
	O	LC	KCMS35	125	135	145	0,04	0,07	0,08	0,05	0,08	0,10	0,06	0,09	0,11	
	I	LC	KCMS40	125	135	145	0,04	0,07	0,08	0,05	0,08	0,10	0,06	0,09	0,11	
P1																
S	O	PK	KCPK10	310	335	360	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28	
	I	PK	KC7140	310	335	360	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28	
	O	PK	KCU25	200	220	240	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20	
	I	PK	KC7140	200	220	240	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20	
	O	PK	KCU40	125	135	145	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17	
	I	PK	KC7140	125	135	145	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17	
P2																
S	O	PK	KCPK10	310	335	360	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28	
	I	PK	KC7140	310	335	360	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28	
	O	PK	KCU25	200	220	240	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20	
	I	PK	KC7140	200	220	240	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20	
	O	PK	KCU40	125	135	145	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17	
	I	PK	KC7140	125	135	145	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17	
P3																
S	O	PK	KCPK10	260	290	320	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28	
	I	PK	KC7140	260	290	320	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28	
	O	PK	KCU25	170	190	210	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20	
	I	PK	KC7140	170	190	210	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20	
	O	PK	KCU40	105	120	135	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17	
	I	PK	KC7140	105	120	135	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17	
P4																
S	O	PK	KCPK10	220	260	300	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28	
	I	PK	KC7140	220	260	300	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28	
	O	PK	KCU25	145	170	195	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20	
	I	PK	KC7140	145	170	195	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20	
	O	PK	KCU40	90	105	120	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17	
	I	PK	KC7140	90	105	120	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17	
P5																
S	O	PK	KCU25	180	200	220	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28	
	I	PK	KC7140	180	200	220	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28	
	O	PK	KCU40	115	130	145	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20	
	I	PK	KC7140	115	130	145	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20	
	O	PK	KC7140	70	80	90	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17	
	I	PK	KC7140	70	80	90	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17	
P6																
S	O	PK	KCU25	180	200	220	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28	
	I	PK	KC7140	180	200	220	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28	
	O	PK	KCU40	115	130	145	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20	
	I	PK	KC7140	115	130	145	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20	
	O	PK	KC7140	70	80	90	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17	
	I	PK	KC7140	70	80	90	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17	

Drill Fix PRO™ • Application Data • Speed Vc in m/min and Feed fz in mm/rev

MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 37,5–45,49mm			Ø 45,5–54,49mm			Ø 54,5–65mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
P0																
	S	O	LC	KCMS35	310	335	360	0,07	0,14	0,20	0,08	0,15	0,21	0,08	0,16	0,23
	S	I	LC	KCMS40	310	335	360	0,07	0,14	0,20	0,08	0,15	0,21	0,08	0,16	0,23
	U	O	LC	KCMS35	200	220	240	0,06	0,10	0,14	0,06	0,11	0,15	0,06	0,12	0,16
	U	I	LC	KCMS40	200	220	240	0,06	0,10	0,14	0,06	0,11	0,15	0,06	0,12	0,16
	I	O	LC	KCMS35	125	135	145	0,06	0,09	0,12	0,06	0,10	0,13	0,06	0,11	0,14
	I	I	LC	KCMS40	125	135	145	0,06	0,09	0,12	0,06	0,10	0,13	0,06	0,11	0,14
P1																
	S	O	PK	KCPK10	310	335	360	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	S	I	PK	KC7140	310	335	360	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	U	O	PK	KCU25	200	220	240	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	U	I	PK	KC7140	200	220	240	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	I	O	PK	KCU40	125	135	145	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
	I	I	PK	KC7140	125	135	145	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
P2																
	S	O	PK	KCPK10	310	335	360	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	S	I	PK	KC7140	310	335	360	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	U	O	PK	KCU25	200	220	240	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	U	I	PK	KC7140	200	220	240	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	I	O	PK	KCU40	125	135	145	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
	I	I	PK	KC7140	125	135	145	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
P3																
	S	O	PK	KCPK10	260	290	320	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	S	I	PK	KC7140	260	290	320	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	U	O	PK	KCU25	170	190	210	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	U	I	PK	KC7140	170	190	210	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	I	O	PK	KCU40	105	120	135	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
	I	I	PK	KC7140	105	120	135	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
P4																
	S	O	PK	KCPK10	220	260	300	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	S	I	PK	KC7140	220	260	300	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	U	O	PK	KCU25	145	170	195	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	U	I	PK	KC7140	145	170	195	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	I	O	PK	KCU40	90	105	120	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
	I	I	PK	KC7140	90	105	120	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
P5																
	S	O	PK	KCU25	180	200	220	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	S	I	PK	KC7140	180	200	220	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	U	O	PK	KCU40	115	130	145	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	U	I	PK	KC7140	115	130	145	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	I	O	PK	KC7140	70	80	90	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
	I	I	PK	KC7140	70	80	90	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
P6																
	S	O	PK	KCU25	180	200	220	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	S	I	PK	KC7140	180	200	220	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	U	O	PK	KCU40	115	130	145	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	U	I	PK	KC7140	115	130	145	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	I	O	PK	KC7140	70	80	90	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
	I	I	PK	KC7140	70	80	90	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22

Drill Fix PRO™ • Application Data • Speed Vc in m/min and Feed fz in mm/rev

MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 12–13,99mm			Ø 14–16,49mm			Ø 16,5–19,99mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
M1																
	S	O	MS	KCMS35	150	190	230	0,05	0,08	0,10	0,05	0,09	0,12	0,05	0,10	0,14
	S	I	MS	KCMS40	150	190	230	0,05	0,08	0,10	0,05	0,09	0,12	0,05	0,10	0,14
	U	O	MS	KCMS40	100	125	150	0,04	0,06	0,07	0,04	0,07	0,08	0,04	0,07	0,10
	U	I	MS	KCMS40	100	125	150	0,04	0,06	0,07	0,04	0,07	0,08	0,04	0,07	0,10
	I	O	MS	KCMS40	60	75	90	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,07	0,08
	I	I	MS	KCMS40	60	75	90	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,07	0,08
M2																
	S	O	MS	KCMS35	150	180	210	0,05	0,08	0,10	0,05	0,09	0,12	0,05	0,10	0,14
	S	I	MS	KCMS40	150	180	210	0,05	0,08	0,10	0,05	0,09	0,12	0,05	0,10	0,14
	U	O	MS	KCMS40	100	120	140	0,04	0,06	0,07	0,04	0,07	0,08	0,04	0,07	0,10
	U	I	MS	KCMS40	100	120	140	0,04	0,06	0,07	0,04	0,07	0,08	0,04	0,07	0,10
	I	O	MS	KCMS40	60	75	90	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,07	0,08
	I	I	MS	KCMS40	60	75	90	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,07	0,08
M3																
	S	O	MS	KCMS35	100	130	160	0,04	0,07	0,09	0,04	0,08	0,10	0,04	0,09	0,12
	S	I	MS	KCMS40	100	130	160	0,04	0,07	0,09	0,04	0,08	0,10	0,04	0,09	0,12
	U	O	MS	KCMS40	65	85	105	0,03	0,05	0,06	0,03	0,06	0,07	0,03	0,06	0,08
	U	I	MS	KCMS40	65	85	105	0,03	0,05	0,06	0,03	0,06	0,07	0,03	0,06	0,08
	I	O	MS	KCMS40	40	55	70	0,03	0,05	0,05	0,03	0,05	0,06	0,03	0,06	0,07
	I	I	MS	KCMS40	40	55	70	0,03	0,05	0,05	0,03	0,05	0,06	0,03	0,06	0,07

Drill Fix PRO • Application Data • Speed Vc in m/min and Feed fz in mm/rev

MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 20–24,49mm			Ø 25–30,49mm			Ø 30,5–37,49mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
M1																
	S	O	MS	KCMS35	150	190	230	0,05	0,10	0,15	0,06	0,11	0,16	0,07	0,13	0,18
	S	I	MS	KCMS40	150	190	230	0,05	0,10	0,15	0,06	0,11	0,16	0,07	0,13	0,18
	U	O	MS	KCMS40	100	125	150	0,04	0,08	0,11	0,05	0,08	0,11	0,06	0,10	0,13
	U	I	MS	KCMS40	100	125	150	0,04	0,08	0,11	0,05	0,08	0,11	0,06	0,10	0,13
	I	O	MS	KCMS40	60	75	90	0,04	0,07	0,09	0,05	0,08	0,10	0,06	0,09	0,11
	I	I	MS	KCMS40	60	75	90	0,04	0,07	0,09	0,05	0,08	0,10	0,06	0,09	0,11
M2																
	S	O	MS	KCMS35	150	180	210	0,05	0,10	0,15	0,06	0,11	0,16	0,07	0,13	0,18
	S	I	MS	KCMS40	150	180	210	0,05	0,10	0,15	0,06	0,11	0,16	0,07	0,13	0,18
	U	O	MS	KCMS40	100	120	140	0,04	0,08	0,11	0,05	0,08	0,11	0,06	0,10	0,13
	U	I	MS	KCMS40	100	120	140	0,04	0,08	0,11	0,05	0,08	0,11	0,06	0,10	0,13
	I	O	MS	KCMS40	60	75	90	0,04	0,07	0,09	0,05	0,08	0,10	0,06	0,09	0,11
	I	I	MS	KCMS40	60	75	90	0,04	0,07	0,09	0,05	0,08	0,10	0,06	0,09	0,11
M3																
	S	O	MS	KCMS35	100	130	160	0,04	0,09	0,13	0,05	0,10	0,14	0,06	0,11	0,15
	S	I	MS	KCMS40	100	130	160	0,04	0,09	0,13	0,05	0,10	0,14	0,06	0,11	0,15
	U	O	MS	KCMS40	65	85	105	0,03	0,07	0,09	0,04	0,07	0,10	0,05	0,08	0,11
	U	I	MS	KCMS40	65	85	105	0,03	0,07	0,09	0,04	0,07	0,10	0,05	0,08	0,11
	I	O	MS	KCMS40	40	55	70	0,03	0,06	0,08	0,04	0,07	0,08	0,05	0,07	0,09
	I	I	MS	KCMS40	40	55	70	0,03	0,06	0,08	0,04	0,07	0,08	0,05	0,07	0,09

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MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 37,5–45,49mm			Ø 45,5–54,49mm			Ø 54,5–65mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
M1																
	S	O	MS	KCMS35	150	190	230	0,07	0,14	0,20	0,08	0,15	0,22	0,08	0,16	0,24
	S	I	MS	KCMS40	150	190	230	0,07	0,14	0,20	0,08	0,15	0,22	0,08	0,16	0,24
	U	O	MS	KCMS40	100	125	150	0,06	0,10	0,14	0,06	0,11	0,15	0,06	0,12	0,17
	U	I	MS	KCMS40	100	125	150	0,06	0,10	0,14	0,06	0,11	0,15	0,06	0,12	0,17
	I	O	MS	KCMS40	60	75	90	0,06	0,09	0,12	0,06	0,10	0,13	0,06	0,11	0,14
	I	I	MS	KCMS40	60	75	90	0,06	0,09	0,12	0,06	0,10	0,13	0,06	0,11	0,14
M2																
	S	O	MS	KCMS35	150	180	210	0,07	0,14	0,20	0,08	0,15	0,22	0,08	0,16	0,24
	S	I	MS	KCMS40	150	180	210	0,07	0,14	0,20	0,08	0,15	0,22	0,08	0,16	0,24
	U	O	MS	KCMS40	100	120	140	0,06	0,10	0,14	0,06	0,11	0,15	0,06	0,12	0,17
	U	I	MS	KCMS40	100	120	140	0,06	0,10	0,14	0,06	0,11	0,15	0,06	0,12	0,17
	I	O	MS	KCMS40	60	75	90	0,06	0,09	0,12	0,06	0,10	0,13	0,06	0,11	0,14
	I	I	MS	KCMS40	60	75	90	0,06	0,09	0,12	0,06	0,10	0,13	0,06	0,11	0,14
M3																
	S	O	MS	KCMS35	100	130	160	0,06	0,12	0,17	0,07	0,13	0,19	0,07	0,14	0,20
	S	I	MS	KCMS40	100	130	160	0,06	0,12	0,17	0,07	0,13	0,19	0,07	0,14	0,20
	U	O	MS	KCMS40	65	85	105	0,05	0,09	0,12	0,05	0,10	0,13	0,05	0,10	0,14
	U	I	MS	KCMS40	65	85	105	0,05	0,09	0,12	0,05	0,10	0,13	0,05	0,10	0,14
	I	O	MS	KCMS40	40	55	70	0,05	0,08	0,10	0,05	0,09	0,11	0,05	0,09	0,12
	I	I	MS	KCMS40	40	55	70	0,05	0,08	0,10	0,05	0,09	0,11	0,05	0,09	0,12

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MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 12–13,99mm			Ø 14–16,49mm			Ø 16,5–19,99mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
K1																
	S	O	PK	KCPK10	200	250	300	0,07	0,13	0,18	0,08	0,14	0,20	0,08	0,15	0,22
	S	I	PK	KC7140	200	250	300	0,07	0,13	0,18	0,08	0,14	0,20	0,08	0,15	0,22
	U	O	PK	KCU25	130	165	200	0,05	0,09	0,12	0,06	0,11	0,14	0,06	0,11	0,15
	U	I	PK	KC7140	130	165	200	0,05	0,09	0,12	0,06	0,11	0,14	0,06	0,11	0,15
	I	O	PK	KCU40	80	100	120	0,05	0,08	0,11	0,06	0,10	0,12	0,06	0,10	0,13
	I	I	PK	KC7140	80	100	120	0,05	0,08	0,11	0,06	0,10	0,12	0,06	0,10	0,13
K2																
	S	O	PK	KCPK10	180	220	260	0,07	0,13	0,18	0,08	0,14	0,20	0,08	0,15	0,22
	S	I	PK	KC7140	180	220	260	0,07	0,13	0,18	0,08	0,14	0,20	0,08	0,15	0,22
	U	O	PK	KCU25	120	145	170	0,05	0,09	0,12	0,06	0,11	0,14	0,06	0,11	0,15
	U	I	PK	KC7140	120	145	170	0,05	0,09	0,12	0,06	0,11	0,14	0,06	0,11	0,15
	I	O	PK	KCU40	70	90	110	0,05	0,08	0,11	0,06	0,10	0,12	0,06	0,10	0,13
	I	I	PK	KC7140	70	90	110	0,05	0,08	0,11	0,06	0,10	0,12	0,06	0,10	0,13
K3																
	S	O	PK	KCPK10	180	220	260	0,07	0,13	0,18	0,08	0,14	0,20	0,08	0,15	0,22
	S	I	PK	KC7140	180	220	260	0,07	0,13	0,18	0,08	0,14	0,20	0,08	0,15	0,22
	U	O	PK	KCU25	120	145	170	0,05	0,09	0,12	0,06	0,11	0,14	0,06	0,11	0,15
	U	I	PK	KC7140	120	145	170	0,05	0,09	0,12	0,06	0,11	0,14	0,06	0,11	0,15
	I	O	PK	KCU40	70	90	110	0,05	0,08	0,11	0,06	0,10	0,12	0,06	0,10	0,13
	I	I	PK	KC7140	70	90	110	0,05	0,08	0,11	0,06	0,10	0,12	0,06	0,10	0,13

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MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 20–24,49mm			Ø 25–30,49mm			Ø 30,5–37,49mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
K1																
	S	O	PK	KCPK10	200	250	300	0,09	0,17	0,24	0,09	0,19	0,28	0,10	0,21	0,31
	S	I	PK	KC7140	200	250	300	0,09	0,17	0,24	0,09	0,19	0,28	0,10	0,21	0,31
	U	O	PK	KCU25	130	165	200	0,07	0,12	0,17	0,07	0,14	0,19	0,08	0,15	0,22
	U	I	PK	KC7140	130	165	200	0,07	0,12	0,17	0,07	0,14	0,19	0,08	0,15	0,22
	I	O	PK	KCU40	80	100	120	0,07	0,11	0,15	0,07	0,12	0,17	0,08	0,14	0,18
	I	I	PK	KC7140	80	100	120	0,07	0,11	0,15	0,07	0,12	0,17	0,08	0,14	0,18
K2																
	S	O	PK	KCPK10	180	220	260	0,09	0,17	0,24	0,09	0,19	0,28	0,10	0,21	0,31
	S	I	PK	KC7140	180	220	260	0,09	0,17	0,24	0,09	0,19	0,28	0,10	0,21	0,31
	U	O	PK	KCU25	120	145	170	0,07	0,12	0,17	0,07	0,14	0,19	0,08	0,15	0,22
	U	I	PK	KC7140	120	145	170	0,07	0,12	0,17	0,07	0,14	0,19	0,08	0,15	0,22
	I	O	PK	KCU40	70	90	110	0,07	0,11	0,15	0,07	0,12	0,17	0,08	0,14	0,18
	I	I	PK	KC7140	70	90	110	0,07	0,11	0,15	0,07	0,12	0,17	0,08	0,14	0,18
K3																
	S	O	PK	KCPK10	180	220	260	0,09	0,17	0,24	0,09	0,19	0,28	0,10	0,21	0,31
	S	I	PK	KC7140	180	220	260	0,09	0,17	0,24	0,09	0,19	0,28	0,10	0,21	0,31
	U	O	PK	KCU25	120	145	170	0,07	0,12	0,17	0,07	0,14	0,19	0,08	0,15	0,22
	U	I	PK	KC7140	120	145	170	0,07	0,12	0,17	0,07	0,14	0,19	0,08	0,15	0,22
	I	O	PK	KCU40	70	90	110	0,07	0,11	0,15	0,07	0,12	0,17	0,08	0,14	0,18
	I	I	PK	KC7140	70	90	110	0,07	0,11	0,15	0,07	0,12	0,17	0,08	0,14	0,18

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MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
K1																
	S	O	PK	KCPK10	200	250	300	0,11	0,23	0,34	0,11	0,24	0,36	0,12	0,26	0,40
	S	I	PK	KC7140	200	250	300	0,11	0,23	0,34	0,11	0,24	0,36	0,12	0,26	0,40
	U	O	PK	KCU25	130	165	200	0,09	0,17	0,24	0,09	0,18	0,25	0,10	0,19	0,28
	U	I	PK	KC7140	130	165	200	0,09	0,17	0,24	0,09	0,18	0,25	0,10	0,19	0,28
	I	O	PK	KCU40	80	100	120	0,09	0,15	0,20	0,09	0,16	0,22	0,10	0,17	0,24
	I	I	PK	KC7140	80	100	120	0,09	0,15	0,20	0,09	0,16	0,22	0,10	0,17	0,24
K2																
	S	O	PK	KCPK10	180	220	260	0,11	0,23	0,34	0,11	0,24	0,36	0,12	0,26	0,40
	S	I	PK	KC7140	180	220	260	0,11	0,23	0,34	0,11	0,24	0,36	0,12	0,26	0,40
	U	O	PK	KCU25	120	145	170	0,09	0,17	0,24	0,09	0,18	0,25	0,10	0,19	0,28
	U	I	PK	KC7140	120	145	170	0,09	0,17	0,24	0,09	0,18	0,25	0,10	0,19	0,28
	I	O	PK	KCU40	70	90	110	0,09	0,15	0,20	0,09	0,16	0,22	0,10	0,17	0,24
	I	I	PK	KC7140	70	90	110	0,09	0,15	0,20	0,09	0,16	0,22	0,10	0,17	0,24
K3																
	S	O	PK	KCPK10	180	220	260	0,11	0,23	0,34	0,11	0,24	0,36	0,12	0,26	0,40
	S	I	PK	KC7140	180	220	260	0,11	0,23	0,34	0,11	0,24	0,36	0,12	0,26	0,40
	U	O	PK	KCU25	120	145	170	0,09	0,17	0,24	0,09	0,18	0,25	0,10	0,19	0,28
	U	I	PK	KC7140	120	145	170	0,09	0,17	0,24	0,09	0,18	0,25	0,10	0,19	0,28
	I	O	PK	KCU40	70	90	110	0,09	0,15	0,20	0,09	0,16	0,22	0,10	0,17	0,24
	I	I	PK	KC7140	70	90	110	0,09	0,15	0,20	0,09	0,16	0,22	0,10	0,17	0,24

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MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
N1																
	S	O	MS	KCMS35	350	500	650	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	S	I	MS	KCMS40	350	500	650	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	U	O	MS	KCMS35	300	425	550	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	U	I	MS	KCMS40	300	425	550	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	I	O	MS	KCMS40	210	300	390	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	MS	KCMS40	210	300	390	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
N2																
	S	O	MS	KCMS35	300	400	500	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	S	I	MS	KCMS40	300	400	500	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	U	O	MS	KCMS35	250	335	420	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	U	I	MS	KCMS40	250	335	420	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	I	O	MS	KCMS40	180	240	300	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	MS	KCMS40	180	240	300	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
N3																
	S	O	MS	KCMS35	300	400	500	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	S	I	MS	KCMS40	300	400	500	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	U	O	MS	KCMS35	250	335	420	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	U	I	MS	KCMS40	250	335	420	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	I	O	MS	KCMS40	180	240	300	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	MS	KCMS40	180	240	300	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
N4																
	S	O	MS	KCMS35	300	400	500	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	S	I	MS	KCMS40	300	400	500	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	U	O	MS	KCMS35	250	335	420	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	U	I	MS	KCMS40	250	335	420	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	I	O	MS	KCMS40	180	240	300	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	MS	KCMS40	180	240	300	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
N5																
	S	O	MS	KCMS35	300	400	500	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	S	I	MS	KCMS40	300	400	500	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	U	O	MS	KCMS35	250	335	420	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	U	I	MS	KCMS40	250	335	420	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	I	O	MS	KCMS40	180	240	300	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	MS	KCMS40	180	240	300	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
N6																
	S	O	MS	KCMS35	400	450	500	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	S	I	MS	KCMS40	400	450	500	0,06	0,11	0,16	0,07	0,13	0,18	0,07	0,14	0,20
	U	O	MS	KCMS35	340	380	420	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	U	I	MS	KCMS40	340	380	420	0,05	0,08	0,11	0,06	0,10	0,13	0,06	0,10	0,14
	I	O	MS	KCMS40	240	270	300	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	MS	KCMS40	240	270	300	0,05	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12

Drill Fix PRO™ • Application Data • Speed Vc in m/min and Feed fz in mm/rev

MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 20–24,49mm			Ø 25–30,49mm			Ø 30,5–37,49mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
N1																
	S	O	MS	KCMS35	350	500	650	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28
	S	I	MS	KCMS40	350	500	650	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28
	U	O	MS	KCMS35	300	425	550	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20
	U	I	MS	KCMS40	300	425	550	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20
	I	O	MS	KCMS40	210	300	390	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17
	I	I	MS	KCMS40	210	300	390	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17
N2																
	S	O	MS	KCMS35	300	400	500	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28
	S	I	MS	KCMS40	300	400	500	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28
	U	O	MS	KCMS35	250	335	420	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20
	U	I	MS	KCMS40	250	335	420	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20
	I	O	MS	KCMS40	180	240	300	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17
	I	I	MS	KCMS40	180	240	300	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17
N3																
	S	O	MS	KCMS35	300	400	500	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28
	S	I	MS	KCMS40	300	400	500	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28
	U	O	MS	KCMS35	250	335	420	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20
	U	I	MS	KCMS40	250	335	420	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20
	I	O	MS	KCMS40	180	240	300	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17
	I	I	MS	KCMS40	180	240	300	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17
N4																
	S	O	MS	KCMS35	300	400	500	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28
	S	I	MS	KCMS40	300	400	500	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28
	U	O	MS	KCMS35	250	335	420	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20
	U	I	MS	KCMS40	250	335	420	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20
	I	O	MS	KCMS40	180	240	300	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17
	I	I	MS	KCMS40	180	240	300	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17
N5																
	S	O	MS	KCMS35	300	400	500	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28
	S	I	MS	KCMS40	300	400	500	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28
	U	O	MS	KCMS35	250	335	420	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20
	U	I	MS	KCMS40	250	335	420	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20
	I	O	MS	KCMS40	180	240	300	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17
	I	I	MS	KCMS40	180	240	300	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17
N6																
	S	O	MS	KCMS35	400	450	500	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28
	S	I	MS	KCMS40	400	450	500	0,08	0,15	0,22	0,08	0,17	0,25	0,09	0,19	0,28
	U	O	MS	KCMS35	340	380	420	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20
	U	I	MS	KCMS40	340	380	420	0,06	0,11	0,15	0,06	0,12	0,18	0,07	0,14	0,20
	I	O	MS	KCMS40	240	270	300	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17
	I	I	MS	KCMS40	240	270	300	0,06	0,10	0,13	0,06	0,11	0,15	0,07	0,12	0,17

Drill Fix PRO™ • Application Data • Speed Vc in m/min and Feed fz in mm/rev

MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 37,5–45,49mm			Ø 45,5–54,49mm			Ø 54,5–65mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
N1																
	S	O	MS	KCMS35	350	500	650	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	S	I	MS	KCMS40	350	500	650	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	U	O	MS	KCMS35	300	425	550	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	U	I	MS	KCMS40	300	425	550	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	I	O	MS	KCMS40	210	300	390	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
	I	I	MS	KCMS40	210	300	390	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
N2																
	S	O	MS	KCMS35	300	400	500	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	S	I	MS	KCMS40	300	400	500	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	U	O	MS	KCMS35	250	335	420	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	U	I	MS	KCMS40	250	335	420	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	I	O	MS	KCMS40	180	240	300	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
	I	I	MS	KCMS40	180	240	300	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
N3																
	S	O	MS	KCMS35	300	400	500	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	S	I	MS	KCMS40	300	400	500	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	U	O	MS	KCMS35	250	335	420	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	U	I	MS	KCMS40	250	335	420	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	I	O	MS	KCMS40	180	240	300	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
	I	I	MS	KCMS40	180	240	300	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
N4																
	S	O	MS	KCMS35	300	400	500	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	S	I	MS	KCMS40	300	400	500	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	U	O	MS	KCMS35	250	335	420	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	U	I	MS	KCMS40	250	335	420	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	I	O	MS	KCMS40	180	240	300	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
	I	I	MS	KCMS40	180	240	300	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
N5																
	S	O	MS	KCMS35	300	400	500	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	S	I	MS	KCMS40	300	400	500	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	U	O	MS	KCMS35	250	335	420	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	U	I	MS	KCMS40	250	335	420	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	I	O	MS	KCMS40	180	240	300	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
	I	I	MS	KCMS40	180	240	300	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
N6																
	S	O	MS	KCMS35	400	450	500	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	S	I	MS	KCMS40	400	450	500	0,10	0,21	0,31	0,10	0,22	0,33	0,11	0,24	0,36
	U	O	MS	KCMS35	340	380	420	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	U	I	MS	KCMS40	340	380	420	0,08	0,15	0,22	0,08	0,16	0,23	0,09	0,17	0,25
	I	O	MS	KCMS40	240	270	300	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22
	I	I	MS	KCMS40	240	270	300	0,08	0,14	0,19	0,08	0,14	0,20	0,09	0,16	0,22

Drill Fix PRO™ • Application Data • Speed Vc in m/min and Feed fz in mm/rev

MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 12–13,99mm			Ø 14–16,49mm			Ø 16,5–19,99mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
S1																
	S	O	MS	KCMS35	60	70	80	0,05	0,07	0,08	0,05	0,08	0,10	0,05	0,09	0,11
	S	I	MS	KCMS40	60	70	80	0,05	0,07	0,08	0,05	0,08	0,10	0,05	0,09	0,11
	U	O	MS	KCMS40	40	45	50	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,06	0,08
	U	I	MS	KCMS40	40	45	50	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,06	0,08
	I	O	MS	KCMS40	25	33	40	0,04	0,05	0,05	0,04	0,05	0,06	0,04	0,06	0,07
	I	I	MS	KCMS40	25	33	40	0,04	0,05	0,05	0,04	0,05	0,06	0,04	0,06	0,07
S2																
	S	O	MS	KCMS35	50	60	70	0,05	0,07	0,08	0,05	0,08	0,10	0,05	0,09	0,11
	S	I	MS	KCMS40	50	60	70	0,05	0,07	0,08	0,05	0,08	0,10	0,05	0,09	0,11
	U	O	MS	KCMS40	30	40	50	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,06	0,08
	U	I	MS	KCMS40	30	40	50	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,06	0,08
	I	O	MS	KCMS40	25	33	40	0,04	0,05	0,05	0,04	0,05	0,06	0,04	0,06	0,07
	I	I	MS	KCMS40	25	33	40	0,04	0,05	0,05	0,04	0,05	0,06	0,04	0,06	0,07
S3																
	S	O	MS	KCMS35	70	80	90	0,05	0,07	0,08	0,05	0,08	0,10	0,05	0,09	0,11
	S	I	MS	KCMS40	70	80	90	0,05	0,07	0,08	0,05	0,08	0,10	0,05	0,09	0,11
	U	O	MS	KCMS40	50	60	70	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,06	0,08
	U	I	MS	KCMS40	50	60	70	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,06	0,08
	I	O	MS	KCMS40	30	35	40	0,04	0,05	0,05	0,04	0,05	0,06	0,04	0,06	0,07
	I	I	MS	KCMS40	30	35	40	0,04	0,05	0,05	0,04	0,05	0,06	0,04	0,06	0,07
S4																
	S	O	MS	KCMS35	70	80	90	0,05	0,07	0,08	0,05	0,08	0,10	0,05	0,09	0,11
	S	I	MS	KCMS40	70	80	90	0,05	0,07	0,08	0,05	0,08	0,10	0,05	0,09	0,11
	U	O	MS	KCMS40	45	55	65	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,06	0,08
	U	I	MS	KCMS40	45	55	65	0,04	0,05	0,06	0,04	0,06	0,07	0,04	0,06	0,08
	I	O	MS	KCMS40	30	40	50	0,04	0,05	0,05	0,04	0,05	0,06	0,04	0,06	0,07
	I	I	MS	KCMS40	30	40	50	0,04	0,05	0,05	0,04	0,05	0,06	0,04	0,06	0,07

Drill Fix PRO™ • Application Data • Speed Vc in m/min and Feed fz in mm/rev

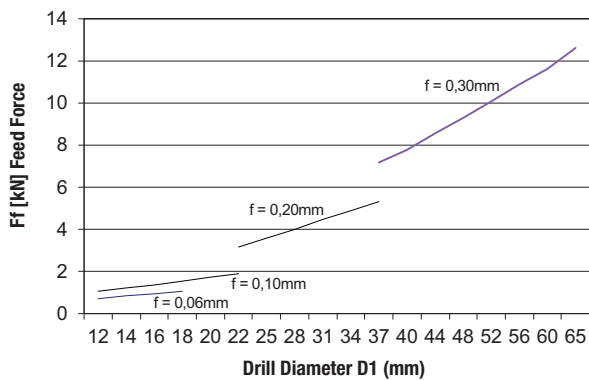
MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 20–24,49mm			Ø 25–30,49mm			Ø 30,5–37,49mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
S1																
	S	O	MS	KCMS35	60	70	80	0,05	0,09	0,12	0,06	0,10	0,13	0,07	0,11	0,14
	S	I	MS	KCMS40	60	70	80	0,05	0,09	0,12	0,06	0,10	0,13	0,07	0,11	0,14
	U	O	MS	KCMS40	40	45	50	0,04	0,07	0,08	0,05	0,07	0,09	0,06	0,08	0,10
	U	I	MS	KCMS40	40	45	50	0,04	0,07	0,08	0,05	0,07	0,09	0,06	0,08	0,10
	I	O	MS	KCMS40	25	33	40	0,04	0,06	0,07	0,05	0,07	0,08	0,06	0,08	0,09
	I	I	MS	KCMS40	25	33	40	0,04	0,06	0,07	0,05	0,07	0,08	0,06	0,08	0,09
S2																
	S	O	MS	KCMS35	50	60	70	0,05	0,09	0,12	0,06	0,10	0,13	0,07	0,11	0,14
	S	I	MS	KCMS40	50	60	70	0,05	0,09	0,12	0,06	0,10	0,13	0,07	0,11	0,14
	U	O	MS	KCMS40	30	40	50	0,04	0,07	0,08	0,05	0,07	0,09	0,06	0,08	0,10
	U	I	MS	KCMS40	30	40	50	0,04	0,07	0,08	0,05	0,07	0,09	0,06	0,08	0,10
	I	O	MS	KCMS40	25	33	40	0,04	0,06	0,07	0,05	0,07	0,08	0,06	0,08	0,09
	I	I	MS	KCMS40	25	33	40	0,04	0,06	0,07	0,05	0,07	0,08	0,06	0,08	0,09
S3																
	S	O	MS	KCMS35	70	80	90	0,05	0,09	0,12	0,06	0,10	0,13	0,07	0,11	0,14
	S	I	MS	KCMS40	70	80	90	0,05	0,09	0,12	0,06	0,10	0,13	0,07	0,11	0,14
	U	O	MS	KCMS40	50	60	70	0,04	0,07	0,08	0,05	0,07	0,09	0,06	0,08	0,10
	U	I	MS	KCMS40	50	60	70	0,04	0,07	0,08	0,05	0,07	0,09	0,06	0,08	0,10
	I	O	MS	KCMS40	30	35	40	0,04	0,06	0,07	0,05	0,07	0,08	0,06	0,08	0,09
	I	I	MS	KCMS40	30	35	40	0,04	0,06	0,07	0,05	0,07	0,08	0,06	0,08	0,09
S4																
	S	O	MS	KCMS35	70	80	90	0,05	0,09	0,12	0,06	0,10	0,13	0,07	0,11	0,14
	S	I	MS	KCMS40	70	80	90	0,05	0,09	0,12	0,06	0,10	0,13	0,07	0,11	0,14
	U	O	MS	KCMS40	45	55	65	0,04	0,07	0,08	0,05	0,07	0,09	0,06	0,08	0,10
	U	I	MS	KCMS40	45	55	65	0,04	0,07	0,08	0,05	0,07	0,09	0,06	0,08	0,10
	I	O	MS	KCMS40	30	40	50	0,04	0,06	0,07	0,05	0,07	0,08	0,06	0,08	0,09
	I	I	MS	KCMS40	30	40	50	0,04	0,06	0,07	0,05	0,07	0,08	0,06	0,08	0,09

Drill Fix PRO™ • Application Data • Speed Vc in m/min and Feed fz in mm/rev

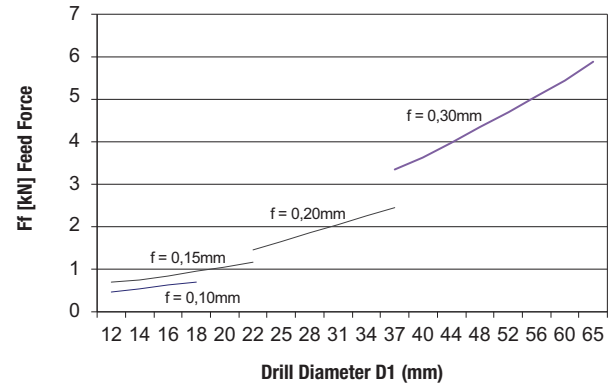
MG = Material Group CC = Cutting Condition S = Stable U = Unstable I = Interrupted IP = Insert Position O = Outboard I = Inboard GEO = Insert Geometry								Ø 37,5–45,49mm			Ø 45,5–54,49mm			Ø 54,5–65mm		
MG	CC	IP	GEO	Grade	Min	Vc m/min Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max	Min	fz mm/rev Start	Max
S1																
	S	O	MS	KCMS35	60	70	80	0,07	0,12	0,16	0,08	0,13	0,18	0,08	0,14	0,19
	S	I	MS	KCMS40	60	70	80	0,07	0,12	0,16	0,08	0,13	0,18	0,08	0,14	0,19
	U	O	MS	KCMS40	40	45	50	0,06	0,09	0,11	0,06	0,10	0,12	0,06	0,10	0,13
	U	I	MS	KCMS40	40	45	50	0,06	0,09	0,11	0,06	0,10	0,12	0,06	0,10	0,13
	I	O	MS	KCMS40	25	33	40	0,06	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	MS	KCMS40	25	33	40	0,06	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
S2																
	S	O	MS	KCMS35	50	60	70	0,07	0,12	0,16	0,08	0,13	0,18	0,08	0,14	0,19
	S	I	MS	KCMS40	50	60	70	0,07	0,12	0,16	0,08	0,13	0,18	0,08	0,14	0,19
	U	O	MS	KCMS40	30	40	50	0,06	0,09	0,11	0,06	0,10	0,12	0,06	0,10	0,13
	U	I	MS	KCMS40	30	40	50	0,06	0,09	0,11	0,06	0,10	0,12	0,06	0,10	0,13
	I	O	MS	KCMS40	25	33	40	0,06	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	MS	KCMS40	25	33	40	0,06	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
S3																
	S	O	MS	KCMS35	70	80	90	0,07	0,12	0,16	0,08	0,13	0,18	0,08	0,14	0,19
	S	I	MS	KCMS40	70	80	90	0,07	0,12	0,16	0,08	0,13	0,18	0,08	0,14	0,19
	U	O	MS	KCMS40	50	60	70	0,06	0,09	0,11	0,06	0,10	0,12	0,06	0,10	0,13
	U	I	MS	KCMS40	50	60	70	0,06	0,09	0,11	0,06	0,10	0,12	0,06	0,10	0,13
	I	O	MS	KCMS40	30	35	40	0,06	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	MS	KCMS40	30	35	40	0,06	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
S4																
	S	O	MS	KCMS35	70	80	90	0,07	0,12	0,16	0,08	0,13	0,18	0,08	0,14	0,19
	S	I	MS	KCMS40	70	80	90	0,07	0,12	0,16	0,08	0,13	0,18	0,08	0,14	0,19
	U	O	MS	KCMS40	45	55	65	0,06	0,09	0,11	0,06	0,10	0,12	0,06	0,10	0,13
	U	I	MS	KCMS40	45	55	65	0,06	0,09	0,11	0,06	0,10	0,12	0,06	0,10	0,13
	I	O	MS	KCMS40	30	40	50	0,06	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12
	I	I	MS	KCMS40	30	40	50	0,06	0,08	0,10	0,06	0,09	0,11	0,06	0,09	0,12

Feed Force Requirement • Metric

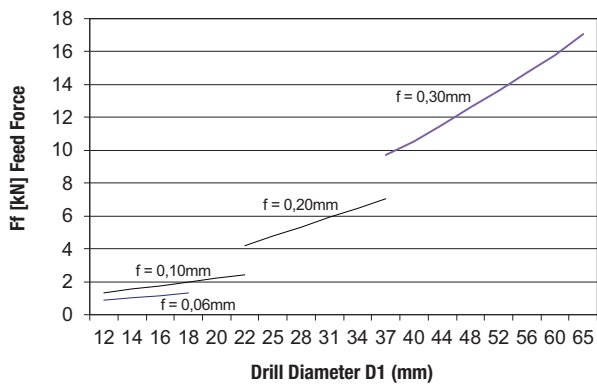
P Steel 42CrMo4



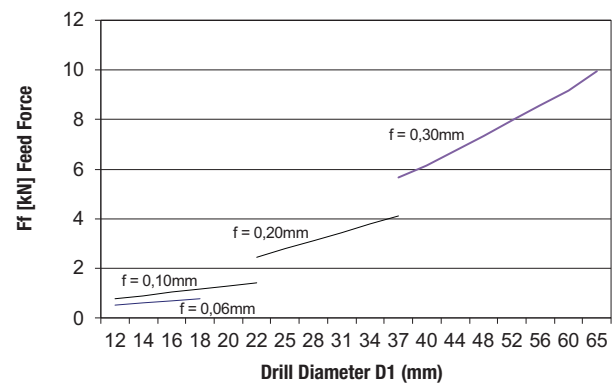
N Non-Ferrous Material 1.3535 AlMg3



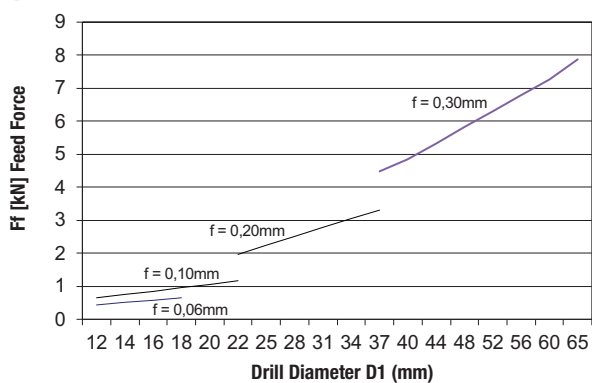
M Stainless Steel 1.4301 (304H)



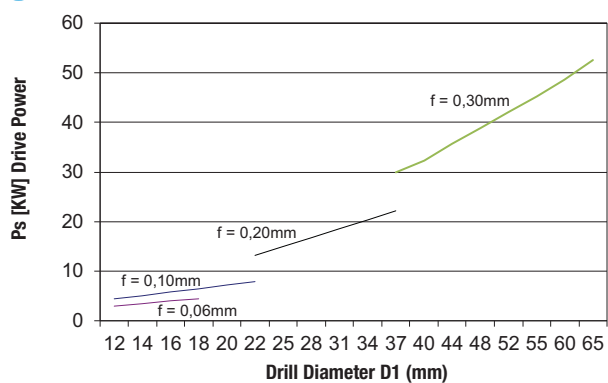
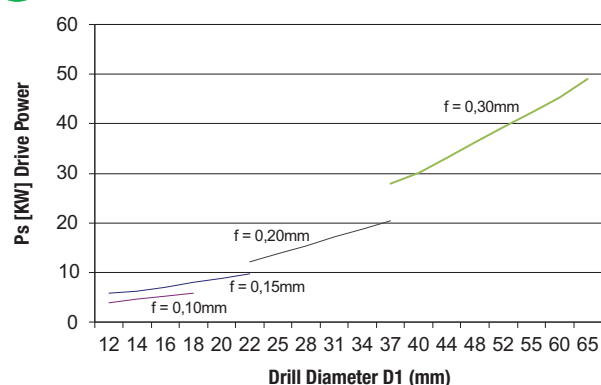
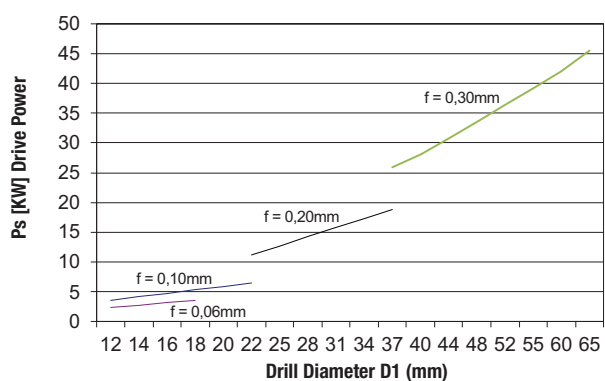
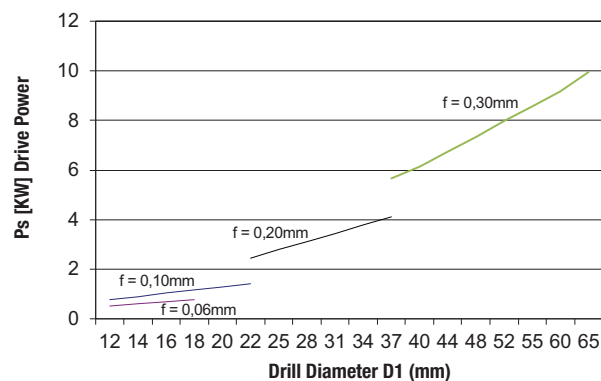
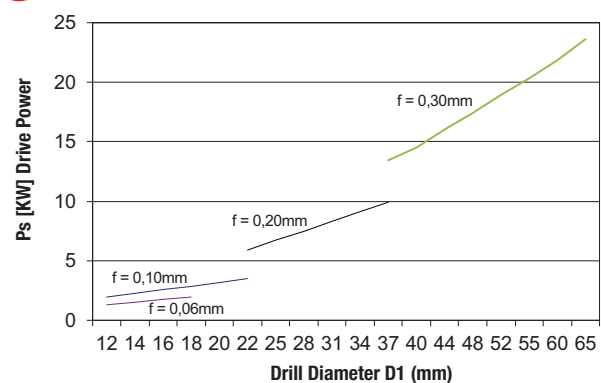
S High-Temperature Alloys 3.7164 TiAl6V4



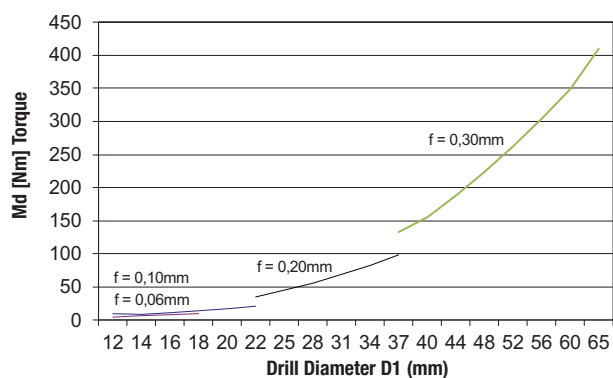
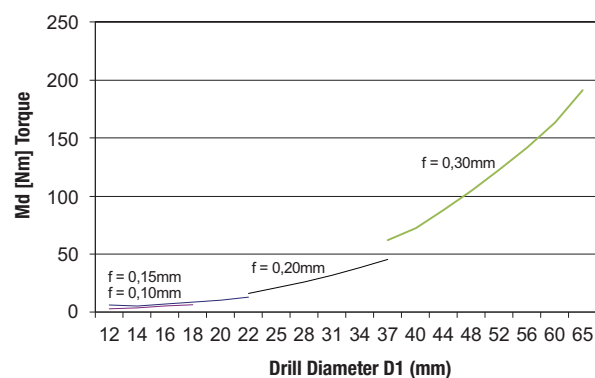
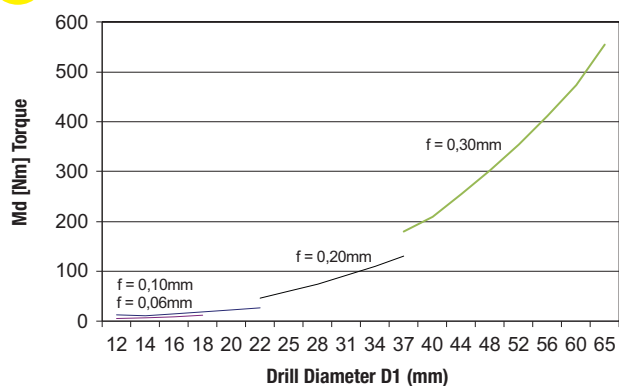
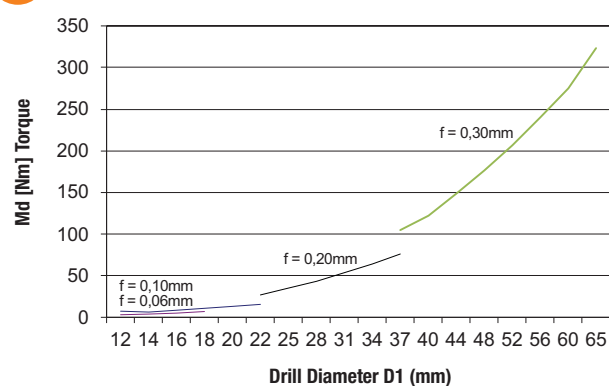
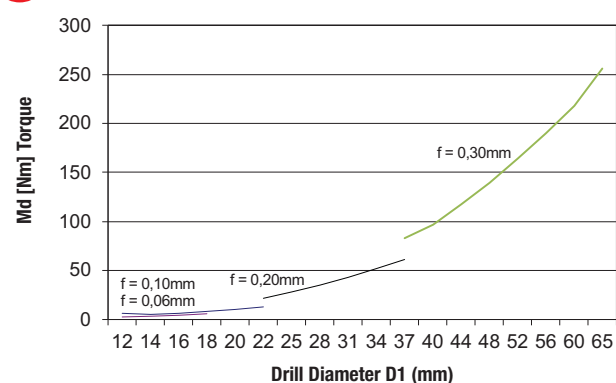
K Cast Iron GGG 40



Power Recommendation • Metric

P Steel 42CrMo4**N** Non-Ferrous Material 1.3535 AlMg3**M** Stainless Steel 1.4301 (304H)**S** High-Temperature Alloys 3.7164 TiAl6V4**K** Cast Iron GGG 40

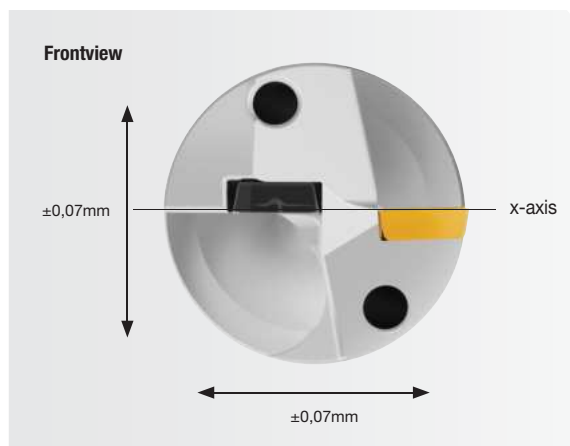
Torque Recommendation • Metric

P Steel 42CrMo4**N** Non-Ferrous Material 1.3535 AlMg3**M** Stainless Steel 1.4301 (304H)**S** High-Temperature Alloys 3.7164 TiAl6V4**K** Cast Iron GGG 40

Stationary Applications

Drill Fix PRO™ drills were also designed for use on lathes or any machine where the tool remains stationary and the workpiece rotates. An “x” is marked on the SSF-shank drills 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 0,07mm within the designated drill depth.



Tool Selection Guide • Material-Specific Drills

	KenDrill™ Micro	KenDrill Deep SGL	KenDrill Deep HPR	KenDrill Deep HPS
	NEW! 		NEW! 	
Series	B068 B070 B071 B072 B073 B074 B075 B076	B271*SGL B272*SGL B273*SGL B274*SGL B275*SGL	B271*HPR B272*HPR B273*HPR B274*HPR B275*HPR	B271*HPS B272*HPS B273*HPS B274*HPS B275*HPS
Page	52–55	kennametal.com	44–48	kennametal.com
Workpiece material				
Primary	P M S	M S	P K	N
Secondary	K N	P		
Hole tolerance	IT9–IT10	IT9–IT10	IT9–IT10	IT9–IT10
Standard range				
Cutting diameter [D1]	1,0–2,9mm	2,4–16,0mm	2,4–16,0mm	2,4–16,0mm
Drill length [L4 max]	2,0–126,0mm	44,0–450,0mm	44,0–450,0mm	44,0–450,0mm
Drilling depth L/D1	2–50 x D	15–30 x D	15–30 x D	15–30 x D
Point angle	141°/139°	135°	135°	135°
Flute angle	28°	30°	30°	30°
Coolant		 	 	 
Operations	 	   	   	   
Flutes and margin				
Corner chamfer				
Shank				

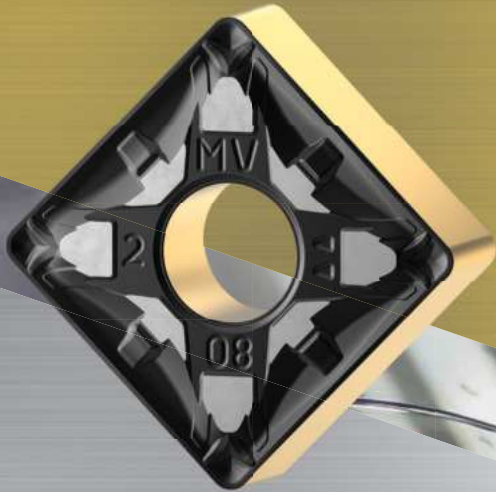
Tool Selection Guide • Material-Specific Drills

	SGL Drills	HPX Drills	HPX Drills	HPR Drills	HPS Drills	Y-TECH™ Drills	KMH Drills	KMH Drills
								
Series	B210_SGL B211_SGL B212_SGL	B221_HPX B222_HPX	B224_HPX B225_HPX B226_HPX	B254_HPR B255_HPR B256_HPR	B284_HPS B285_HPS B286_HPS	B291_YPL B292_YPL	B941A	B951A
Page	kennametal.com	kennametal.com	kennametal.com	kennametal.com	kennametal.com	kennametal.com	kennametal.com	kennametal.com
Workpiece material								
Primary	M S	P	P	K	N	M S	H	H
Secondary	P	K				P	P K	P K
Hole tolerance	IT9–IT10	IT9–IT10	IT9–IT10	IT9–IT10	IT9–IT10	IT9–IT10	IT9–IT10	IT9–IT10
Standard range								
Cutting diameter [D1]	2,5–20,0mm	3,0–20,0mm	3,0–20,0mm	3,0–20,0mm	3,0–20,0mm	3,0–20,0mm	2,5–14,0mm	3,0–16,0mm
Drill length [L4 max]	12,0–160,0mm	14,0–85,0mm	14,0–160,0mm	14,0–160,0mm	14,0–124,0mm	14,0–77,0mm	14,0–43,0mm	14,0–45,0mm
Drilling depth L/D1	3–8 x D	3–5 x D	3–8 x D	3–8 x D	3–8 x D	3–5 x D	3 x D	3 x D
Point angle	140°	140°	140°	143°	135°	140°	142°	140°
Flute angle	30°	30°	30°	30°	30°	30°	15°	30°
Coolant		 	 	 	 	 	 	 
Operations	 	 	 	   	 		  	  
Flutes and margin								
Corner chamfer								
Shank								

Tool Selection Guide • Versatile Drills

	GOdrill™	GOdrill	Kenna Universal™ Drills	Kenna Universal Drills	Kenna Universal Step Drills
					
Series	B041A_CPG B042A_CPG	B051A_CPG B052A_CPG B053A_CPG	B966A B967A	B976A B977A B978A B979A	B731A B732A
Page	kennametal.com	kennametal.com	kennametal.com	kennametal.com	kennametal.com
Workpiece material					
Primary	P M K N S	P M K N S	P K	P K	P K
Secondary	H	H	M N S	M N S	M N S
Hole tolerance	IT9–IT10	IT9–IT10	IT9–IT10	IT9–IT10	IT9–IT10
Standard range					
Cutting diameter [D1]	1,0–20,0mm	1,0–20,0mm	3,0–20,0mm	2,4–20,0mm	3,0–20,0mm
Drill length [L4 max]	5,0–77,0mm	5,0–124,0mm	14,0–85,0mm	12,0–124,0mm	—
Drilling depth L/D1	3–5 x D	3–8 x D	3–5 x D	3–12 x D	—
Point angle	140°	140°	140°	140°/132°	140°
Flute angle	30°	30°	30°	30°	30°
Coolant			 	 	 
Operations			   	   	    
Flutes and margin					
Corner chamfer					
Shank	 	 	 	 	

New KCP25C Steel Turning Grade with **KenGold™** CVD Coating Technology



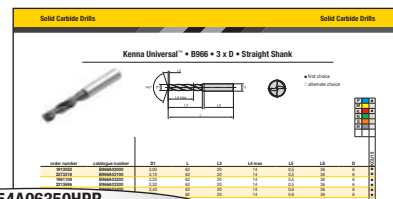
The new KCP25C grade featuring our new KENGold™ CVD coating sets a new standard in steel turning. With our proprietary coating technology, you can machine longer and with greater productivity and efficiency. KENGold delivers the higher metal removal rates and improved wear resistance you need.

KENGold™ Predictable Performance Turn After Turn



Solid Carbide Drills • Catalog Numbering System

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.



B254A06350HPR
K254A02500HPR

B**25****4****A****K****25****4****A**

Tool Type

Series

Length to Diameter Ratio

Shank Style

B = Metric (metric shank with 2mm steps)
K = Inch (inch shank)

04 = GDrill™
05 = GDrill Internal Coolant
06 = Microdrills Internal Coolant
10 = TF Drill
21 = HP Drill Internal Coolant for stainless steel

22 = HP Drill for steel

25 = HP Drill Internal Coolant for cast iron

26 = HP Drill Internal Coolant
07 = Micro Deep-Hole Drills Internal Coolant
27 = Deep-Hole Drill Internal Coolant

28 = HP Drill Internal Coolant for non-ferrous materials

29 = Y-TECH™ Drill Internal Coolant for difficult-to-machine materials

34 = BF Drill Internal Coolant

41 = TX Drill Internal Coolant
42 = TX Light Drill Internal Coolant

50 = Non-Coolant Spotdrill

51 = SPF PCD Drill Internal Coolant
53 = SPF Drill

55 = DAL Drill

56 = DAL PCD Drill Internal Coolant

70 = Flat Bottom Drill Internal Coolant

72 = Step Drill
73 = Step Drill Internal Coolant

94 = Hard Drill
95 = Hard Drill Internal Coolant

96 = Kenna Universal™ Drill
97 = Kenna Universal Drill Internal Coolant

1 = 3 x D
2 = 5 x D
3 = 8 x D

8 = 2 x D
5 = 5 x D

0 = 3 x D
1 = 5 x D
2 = 8 x D

1 = 3 x D
2 = 5 x D
4 = 3 x D Internal Coolant
5 = 5 x D Internal Coolant
6 = 8 x D Internal Coolant

4 = 3 x D
5 = 5 x D
6 = 8 x D

9 = 12 x D
0 = 7 x D

1 = 15 x D
2 = 20 x D
3 = 25 x D
4 = 30 x D
5 = 40 x D
6 = 50 x D

4 = 3 x D
5 = 5 x D
6 = 8 x D

1 = 3 x D
2 = 5 x D
3 = Medium Length
1 = 5 x D

1 = 120°
5 = 90°

1 = 3 x D
2 = 5 x D
6 = 3 x D Internal Coolant
7 = 5 x D Internal Coolant

7 = 3 x D

1 = Short
2 = Long

1 = 3 x D
2 = 5 x D

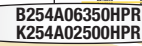
6 = 3 x D
7 = 5 x D
8 = 8 x D
9 = 12 x D

A = Straight Shank
F = Whistle Notch™ Shank

Z = Straight Shank (1mm steps)

S = Straight Shank (1mm steps)
H = Extended Shank for HIPACS

(continued)



KenDrill™ Deep HPR

Solid Carbide Deep-Hole Drilling

Materials



Applications



Drilling



Drilling:
Inclined Exit



Drilling:
Stacked Plate



Drilling:
Cross Hole



The new KenDrill Deep HPR improves on our existing range of solid carbide deep-hole drilling tools with its steel and iron capabilities.

A material-specific deep-hole drill, KenDrill Deep HPR is in stock and available in an extensive range of lengths and diameters.

Proven performance with our HPR drills geometry, featuring our heat- and wear-resistant KCK10A grade.

High productivity with speeds up to four times faster than conventional drills.

Longer tool life in steel and iron compared to competitors.

Bottom-line savings from increased metal removal rate.

15 x D

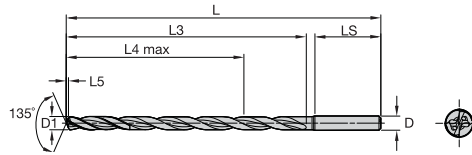
20 x D

25 x D

30 x D

40 x D

KenDrill™ Deep HPR • 15 x D • Internal Coolant • Straight Shank • Metric

NEW!

● first choice

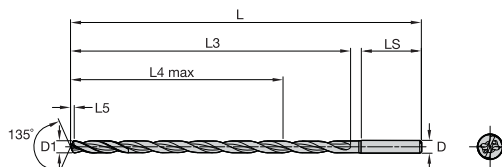
○ alternate choice

P	●
M	●
K	●
N	●
S	●
H	●

order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCK10A
7081612	B271Z02383KMR	2,38	86	51	44	0,4	30	3	●
7081613	B271Z02500KMR	2,50	86	51	44	0,5	30	3	●
7081614	B271Z02642KMR	2,64	86	51	44	0,5	30	3	●
7081615	B271Z02705KMR	2,71	86	52	45	0,5	30	3	●
7081616	B271Z02779KMR	2,78	86	52	45	0,5	30	3	●
7081617	B271Z02820KMR	2,82	86	52	45	0,5	30	3	●
7081618	B271Z03000KMR	3,00	86	52	45	0,6	30	3	●
7081619	B271Z03175KMR	3,18	105	67	58	0,6	32	4	●
7081620	B271Z03200KMR	3,20	105	67	58	0,6	32	4	●
7081631	B271Z03500KMR	3,50	105	68	59	0,7	32	4	●
7081632	B271Z03600KMR	3,60	105	68	59	0,7	32	4	●
7081633	B271Z03700KMR	3,70	105	69	60	0,7	32	4	●
7081634	B271Z03970KMR	3,97	105	70	60	0,8	32	4	●
7081635	B271Z04000KMR	4,00	105	70	60	0,8	32	4	●
7081636	B271Z04500HPR	4,50	124	85	74	1,5	34	5	●
7081637	B271Z04623HPR	4,62	124	86	75	1,5	34	5	●
7081638	B271Z04763HPR	4,76	124	86	75	1,6	34	5	●
7081639	B271Z04800HPR	4,80	124	86	75	1,6	34	5	●
7081640	B271Z05000HPR	5,00	124	87	75	1,7	34	5	●
7081641	B271Z05060HPR	5,06	143	101	88	1,7	36	6	●
7081642	B271Z05260HPR	5,26	143	102	89	1,8	36	6	●
7081643	B271Z05410HPR	5,41	143	102	89	1,8	36	6	●
7081644	B271Z05500HPR	5,50	143	102	89	1,8	36	6	●
7081645	B271Z05558HPR	5,56	143	102	89	1,9	36	6	●
7081646	B271Z05800HPR	5,80	143	103	89	1,9	36	6	●
7081647	B271Z05900HPR	5,90	143	103	89	2,0	36	6	●
7081648	B271Z06000HPR	6,00	143	104	90	2,0	36	6	●
7081649	B271Z06200HPR	6,20	162	118	103	2,1	38	7	●
7081650	B271Z06350HPR	6,35	162	119	104	2,1	38	7	●
7081651	B271Z06500HPR	6,50	162	119	104	2,2	38	7	●
7081652	B271Z06528HPR	6,53	162	119	104	2,2	38	7	●
7081653	B271Z06746HPR	6,75	162	120	104	2,3	38	7	●
7081654	B271Z06909HPR	6,91	162	121	105	2,3	38	7	●
7081655	B271Z07000HPR	7,00	162	121	105	2,3	38	7	●
7081656	B271Z07145HPR	7,15	181	135	118	2,4	40	8	●
7081657	B271Z07500HPR	7,50	181	136	119	2,5	40	8	●
7081658	B271Z07541HPR	7,54	181	136	119	2,5	40	8	●
7081659	B271Z07938HPR	7,94	181	138	120	2,7	40	8	●
7081660	B271Z08000HPR	8,00	181	138	120	2,7	40	8	●
7081661	B271Z08200HPR	8,20	200	152	133	2,7	42	9	●
7081662	B271Z08334HPR	8,33	200	153	134	2,8	42	9	●
7081663	B271Z08500HPR	8,50	200	153	134	2,8	42	9	●
7081664	B271Z08733HPR	8,73	200	154	134	2,9	42	9	●
7081667	B271Z09000HPR	9,00	200	155	135	3,0	42	9	●
7081668	B271Z09100HPR	9,10	219	169	148	3,0	44	10	●
7081669	B271Z09200HPR	9,20	219	169	148	3,1	44	10	●
7081670	B271Z09500HPR	9,50	219	170	149	3,2	44	10	●
7081671	B271Z09525HPR	9,53	219	170	149	3,2	44	10	●
7081672	B271Z09750HPR	9,75	219	171	149	3,3	44	10	●
7081673	B271Z10000HPR	10,00	219	172	150	3,3	44	10	●
7081674	B271Z10200HPR	10,20	238	186	163	3,4	46	11	●
7081675	B271Z10500HPR	10,50	238	187	164	3,5	46	11	●
7081676	B271Z10716HPR	10,72	238	188	165	3,6	46	11	●
7081677	B271Z10800HPR	10,80	238	188	164	3,6	46	11	●
7081678	B271Z11000HPR	11,00	238	189	165	3,7	46	11	●
7081680	B271Z11500HPR	11,50	257	204	179	3,8	48	12	●
7081691	B271Z12000HPR	12,00	257	206	180	4,0	48	12	●
7081692	B271Z12500HPR	12,50	276	221	194	4,2	50	13	●
7081694	B271Z12700HPR	12,70	276	222	195	4,2	50	13	●
7081695	B271Z13000HPR	13,00	276	223	195	4,3	50	13	●
7081696	B271Z13500HPR	13,50	295	238	209	4,5	52	14	●
7081697	B271Z14000HPR	14,00	295	240	210	4,7	52	14	●
7081698	B271Z14288HPR	14,29	314	255	224	4,8	54	15	●
7081699	B271Z14500HPR	14,50	314	255	224	4,8	54	15	●
7081700	B271Z15000HPR	15,00	314	257	225	5,0	54	15	●
7081711	B271Z15300HPR	15,30	333	272	239	5,1	56	16	●
7081712	B271Z15875HPR	15,88	333	273	240	5,3	56	16	●
7081713	B271Z16000HPR	16,00	333	274	240	5,4	56	16	●

KenDrill™ Deep HPR • 20 x D • Internal Coolant • Straight Shank • Metric

NEW!



● first choice

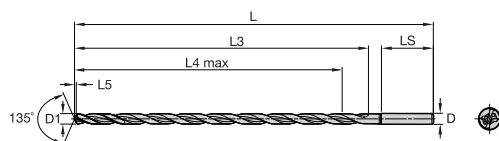
○ alternate choice

P	●
M	●
K	●
N	●
S	●
H	●

order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCK10A
7081716	B272Z02383KMR	2,38	101	63	56	0,4	30	3	●
7081717	B272Z02400KMR	2,40	101	63	56	0,4	30	3	●
7081718	B272Z02489KMR	2,49	101	63	56	0,5	30	3	●
7081719	B272Z02500KMR	2,50	101	63	56	0,5	30	3	●
7081720	B272Z02779KMR	2,78	101	66	59	0,5	30	3	●
7081731	B272Z03000KMR	3,00	101	67	60	0,6	30	3	●
7081732	B272Z03150KMR	3,15	125	83	74	0,6	32	4	●
7081733	B272Z03175KMR	3,18	125	83	74	0,6	32	4	●
7081734	B272Z03300KMR	3,30	125	84	75	0,6	32	4	●
7081735	B272Z03500KMR	3,50	125	86	77	0,7	32	4	●
7081736	B272Z03850KMR	3,85	125	88	79	0,7	32	4	●
7081737	B272Z03970KMR	3,97	125	89	79	0,8	32	4	●
7081738	B272Z04000KMR	4,00	125	90	80	0,8	32	4	●
7081739	B272Z04500HPR	4,50	149	108	97	1,5	34	5	●
7081740	B272Z04623HPR	4,62	149	109	98	1,5	34	5	●
7081741	B272Z04763HPR	4,76	149	110	99	1,6	34	5	●
7081742	B272Z05000HPR	5,00	149	112	100	1,7	34	5	●
7081744	B272Z05200HPR	5,20	173	127	114	1,7	36	6	●
7081745	B272Z05260HPR	5,26	173	128	115	1,8	36	6	●
7081746	B272Z05410HPR	5,41	173	129	116	1,8	36	6	●
7081747	B272Z05500HPR	5,50	173	130	117	1,8	36	6	●
7081748	B272Z05558HPR	5,56	173	130	117	1,9	36	6	●
7081749	B272Z05800HPR	5,80	173	132	118	1,9	36	6	●
7081750	B272Z06000HPR	6,00	173	134	120	2,0	36	6	●
7081771	B272Z06200HPR	6,20	197	149	134	2,1	38	7	●
7081772	B272Z06350HPR	6,35	197	151	136	2,1	38	7	●
7081774	B272Z06500HPR	6,50	197	152	137	2,2	38	7	●
7081775	B272Z06528HPR	6,53	197	152	137	2,2	38	7	●
7081776	B272Z06746HPR	6,75	197	154	138	2,3	38	7	●
7081777	B272Z06800HPR	6,80	197	154	138	2,3	38	7	●
7081778	B272Z06909HPR	6,91	197	155	139	2,3	38	7	●
7081779	B272Z07000HPR	7,00	197	156	140	2,3	38	7	●
7081780	B272Z07145HPR	7,15	221	171	154	2,4	40	8	●
7081781	B272Z07200HPR	7,20	221	171	154	2,4	40	8	●
7081782	B272Z07500HPR	7,50	221	174	157	2,5	40	8	●
7081783	B272Z07541HPR	7,54	221	174	157	2,5	40	8	●
7081784	B272Z07938HPR	7,94	221	177	159	2,7	40	8	●
7081785	B272Z08000HPR	8,00	221	178	160	2,7	40	8	●
7081786	B272Z08334HPR	8,33	245	194	175	2,8	42	9	●
7081787	B272Z08433HPR	8,43	245	195	176	2,8	42	9	●
7081788	B272Z08500HPR	8,50	245	196	177	2,8	42	9	●
7081789	B272Z08733HPR	8,73	245	198	178	2,9	42	9	●
7081790	B272Z09000HPR	9,00	245	200	180	3,0	42	9	●
7081791	B272Z09100HPR	9,10	269	215	194	3,0	44	10	●
7081792	B272Z09500HPR	9,50	269	218	197	3,2	44	10	●
7081793	B272Z09525HPR	9,53	269	218	197	3,2	44	10	●
7081794	B272Z09750HPR	9,75	269	220	198	3,3	44	10	●
7081795	B272Z10000HPR	10,00	269	222	200	3,3	44	10	●
7081796	B272Z10200HPR	10,20	293	237	214	3,4	46	11	●
7081797	B272Z10500HPR	10,50	293	240	217	3,5	46	11	●
7081798	B272Z10716HPR	10,72	293	242	219	3,6	46	11	●
7081799	B272Z11000HPR	11,00	293	244	220	3,7	46	11	●
7081800	B272Z11500HPR	11,50	317	262	237	3,8	48	12	●
7081801	B272Z11800HPR	11,80	317	264	238	3,9	48	12	●
7081802	B272Z12000HPR	12,00	317	266	240	4,0	48	12	●
7081803	B272Z12500HPR	12,50	341	284	257	4,2	50	13	●
7081804	B272Z12700HPR	12,70	341	285	258	4,2	50	13	●
7081805	B272Z13000HPR	13,00	341	288	260	4,3	50	13	●
7081806	B272Z13100HPR	13,10	365	302	273	4,4	52	14	●
7081807	B272Z13500HPR	13,50	365	306	277	4,5	52	14	●
7081808	B272Z14000HPR	14,00	365	310	280	4,7	52	14	●
7081809	B272Z14500HPR	14,50	389	328	297	4,8	54	15	●
7081810	B272Z15000HPR	15,00	389	332	300	5,0	54	15	●
7081811	B272Z15500HPR	15,50	413	350	317	5,2	56	16	●
7081812	B272Z16000HPR	16,00	413	354	320	5,4	56	16	●

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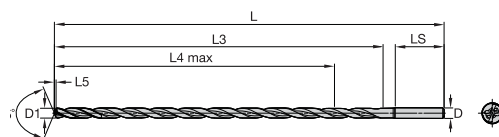
○ alternate choice

P	●
M	●
K	●
N	●
S	●
H	●

order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCK10A
7081813	B273Z02383KMR	2,38	116	74	67	0,4	30	3	●
7081814	B273Z02500KMR	2,50	116	76	69	0,5	30	3	●
7081816	B273Z02600KMR	2,60	116	77	70	0,5	30	3	●
7081817	B273Z03000KMR	3,00	116	82	75	0,6	30	3	●
7081818	B273Z03175KMR	3,18	145	99	90	0,6	32	4	●
7081819	B273Z03500KMR	3,50	145	103	94	0,7	32	4	●
7081820	B273Z04000KMR	4,00	145	110	100	0,8	32	4	●
7081821	B273Z05000HPR	5,00	174	137	125	1,7	34	5	●
7081822	B273Z05100HPR	5,10	203	152	139	1,7	36	6	●
7081823	B273Z05500HPR	5,50	203	157	144	1,8	36	6	●
7081824	B273Z05800HPR	5,80	203	161	147	1,9	36	6	●
7081825	B273Z06000HPR	6,00	203	164	150	2,0	36	6	●
7081826	B273Z06350HPR	6,35	232	182	167	2,1	38	7	●
7081827	B273Z06500HPR	6,50	232	184	169	2,2	38	7	●
7081828	B273Z06746HPR	6,75	232	187	171	2,3	38	7	●
7081829	B273Z07000HPR	7,00	232	191	175	2,3	38	7	●
7081830	B273Z07500HPR	7,50	261	211	194	2,5	40	8	●
7081831	B273Z08000HPR	8,00	261	218	200	2,7	40	8	●
7081832	B273Z08500HPR	8,50	290	238	219	2,8	42	9	●
7081833	B273Z08733HPR	8,73	290	241	221	2,9	42	9	●
7081834	B273Z09000HPR	9,00	290	245	225	3,0	42	9	●
7081835	B273Z10000HPR	10,00	319	272	250	3,3	44	10	●
7081836	B273Z10200HPR	10,20	348	288	265	3,4	46	11	●
7081837	B273Z10500HPR	10,50	348	292	269	3,5	46	11	●
7081838	B273Z11000HPR	11,00	348	299	275	3,7	46	11	●
7081839	B273Z11500HPR	11,50	377	319	294	3,8	48	12	●
7081840	B273Z12000HPR	12,00	377	326	300	4,0	48	12	●
7081841	B273Z12500HPR	12,50	406	346	319	4,2	50	13	●
7081842	B273Z12700HPR	12,70	406	349	322	4,2	50	13	●
7081843	B273Z13000HPR	13,00	406	353	325	4,3	50	13	●
7081844	B273Z13500HPR	13,50	435	373	344	4,5	52	14	●
7081845	B273Z14000HPR	14,00	435	380	350	4,7	52	14	●
7081846	B273Z14288HPR	14,29	464	397	366	4,8	54	15	●
7081847	B273Z14500HPR	14,50	464	400	369	4,8	54	15	●
7081848	B273Z15000HPR	15,00	464	407	375	5,0	54	15	●
7081849	B273Z16000HPR	16,00	493	434	400	5,4	56	16	●

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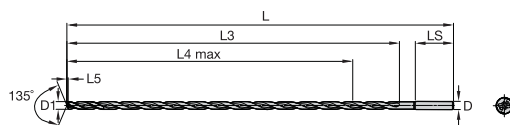
○ alternate choice

P	●
M	●
K	●
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S	●
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order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCK10A
7080419	B274Z02383KMR	2,38	131	86	79	0,4	30	3	●
7080420	B274Z02500KMR	2,50	131	88	81	0,5	30	3	●
7080421	B274Z02600KMR	2,60	131	90	83	0,5	30	3	●
7080422	B274Z02800KMR	2,80	131	94	87	0,5	30	3	●
7080423	B274Z03000KMR	3,00	131	97	90	0,6	30	3	●
7080424	B274Z03175KMR	3,18	165	115	106	0,6	32	4	●
7080425	B274Z03500KMR	3,50	165	121	112	0,7	32	4	●
7080426	B274Z03970KMR	3,97	165	129	119	0,8	32	4	●
7080427	B274Z04000KMR	4,00	165	130	120	0,8	32	4	●
7080428	B274Z04300HPR	4,30	199	149	138	1,4	34	5	●
7080429	B274Z04500HPR	4,50	199	153	142	1,5	34	5	●
7080430	B274Z04763HPR	4,76	199	157	146	1,6	34	5	●
7080431	B274Z05000HPR	5,00	199	162	150	1,7	34	5	●
7080432	B274Z05500HPR	5,50	233	185	172	1,8	36	6	●
7080433	B274Z05700HPR	5,70	233	188	175	1,9	36	6	●
7080434	B274Z06000HPR	6,00	233	194	180	2,0	36	6	●
7080435	B274Z06350HPR	6,35	267	214	199	2,1	38	7	●
7080436	B274Z06500HPR	6,50	267	217	202	2,2	38	7	●
7080437	B274Z06800HPR	6,80	267	222	206	2,3	38	7	●
7080438	B274Z07000HPR	7,00	267	226	210	2,3	38	7	●
7080439	B274Z07700HPR	7,70	301	252	235	2,6	40	8	●
7080440	B274Z07938HPR	7,94	301	257	239	2,7	40	8	●
7080441	B274Z08000HPR	8,00	301	258	240	2,7	40	8	●
7080442	B274Z08334HPR	8,33	335	278	259	2,8	42	9	●
7080443	B274Z08500HPR	8,50	335	281	262	2,8	42	9	●
7080444	B274Z08700HPR	8,70	335	284	264	2,9	42	9	●
7080445	B274Z09000HPR	9,00	335	290	270	3,0	42	9	●
7080446	B274Z09525HPR	9,53	369	313	292	3,2	44	10	●
7080447	B274Z10000HPR	10,00	369	322	300	3,3	44	10	●
7080448	B274Z10200HPR	10,20	403	339	316	3,4	46	11	●
7080449	B274Z10500HPR	10,50	403	345	322	3,5	46	11	●
7080450	B274Z10716HPR	10,72	403	349	326	3,6	46	11	●
7080451	B274Z11000HPR	11,00	403	354	330	3,7	46	11	●
7080452	B274Z11500HPR	11,50	437	377	352	3,8	48	12	●
7080453	B274Z11800HPR	11,80	437	382	356	3,9	48	12	●
7080454	B274Z12000HPR	12,00	437	386	360	4,0	48	12	●
7080455	B274Z12500HPR	12,50	471	409	382	4,2	50	13	●
7080456	B274Z12700HPR	12,70	471	412	385	4,2	50	13	●
7080457	B274Z13000HPR	13,00	471	418	390	4,3	50	13	●
7080458	B274Z13500HPR	13,50	505	441	412	4,5	52	14	●
7080459	B274Z14000HPR	14,00	505	450	420	4,7	52	14	●
7080460	B274Z15000HPR	15,00	539	482	450	5,0	54	15	●

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● first choice

○ alternate choice

P	●
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H	●

order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCK10A
7080289	B275Z02500KMR	2,50	161	113	106	0,5	30	3	●
7080290	B275Z03000KMR	3,00	161	127	120	0,6	30	3	●
7080391	B275Z03175KMR	3,18	205	146	137	0,6	32	4	●
7080392	B275Z03500KMR	3,50	205	156	147	0,7	32	4	●
7080393	B275Z03571KMR	3,57	205	158	149	0,7	32	4	●
7080394	B275Z03970KMR	3,97	205	169	159	0,8	32	4	●
7080395	B275Z04000KMR	4,00	205	170	160	0,8	32	4	●
7080396	B275Z04200HPR	4,20	249	189	178	1,4	34	5	●
7080397	B275Z04500HPR	4,50	249	198	187	1,5	34	5	●
7080398	B275Z04763HPR	4,76	249	205	194	1,6	34	5	●
7080399	B275Z05000HPR	5,00	249	212	200	1,7	34	5	●
7080400	B275Z05500HPR	5,50	293	240	227	1,8	36	6	●
7080401	B275Z05558HPR	5,56	293	241	228	1,9	36	6	●
7080402	B275Z06000HPR	6,00	293	254	240	2,0	36	6	●
7080403	B275Z06350HPR	6,35	337	278	263	2,1	38	7	●
7080404	B275Z06500HPR	6,50	337	282	267	2,2	38	7	●
7080405	B275Z06800HPR	6,80	337	290	274	2,3	38	7	●
7080406	B275Z07000HPR	7,00	337	296	280	2,3	38	7	●
7080407	B275Z07145HPR	7,15	381	314	297	2,4	40	8	●
7080408	B275Z07500HPR	7,50	381	324	307	2,5	40	8	●
7080409	B275Z07938HPR	7,94	381	336	318	2,7	40	8	●
7080410	B275Z08000HPR	8,00	381	338	320	2,7	40	8	●
7080411	B275Z08500HPR	8,50	425	366	347	2,8	42	9	●
7080412	B275Z08733HPR	8,73	425	372	352	2,9	42	9	●
7080413	B275Z09000HPR	9,00	425	380	360	3,0	42	9	●
7080414	B275Z09525HPR	9,53	469	408	387	3,2	44	10	●
7080415	B275Z10000HPR	10,00	469	422	400	3,3	44	10	●
7080416	B275Z10200HPR	10,20	513	441	418	3,4	46	11	●
7080417	B275Z10320HPR	10,32	513	445	422	3,5	46	11	●
7080418	B275Z11000HPR	11,00	513	464	440	3,7	46	11	●

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KenDrill™ Deep HPR • Application Data • Metric

Material Group	Cutting Speed — vc m/min			Feed rate (f) = mm/r by diameter							
	Min	Starting Value	Max	3,0	4,0	6,0	8,0	10,0	12,0	14,0	16,0
P											
0	100	100	125	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	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	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	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	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	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	60	70	80	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
K											
1	80	100	120	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	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	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

KenDrill™ Micro

Solid Carbide Deep-Hole Drilling

Materials



Applications



Drilling



KenDrill Micro delivers powerful coolant supply to improve chip evacuation and avoid frustrating tool breakages. With a reliable drill design that reduces cutting forces and optimizes chip flow, you can expect process consistency.

KenDrill Micro supports machining many materials, providing versatility on the shop floor. This small diameter solid carbide drill will bring a new level of accuracy and longevity to small-part machining.

**KenDrill™ Micro – Kennametal's First
Comprehensive Micro Drilling Portfolio**
for short- and deep-hole applications.

**Versatile Design Supports Machining Multiple
Materials** with one of the highest coolant volume
supplies on the market.

Featuring a Broad Micro Drill Selection
with diameters starting from 1.0mm and length offerings
from 2 x D to 50 x D, including through coolant versions.

2 x D

7 x D

12 x D

20 x D

25 x D

30 x D

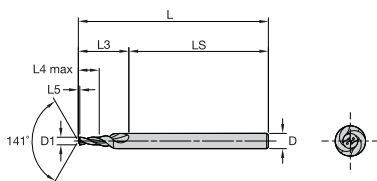
40 x D

50 x D



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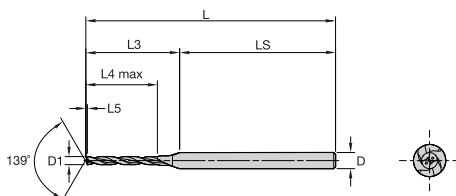
○ alternate choice

P	●
M	●
K	○
N	○
S	●
H	○

order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCU10
7070756	B068A01000	1,00	50	9	2	0,2	41	4	●
7070757	B068A01100	1,10	50	9	2	0,2	41	4	●
7070758	B068A01200	1,20	50	10	3	0,2	41	4	●
7070759	B068A01300	1,30	50	10	3	0,2	40	4	●
7070760	B068A01400	1,40	50	10	3	0,2	40	4	●
7070761	B068A01500	1,50	50	11	3	0,3	39	4	●
7070762	B068A01600	1,60	50	11	4	0,3	39	4	●
7070763	B068A01700	1,70	50	12	4	0,3	38	4	●
7070764	B068A01800	1,80	50	12	4	0,3	38	4	●
7070765	B068A01900	1,90	50	12	4	0,3	38	4	●
7070766	B068A02000	2,00	50	13	4	0,4	37	4	●
7070767	B068A02100	2,10	50	13	5	0,4	37	4	●
7070768	B068A02200	2,20	50	14	5	0,4	36	4	●
7070769	B068A02300	2,30	55	14	5	0,4	41	4	●
7070770	B068A02400	2,40	55	15	5	0,4	40	4	●
7070771	B068A02500	2,50	55	15	5	0,4	40	4	●
7070772	B068A02600	2,60	55	16	6	0,5	40	4	●
7070773	B068A02700	2,70	55	16	6	0,5	39	4	●
7070774	B068A02800	2,80	55	16	6	0,5	39	4	●
7070775	B068A02900	2,90	55	17	6	0,5	38	4	●

KenDrill Micro • 7 x D • Internal Coolant • Straight Shank • Metric

NEW!



● first choice

○ alternate choice

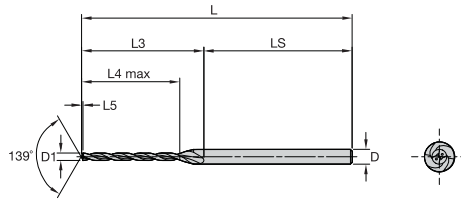
P	●
M	●
K	○
N	○
S	●
H	○

order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCU10
7070643	B070A01000	1,00	55	14	7	0,2	41	4	●
7070644	B070A01100	1,10	55	15	8	0,2	40	4	●
7070645	B070A01200	1,20	55	16	9	0,2	40	4	●
7070646	B070A01300	1,30	55	16	9	0,2	39	4	●
7070647	B070A01400	1,40	55	17	10	0,3	38	4	●
7070648	B070A01500	1,50	55	18	11	0,3	37	4	●
7070649	B070A01600	1,60	57	19	12	0,3	38	4	●
7070650	B070A01700	1,70	57	20	12	0,3	37	4	●
7070661	B070A01800	1,80	59	21	13	0,3	38	4	●
7070662	B070A01900	1,90	59	22	14	0,4	37	4	●
7070663	B070A02000	2,00	62	23	14	0,4	39	4	●
7070664	B070A02100	2,10	62	24	15	0,4	38	4	●
7070665	B070A02200	2,20	62	25	16	0,4	37	4	●
7070666	B070A02300	2,30	65	26	17	0,4	39	4	●
7070667	B070A02400	2,40	65	27	17	0,4	38	4	●
7070668	B070A02500	2,50	65	28	18	0,5	37	4	●
7070669	B070A02600	2,60	65	29	19	0,5	37	4	●
7070670	B070A02700	2,70	68	29	19	0,5	39	4	●
7070681	B070A02800	2,80	68	30	20	0,5	38	4	●
7070682	B070A02900	2,90	68	31	21	0,5	37	4	●

117-119	120	40-41	124

KenDrill™ Micro • 12 x D • Internal Coolant • Straight Shank • Metric

NEW!



● first choice

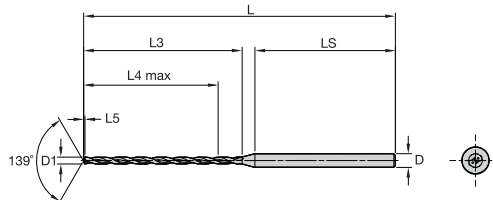
○ alternate choice

P	●
M	●
K	○
N	○
S	●
H	○

order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCU10
7070685	B071A01000	1,00	58	19	12	0,2	39	4	●
7070686	B071A01100	1,10	58	20	13	0,2	38	4	●
7070687	B071A01200	1,20	60	22	15	0,2	39	4	●
7070688	B071A01300	1,30	60	23	16	0,2	37	4	●
7070689	B071A01400	1,40	63	24	17	0,3	39	4	●
7070690	B071A01500	1,50	63	26	18	0,3	37	4	●
7070701	B071A01600	1,60	66	27	20	0,3	39	4	●
7070702	B071A01700	1,70	66	29	21	0,3	37	4	●
7070703	B071A01800	1,80	69	30	22	0,3	39	4	●
7070704	B071A01900	1,90	69	32	23	0,4	38	4	●
7070705	B071A02000	2,00	73	33	24	0,4	40	4	●
7070706	B071A02100	2,10	73	34	26	0,4	39	4	●
7070707	B071A02200	2,20	73	36	27	0,4	37	4	●
7070708	B071A02300	2,30	78	37	28	0,4	41	4	●
7070709	B071A02400	2,40	78	39	29	0,4	39	4	●
7070710	B071A02500	2,50	78	40	31	0,5	38	4	●
7070711	B071A02600	2,60	78	42	32	0,5	37	4	●
7070712	B071A02700	2,70	83	43	33	0,5	40	4	●
7070713	B071A02800	2,80	83	44	34	0,5	39	4	●
7070714	B071A02900	2,90	83	46	35	0,5	37	4	●

KenDrill Micro • 20 x D • Internal Coolant • Straight Shank • Metric

NEW!



● first choice

○ alternate choice

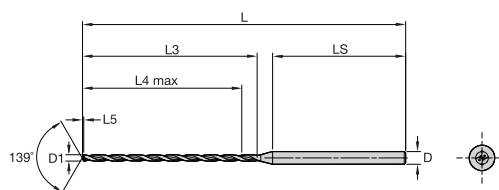
P	●
M	●
K	○
N	○
S	●
H	○

order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCU10
7070776	B072A01000	1,00	67	23	20	0,2	38	4	●
7070777	B072A01100	1,10	67	26	22	0,2	36	4	●
7070778	B072A01200	1,20	71	28	24	0,2	38	4	●
7070779	B072A01300	1,30	71	30	26	0,2	36	4	●
7070780	B072A01400	1,40	75	33	28	0,3	38	4	●
7070801	B072A01500	1,50	75	35	30	0,3	36	4	●
7070802	B072A01600	1,60	79	37	32	0,3	37	4	●
7070803	B072A01700	1,70	79	39	34	0,3	35	4	●
7070804	B072A01800	1,80	84	42	36	0,3	38	4	●
7070805	B072A01900	1,90	84	44	38	0,4	36	4	●
7070806	B072A02000	2,00	91	46	40	0,4	41	4	●
7070807	B072A02100	2,10	91	49	42	0,4	39	4	●
7070808	B072A02200	2,20	91	51	44	0,4	37	4	●
7070809	B072A02300	2,30	98	53	46	0,4	42	4	●
7070810	B072A02400	2,40	98	56	48	0,4	39	4	●
7070811	B072A02500	2,50	98	58	51	0,5	37	4	●
7070812	B072A02600	2,60	98	60	53	0,5	35	4	●
7070813	B072A02700	2,70	107	63	55	0,5	42	4	●
7070814	B072A02800	2,80	107	65	57	0,5	40	4	●
7070815	B072A02900	2,90	107	67	59	0,5	38	4	●

117-119	120	40-41	124

KenDrill™ Micro • 25 x D • Internal Coolant • Straight Shank • Metric

NEW!



● first choice

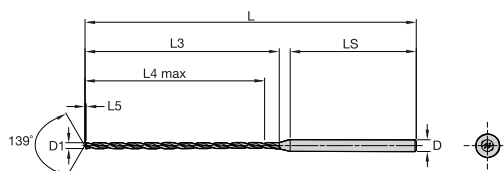
○ alternate choice

P	●
M	●
K	○
N	○
S	●
H	●

order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCU10
7071037	B073A01000	1,00	73	28	25	0,2	39	4	●
7071038	B073A01100	1,10	73	31	28	0,2	37	4	●
7071039	B073A01200	1,20	77	34	30	0,2	38	4	●
7071040	B073A01300	1,30	77	37	33	0,2	35	4	●
7071041	B073A01400	1,40	82	40	35	0,3	38	4	●
7071042	B073A01500	1,50	82	42	38	0,3	35	4	●
7071043	B073A01600	1,60	88	45	40	0,3	38	4	●
7071044	B073A01700	1,70	88	48	43	0,3	36	4	●
7071045	B073A01800	1,80	94	51	45	0,3	39	4	●
7071046	B073A01900	1,90	94	54	48	0,4	37	4	●
7071047	B073A02000	2,00	102	56	50	0,4	42	4	●
7071048	B073A02100	2,10	102	59	53	0,4	39	4	●
7071049	B073A02200	2,20	102	62	55	0,4	37	4	●
7071050	B073A02300	2,30	111	65	58	0,4	43	4	●
7071051	B073A02400	2,40	111	68	60	0,4	40	4	●
7071052	B073A02500	2,50	111	71	63	0,5	38	4	●
7071053	B073A02600	2,60	111	73	66	0,5	35	4	●
7071054	B073A02700	2,70	122	76	68	0,5	44	4	●
7071055	B073A02800	2,80	122	79	71	0,5	41	4	●
7071056	B073A02900	2,90	122	82	73	0,5	38	4	●

KenDrill Micro • 30 x D • Internal Coolant • Straight Shank • Metric

NEW!



● first choice

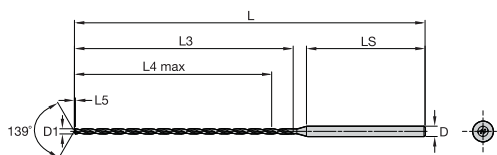
○ alternate choice

P	●
M	●
K	○
N	○
S	●
H	●

order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCU10
7070857	B074A01000	1,00	79	33	30	0,2	40	4	●
7070858	B074A01100	1,10	79	37	33	0,2	37	4	●
7070859	B074A01200	1,20	84	40	36	0,2	39	4	●
7070860	B074A01300	1,30	84	43	39	0,2	36	4	●
7071021	B074A01400	1,40	90	47	42	0,3	39	4	●
7071022	B074A01500	1,50	90	50	45	0,3	36	4	●
7071023	B074A01600	1,60	99	53	48	0,3	41	4	●
7071024	B074A01700	1,70	99	56	51	0,3	38	4	●
7071025	B074A01800	1,80	104	60	54	0,3	40	4	●
7071026	B074A01900	1,90	104	63	57	0,4	37	4	●
7071027	B074A02000	2,00	113	66	60	0,4	43	4	●
7071028	B074A02100	2,10	113	70	63	0,4	40	4	●
7071029	B074A02200	2,20	113	73	66	0,4	37	4	●
7071030	B074A02300	2,30	124	76	69	0,4	45	4	●
7071031	B074A02400	2,40	124	80	72	0,4	41	4	●
7071032	B074A02500	2,50	124	83	76	0,5	38	4	●
7071033	B074A02600	2,60	124	86	79	0,5	35	4	●
7071034	B074A02700	2,70	137	90	82	0,5	45	4	●
7071035	B074A02800	2,80	137	93	85	0,5	42	4	●
7071036	B074A02900	2,90	137	96	88	0,5	39	4	●

117-119	120	40-41	124

KenDrill™ Micro • 40 x D • Internal Coolant • Straight Shank • Metric

NEW!

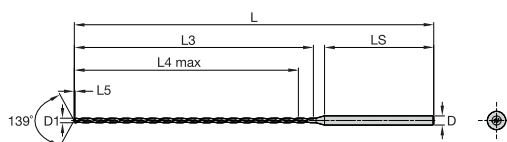
● first choice

○ alternate choice

P	●
M	●
K	○
N	○
S	●
H	●

order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCU10
7071017	B075A01000	1,00	90	43	40	0,2	41	4	●
7071018	B075A01100	1,10	90	48	44	0,2	37	4	●
7071019	B075A01200	1,20	97	52	48	0,2	40	4	●
7071020	B075A01300	1,30	97	56	52	0,2	36	4	●
7071061	B075A01400	1,40	105	61	56	0,3	40	4	●
7071062	B075A01500	1,50	105	65	60	0,3	36	4	●
7071063	B075A01600	1,60	113	69	64	0,3	39	4	●
7071064	B075A01700	1,70	113	73	68	0,3	35	4	●
7071065	B075A01800	1,80	123	78	72	0,3	41	4	●
7071066	B075A01900	1,90	123	82	76	0,4	37	4	●
7071067	B075A02000	2,00	136	86	80	0,4	46	4	●
7071068	B075A02100	2,10	136	91	84	0,4	42	4	●
7071069	B075A02200	2,20	136	95	88	0,4	38	4	●
7071070	B075A02300	2,30	150	99	92	0,4	48	4	●
7071071	B075A02400	2,40	150	104	96	0,4	43	4	●
7071072	B075A02500	2,50	150	108	101	0,5	39	4	●
7071073	B075A02600	2,60	150	112	105	0,5	35	4	●
7071074	B075A02700	2,70	167	117	109	0,5	48	4	●
7071075	B075A02800	2,80	167	121	113	0,5	44	4	●
7071076	B075A02900	2,90	167	125	117	0,5	40	4	●

KenDrill Micro • 50 x D • Internal Coolant • Straight Shank • Metric

NEW!

● first choice

○ alternate choice

P	●
M	●
K	○
N	○
S	●
H	●

order number	catalogue number	D1	L	L3	L4 max	L5	LS	D	KCU10
7071077	B076A01000	1,00	102	53	50	0,2	43	4	●
7071078	B076A01500	1,50	120	80	75	0,3	36	4	●
7071079	B076A02000	2,00	158	106	100	0,4	48	4	●
7071080	B076A02500	2,50	176	133	126	0,5	40	4	●

117-119	120	40-41	124

KenDrill™ Micro • Application Data • Metric

Material Group	Cutting Speed — vc m/min			Feed rate (f) = mm/r by diameter				
	Min	Starting Value	Max	1,0	1,5	2,0	2,5	2,9
P								
0	30	65	100	0,020–0,040	0,030–0,050	0,040–0,080	0,050–0,100	0,058–0,116
1	30	65	100	0,020–0,040	0,030–0,050	0,040–0,080	0,050–0,100	0,058–0,116
2	30	65	100	0,020–0,040	0,030–0,050	0,040–0,080	0,050–0,100	0,058–0,116
3	30	65	100	0,020–0,040	0,030–0,050	0,040–0,080	0,050–0,100	0,058–0,116
4	30	65	100	0,020–0,040	0,030–0,050	0,040–0,080	0,050–0,100	0,058–0,116
5	20	60	100	0,015–0,030	0,020–0,045	0,025–0,060	0,030–0,075	0,034–0,087
6	20	60	100	0,015–0,030	0,020–0,045	0,025–0,060	0,030–0,075	0,034–0,087
M								
1	20	60	100	0,010–0,030	0,015–0,045	0,020–0,060	0,025–0,075	0,029–0,087
2	20	60	100	0,010–0,030	0,015–0,045	0,020–0,060	0,025–0,075	0,029–0,087
3	20	60	100	0,010–0,030	0,015–0,045	0,020–0,060	0,025–0,075	0,029–0,087
K								
1	40	70	100	0,020–0,040	0,030–0,050	0,040–0,080	0,050–0,100	0,058–0,116
2	40	70	100	0,020–0,040	0,030–0,050	0,040–0,080	0,050–0,100	0,058–0,116
3	40	70	100	0,020–0,040	0,030–0,050	0,040–0,080	0,050–0,100	0,058–0,116
N								
1	100	140	180	0,020–0,060	0,030–0,075	0,040–0,100	0,050–0,130	0,058–0,145
2	100	140	180	0,020–0,060	0,030–0,075	0,040–0,100	0,050–0,130	0,058–0,145
3	100	140	180	0,020–0,060	0,030–0,075	0,040–0,100	0,050–0,130	0,058–0,145
4	100	140	180	0,020–0,060	0,030–0,075	0,040–0,100	0,050–0,130	0,058–0,145
S								
1	10	30	50	0,010–0,020	0,015–0,030	0,020–0,040	0,025–0,050	0,029–0,058
2	10	30	50	0,010–0,020	0,015–0,030	0,020–0,040	0,025–0,050	0,029–0,058
3	10	30	50	0,010–0,020	0,015–0,030	0,020–0,040	0,025–0,050	0,029–0,058
4	10	30	50	0,010–0,030	0,015–0,045	0,020–0,060	0,025–0,075	0,029–0,087

KCSM15A

Solid End Milling Grade

Our KCSM15A grade features an advanced PVD coating technology and delivers the best wear resistance in the history of Kennametal solid carbide end milling. This new grade provides increased output, higher metal removal rates and overall reliability when machining stainless steel, titanium and other high-temp alloys.

KCSM15A launches with the **HARVI™ III**, **HARVI II Long**, and **RSM II** platforms that are proven high performance solid carbide end mills for the aerospace, energy, transportation, and general engineering industries.

-
- Copper color provides improved tool life observation and reconditioning management
 - Protection against abrasive wear and minimized edge build-up
 - Increased tool life at high temperatures with minimized chipping
 - Improved process stability
-



Dodeka™ Series

Face Milling

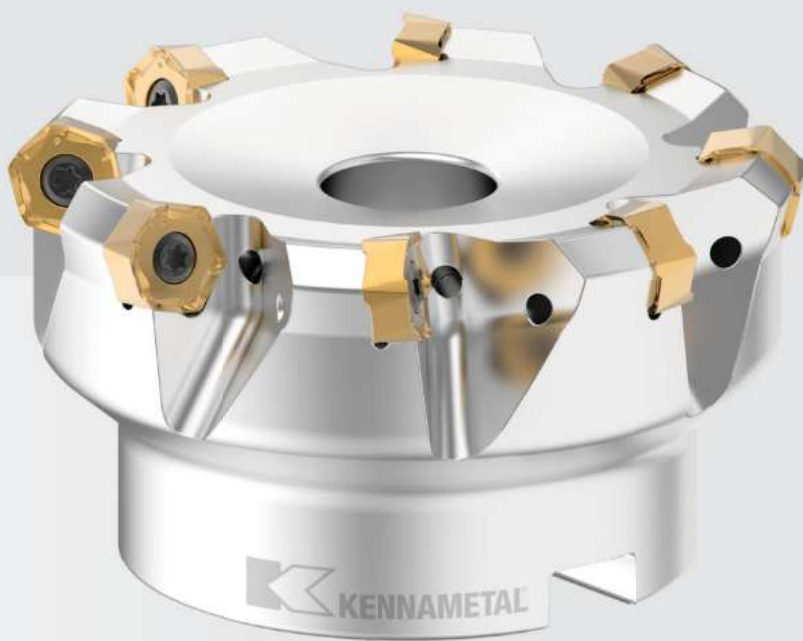
Materials



Applications



Face Milling

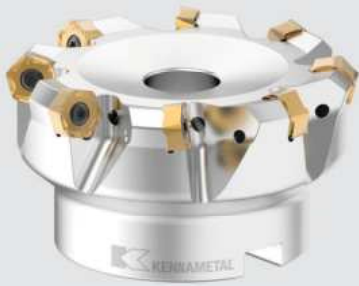


Dodeka Mini, Dodeka, and Dodeka MAX™ face milling platforms are the most comprehensive face milling boosters on the market today. Twelve true cutting edges per insert mean low cost-per-edge and high productivity.

With Beyond™ premium milling grades, achieve up to 30% higher metal removal rates (MRR), 25% lower cutting forces due to soft cutting action, and up to 35% better tool life in light to heavy machining.

Twelve true cutting edges per insert.

Dodeka™ Mini



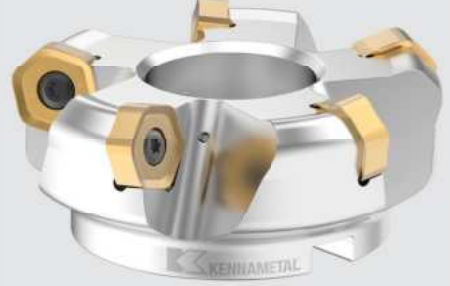
Excellent floor finish.

Dodeka



Best-in-class insert geometry/grade combinations to machine steel, stainless steel, and high-temp alloys.

Dodeka MAX™



Enhanced chip formation and evacuation.

Low cutting forces, soft cutting action.

Elevated machining capabilities.

NEW!

High positive geometries.



LP Geometry:
Light Machining of Steels



GM Geometry:
Medium Machining of
Stainless Steels



LM Geometry:
Light Machining of
Stainless Steels



GP Geometry:
Medium Machining of Steels

Face Milling • Tool Selection Guide

	Dodeka™ Mini HighFeed 15°	Dodeka Mini 45°	Dodeka Mini 60°	Dodeka HighFeed 15°	Dodeka 45°
					
Page	70	74–75	81	85	89
Main operation					
Workpiece materials					
Primary	P M K N S	P M K N S	P M K N S	P M K N S	P M K N S
Secondary					
Approach angle [KRA]	15°	45°	60°	15°	45°
Cutting diameter [D1]	25–80mm	25–125mm	40–125mm	50–160mm	40–315mm
Cutting diameter [D1 max]	38,2–93,1mm	33,2–133,1mm	46,4–131,3mm	67,9–177,9mm	51,0–326,0mm
Maximum cutting depth [Ap1 max]	1,6mm	3,2mm	4,3mm	2,2mm	4,5mm
Cutting edges per insert	12	3*/12	12	12	12
Insert size IC	12,0mm	12,0mm	12,0mm	16,0mm	16,0mm
Insert corner nose radius	1,0–3,2mm	1,0–3,2mm	1,0–3,2mm	1,2–4,4mm	1,2–4,4mm
Axial adjustable pocket seats (Y/N)	N	N	N	N	N
Internal coolant	Y	Y	Y	Y	Y
Connection style machine side (CSMS)					
Fits regular milling adapters	Y	Y	Y	Y	Y

*True Wiper Insert

Face Milling • Tool Selection Guide

	Dodeka MAX™ 45°	7745VOD04	KSOM	KSSM8+ IC10	KSSM8+ IC12
					
Page	95	kennametal.com	kennametal.com	kennametal.com	kennametal.com
Main operation					
Workpiece materials					
Primary	P M K S	P M K S	P M K N S	P M K S	P M K S
Secondary					
Approach angle [KRA]	45°	42°	43°	88°	87°
Cutting diameter [D1]	80–315mm	32–160mm	63–160mm	50–100mm	50–160mm
Cutting diameter [D1 max]	97,3–332,3mm	33,0–168,0mm	74,3–170,9mm	50,64–100,64mm	51,15–161,15mm
Maximum cutting depth [Ap1 max]	8,0mm	3,5/8,0mm	5,0/11,7mm	9,0mm	11,8mm
Cutting edges per insert	12	8	8	8	8
Insert size IC	22,0mm	12,7mm	19,0mm	10,0mm	12,7mm
Insert corner nose radius	1,2–3,5mm	0,8mm	1,2mm	0,8–1,2mm	0,8–1,6mm
Axial adjustable pocket seats (Y/N)	N	N	N	N	N
Internal coolant	Y	Y	Y	Y	Y
Connection style machine side (CSMS)		 			
Fits regular milling adapters	Y	Y	Y	Y	Y

*True Wiper Insert

Face Milling • Tool Selection Guide

	Fix-Perfect™ 70° IC12	Fix-Perfect 90° IC12	HexaCut™ 45°	HexaCut 60°	Mill 16 Screw Clamping
					
Page	kennametal.com	kennametal.com	kennametal.com	kennametal.com	kennametal.com
Main operation					
Workpiece materials					
Primary	K P	K P	K	K	K
Secondary					
Approach angle [KRA]	70°	90°	45°	60°	43.5°
Cutting diameter [D1]	50–250mm	50–250mm	80–160mm	80–250mm	50–250mm
Cutting diameter [D1 max]	—	—	92,8–172,8mm	89–259mm	62,7–262mm
Maximum cutting depth [Ap1 max]	5,9/9,5mm	6,0/10,0mm	6,5mm	8,0mm	5,5mm
Cutting edges per insert	1*/4/8	1*/4/8	12	12	16
Insert size IC	11,4mm	11,4mm	16,2mm	16,2mm	20,0mm
Insert corner nose radius	—	—	0,8–3,0mm	0,8–3,0mm	0,8–3,0mm
Axial adjustable pocket seats (Y/N)	Y, N	Y, N	N	Y	N
Internal coolant	N	N	N	N	Y
Connection style machine side (CSMS)					
Fits regular milling adapters	Y	Y	Y	Y	Y

*True Wiper Insert

Face Milling • Tool Selection Guide

	Mill 16 Wedge Clamping	Mill 16 Split Case Design	KSSR84	FixPerfect™ Finisher	KCFM™ 45 Fine Finisher
					
Page	kennametal.com	kennametal.com	kennametal.com	kennametal.com	kennametal.com
Main operation					
Workpiece materials					
Primary	K	K	K	K	K
Secondary					
Approach angle [KRA]	43.5°	43.5°	84°	30°	45°
Cutting diameter [D1]	50–250mm	315–500mm	63–200mm	51–239mm	80–250mm
Cutting diameter [D1 max]	63–263mm	327,6–512,6mm	65–202mm	63–250mm	90–260mm
Maximum cutting depth [Ap1 max]	5,5mm	5,5mm	5,0mm	1,0mm	1,0mm
Cutting edges per insert	16	16	1*/8	4	4*/6
Insert size IC	20,0mm	20,0mm	12,7mm	13,0mm	12,7mm
Insert corner nose radius	0,8–3,0mm	0,8–3,0mm	1,2–1,6mm	—	0,8mm
Axial adjustable pocket seats (Y/N)	N	N	Y, N	N	Y
Internal coolant	Y	N	Y	Y	Y
Connection style machine side (CSMS)		KMT Split Case Design			
Fits regular milling adapters	Y	KMT Split Case Design	Y	Y	Y

*True Wiper Insert

Face Milling • Tool Selection Guide

	KBDM	FixPerfect™ AL M Line	FixPerfect AL PM Line	FixPerfect AL HPM Line	FixPerfect AL HSM Line
					
Page	kennametal.com	kennametal.com	kennametal.com	kennametal.com	kennametal.com
Main operation					
Workpiece materials					
Primary	N	N	N	N	N
Secondary					
Approach angle [KRA]	90°	90°	90°	90°	90°
Cutting diameter [D1]	63–250mm	40–160mm	40–250mm	50–200mm	50–80mm
Cutting diameter [D1 max]	—	—	—	—	—
Maximum cutting depth [Ap1 max]	12,7mm	9,5mm	9,5mm	9,5mm	9,5mm
Cutting edges per insert	1	1	1	1	1
Insert size IC	15,88mm	15,0mm	15,0mm	15,0mm	15,0mm
Insert corner nose radius	0,8–2,4mm	0,4–1,5mm	0,4–1,5mm	0,4–1,5mm	0,4–1,5mm
Axial adjustable pocket seats (Y/N)	Y	N	Y/N	Y	Y
Internal coolant	N	Y	Y	Y	Y
Connection style machine side (CSMS)					
Fits regular milling adapters	Y	Y	Y	Y	Y

*True Wiper Insert

Face Milling • Tool Selection Guide

	MEGA45
	
Page	kennametal.com
Main operation	
Workpiece materials	
Primary	P M K S
Secondary	
Approach angle [KRA]	45°
Cutting diameter [D1]	125–315mm
Cutting diameter [D1 max]	160,3–350,3mm
Maximum cutting depth [Ap1 max]	17,2mm
Cutting edges per insert	4
Insert size IC	20,0mm
Insert corner nose radius	1,2mm
Axial adjustable pocket seats (Y/N)	N
Internal coolant	N
Connection style machine side (CSMS)	
Fits regular milling adapters	Y

*True Wiper Insert

Mill 4™ -12KT

Tangential Shoulder Milling

Kennametal's Mill 4-12KT requires up to 15% less horsepower, enabling increased feed rates even on 40 taper machines. Its proprietary insert design features a triangular shaped margin that provides unprecedented stability in steel and cast-iron applications and its minimal axial runout delivers excellent floor finish. With seven grades, seven corner radii and a depth-of-cut range up to .472" (12mm), the Mill 4-12KT can bring new versatility to your shoulder milling applications.

Machinists can expect:

- A proprietary insert design that delivers unprecedented stability in steel and cast-iron applications
- A comprehensive portfolio that offers a wide range of standard inch and metric sizes
- **NEW!**
HD geometry and fine pitch cutters to further enhance performance



Milling Tool Bodies • Catalog Numbering System

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.

End Mills

KSHR	HF	025	D	03	A	20	HN06	L120
Series	Series Features	Cutting Diameter D1	Tool Type	Number of Inserts	Connection Style Machine Side (CSMS)	Shank Diameter	Insert Style and IC	Tool Length
KSHR = Dodeka™	HF = High Feed Cutter, 15° Lead Angle Blank: 45° Lead Angle	D1 in mm	D = End Mill		A = Cylindrical Shank B = Weldon® Shank M = Metric Thread R50 = Right Hand, Projection Length 50	D in mm		

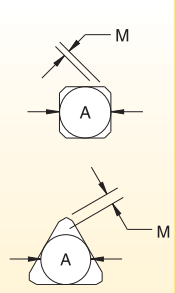
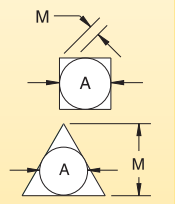
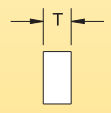
Shell Mills

KSHR	HF	063	A	06	R	S	15	HN06
Series	Series Features	Cutting Diameter D1	Connection Style Machine Side (CSMS)	Number of Inserts	Hand of Tool	Tool Type	Lead Angle	Insert Style and IC
KSHR = Dodeka	HF = High Feed Cutter, 15° Lead Angle Blank: 45° and 60° Lead Angle	D1 in mm	A = Shell Mill, Form A; Tenon drive, socket head cap screw B = Shell Mill Form B; Tenon drive, cutter retaining screw C = Shell Mill Form C; Mounted on centering arbor		R = Right Hand	S = Shell Mill		

Milling Inserts • Catalog Numbering System

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.

HNGJ0604ANENLD

H	N	G	J	06																																																																																																																
Insert Shape	Insert Clearance Angle	Tolerance Class	Geometry and Clamping Type	Size																																																																																																																
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	A 3° B 5° C 7° D 15° E 20° F 25° G 30° N 0° P 11°	 Indexable inserts with facets/wipers  Indexable inserts with corner radii  Insert thickness		“L” for shapes <table border="1"> <thead> <tr> <th>A</th> <th>C</th> <th>T</th> <th>R</th> <th>O</th> <th>C</th> <th>H</th> <th>E</th> </tr> </thead> <tbody> <tr><td>6,00</td><td>—</td><td>—</td><td>06</td><td>—</td><td>—</td><td>—</td><td>—</td></tr> <tr><td>6,35</td><td>06</td><td>11</td><td>06</td><td>02</td><td>06</td><td>03</td><td>06</td></tr> <tr><td>8,00</td><td>—</td><td>—</td><td>08</td><td>—</td><td>—</td><td>—</td><td>—</td></tr> <tr><td>9,52</td><td>09</td><td>16</td><td>09</td><td>04</td><td>09</td><td>05</td><td>09</td></tr> <tr><td>10,00</td><td>—</td><td>—</td><td>10</td><td>—</td><td>—</td><td>—</td><td>—</td></tr> <tr><td>12,00</td><td>—</td><td>—</td><td>12</td><td>—</td><td>—</td><td>—</td><td>—</td></tr> <tr><td>12,70</td><td>12</td><td>22</td><td>12</td><td>05</td><td>12</td><td>07</td><td>13</td></tr> <tr><td>15,88</td><td>15</td><td>27</td><td>15</td><td>06</td><td>16</td><td>09</td><td>16</td></tr> <tr><td>16,00</td><td>—</td><td>—</td><td>16</td><td>—</td><td>—</td><td>—</td><td>—</td></tr> <tr><td>19,05</td><td>19</td><td>33</td><td>19</td><td>07</td><td>19</td><td>11</td><td>19</td></tr> <tr><td>20,00</td><td>—</td><td>—</td><td>20</td><td>—</td><td>—</td><td>—</td><td>—</td></tr> <tr><td>25,00</td><td>—</td><td>—</td><td>25</td><td>—</td><td>—</td><td>—</td><td>—</td></tr> <tr><td>25,40</td><td>25</td><td>44</td><td>25</td><td>10</td><td>25</td><td>14</td><td>26</td></tr> </tbody> </table> For shapes A, L, and X, see position #1; use length of leading cutting edge.	A	C	T	R	O	C	H	E	6,00	—	—	06	—	—	—	—	6,35	06	11	06	02	06	03	06	8,00	—	—	08	—	—	—	—	9,52	09	16	09	04	09	05	09	10,00	—	—	10	—	—	—	—	12,00	—	—	12	—	—	—	—	12,70	12	22	12	05	12	07	13	15,88	15	27	15	06	16	09	16	16,00	—	—	16	—	—	—	—	19,05	19	33	19	07	19	11	19	20,00	—	—	20	—	—	—	—	25,00	—	—	25	—	—	—	—	25,40	25	44	25	10	25	14	26
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tolerance class	tolerance on "A"	tolerance on "M"	tolerance on "T"	tolerance class	tolerance on "A"	tolerance on "M"	tolerance on "T"
A	0,025	0,005	0,025	J	0,05–0,13*	0,005	0,025
B	0,025	0,005	0,13	K	0,05–0,13*	0,013	0,025
C	0,025	0,013	0,025	L	0,05–0,13*	0,025	0,025
D	0,025	0,013	0,13	M	0,05–0,10*	0,05–0,25*	0,13
E	0,025	0,025	0,025	N	0,05–0,10*	0,05–0,25*	0,025
F	0,013	0,005	0,025	P**	0,038	0,038	0,038
G	0,025	0,025	0,13	U	0,08–0,25*	0,13–0,30*	0,13
H	0,013	0,013	0,025	—	—	—	—

*See table below for tolerances according to insert size and class.

**Kennametal standard only.

A	tolerances on "A"		tolerances on "M"	
	classes J, K, L, M, N	class U	classes M & N	class U
4,76–10,00	0,051	0,076	0,076	0,127
11,11–14,29	0,076	0,127	0,127	0,203
15,00–20,64	0,102	0,178	0,152	0,279
22,00–31,16	0,127	0,254	0,178	0,381
31,75–35,00	0,152	0,254	0,203	0,381

symbol	hole	shape of hole	chipbreaker	shape of insert's section
N	without		without	
R			single sided	
F			double sided	
A	with	cylindrical hole	without	
M			single sided	
G			double sided	
W		partly cylindrical hole, 40–60° countersink	without	
T			single sided	
Q		partly cylindrical hole, 40–60° double countersink	without	
U			double sided	
B		partly cylindrical hole, 70–90° countersink	without	
H			single sided	
C		partly cylindrical hole, 70–90° double countersink	without	
J			double sided	
X		special design		

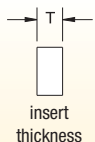
Milling Inserts • Catalog Numbering System

(continued)

HNGJ0604ANENLD

04

Thickness



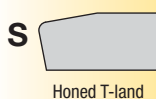
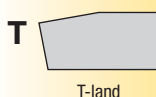
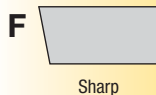
T	
2,38	02
3,18	03
3,97	T3
4,76	04
5,56	05
6,35	06
7,94	07

AN

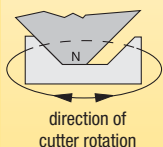
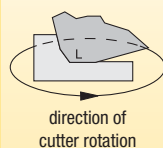
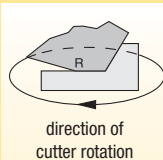
Corner Configuration

E

Cutting Edge Form

**N**

Insert Hand

**L**

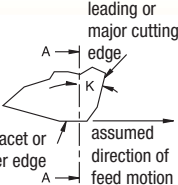
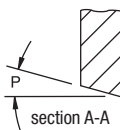
Edge Prep Size

D

Rake Face Angle

Added Info

J = Polished rake face
P = Partial T-land
W = Wiper/radiused facet

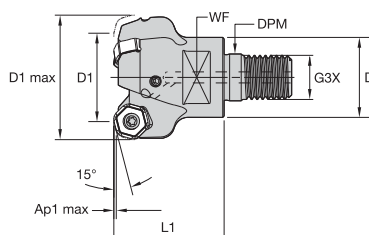
				
radius				
M0	round insert	if letter is replaced by number(s), refer to table for radius "r".	wiper edge clearance P	
01	0,1mm		A	3°
02	0,2mm		B	5°
04	0,4mm		C	7°
05	0,5mm		D	15°
08	0,8mm		E	20°
10	1,0mm		F	25°
12	1,2mm		G	30°
15	1,5mm		N	0°
16	1,6mm		P	11°
24	2,4mm			
32	3,2mm			
		lead angle K		
		A	45°	
		D	60°	
		E	75°	
		P	90°	

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

N	A	B	C	P	D	E	F	G
0° or less	3°	5°	7°	11°	15°	20°	25°	30°

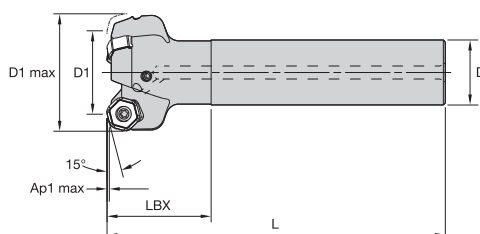
Nominal or average angle of rake on insert face at leading cutting edge before edge prep and before installation.

Dodeka™ Mini High-Feed 15° • End Mill • Screw-On • Metric



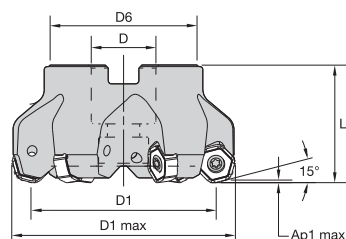
order number	catalogue number	D1	D1 max	D	DPM	G3X	L1	WF	Ap1 max	Z	kg	max RPM
4153687	KSHRHF025D03M16HN06	25	38,2	29	17,0	M16	32,0	22	1,6	3	0,16	20000
4153689	KSHRHF032D04M16HN06	32	45,2	29	17,0	M16	40,0	22	1,6	4	0,25	17600

Dodeka Mini High-Feed 15° • End Mill • Cylindrical Shank • Metric



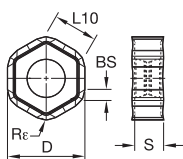
order number	catalogue number	D1	D1 max	D	L	LBX	Ap1 max	Z	kg	max RPM
4153703	KSHRHF025D03A20HN06L120	25	38,2	20	120	32	1,6	3	0,31	20000
4153704	KSHRHF032D03A25HN06L130	32	45,2	25	130	40	1,6	3	0,52	17600

Dodeka Mini High-Feed 15° • Shell Mill • Metric



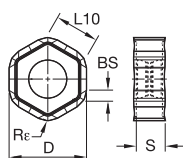
order number	catalogue number	D1	D1 max	D	D6	L	Ap1 max	Z	kg	max RPM
4153706	KSHRHF040A05RS15HN06	40	53,2	22	38	40	1,6	5	0,29	15800
4153707	KSHRHF050A05RS15HN06	50	63,1	22	38	40	1,6	5	0,39	12700
4153708	KSHRHF063A06RS15HN06	63	76,1	22	50	40	1,6	6	0,67	10100
4153709	KSHRHF080A08RS15HN06	80	93,1	27	60	50	1,6	8	1,26	7900

117-119	120	67-69	124



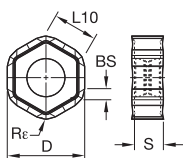
- alternate choice

ISO catalogue number	D	BS	L10	R _e	S	hm	CE	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANFNLDJ	12	1.54	6.44	1.0	4.48	0.02	12	●	●	-	-	-	-	-	-	-	-

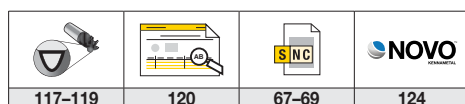
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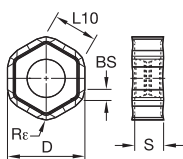
- alternate choice

ISO catalogue number	D	BS	L10	R _E	S	hm	CE	K13	KC410M	KC510M	KC820M	KC922M	KC725M	KCK15	KCPK30	KCPN40	KCSMA0
HNGJ0604ANENLD	12	1,52	6,44	1,0	4,48	0,04	12	-	-	●	-	●	●	●	-	●	●
HNGJ060432ANENLD	12	—	6.43	3.2	4.48	0.05	12	-	-	-	●	●	●	●	-	●	●

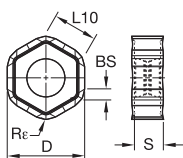
[illegible]

- alternate choice

[illegible][illegible]



- alternate choice

[illegible]

- alternate choice

ISO catalogue number	D	BS	L10	R _E	S	hm	CE	K13	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ0604ANSNHD	12	1,45	6,44	1,0	4,40	0,14	12	-	-	-	•	•	•	•	•	•	•
HNPJ060432ANSNHD	12	—	6.43	3.2	4.41	0.10	12	-	-	-	•	•	•	•	•	•	•



117-119



120



67-69



124

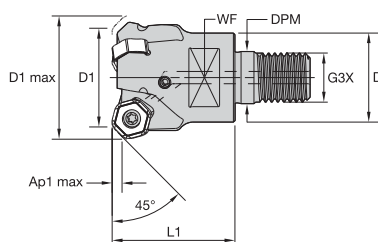
Dodeka™ Mini High Feed 15° • Insert Selection Guide

Material Group	Light Machining		Medium Machining		Heavy Machining	
P1-P2	.E..LD	KC522M	.S..GD	KC522M	.S..HD	KC725M
P3-P4	.E..LD	KCPM40	.S..GD	KCPK30	.S..HD	KCPK30
P5-P6	.E..LD	KCPM40	.S..GD	KCPM40	.S..HD	KCPM40
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	KCK20B	.S..GD	KCK15	.S..HD	KCK15
K3	.E..LD	KCKP10	.S..GD	KCK20B	.S..HD	KCPK30
N1-N2	.F..LDJ	KC410M	.F..LDJ	KC410M	.E..LD	KCKP10
N3	.F..LDJ	KC410M	.F..LDJ	KC410M	.E..LD	KCKP10
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	KCKP10	-	-	-	-

Dodeka Mini High-Feed 15° • Feed Rates [mm]

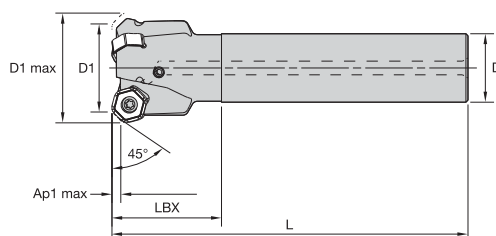
Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)						
Insert Geometry	30%			40-100%		
	L	M	H	L	M	H
.F..LDJ	0,21	0,59	1,01	0,20	0,54	0,93
.E..LD	0,24	0,76	1,27	0,22	0,70	1,16
.S..GD	0,43	1,01	1,52	0,39	0,93	1,39
.S..HD	0,43	1,07	1,72	0,39	0,98	1,57
L = Light Machining; M = Medium Machining; H = Heavy Machining.						

Dodeka™ Mini 45° • End Mill • Screw-On • Metric



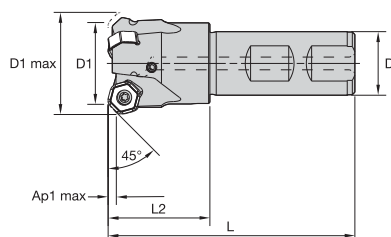
order number	catalogue number	D1	D1 max	D	DPM	G3X	L1	WF	Ap1 max	Z	kg	max RPM
4125882	KSHR025D03M16HN06	25	33,2	29	17,0	M16	32,0	22	3,2	3	0,13	20000
4126343	KSHR032D03M16HN06	32	40,2	29	17,0	M16	40,0	22	3,2	3	0,21	17600
4126344	KSHR032D04M16HN06	32	40,2	29	17,0	M16	40,0	22	3,2	4	0,21	17600

Dodeka Mini 45° • End Mill • Cylindrical Shank • Metric



order number	catalogue number	D1	D1 max	D	L	LBX	Ap1 max	Z	kg	max RPM
4126351	KSHR025D02A20HN06L120	25	33,2	20	120	32	3,2	2	0,28	20000
4126352	KSHR025D03A20HN06L120	25	33,2	20	120	32	3,2	3	0,28	20000
4126386	KSHR025D03A25HN06L200	25	33,2	25	200	32	3,2	3	0,71	20000
4126383	KSHR032D03A25HN06L130	32	40,2	25	130	40	3,2	3	0,50	17600
4126384	KSHR032D04A25HN06L130	32	40,2	25	130	40	3,2	4	0,50	17600

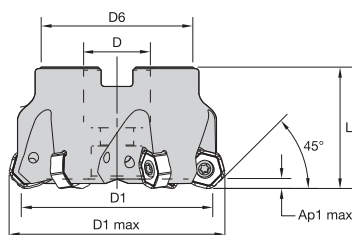
Dodeka Mini 45° • End Mill • Weldon® Shank • Metric



order number	catalogue number	D1	D1 max	D	L	L2	Ap1 max	Z	kg	max RPM
4126348	KSHR025D03B20HN06	25	33,2	20	82	32	3,2	3	0,21	20000
4126349	KSHR032D03B25HN06	32	40,2	25	97	40	3,2	3	0,40	17600
4126350	KSHR032D04B25HN06	32	40,2	25	97	40	3,2	4	0,41	17600

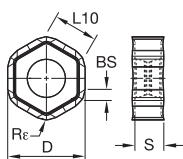
117-119	120	67-69	124

Dodeka™ Mini 45° • Shell Mill • Metric



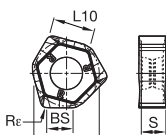
order number	catalogue number	D1	D1 max	D	D6	L	Ap1 max	Z	kg	max RPM
4126387	KSHR040A04RS45HN06	40	48,2	22	38	40	3,2	4	0,25	15800
4124313	KSHR040A05RS45HN06	40	48,2	22	38	40	3,2	5	0,25	15800
4126388	KSHR050A04RS45HN06	50	58,2	22	38	40	3,2	4	0,36	12700
4122886	KSHR050A05RS45HN06	50	58,2	22	38	40	3,2	5	0,37	12700
4126389	KSHR050A06RS45HN06	50	58,2	22	38	40	3,2	6	0,36	12700
4122887	KSHR063A04RS45HN06	63	71,2	22	50	40	3,2	4	0,59	10100
4122889	KSHR063A06RS45HN06	63	71,2	22	50	40	3,2	6	0,65	10100
4126390	KSHR063A08RS45HN06	63	71,2	22	50	40	3,2	8	0,64	10100
4126391	KSHR080A05RS45HN06	80	88,1	27	60	50	3,2	5	1,13	7900
4126392	KSHR080A08RS45HN06	80	88,1	27	64	50	3,2	8	1,25	7900
4126403	KSHR080A10RS45HN06	80	88,1	27	60	50	3,2	10	1,19	7900
4126404	KSHR100B06RS45HN06	100	108,1	32	80	50	3,2	6	1,73	6300
4126405	KSHR100B09RS45HN06	100	108,1	32	80	50	3,2	9	1,84	6300
4126406	KSHR100B12RS45HN06	100	108,1	32	80	50	3,2	12	1,84	6300
4126407	KSHR125B08RS45HN06	125	133,1	40	90	63	3,2	8	2,87	5050
4126408	KSHR125B12RS45HN06	125	133,1	40	90	63	3,2	12	2,98	5050
4124262	KSHR125B16RS45HN06	125	133,1	40	90	63	3,2	16	3,05	5050

117-119	120	67-69	124



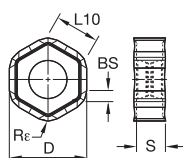
- first choice
- alternate choice

ISO catalogue number	D	BS	L10	R _e	S	hm	CE	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANFNLDJ	12	1.54	6.44	1.0	4.48	0.02	12	●	●	—	—	—	—	—	—	—	—

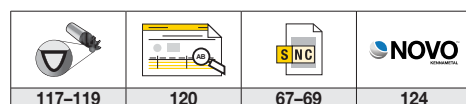
[illegible]

- first choice
- alternate choice

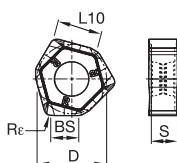
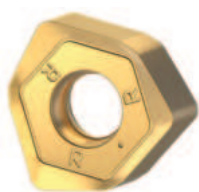
ISO catalogue number	D	BS	L10	R _E	S	hm	CE	K13	KC410M	KC510M	KC520M	KC522M	KC725M	KC115	KCPK30	KCPM40	KCSM40
XNGJ0604ANFNLDJ3W	12	4.80	7.20	1.6	4.51	0.02	6	-	●	-	-	-	-	-	-	-	-

[illegible]

- first choice
- alternate choice

[illegible][illegible]

Dodeka™ Mini 45° • Wiper Carbide Insert • XNGJ-LD3W • Fine Finishing of Multiple Materials

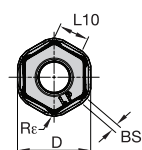


- first choice
- alternate choice

[illegible]

ISO catalogue number	D	BS	L10	R _E	S	hm	CE	K13	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
XNGJ0604ANENLD3W	12	4.80	7.20	1.6	4.51	0.05	6	-	-	●	-	●	-	-	-	●	●

Dodeka Mini 45° • Carbide Insert • HNPJ-LP • Light Machining of Steels

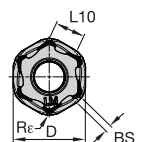
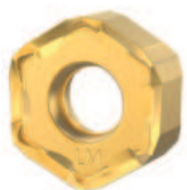


- first choice
- alternate choice

[illegible]

ISO catalogue number	D	S	L10	BS	R _E	hm	CE	KC52M	KCK20B	KCPK30	KCPM40
HNPJ0604ANERLP	12.00	4.72	6.41	1.33	1.0	0.05	12	●	●	●	●

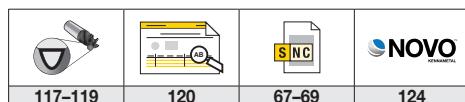
Dodeka Mini 45° • Carbide Insert • HNPJ-LM • Light Machining of Stainless Steels



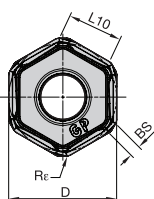
- first choice
- alternate choice

P				
M				
K				
N				
S				
H				
E				
2				

ISO catalogue number	D	S	L10	BS	R _E	hm	CE	KC522M	KC524M
HNPJ0604ANERLM	12.00	4.71	6.41	1.33	1.0	0.05	12	●	●



Dodeka™ Mini 45° • Carbide Insert • HNGJ-GP • Medium Machining of Steels

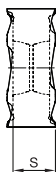
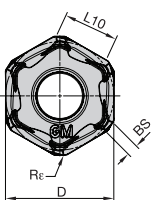
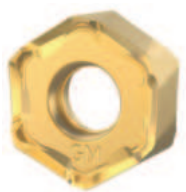


- first choice
- alternate choice

P					
M					
K					
N					
S					
H					

ISO catalogue number	D	S	L10	BS	Rε	hm	CE	KC522M	KCPM40	KTPK20
HNGJ0604ANERGP	12,00	4,70	4,10	1,10	1,0	0,06	12	●	●	●

Dodeka Mini 45° • Carbide Insert • HNGJ-GM • Medium Machining of Stainless Steels

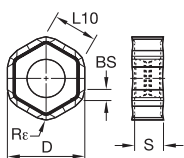


- first choice
- alternate choice

P					
M					
K					
N					
S					
H					

ISO catalogue number	D	S	L10	BS	Rε	hm	CE	KC522M	KCSM40
HNGJ0604ANERGM	15,88	6,74	6,19	2,13	1,2	0,06	12	●	●

Dodeka Mini • Carbide Insert • HNPJ-GD • Medium Machining

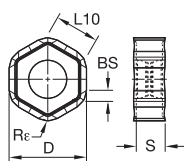


- first choice
- alternate choice

P																			
M																			
K																			
N																			
S																			
H																			

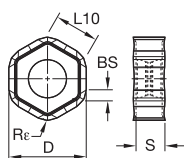
ISO catalogue number	D	BS	L10	Rε	S	hm	CE	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ0604ANSNGD	12	1,45	6,44	1,0	4,45	0,08	12	—	—	—	●	●	●	●	●	●	●

117–119	120	67–69	124

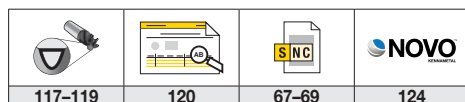


- [illegible]

ISO catalogue number	D	BS	L10	R _e	S	hm	CE	K13	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANSNHD	12	1.45	6.44	1.0	4.40	0.14	12	-	-	-	-	●	-	●	●	●	●



- [illegible]

[illegible]

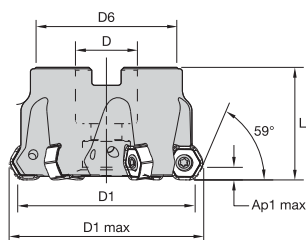
Dodeka™ Mini 45 • Insert Selection Guide

Material Group	Light Machining				Medium Machining				Heavy Machining	
P1-P2	.E..LD	KC522M	.E..LP	KC522M	.E..GP	KC522M	.S..GD	KC522M	.S..HD	KC725M
P3-P4	.E..LD	KCPM40	.E..LP	KCPM40	.E..GP	KCPM40	.S..GD	KCPK30	.S..HD	KCPK30
P5-P6	.E..LD	KCPM40	.E..LP	KCPM40	.E..GP	KCPM40	.S..GD	KCPM40	.S..HD	KCPM40
M1-M2	.E..LD	KC522M	.E..LM	KC522M	.E..GM	KCSM40	.S..GD	KCSM40	.S..HD	KCSM40
M3	.E..LD	KCSM40	.E..LM	KCSM40	.E..GM	KCSM40	.S..GD	KCSM40	.S..HD	KCPM40
K1-K2	.E..LD	KCK20B	.E..LP	KCK20B	.E..LP	KCK20B	.S..GD	KCK15	.S..HD	KCK15
K3	.E..LD	KCKP10	.E..LP	KCPK30	.E..LP	KCPK30	.S..GD	KCK20B	.S..HD	KCPK30
N1-N2	.F..LDJ	KC410M	.F..LDJ	KC410M	.F..LDJ	KC410M	.F..LDJ	KC410M	.E..LD	KCKP10
N3	.F..LDJ	KC410M	.F..LDJ	KC410M	.F..LDJ	KC410M	.F..LDJ	KC410M	.E..LD	KCKP10
S1-S2	.E..LD	KC725M	.E..LM	KCSM40	.E..GM	KCSM40	.S..GD	KC725M	.S..HD	KC725M
S3	.E..LD	KCSM40	.E..LM	KCSM40	.E..GM	KCSM40	.S..GD	KCSM40	.S..HD	KCSM40
S4	.E..LD	KCSM40	.E..LM	KCSM40	.E..GM	KCSM40	.S..GD	KCSM40	.S..HD	KCSM40
H1	.E..LD	KCKP10	-	-	.E..GP	KC522M	-	-	-	-

Dodeka Mini 45° • Feed Rates [mm]

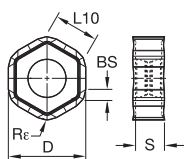
Insert Geometry	Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)					
	30%			40-100%		
	L	M	H	L	M	H
.F..LDJ	0,08	0,22	0,37	0,07	0,20	0,34
.E..LD	0,09	0,28	0,46	0,08	0,25	0,42
.E..LM	0,08	0,23	0,38	0,07	0,21	0,35
.E..LP	0,08	0,28	0,43	0,07	0,25	0,40
.E..GM	0,08	0,23	0,38	0,07	0,21	0,35
.E..GP	0,08	0,28	0,44	0,07	0,25	0,40
.S..GD	0,16	0,37	0,56	0,14	0,34	0,51
.S..HD	0,16	0,39	0,63	0,14	0,36	0,57
L = Light Machining; M = Medium Machining; H = Heavy Machining.						

Dodeka™ Mini 60° • Shell Mill • Heavy Machining • Metric



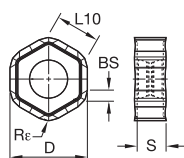
order number	catalogue number	D1	D1 max	D	D6	L	Ap1 max	Z	kg	max RPM
4147022	KSHR040A04RS60HN06	40	46,4	22	38	40	4,3	4	0,21	15800
4147713	KSHR040A05RS60HN06	40	46,4	22	38	40	4,3	5	0,21	15800
4147714	KSHR050A04RS60HN06	50	56,4	22	38	40	4,3	4	0,32	12700
4147715	KSHR050A05RS60HN06	50	56,4	22	38	40	4,3	5	0,32	12700
4147716	KSHR063A04RS60HN06	63	69,3	22	50	40	4,3	4	0,57	10100
4147717	KSHR063A06RS60HN06	63	69,3	22	50	40	4,3	6	0,59	10100
4147718	KSHR080A05RS60HN06	80	86,3	27	60	50	4,3	5	1,08	7900
4147719	KSHR080A08RS60HN06	80	86,3	27	60	50	4,3	8	1,15	7900
4147720	KSHR100B06RS60HN06	100	106,3	32	80	50	4,3	6	1,70	6300
4147721	KSHR100B09RS60HN06	100	106,3	32	80	50	4,3	9	1,78	6300
4147722	KSHR125B08RS60HN06	125	131,3	40	90	63	4,3	8	2,92	5050
4147723	KSHR125B12RS60HN06	125	131,3	40	90	63	4,3	12	2,96	5050

			
117-119	120	67-69	124



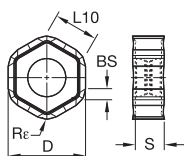
- first choice
- alternate choice

ISO catalogue number	D	BS	L10	R _e	S	hm	CE	K13	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANFNLDJ	12	1.54	6.44	1.0	4.48	0.02	12	●	●	—	—	—	—	—	—	—	—

[illegible]

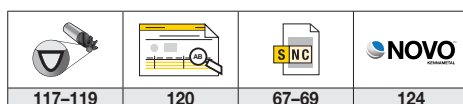
- first choice
- alternate choice

ISO catalogue number	D	BS	L10	R _E	S	hm	CE	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANENLD	12	1,52	6,44	1,0	4,48	0,04	12	-	-	●	-	●	●	●	●	●	●
HNGJ060432ANENLD	12	—	6.43	3.2	4.48	0.05	12	-	-	-	●	●	●	●	●	●	●

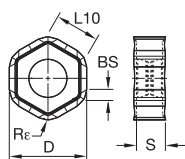
[illegible]

- first choice
- alternate choice

ISO catalogue number	D	BS	L10	R _ε	S	hm	CE	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ0604ANSNGD	12	1.45	6.44	1.0	4.45	0.08	12	-	-	-	●	●	●	●	●	●	●

[illegible]

Dodeka™ Mini • Carbide Insert • HNGJ-HD • Heavy Machining

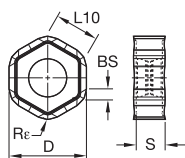


- first choice

- alternate choice

ISO catalogue number	D	BS	L10	R _e	S	hm	CE	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ0604ANSNHD	12	1.45	6.44	1.0	4.40	0.14	12	-	-	-	●	●	-	●	●	●	●

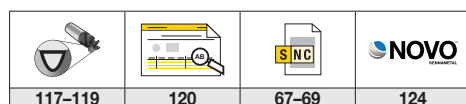
Dodeka Mini • Carbide Insert • HNPJ-HD • Heavy Machining



- first choice

- alternate choice

ISO catalogue number	D	BS	L10	R _E	S	hm	CE	K313	KC410M	KC510M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ0604ANSNHD	12	1,45	6,44	1,0	4,40	0,14	12	-	-	-	●	●	●	●	●	●	●
HNPJ060432ANSNHD	12	—	6.43	3.2	4.41	0.10	12	-	-	-	●	●	●	●	●	●	●



Dodeka™ Mini 60° • Insert Selection Guide

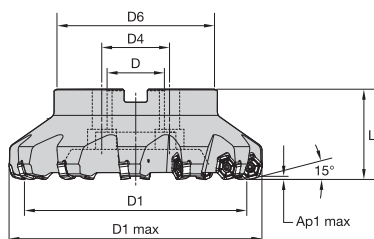
Material Group	Light Machining		Medium Machining		Heavy Machining	
P1-P2	.E..LD	KC522M	.S..GD	KC522M	.S..HD	KC725M
P3-P4	.E..LD	KCPM40	.S..GD	KCPK30	.S..HD	KCPK30
P5-P6	.E..LD	KCPM40	.S..GD	KCPM40	.S..HD	KCPM40
M1-M2	.E..LD	KC522M	.S..GD	KCSM40	.S..HD	KCSM40
M3	.E..LD	KCSM40	.S..GD	KCSM40	.S..HD	KCPM40
K1-K2	.E..LD	KCK20B	.S..GD	KCK15	.S..HD	KCK15
K3	.E..LD	KCKP10	.S..GD	KCK20B	.S..HD	KCPK30
N1-N2	.F..LDJ	KC410M	.F..LDJ	KC410M	.E..LD	KCKP10
N3	.F..LDJ	KC410M	.F..LDJ	KC410M	.E..LD	KCKP10
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	KCKP10	-	-	-	-

Dodeka Mini 60° • Feed Rates [mm]

Insert Geometry	Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)					
	30%			40-100%		
	L	M	H	L	M	H
.F..LDJ	0,06	0,18	0,30	0,06	0,16	0,28
.E..LD	0,07	0,23	0,38	0,07	0,21	0,35
.S..GD	0,13	0,30	0,45	0,12	0,28	0,42
.S..HD	0,13	0,32	0,51	0,12	0,29	0,47

L = Light Machining; M = Medium Machining; H = Heavy Machining.

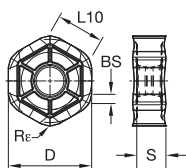
Dodeka™ High-Feed 15° • Shell Mill • Metric



order number	catalogue number	D1	D1 max	D	D4	D6	L	Ap1 max	Z	kg	max RPM
4042332	KSHRHF50A04RS15HN09	50	67,9	22	—	38	40	2,2	4	0,41	11400
4042533	KSHRHF63A05RS15HN09	63	80,9	22	—	50	40	2,2	5	0,65	8950
4042534	KSHRHF80A06RS15HN09	80	97,9	27	—	60	50	2,2	6	1,24	7300
4042535	KSHRHF100B08RS15HN09	100	117,9	32	—	80	50	2,2	8	1,89	5900
4042536	KSHRHF125B09RS15HN09	125	142,9	40	—	90	63	2,2	9	3,23	4800
4042537	KSHRHF160C12RS15HN09	160	177,9	40	67	110	63	2,2	12	5,14	3900

117-119	120	67-69	124

Dodeka™ • Carbide Insert • HNGJ-LDJ • Light Machining of Aluminum

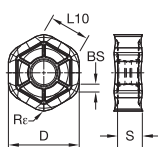


- first choice
○ alternate choice

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

ISO catalogue number	D	BS	L10	Rε	S	hm	CE		KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANFNLDJ	16	1,81	8,58	1,2	5,56	0,02	12		●	-	-	-	-	-	-	-	-

Dodeka • Carbide Insert • HNGJ-LD • Light Machining

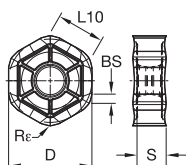


- first choice
○ alternate choice

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

ISO catalogue number	D	BS	L10	Rε	S	hm	CE		KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANENLD	16	1,76	8,58	1,2	5,56	0,05	12		-	●	●	●	●	●	-	●	-

Dodeka • Carbide Insert • HNPJ-GD • Medium Machining



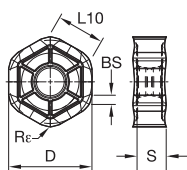
- first choice
○ alternate choice

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

ISO catalogue number	D	BS	L10	Rε	S	hm	CE		KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNPJ0905ANSNGD	16	1,80	8,58	1,2	5,56	0,10	12		-	●	●	●	●	●	●	-	-

117-119	120	67-69	124

Dodeka™ • Carbide Insert • HNGJ-GD • Medium Machining

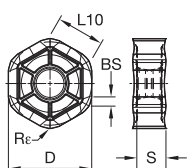


- first choice
○ alternate choice

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

ISO catalogue number	D	BS	L10	Rε	S	hm	CE	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANSNGD	16	1,71	8,59	1,2	5,56	0,10	12	-	-	-	●	●	●	●	●	●

Dodeka • Carbide Insert • HNGJ-HD • Heavy Machining

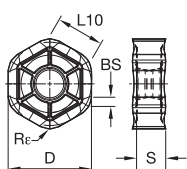


- first choice
○ alternate choice

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

ISO catalogue number	D	BS	L10	Rε	S	hm	CE	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANSNHD	16	1,65	8,59	1,2	5,46	0,17	12	-	●	-	●	●	●	●	●	-
HNGJ090543ANSNHD	16	—	8,50	4,4	5,44	0,20	12	-	●	-	●	●	●	●	●	-

Dodeka • Carbide Insert • HNPJ-HD • Heavy Machining



- first choice
○ alternate choice

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

ISO catalogue number	D	BS	L10	Rε	S	hm	CE	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNPJ0905ANSNHD	16	1,65	8,59	1,2	5,46	0,18	12	-	●	●	●	●	●	●	●	-
HNPJ090543ANSNHD	16	—	8,50	4,4	5,44	0,13	12	-	●	-	●	●	●	●	●	-

117-119	120	67-69	124

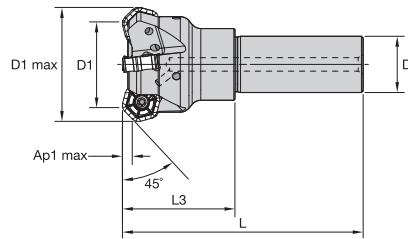
Dodeka™ 15° High-Feed • Insert Selection Guide

Material Group	Light Machining		Medium Machining		Heavy Machining	
P1-P2	.E..LD	KC522M	.S..GD	KC522M	.S..HD	KC725M
P3-P4	.E..LD	KCPK30	.S..GD	KCPK30	.S..HD	KCPK30
P5-P6	.E..LD	KC725M	.S..GD	KCPM40	.S..HD	KCPM40
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	KCK20B	.S..GD	KCK15	.S..HD	KCK15
K3	.E..LD	KCK20B	.S..GD	KCK20B	.S..HD	KCPK30
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

Dodeka 15° High-Feed • Feed Rates [mm]

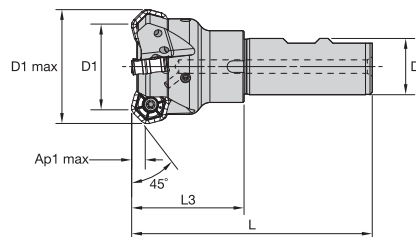
Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)						
Insert Geometry	30%			40-100%		
	L	M	H	L	M	H
.F..LDJ	0,21	0,59	1,01	0,20	0,54	0,93
.E..LD	0,30	0,84	1,27	0,27	0,77	1,16
.S..GD	0,43	0,92	1,46	0,39	0,84	1,34
.S..HD	0,43	1,07	1,72	0,39	0,98	1,57
L = Light Machining; M = Medium Machining; H = Heavy Machining.						

Dodeka™ 45° • End Mill • Cylindrical Shank • Metric



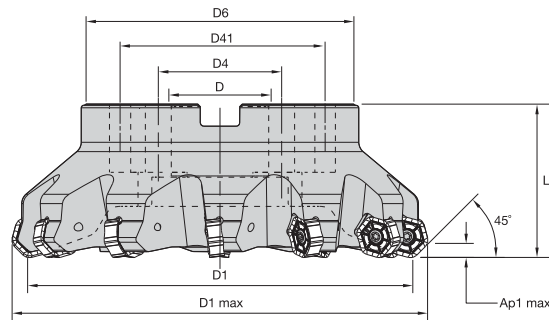
order number	catalogue number	D1	D1 max	D	L	L3	Ap1 max	Z	kg	max RPM
3644452	KSHR40D03R50A25SHN09	40	51,0	25	107	50	4,5	3	0,53	15800
3645083	KSHR40D04R50A25SHN09	40	51,0	25	107	50	4,5	4	0,53	15800

Dodeka 45° • End Mill • Weldon® Shank • Metric



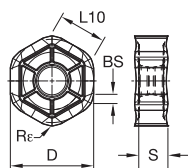
order number	catalogue number	D1	D1 max	D	L	L3	Ap1 max	Z	kg	max RPM
3324830	KSHR40D04R50B25SHN09	40	51,0	25	107	50,00	4,5	4	0,52	15800
3324829	KSHR40D03R50B25SHN09	40	51,0	25	107	50,00	4,5	3	0,53	15800

Dodeka 45° • Shell Mill • Metric



order number	catalogue number	D1	D1 max	D	D4	D41	D6	L	Ap1 max	Z	kg	max RPM
3647201	KSHR40A04RS45HN09	40	51,0	22	—	—	39	40	4,5	4	0,25	15800
3324831	KSHR50A04RS45HN09	50	61,0	22	—	—	38	40	4,5	4	0,32	12700
3324832	KSHR50A05RS45HN09	50	61,0	22	—	—	38	40	4,5	5	0,33	12700
3749959	KSHR63A05RS45HN09	63	74,0	22	—	—	50	40	4,5	5	0,60	10100
3325163	KSHR63A06RS45HN09	63	74,0	22	—	—	50	40	4,5	6	0,56	10100
3325164	KSHR63A07RS45HN09	63	74,0	22	—	—	50	40	4,5	7	0,57	10100
3749960	KSHR80A05RS45HN09	80	91,0	27	—	—	60	50	4,5	5	1,12	7900
3325165	KSHR80A06RS45HN09	80	91,0	27	—	—	60	50	4,5	6	1,07	7900
3325166	KSHR80A09RS45HN09	80	91,0	27	—	—	60	50	4,5	9	1,11	7900
3749961	KSHR100B06RS45HN09	100	111,0	32	—	—	80	50	4,5	6	1,73	6300
3325167	KSHR100B08RS45HN09	100	111,0	32	—	—	80	50	4,5	8	1,68	6300
3325168	KSHR100B11RS45HN09	100	111,0	32	—	—	80	50	4,5	11	1,73	6300
3749962	KSHR125B08RS45HN09	125	135,9	40	—	—	90	63	4,5	8	2,84	5050
3325169	KSHR125B10RS45HN09	125	135,9	40	—	—	90	63	4,5	10	2,77	5050
3325170	KSHR125B14RS45HN09	125	136,0	40	—	—	90	63	4,5	14	2,86	5050
3750013	KSHR160C10RS45HN09	160	171,0	40	67	—	110	63	4,5	10	4,75	3900
3325171	KSHR160C12RS45HN09	160	171,0	40	67	—	110	63	4,5	12	4,56	3900
3325172	KSHR160C16RS45HN09	160	171,0	40	67	—	110	63	4,5	16	4,70	3900
3587732	KSHR200C16RS45HN09	200	211,0	60	102	—	130	63	4,5	16	6,43	3180
3587753	KSHR250C20RS45HN09	250	261,0	60	102	—	130	63	4,5	20	9,93	2550
3587754	KSHR315C24RS45HN09	315	326,0	60	102	178	230	80	4,5	24	22,90	2020

Dodeka™ • Carbide Insert • HNGJ-LDJ • Light Machining of Aluminum

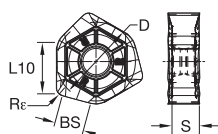


- first choice
○ alternate choice

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

ISO catalogue number	D	BS	L10	Rε	S	hm	CE	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANFNLDJ	16	1,81	8,58	1,2	5,56	0,02	12	●	-	-	-	-	-	-	-	-

Dodeka 45° • Wiper Carbide Insert • XNGJ-LDJ3W • Fine Finishing of Aluminum

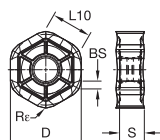


- first choice
○ alternate choice

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

ISO catalogue number	D	BS	L10	Rε	S	hm	CE	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
XNGJ0905ANFNLDJ3W	16	6,00	9,56	1,6	5,51	0,02	6	●	-	-	-	-	-	-	-	-

Dodeka • Carbide Insert • HNGJ-LD • Light Machining



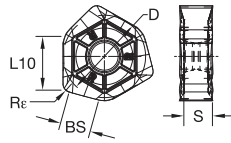
- first choice
○ alternate choice

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

ISO catalogue number	D	BS	L10	Rε	S	hm	CE	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANENLD	16	1,76	8,58	1,2	5,56	0,05	12	-	●	●	●	●	●	-	●	-

117-119	120	67-69	124

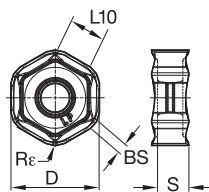
Dodeka™ 45° • Wiper Carbide Insert • XNGJ-GD3W • Fine Finishing of Multiple Materials



- first choice
- alternate choice

[illegible][illegible]

Dodeka 45° • Carbide Insert • HNPJ-LP • Light Machining of Steels

NEW!

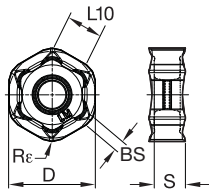
- first choice
- alternate choice

P					
M					
K					
N					
S					
H					

ISO catalogue number	L10	BS	D	S	Rε	hm	CE	KC522M	KCK20B	KCPK30	KCPM40
HNPJ0905ANERLP	8,59	1,68	15,88	5,7	1,2	0,05	12	●	●	●	●

Dodeka 45° • Carbide Insert • HNPJ-LM • Light Machining of Stainless Steels

NEW!



- first choice
- alternate choice

P			
M			
K			
N			
S			
H			

ISO catalogue number	L10	BS	D	S	R _E	h _m	CE			KC522M	KCSM40
HNPJ0905ANERLM	8,58	1,73	15,88	5,7	1,2	0,05	12			●	●



117-119



120

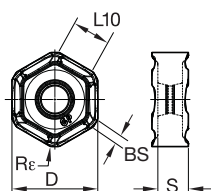


67-69



124

Dodeka™ 45° • Carbide Insert • HNGJ-GP • Medium Machining of Steels

NEW!

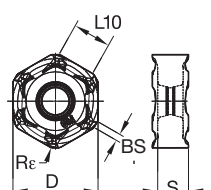
● first choice

○ alternate choice

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

ISO catalogue number	L10	BS	D	S	Rε	hm	CE	KC522M	KCPM40
HNGJ0905ANERGP	6,19	2,13	15,88	5,8	1,2	0,06	12	●	●

Dodeka 45° • Carbide Insert • HNGJ-GM • Medium Machining of Stainless Steels

NEW!

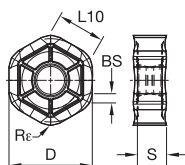
● first choice

○ alternate choice

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

ISO catalogue number	L10	BS	D	S	Rε	hm	CE	KC522M	KCSM40
HNGJ0905ANERGM	6,19	2,13	15,88	5,8	1,2	0,06	12	●	●

Dodeka • Carbide Insert • HNGJ-GD • Medium Machining



● first choice

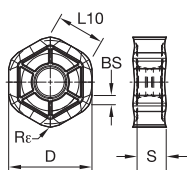
○ alternate choice

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

ISO catalogue number	D	BS	L10	Rε	S	hm	CE	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KY3500
HNGJ0905ANSNGD	16	1,71	8,59	1,2	5,56	0,10	12	●	●	●	●	●	●	●	●	●

117-119	120	67-69	124

Dodeka™ • Carbide Insert • HNPJ-GD • Medium Machining

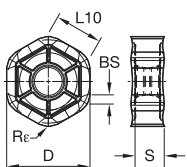


- first choice
- alternate choice

ISO	D	BS	L10	R _E	S	hm	CE	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	KV3500
catalogue number																
HNP.10905ANSNGD	16	1 80	8 58	1 2	5 56	0 10	12									

[illegible]

Dodeka • Carbide Insert • HNGJ-HD • Heavy Machining

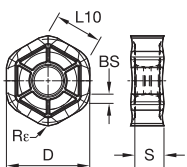


- first choice
- alternate choice

ISO catalogue number	D	BS	L10	R _E	S	hm	CE	KC410M	KC520M	KC522M	KC725M	KK15	KCP/K30	KCFM40	KCSM40	KV35/00
HNGJ0905ANSNHD	16	1,65	8,59	1,2	5,46	0,17	12	-	●	-	●	●	●	●	●	-
HNGJ090543ANSNHD	16	—	8,50	4,4	5,44	0,20	12	-	●	-	●	●	●	●	●	-

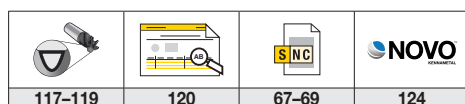
[illegible]

Dodeka • Carbide Insert • HNPJ-HD • Heavy Machining

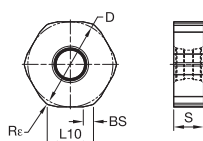


- first choice
- alternate choice

ISO catalogue number	D	BS	L10	R _e	S	hm	CE	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSN40	KV3500
HNPJ0905ANSNHD	16	1,65	8,59	1,2	5,46	0,18	12	-	-	●	●	●	●	●	●	-
HNPJ090543ANSNHD	16	-	8,50	4,4	5,44	0,13	12	-	-	●	●	●	●	●	●	-

[illegible]

Dodeka™ 45° • Ceramic Insert • HNEC • High-Speed Machining of Cast Iron



- first choice

- alternate choice

[illegible]

Dodeka 45° • Insert Selection Guide

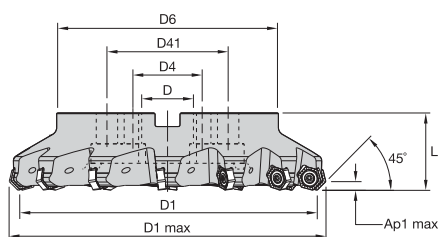
Material Group	Light Machining				Medium Machining				Heavy Machining	
P1-P2	.E..LD	KC522M	.E..LP	KC522M	.E..GP	KC522M	.S..GD	KC522M	.S..HD	KC725M
P3-P4	.E..LD	KCPK30	.E..LP	KCPM40	.E..GP	KCPM40	.S..GD	KCPK30	.S..HD	KCPK30
P5-P6	.E..LD	KC725M	.E..LP	KCPM40	.E..GP	KCPM40	.S..GD	KCPM40	.S..HD	KCPM40
M1-M2	.E..LD	KC522M	.E..LM	KC522M	.E..GM	KCSM40	.S..GD	KCSM40	.S..HD	KCSM40
M3	.E..LD	KCSM40	.E..LM	KCSM40	.E..GM	KCSM40	.S..GD	KCSM40	.S..HD	KCPM40
K1-K2	.E..LD	KCK20B	.E..LP	KCK20B	.E..LP	KCK20B	.S..GD	KCK15	.S..HD	KCK15
K3	.E..LD	KCK20B	.E..LP	KCKP30	.E..LP	KCPK30	.S..GD	KCK20B	.S..HD	KCPK30
N1-N2	.F..LDJ	KC410M	.F..LDJ	KC410M	.F..LDJ	KC410M	.F..LDJ	KC410M	.F..LDJ	KC410M
N3	.F..LDJ	KC410M	.F..LDJ	KC410M	.F..LDJ	KC410M	.F..LDJ	KC410M	.F..LDJ	KC410M
S1-S2	.E..LD	KC725M	.E..LM	KCSM40	.E..GM	KCSM40	.S..GD	KC725M	.S..HD	KC725M
S3	.E..LD	KCSM40	.E..LM	KCSM40	.E..GM	KCSM40	.S..GD	KCSM40	.S..HD	KCSM40
S4	.E..LD	KCSM40	.E..LM	KCSM40	.E..GM	KCSM40	.S..GD	KCSM40	.S..HD	KCSM40
H1	—	—	—	—	.E..GP	KC522M	—	—	—	—

Dodeka 45° • Feed Rates [mm]

		Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)					
		30%			40–100%		
Insert Geometry	L	M	H	L	M	H	
.F..LDJ	0,08	0,22	0,37	0,07	0,20	0,34	
.E..LD	0,11	0,31	0,46	0,10	0,28	0,42	
.E..LM	0,08	0,23	0,38	0,07	0,21	0,35	
.E..LP	0,08	0,28	0,43	0,07	0,25	0,40	
.E..GM	0,08	0,23	0,38	0,07	0,21	0,35	
.E..GP	0,08	0,28	0,44	0,07	0,25	0,40	
.S..GD	0,16	0,34	0,54	0,14	0,31	0,49	
.S..HD	0,16	0,39	0,63	0,14	0,36	0,57	
L = Light Machining; M = Medium Machining; H = Heavy Machining.							

			
117-119	120	67-69	124

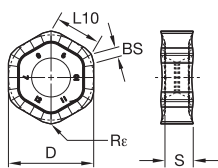
Dodeka MAX™ 45° • Shell Mill • Metric



order number	catalogue number	D1	D1 max	D	D4	D41	D6	L	Ap1 max	Z	kg	max RPM
4059463	KSHR80A04RS45HN13	80	97,3	27	—	—	60	50	8,0	4	1,26	7900
4060935	KSHR100B05RS45HN13	100	117,3	32	—	—	80	50	8,0	5	1,81	6300
4060936	KSHR125B06RS45HN13	125	142,3	40	—	—	90	63	8,0	6	3,07	5050
4059485	KSHR160C09RS45HN13	160	177,3	40	66,7	—	110	63	8,0	9	4,34	3900
4060912	KSHR200C10RS45HN13	200	217,3	60	101,6	—	130	63	8,0	10	6,41	3180
4060937	KSHR200C12RS45HN13	200	217,3	60	101,6	—	130	63	8,0	12	6,48	3180
4060933	KSHR250C12RS45HN13	250	267,3	60	101,6	—	130	63	8,0	12	10,30	2550
4060938	KSHR250C14RS45HN13	250	267,3	60	101,6	—	130	63	8,0	14	10,27	2550
4060934	KSHR315C14RS45HN13	315	332,3	60	101,6	177,8	230	80	8,0	14	24,04	2020
4059486	KSHR315C18RS45HN13	315	332,3	60	101,6	177,8	230	80	8,0	18	24,62	2020

117-119	120	67-69	124

Dodeka MAX™ 45° • Carbide Insert • HNGJ-GD • Medium Machining

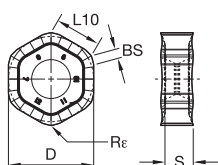


- first choice
- alternate choice

P						
M						
K						
N						
S						
H						

ISO catalogue number	D	BS	L10	Rε	S	hm	CE	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNGJ1307ANENG	22	1,88	12,11	1,2	7,41	0,05	12	-	●	-	●	●	○

Dodeka MAX 45° • Carbide Insert • HNPJ-GD • Medium Machining

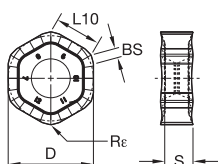


- first choice
- alternate choice

P						
M						
K						
N						
S						
H						

ISO catalogue number	D	BS	L10	Rε	S	hm	CE	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ130720ANSNGD	22	—	12,83	2,0	7,53	0,13	12	-	●	●	●	-	-

Dodeka MAX 45° • Carbide Insert • HNPJ-HD • Heavy Machining



- first choice
- alternate choice

P						
M						
K						
N						
S						
H						

ISO catalogue number	D	BS	L10	Rε	S	hm	CE	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
HNPJ1307ANSNHD	22	1,88	12,83	1,2	7,34	0,25	12	-	●	-	●	●	○
HNPJ130720ANSNHD	22	—	12,83	2,0	7,42	0,23	12	-	●	●	●	●	-
HNPJ130735ANSNHD	22	—	12,29	3,5	7,33	0,23	12	-	-	●	●	-	-

117-119	120	67-69	124

Dodeka MAX™ 45° • Insert Selection Guide

Material Group	Light Machining		Medium Machining		Heavy Machining	
P1-P2	.E..GD	KCPM40	.S..GD	KCPK30	.S..HD	KC725M
P3-P4	.E..GD	KCPK30	.S..GD	KCPK30	.S..HD	KCPK30
P5-P6	.E..GD	KC725M	.S..GD	KC725M	.S..HD	KCPM40
M1-M2	.E..GD	KC725M	.S..GD	KC725M	.S..HD	KCSM40
M3	.E..GD	KCPM40	.S..GD	KC725M	.S..HD	KCPM40
K1-K2	.S..GD	KCK15	.S..GD	KCK15	.S..HD	KCK15
K3	.S..GD	KCK15	.S..GD	KCK15	.S..HD	KCPK30
S1-S2	.E..GD	KC725M	.S..GD	KC725M	.S..HD	KC725M
S3	.E..GD	KCPM40	.S..GD	KC725M	.S..HD	KCSM40
S4	.E..GD	KC725M	.S..GD	KC725M	.S..HD	KCSM40

Dodeka MAX 45° • Feed Rates [mm]

Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)						
Insert Geometry	30%			40-100%		
	L	M	H	L	M	H
.E..GD	0,11	0,31	0,54	0,10	0,28	0,49
.S..GD	0,16	0,35	0,59	0,14	0,32	0,54
.S..HD	0,16	0,39	0,63	0,14	0,36	0,57
L = Light Machining; M = Medium Machining; H = Heavy Machining.						

Speed Information Dodeka™ Series • Metric

	K313			KC410M			KC522M			KC725M			KCK15			KCPK30			KCKP10		
Chip Thickness h_{ex} mm	Min		Max	Min		Max	Min		Max	Min		Max	Min		Max	Min		Max	Min		Max
Cutting Speed (m/min)	Max	Start	Min	Max	Start	Min	Max	Start	Min	Max	Start	Min	Max	Start	Min	Max	Start	Min	Max	Start	Min
P																					
1	-	-	-	-	-	-	395	345	325	310	275	260	-	-	-	545	475	445	370	340	310
2	-	-	-	-	-	-	330	290	240	265	230	190	-	-	-	335	305	275	350	315	280
3	-	-	-	-	-	-	305	260	210	240	205	170	-	-	-	305	275	245	330	280	245
4	-	-	-	-	-	-	270	220	180	215	180	145	-	-	-	270	220	190	280	245	190
5	-	-	-	-	-	-	220	205	180	180	160	145	-	-	-	225	200	180	250	190	150
6	-	-	-	-	-	-	200	150	120	155	120	95	-	-	-	190	160	130	190	150	130
M																					
1	-	-	-	-	-	-	245	215	200	205	180	160	-	-	-	245	220	185	-	-	-
2	-	-	-	-	-	-	220	190	180	185	155	130	-	-	-	220	190	170	-	-	-
3	-	-	-	-	-	-	170	145	115	140	120	95	-	-	-	175	155	140	-	-	-
K																					
1	190	165	140	-	-	-	275	245	220	-	-	-	505	460	410	355	320	290	490	390	280
2	-	-	-	-	-	-	215	190	180	-	-	-	400	355	330	280	250	230	335	290	225
3	-	-	-	-	-	-	180	160	145	-	-	-	335	300	275	235	210	190	280	230	190
N																					
1	875	765	660	1335	1185	1090	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
2	-	-	-	1185	1090	950	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
3	-	-	-	1185	1090	950	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S																					
1	-	-	-	-	-	-	40	35	25	35	30	25	-	-	-	-	-	-	-	-	-
2	-	-	-	-	-	-	40	35	25	35	30	25	-	-	-	-	-	-	-	-	-
3	-	-	-	-	-	-	50	40	25	45	35	25	-	-	-	-	-	-	-	-	-
4	-	-	-	-	-	-	50	45	35	50	45	35	-	-	-	60	50	40	-	-	-
H																					
1	-	-	-	-	-	-	145	110	85	-	-	-	-	-	-	-	-	-	160	120	95

Recommended starting speeds are in bold type. As the average chip thickness increases, speed should be decreased.

Material groups P, M, K, and H show recommended starting speeds for dry machining. For wet machining, reduce speed by 20%.

Material groups N and S show recommended starting speeds for wet machining. Not recommended for dry machining.

	KCK20B			KCPM40			KCSM30			KCSM40			KTPK20			KY3500		
Chip Thickness h_{ex} mm	Min		Max	Min		Max	Min		Max	Min		Max	Min		Max	Min		Max
Cutting Speed (m/min)	Max	Start	Min	Max	Start	Min	Max	Start	Min	Max	Start	Min	Max	Start	Min	Max	Start	Min
P																		
1	-	-	-	355	310	295	440	380	350	420	375	345	430	360	300	-	-	-
2	-	-	-	300	260	215	365	320	260	360	320	255	315	260	240	-	-	-
3	-	-	-	275	235	190	340	285	234	335	275	230	290	240	215	-	-	-
4	-	-	-	245	205	160	300	245	195	285	240	190	250	215	190	-	-	-
5	-	-	-	205	185	160	245	220	190	240	210	180	220	200	180	-	-	-
6	-	-	-	180	140	110	215	165	130	210	155	120	190	155	120	-	-	-
M																		
1	-	-	-	235	205	185	255	210	190	290	230	200	260	210	180	-	-	-
2	-	-	-	210	180	150	230	190	150	260	205	170	235	200	165	-	-	-
3	-	-	-	155	140	110	170	145	115	190	160	125	175	145	120	-	-	-
K																		
1	430	340	280	-	-	-	-	-	-	-	-	-	275	235	190	965	875	780
2	330	270	220	-	-	-	-	-	-	-	-	-	220	180	155	760	685	635
3	250	210	165	-	-	-	-	-	-	-	-	-	180	155	125	-	-	-
N																		
1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S																		
1	-	-	-	45	40	35	50	45	35	60	45	30	-	-	-	-	-	-
2	-	-	-	45	40	35	50	45	35	65	45	30	-	-	-	-	-	-
3	-	-	-	60	45	35	65	50	35	75	50	35	-	-	-	-	-	-
4	-	-	-	65	60	40	70	65	45	90	70	45	-	-	-	-	-	-
H																		
1	-	-	-	-	-	-	160	120	90	-	-	-	-	-	-	-	-	-

Recommended starting speeds are in bold type. As the average chip thickness increases, speed should be decreased.

Material groups P, M, K, and H show recommended starting speeds for dry machining. For wet machining, reduce speed by 20%.

Material groups N and S show recommended starting speeds for wet machining. Not recommended for dry machining.

KCSM15A

Solid End Milling Grade

Our KCSM15A grade features an advanced PVD coating technology and delivers the best wear resistance in the history of Kennametal solid carbide end milling. This new grade provides increased output, higher metal removal rates and overall reliability when machining stainless steel, titanium and other high-temp alloys.

KCSM15A launches with the **HARVI™ III**, **HARVI II Long**, and **RSM II** platforms that are proven high performance solid carbide end mills for the aerospace, energy, transportation, and general engineering industries.

- Copper color provides improved tool life observation and reconditioning management
- Protection against abrasive wear and minimized edge build-up
- Increased tool life at high temperatures with minimized chipping
- Improved process stability



Tool Selector

HIGH-PERFORMANCE ROUGHING AND FINISHING						
HARVI™ I TE						
						
Series	H1TE4CH..R..	H1TE4CH..N..	H1TE4CH..S..	H1TE4RA..N..	H1TE4RA..E..	H1TE4SE..N..
Page	10*	11*	12*	13–14*	15–17*	18*
Tool type						
Rougher	●	●	●	●	●	●
Finisher	○	○	○	○	○	○
Chamfering						
Main operation						
Workpiece material						
Primary	P M K	P M K	P M K	P M K S	P M K S	P M K
Secondary	S H	S H	S H	H	H	S H
Corner style						
Corner radius [R _c]	—	—	—	0,25–6,0mm	0,25–6,0mm	—
Corner chamfer width [BCH]	0,2–0,5mm	0,15–0,35mm	0,1–0,35mm	—	—	—
Cutter diameter [D1]	2–25mm	2–25mm	2–25mm	4–25mm	4–25mm	2–25mm
Length of cut	1,8–3 x D1	1,8–3 x D1	1,2–2 x D1	1,5 x D	1,8–2,75 x D1	1,8–3 x D1
Maximum cutting depth [A _{p1} max]	5–45mm	6–45mm	4–30mm	6–37,5mm	11–45mm	6–45mm
Flute helix angle	36°/39°	36°/39°	36°/39°	36°/39°	36/39	36°/39°
Number of flutes [ZU]	4	4	4	4	4	4
Center cutting	✓	✓	✓	✓	✓	✓
Additional operations	 	 	 	 	 	 
	 	 	 	 	 	 

*See page in the Kennametal SCEM Master Catalog 2024 • 153258-23

- Primary
- Secondary

Tool Selector

HIGH-PERFORMANCE ROUGHING AND FINISHING						
	HARVI™ I TE		HARVI II		HARVI III	
						
Series	H1TE4SE..S..	H1TEBN..N-L	UCDE	UDDE	HA3R6RA/SE..S-X..	HA3R6RA/SE..N..
Page	19*	20*	28–30*	31–33*	106	107–108
Tool type						
Rougher	●	●	●	●	○	○
Finisher	○	○	○	○	●	●
Chamfering						
Main operation						
Workpiece material						
Primary	P M K	P M K	P M K S	P M S	M S	M S
Secondary	S H	S H	H	H	P H	P H
Corner style			 	 	 	 
Corner radius [R _c]	—	—	0,25–0,75mm	0,20–6mm	0,50–0,75mm	0,50–6mm
Corner chamfer width [BCH]	—	—	—	—	—	—
Cutter diameter [D1]	2–25mm	2–20mm	4–25mm	6–25mm	10–25mm	10–25mm
Length of cut	1,2–2 x D1	1–2,7 x D	1,8–2,7 x D1	1,8–2,4 x D	1,8–2,2 x D	1,8–2,2 x D
Maximum cutting depth [A _{p1} max]	4–30mm	2–50mm	11–45mm	13–45mm	22–45mm	22–45mm
Flute helix angle	36°/39°	36°/39°	38°	38°	38°	38°
Number of flutes [ZU]	4	4	5	5	6	6
Center cutting	✓	✓			✓	✓
Additional operations	   	   	  	  	  	  

*See page in the Kennametal SCEM Master Catalog 2024 • 153258-23

- Primary
- Secondary

Tool Selector

HIGH-PERFORMANCE ROUGHING AND FINISHING				
	HARVI™ III		HARVI II Long	
	NEW! 	NEW! 	NEW! 	NEW! 
Series	HA3R6BN..N..	HA3R6TB..L-X..	HA2L5RA..L..	HA2L5RA..X..
Page	108	109	110	111
Tool type				
Rougher	○	○		
Finisher	●	●	●	●
Chamfering				
Main operation				
Workpiece material				
Primary	M S	M S	P M S	P M S
Secondary	P H	P H	K H	K H
Corner style				
Corner radius [R _e]	—	—	0,20–6mm	0,20–6mm
Corner chamfer width [BCH]	—	—	—	—
Cutter diameter [D1]	10–20mm	4–10mm	6–25mm	6–25mm
Length of cut	1 x D1	4,7–7 x D	3 x D	5 x D
Maximum cutting depth [A _{p1} max]	10–20mm	26–39mm	18–75mm	30–125mm
Flute helix angle	38°	38°	43°	43°
Number of flutes [ZU]	6	6	5	5
Center cutting	✓	✓		
Additional operations	 	 		

● Primary

○ Secondary

Tool Selector

DYNAMIC MILLING							
	KOR5™ DS		KOR5™ DA			KOR6™ DT	
							
Series	KOR5..R..	KOR5..L..	KOR5..R..I	KOR5..L..I..	KOR5..R..C	KOR6..R..	KOR6..L..
Page	48*	49*	50–51*	53–55*	51–53*	55–56*	56–57*
Tool type							
Rougher	●	●	●	●	●	●	●
Finisher	○	○	○	○	○		
Chamfering							
Main operation							
Workpiece material							
Primary	P M	P M	N	N	N	S	S
Secondary	K S H	K S H				P M K H	P M K H
Corner style			 	 	 		
Corner radius [R _ε]	0,50–1mm	0,50–1mm	0,20–2,50mm	0,20–2,50mm	0,20–2,50mm	0,05–1mm	0,50–1mm
Corner chamfer width [BCH]	—	—	—	—	—	—	—
Cutter diameter [D1]	8–25mm	8–25mm	10–25mm	10–25mm	10–25mm	8–25mm	8–25mm
Length of cut	3 x D	5 x D	3 x D	5 x D	3 x D	3 x D	5 x D
Maximum cutting depth [A _{p1} max]	24–75mm	40–125mm	30–60mm	50–125mm	30–60mm	24–75mm	40–125mm
Flute helix angle	40°	40°	35°	35°	35°	38°	38°
Number of flutes [ZU]	5	5	5	5	5	6	6
Coolant							
Additional operations	 	 	 	 	 	 	 

*See page in the Kennametal SCEM Master Catalog 2024 • 153258-23

- Primary
- Secondary

HARVI™ Series

High-Performance
Roughing and Finishing

Materials



Applications



Ramping



Slotting: Square End



Trochoidal Milling



Shoulder Milling



Profiling



NEW!

KCSM15A Grade for
high-temperature alloys.

Roughing and finishing in multiple materials.

Unequally spaced flutes to minimize vibrations and provide high tool life and superior surface quality. Safe-Lock™ shanks with pullout protection deliver increased process safety. Proprietary tapered-core design improves tool stability in roughing and finishing applications.

HARVI II

Five-flute end mill for high-feed roughing and finishing with one tool in multiple materials.

HARVI II Long

Five-flute end mill for semi-finishing and finishing of thin walls and deep pockets in titanium, steels, and stainless steels with excellent surface finishes.

HARVI™ II



Harvi II: Non-center cutting.

Harvi II Long: High feed rate capability for corner machining operations delivers additional productivity.

HARVI III



Harvi III & Harvi III Ball Nose: Tailored axial and radial rake angles result in lower cutting forces and lower pressure on cutting edge, providing smooth cutting action and best surface finishes.

Center cutting design enables radial and axial finishing pass after roughing operation.

Harvi III Taper Ball Nose: Six flutes in ball nose section and taper section for highest metal removal rates.

Taper angles of 4° and 6° for a broad range of applications.

HARVI III

Six-flute end mill for high-feed roughing and finishing with maximum metal removal rates in titanium and stainless steel with excellent surfaces.

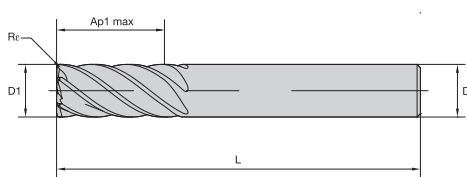
HARVI III Ball Nose

Six-flute end mill for 3D profiling with highest productivity in titanium and stainless steel.

HARVI III Taper Ball Nose

Six-flute end mill for 5-axis machining of steel, stainless steel, nickel-based alloys, and titanium to significantly increase output and decrease machining time.

HARVI™ III • Radiused • 6 Flutes • Plain Shank • Metric

NEW!


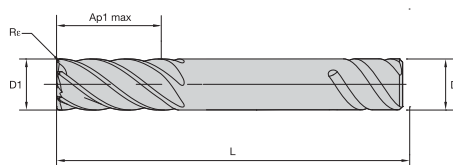
- first choice
○ alternate choice

P	●
M	●
K	●
N	●
S	●
H	○

order number	catalogue number	D1	D	Ap1 max	L	Re	
7077115	HA3R6RA1000R022HAR050M	10,00	10,00	22,00	72,00	0,50	●
7077117	HA3R6RA1200R026HAR075M	12,00	12,00	26,00	83,00	0,75	●
7077119	HA3R6RA1400R026HAR075M	14,00	14,00	26,00	83,00	0,75	●
7077261	HA3R6RA1600R032HAR075M	16,00	16,00	32,00	92,00	0,75	●
7077263	HA3R6RA2000R038HAR075M	20,00	20,00	38,00	104,00	0,75	●
7077265	HA3R6RA2500R045HAR075M	25,00	25,00	45,00	121,00	0,75	●

KCSM15A

HARVI III • Radiused • 6 Flutes • Safe-Lock™ Shank • Metric

NEW!


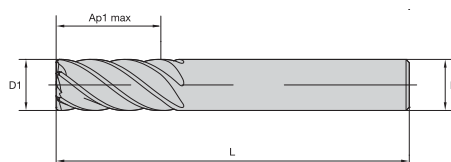
- first choice
○ alternate choice

P	●
M	●
K	●
N	●
S	●
H	○

order number	catalogue number	D1	D	Ap1 max	L	Re	
7077267	HA3R6RA1200R026SLR075M	12,00	12,00	26,00	83,00	0,75	●
7077268	HA3R6RA1600R032SLR075M	16,00	16,00	32,00	92,00	0,75	●
7077269	HA3R6RA2000R038SLR075M	20,00	20,00	38,00	104,00	0,75	●
7077270	HA3R6RA2500R045SLR075M	25,00	25,00	45,00	121,00	0,75	●

KCSM15A

HARVI III • Square End • 6 Flutes • Plain Shank • Metric

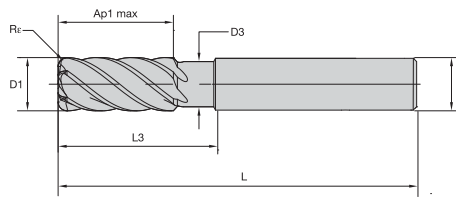
NEW!


- first choice
○ alternate choice

P	●
M	●
K	●
N	●
S	●
H	○

order number	catalogue number	D1	D	Ap1 max	L	
7077116	HA3R6SE1000R022HAM	10,00	10,00	22,00	72,00	●
7077118	HA3R6SE1200R026HAM	12,00	12,00	26,00	83,00	●
7077120	HA3R6SE1400R026HAM	14,00	14,00	26,00	83,00	●
7077262	HA3R6SE1600R032HAM	16,00	16,00	32,00	92,00	●
7077264	HA3R6SE2000R038HAM	20,00	20,00	38,00	104,00	●
7077266	HA3R6SE2500R045HAM	25,00	25,00	45,00	121,00	●

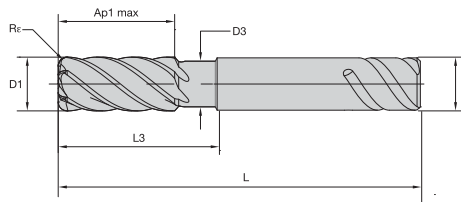
KCSM15A

HARVI™ III • Radiused • 6 Flutes • Necked • Plain Shank • Metric**NEW!**

- first choice
○ alternate choice

P	Blue	○
M	Yellow	●
K	Red	●
N	Green	●
S	Orange	●
H	Grey	○

order number	catalogue number	D1	D	D3	Ap1 max	L3	L	R _E	KCSM15A
7077281	HA3R6RA1000N022HAR050M	10,00	10,00	9,40	22,00	30,00	76,00	0,50	●
7077282	HA3R6RA1000N022HAR100M	10,00	10,00	9,40	22,00	30,00	76,00	1,00	●
7077283	HA3R6RA1000N022HAR200M	10,00	10,00	9,40	22,00	30,00	76,00	2,00	●
7077285	HA3R6RA1200N026HAR050M	12,00	12,00	11,28	26,00	36,00	83,00	0,50	●
7077286	HA3R6RA1200N026HAR100M	12,00	12,00	11,28	26,00	36,00	83,00	1,00	●
7077287	HA3R6RA1200N026HAR200M	12,00	12,00	11,28	26,00	36,00	83,00	2,00	●
7077288	HA3R6RA1200N026HAR300M	12,00	12,00	11,28	26,00	36,00	83,00	3,00	●
7077291	HA3R6RA1600N032HAR050M	16,00	16,00	15,04	32,00	48,00	100,00	0,50	●
7077292	HA3R6RA1600N032HAR100M	16,00	16,00	15,04	32,00	48,00	100,00	1,00	●
7077293	HA3R6RA1600N032HAR200M	16,00	16,00	15,04	32,00	48,00	100,00	2,00	●
7077294	HA3R6RA1600N032HAR300M	16,00	16,00	15,04	32,00	48,00	100,00	3,00	●
7077295	HA3R6RA1600N032HAR400M	16,00	16,00	15,04	32,00	48,00	100,00	4,00	●
7077296	HA3R6RA1600N032HAR600M	16,00	16,00	15,04	32,00	48,00	100,00	6,00	●
7077298	HA3R6RA2000N038HAR050M	20,00	20,00	18,80	38,00	60,00	115,00	0,50	●
7077299	HA3R6RA2000N038HAR100M	20,00	20,00	18,80	38,00	60,00	115,00	1,00	●
7077300	HA3R6RA2000N038HAR200M	20,00	20,00	18,80	38,00	60,00	115,00	2,00	●
7077301	HA3R6RA2000N038HAR300M	20,00	20,00	18,80	38,00	60,00	115,00	3,00	●
7077302	HA3R6RA2000N038HAR400M	20,00	20,00	18,80	38,00	60,00	115,00	4,00	●
7077303	HA3R6RA2000N038HAR600M	20,00	20,00	18,80	38,00	60,00	115,00	6,00	●
7077305	HA3R6RA2500N045HAR100M	25,00	25,00	23,50	45,00	75,00	135,00	1,00	●
7077306	HA3R6RA2500N045HAR400M	25,00	25,00	23,50	45,00	75,00	135,00	4,00	●

HARVI III • Radiused • 6 Flutes • Necked • Safe-Lock™ Shank • Metric**NEW!**

- first choice
○ alternate choice

P	Blue	○
M	Yellow	●
K	Red	●
N	Green	●
S	Orange	●
H	Grey	○

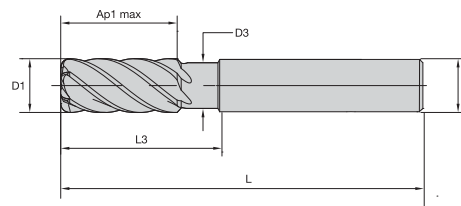
order number	catalogue number	D1	D	D3	Ap1 max	L3	L	R _E	KCSM15A
7077307	HA3R6RA1200N026SLR050M	12,00	12,00	11,28	26,00	36,00	83,00	0,50	●
7077308	HA3R6RA1200N026SLR100M	12,00	12,00	11,28	26,00	36,00	83,00	1,00	●
7077309	HA3R6RA1600N032SLR050M	16,00	16,00	15,04	32,00	48,00	100,00	0,50	●
7077310	HA3R6RA1600N032SLR100M	16,00	16,00	15,04	32,00	48,00	100,00	1,00	●
7077311	HA3R6RA1600N032SLR200M	16,00	16,00	15,04	32,00	48,00	100,00	2,00	●
7077312	HA3R6RA1600N032SLR400M	16,00	16,00	15,04	32,00	48,00	100,00	4,00	●
7077313	HA3R6RA2000N038SLR050M	20,00	20,00	18,80	38,00	60,00	115,00	0,50	●
7077314	HA3R6RA2000N038SLR100M	20,00	20,00	18,80	38,00	60,00	115,00	1,00	●
7077316	HA3R6RA2000N038SLR200M	20,00	20,00	18,80	38,00	60,00	115,00	2,00	●
7077317	HA3R6RA2000N038SLR400M	20,00	20,00	18,80	38,00	60,00	115,00	4,00	●
7077318	HA3R6RA2500N045SLR050M	25,00	25,00	23,50	45,00	75,00	135,00	0,50	●

117-119	120	116	124

HARVI™ III • Square End • 6 Flutes • Necked • Plain Shank • Metric

● first choice

○ alternate choice

NEW!

P		
M		●
K		
N		
S		●
H		○

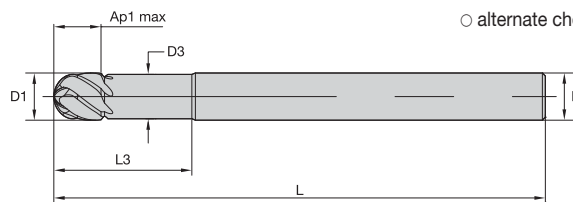
KCSM15A

order number	catalogue number	D1	D	D3	Ap1 max	L3	L	
7077284	HA3R6SE1000N022HAM	10,00	10,00	9,40	22,00	30,00	76,00	●
7077290	HA3R6SE1200N026HAM	12,00	12,00	11,28	26,00	36,00	83,00	●
7077297	HA3R6SE1600N032HAM	16,00	16,00	15,04	32,00	48,00	100,00	●
7077304	HA3R6SE2000N038HAM	20,00	20,00	18,80	38,00	60,00	115,00	●

HARVI III • Ball Nose • 6 Flutes • Necked • Plain Shank • Metric

● first choice

○ alternate choice

NEW!

P		
M		●
K		
N		
S		●
H		○

KCSM15A

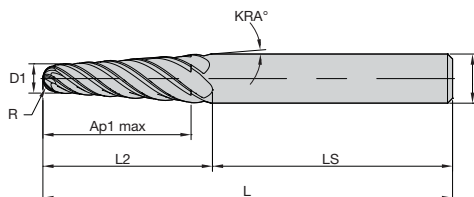
order number	catalogue number	D1	D	D3	Ap1 max	L3	L	
7077319	HA3R6BN1000N010HAM	10,00	10,00	9,40	10,00	30,00	72,00	●
7077320	HA3R6BN1000N010HAEM	10,00	10,00	9,40	10,00	30,00	121,00	●
7077321	HA3R6BN1200N012HAM	12,00	12,00	11,28	12,00	36,00	83,00	●
7077322	HA3R6BN1200N012HAEM	12,00	12,00	11,28	12,00	36,00	125,00	●
7077323	HA3R6BN1600N016HAM	16,00	16,00	15,04	16,00	48,00	100,00	●
7077324	HA3R6BN1600N016HAEM	16,00	16,00	15,04	16,00	48,00	150,00	●
7077325	HA3R6BN2000N020HAM	20,00	20,00	18,80	20,00	60,00	115,00	●
7077326	HA3R6BN2000N020HAEM	20,00	20,00	18,80	20,00	60,00	150,00	●

117-119	120	116	124

HARVI™ III • Taper Ball Nose • 6 Flutes • Plain Shank • Metric

● first choice

○ alternate choice

NEW!

P		
M		●
K		
N		
S		●
H		○

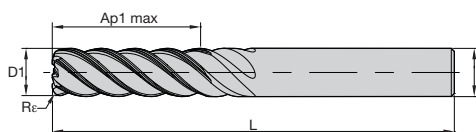
order number	catalogue number	D1	D	Ap1 max	L2	LS	L	R	KRA	KCSM15A
7078273	HA3R6TB0400X026HAM	4,00	8,00	26,00	30,53	45,47	76,00	2,00	4,00	
7078272	HA3R6TB0400L025HAM	4,00	10,00	25,00	30,44	58,56	89,00	2,00	6,00	
7078275	HA3R6TB0500X033HAM	5,00	10,00	33,00	38,16	50,84	89,00	2,50	4,00	
7078274	HA3R6TB0500L029HAM	5,00	12,00	29,00	35,67	64,33	100,00	2,50	6,00	
7078277	HA3R6TB0600L039HAM	6,00	12,00	39,00	45,80	54,20	100,00	3,00	4,00	
7078278	HA3R6TB0600X042HAM	6,00	16,00	42,00	50,42	59,59	110,00	3,00	6,00	
7078301	HA3R6TB0800X039HAM	8,00	14,00	39,00	46,76	53,24	100,00	4,00	4,00	
7078280	HA3R6TB0800L033HAM	8,00	16,00	33,00	41,85	68,15	110,00	4,00	6,00	
7078302	HA3R6TB1000L025HAM	10,00	16,00	25,00	33,28	76,72	110,00	5,00	6,00	
7078303	HA3R6TB1000X039HAM	10,00	16,00	39,00	47,73	62,27	110,00	5,00	4,00	

117-119	120	116	124

HARVI™ II Long • Radiused • 5 Flutes • 3 x D • Plain Shank • Metric

● first choice

○ alternate choice

NEW!

P		●
M		●
K		○
N		●
S		●
H		○

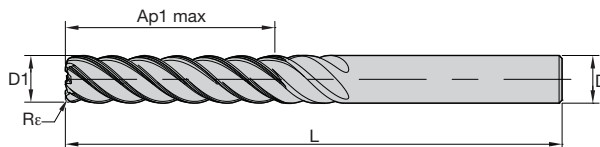
order number	catalogue number	D1	D	Ap1 max	L	Re	KCSM15A
7077633	HA2L5RA0600L018HAR020M	6,00	6,00	18,00	63,00	0,20	●
7077634	HA2L5RA0600L018HAR050M	6,00	6,00	18,00	63,00	0,50	●
7077635	HA2L5RA0600L018HAR100M	6,00	6,00	18,00	63,00	1,00	●
7077636	HA2L5RA0800L024HAR020M	8,00	8,00	24,00	67,00	0,20	●
7077637	HA2L5RA0800L024HAR050M	8,00	8,00	24,00	67,00	0,50	●
7077638	HA2L5RA0800L024HAR100M	8,00	8,00	24,00	67,00	1,00	●
7077639	HA2L5RA1000L030HAR050M	10,00	10,00	30,00	76,00	0,50	●
7077640	HA2L5RA1000L030HAR100M	10,00	10,00	30,00	76,00	1,00	●
7077871	HA2L5RA1000L030HAR200M	10,00	10,00	30,00	76,00	2,00	●
7077872	HA2L5RA1000L030HAR250M	10,00	10,00	30,00	76,00	2,50	●
7077873	HA2L5RA1200L036HAR050M	12,00	12,00	36,00	100,00	0,50	●
7077874	HA2L5RA1200L036HAR100M	12,00	12,00	36,00	100,00	1,00	●
7077875	HA2L5RA1200L036HAR200M	12,00	12,00	36,00	100,00	2,00	●
7077876	HA2L5RA1200L036HAR250M	12,00	12,00	36,00	100,00	2,50	●
7077877	HA2L5RA1400L042HAR300M	14,00	14,00	42,00	100,00	3,00	●
7077878	HA2L5RA1600L048HAR100M	16,00	16,00	48,00	110,00	1,00	●
7077879	HA2L5RA1600L048HAR200M	16,00	16,00	48,00	110,00	2,00	●
7077880	HA2L5RA1600L048HAR250M	16,00	16,00	48,00	110,00	2,50	●
7077881	HA2L5RA1600L048HAR300M	16,00	16,00	48,00	110,00	3,00	●
7077882	HA2L5RA1600L048HAR400M	16,00	16,00	48,00	110,00	4,00	●
7077884	HA2L5RA1600L048HAR600M	16,00	16,00	48,00	110,00	6,00	●
7077886	HA2L5RA2000L060HAR100M	20,00	20,00	60,00	125,00	1,00	●
7077888	HA2L5RA2000L060HAR200M	20,00	20,00	60,00	125,00	2,00	●
7077890	HA2L5RA2000L060HAR250M	20,00	20,00	60,00	125,00	2,50	●
7077892	HA2L5RA2000L060HAR300M	20,00	20,00	60,00	125,00	3,00	●
7077894	HA2L5RA2000L060HAR400M	20,00	20,00	60,00	125,00	4,00	●
7077896	HA2L5RA2000L060HAR600M	20,00	20,00	60,00	125,00	6,00	●
7077898	HA2L5RA2500L075HAR100M	25,00	25,00	75,00	150,00	1,00	●
7077900	HA2L5RA2500L075HAR200M	25,00	25,00	75,00	150,00	2,00	●
7077912	HA2L5RA2500L075HAR250M	25,00	25,00	75,00	150,00	2,50	●
7077914	HA2L5RA2500L075HAR300M	25,00	25,00	75,00	150,00	3,00	●
7077916	HA2L5RA2500L075HAR400M	25,00	25,00	75,00	150,00	4,00	●
7077918	HA2L5RA2500L075HAR600M	25,00	25,00	75,00	150,00	6,00	●

117-119	120	116	124

HARVI™ II Long • Radiused • 5 Flutes • 5 x D • Plain Shank • Metric

● first choice

○ alternate choice

NEW!

P	●
M	●
K	○
N	●
S	●
H	○

order number	catalogue number	D1	D	Ap1 max	L	Re	KCSM15A
7077920	HA2L5RA0600X030HAR020M	6,00	6,00	30,00	76,00	0,20	●
7077932	HA2L5RA0600X030HAR050M	6,00	6,00	30,00	76,00	0,50	●
7077933	HA2L5RA0600X030HAR100M	6,00	6,00	30,00	76,00	1,00	●
7077934	HA2L5RA0800X040HAR020M	8,00	8,00	40,00	87,00	0,20	●
7077935	HA2L5RA0800X040HAR050M	8,00	8,00	40,00	87,00	0,50	●
7077936	HA2L5RA0800X040HAR100M	8,00	8,00	40,00	87,00	1,00	●
7077937	HA2L5RA1000X050HAR050M	10,00	10,00	50,00	100,00	0,50	●
7077938	HA2L5RA1000X050HAR100M	10,00	10,00	50,00	100,00	1,00	●
7077939	HA2L5RA1000X050HAR200M	10,00	10,00	50,00	100,00	2,00	●
7077940	HA2L5RA1000X050HAR250M	10,00	10,00	50,00	100,00	2,50	●
7077941	HA2L5RA1200X060HAR050M	12,00	12,00	60,00	125,00	0,50	●
7077942	HA2L5RA1200X060HAR100M	12,00	12,00	60,00	125,00	1,00	●
7077943	HA2L5RA1200X060HAR200M	12,00	12,00	60,00	125,00	2,00	●
7077944	HA2L5RA1200X060HAR250M	12,00	12,00	60,00	125,00	2,50	●
7077945	HA2L5RA1400X070HAR300M	14,00	14,00	70,00	120,00	3,00	●
7077946	HA2L5RA1600X080HAR100M	16,00	16,00	80,00	141,00	1,00	●
7077947	HA2L5RA1600X080HAR200M	16,00	16,00	80,00	141,00	2,00	●
7077883	HA2L5RA1600X080HAR250M	16,00	16,00	80,00	141,00	2,50	●
7077885	HA2L5RA1600X080HAR300M	16,00	16,00	80,00	141,00	3,00	●
7077887	HA2L5RA1600X080HAR400M	16,00	16,00	80,00	141,00	4,00	●
7077889	HA2L5RA1600X080HAR600M	16,00	16,00	80,00	141,00	6,00	●
7077891	HA2L5RA2000X100HAR100M	20,00	20,00	100,00	166,00	1,00	●
7077893	HA2L5RA2000X100HAR200M	20,00	20,00	100,00	166,00	2,00	●
7077895	HA2L5RA2000X100HAR250M	20,00	20,00	100,00	166,00	2,50	●
7077897	HA2L5RA2000X100HAR300M	20,00	20,00	100,00	166,00	3,00	●
7077899	HA2L5RA2000X100HAR400M	20,00	20,00	100,00	166,00	4,00	●
7077911	HA2L5RA2000X100HAR600M	20,00	20,00	100,00	166,00	6,00	●
7077913	HA2L5RA2500X125HAR100M	25,00	25,00	125,00	190,00	1,00	●
7077915	HA2L5RA2500X125HAR200M	25,00	25,00	125,00	190,00	2,00	●
7077917	HA2L5RA2500X125HAR300M	25,00	25,00	125,00	190,00	3,00	●
7077919	HA2L5RA2500X125HAR400M	25,00	25,00	125,00	190,00	4,00	●
7077931	HA2L5RA2500X125HAR600M	25,00	25,00	125,00	190,00	6,00	●

117-119	120	116	124

HARVI™ III • Application Data • Metric



With Neck



Without Neck

Material Group			KCSM15A		Recommended feed per tooth (fz = mm/th) for side milling.								
			Cutting Speed — vc m/min		mm	D1 — Diameter							
			ap	ae		Min	Max	10,0	12,0	14,0	16,0	18,0	20,0
P	4	ap max	0,4 x D	90	150	Fz	0,054	0,062	0,070	0,077	0,083	0,088	0,098
	5	ap max	0,4 x D	60	100	Fz	0,048	0,056	0,063	0,070	0,076	0,081	0,091
M	1	ap max	0,4 x D	90	115	Fz	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	2	ap max	0,4 x D	60	80	Fz	0,048	0,056	0,063	0,070	0,076	0,081	0,091
S	3	ap max	0,4 x D	60	70	Fz	0,040	0,047	0,052	0,057	0,061	0,065	0,071
	1	ap max	0,4 x D	50	90	Fz	0,061	0,070	0,079	0,087	0,095	0,101	0,114
	2	ap max	0,4 x D	25	50	Fz	0,032	0,037	0,042	0,046	0,050	0,054	0,061
	3	ap max	0,4 x D	25	40	Fz	0,032	0,037	0,042	0,046	0,050	0,054	0,061
H	4	ap max	0,4 x D	50	60	Fz	0,045	0,052	0,058	0,064	0,069	0,074	0,084
	1	ap max	0,4 x D	80	140	Fz	0,054	0,062	0,070	0,077	0,083	0,088	0,098
	2	ap max	0,4 x D	70	120	Fz	0,040	0,047	0,052	0,057	0,061	0,065	0,071

NOTE: These guidelines may require variations to achieve optimum results.

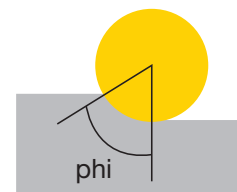
Lower value of cutting speed is used for high stock removal applications or for higher hardness (machinability) within group.

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 >12mm diameter.

HARVI III • Adjustment Factor for Feed and Speed Calculation • Metric

	Ae/D	2%	4%	5%	8%	10%	12%	20%	30%
Speed factor	Kv	1,75–3,0	1,33–2,52	1,33–2,1	1,33	1,17	1,15	1,08	1,00
Feed factor	KFz	3,28	2,35	2,11	1,69	1,53	1,41	1,15	1,00
phi [°]		16,26	23,07	25,84	32,86	36,87	40,54	53,13	66,42



NOTE: For an Ae/D ratio of 5% or less there is a range given for speed factor Kv, which allows the user to either be more conservative at the lower value or more aggressive with the higher value.

This can also be considered based on the machinability of the material, from difficult to free cutting.

These calculations are for roughing/semi-finishing cuts when used with the recommended base Fz.

For light finishing cuts requiring improved surface quality it is recommended to reduce the base Fz approximately 50% and then apply these factors.

To calculate application specific cutting data, please use above Kv coefficient for adaptation of cutting speed and KFz for feed respectively.

$$Vc_{new} = Vc \cdot Kv$$

$$Fz_{new} = Fz \cdot KFz$$

Calculation example:

Application: D1 = 16,0mm;

S4 material group;

Ae 1,6mm (Ae = 10% of D)

Cutting data recommendation: Vc = 60m/min;

Fz = 0,064mm/th

Adjustment coefficients: Kv = 1,17mm;

KFz = 1,53

Final cutting data recommendation:

Vc new = 60 * 1,17 = 70m/min

Fz new = 0,064128 * 1,53 = 0,098mm/th

HARVI™ III Ballnose • HARVI III Taper Ball Nose • Application Data • Roughing • Metric



Ball Nose With Neck



Taper Ball Nose

Material Group				KCSM15A			Recommended feed per tooth (fz = mm/th) for side milling.												
				Cutting Speed — vc m/min				D1 — Diameter											
ap	ae	Min		Max	mm	4,0	5,0	6,0	8,0	10,0	12,0	14,0	16,0	18,0	20,0	25,0			
P	0	Ap max	0,4 x D	150	—	200	Fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124	
	1	Ap max	0,4 x D	150	—	200	Fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124	
	2	Ap max	0,4 x D	140	—	190	Fz	0,028	0,036	0,044	0,060	0,072	0,083	0,092	0,101	0,108	0,114	0,124	
	3	Ap max	0,4 x D	120	—	160	Fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114	
	4	Ap max	0,4 x D	90	—	150	Fz	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098	
	5	Ap max	0,4 x D	60	—	100	Fz	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091	
M	6	Ap max	0,4 x D	50	—	75	Fz	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071	
	1	Ap max	0,4 x D	90	—	115	Fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114	
	2	Ap max	0,4 x D	60	—	80	Fz	0,019	0,024	0,029	0,040	0,048	0,056	0,063	0,070	0,076	0,081	0,091	
S	3	Ap max	0,4 x D	60	—	70	Fz	0,016	0,020	0,025	0,034	0,040	0,047	0,052	0,057	0,061	0,065	0,071	
	1	Ap max	0,4 x D	50	—	90	Fz	0,023	0,030	0,036	0,050	0,061	0,070	0,079	0,087	0,095	0,101	0,114	
	2	Ap max	0,4 x D	25	—	50	Fz	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061	
	3	Ap max	0,4 x D	25	—	40	Fz	0,013	0,016	0,019	0,026	0,032	0,037	0,042	0,046	0,050	0,054	0,061	
H	4	Ap max	0,4 x D	50	—	60	Fz	0,016	0,021	0,026	0,037	0,045	0,052	0,058	0,064	0,069	0,074	0,084	
	1	Ap max	0,4 x D	80	—	140	Fz	0,021	0,027	0,033	0,045	0,054	0,062	0,070	0,077	0,083	0,088	0,098	

NOTE: 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 >12mm diameter.

HARVI III Ballnose • HARVI III Taper Ball Nose • Application Data • Finishing • Metric



Ball Nose With Neck



Taper Ball Nose

Material Group				KCSM15A			Recommended feed per tooth (fz = mm/th) for side milling.											
				Cutting Speed — vc m/min				D1 — Diameter										
ap	ae	Min		Max	mm	4,0	5,0	6,0	8,0	10,0	12,0	16,0	18,0	20,0	25,0			
P	0	Ap max	0,06 x D	285	—	380	Fz	0,034	0,043	0,053	0,072	0,086	0,099	0,121	0,130	0,137	0,149	
	1	Ap max	0,06 x D	285	—	380	Fz	0,034	0,043	0,053	0,072	0,086	0,099	0,121	0,130	0,137	0,149	
	2	Ap max	0,06 x D	266	—	361	Fz	0,034	0,043	0,053	0,072	0,086	0,099	0,121	0,130	0,137	0,149	
	3	Ap max	0,06 x D	228	—	304	Fz	0,028	0,036	0,044	0,060	0,073	0,084	0,105	0,113	0,121	0,137	
	4	Ap max	0,06 x D	171	—	285	Fz	0,026	0,033	0,039	0,054	0,065	0,075	0,092	0,099	0,106	0,117	
	5	Ap max	0,06 x D	114	—	190	Fz	0,023	0,029	0,035	0,048	0,058	0,067	0,084	0,091	0,097	0,109	
M	6	Ap max	0,06 x D	95	—	142,5	Fz	0,019	0,024	0,030	0,040	0,048	0,056	0,068	0,073	0,078	0,085	
	1	Ap max	0,06 x D	171	—	218,5	Fz	0,028	0,036	0,044	0,060	0,073	0,084	0,105	0,113	0,121	0,137	
S	2	Ap max	0,06 x D	114	—	152	Fz	0,023	0,029	0,035	0,048	0,058	0,067	0,084	0,091	0,097	0,109	
	3	Ap max	0,06 x D	114	—	133	Fz	0,019	0,024	0,030	0,040	0,048	0,056	0,068	0,073	0,078	0,085	
	1	Ap max	0,06 x D	95	—	171	Fz	0,028	0,036	0,044	0,060	0,073	0,084	0,105	0,113	0,121	0,137	
	2	Ap max	0,06 x D	47,5	—	95	Fz	0,015	0,019	0,023	0,032	0,038	0,045	0,056	0,060	0,065	0,074	
H	3	Ap max	0,06 x D	47,5	—	76	Fz	0,015	0,019	0,023	0,032	0,038	0,045	0,056	0,060	0,065	0,074	
	4	Ap max	0,06 x D	95	—	114	Fz	0,019	0,025	0,031	0,044	0,053	0,062	0,077	0,083	0,089	0,100	
	1	Ap max	0,06 x D	152	—	266	Fz	0,026	0,033	0,039	0,054	0,065	0,075	0,092	0,099	0,106	0,117	

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 >12mm diameter.

HARVI™ II Long • 3 x D and 5 x D • Application Data • Metric



3 x D Lengths of Cut



5 x D Lengths of Cut

Material Group				KCSM15A		Recommended feed per tooth (fz = mm/th) for side milling.									
				Cutting Speed — vc m/min			D1 — Diameter								
		ap	ae	Min	Max	mm	6,0	8,0	10,0	12,0	14,0	16,0	20,0	25,0	
P	0	ap max	0,05 x D	300	400	Fz	0,044	0,060	0,072	0,083	0,092	0,101	0,114	0,124	
	1	ap max	0,05 x D	300	400	Fz	0,044	0,060	0,072	0,083	0,092	0,101	0,114	0,124	
	2	ap max	0,05 x D	280	380	Fz	0,044	0,060	0,072	0,083	0,092	0,101	0,114	0,124	
	3	ap max	0,05 x D	240	320	Fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114	
	4	ap max	0,05 x D	180	300	Fz	0,033	0,045	0,054	0,062	0,070	0,077	0,088	0,098	
	5	ap max	0,05 x D	120	200	Fz	0,029	0,040	0,048	0,056	0,063	0,070	0,081	0,091	
M	6	ap max	0,05 x D	100	150	Fz	0,025	0,034	0,040	0,047	0,052	0,057	0,065	0,071	
	1	ap max	0,05 x D	180	230	Fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114	
	2	ap max	0,05 x D	120	160	Fz	0,029	0,040	0,048	0,056	0,063	0,070	0,081	0,091	
K	3	ap max	0,05 x D	120	140	Fz	0,025	0,034	0,040	0,047	0,052	0,057	0,065	0,071	
	1	ap max	0,05 x D	240	300	Fz	0,044	0,060	0,072	0,083	0,092	0,101	0,114	0,124	
	2	ap max	0,05 x D	220	280	Fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114	
S	3	ap max	0,05 x D	220	260	Fz	0,029	0,040	0,048	0,056	0,063	0,070	0,081	0,091	
	1	ap max	0,05 x D	100	180	Fz	0,036	0,050	0,061	0,070	0,079	0,087	0,101	0,114	
	2	ap max	0,05 x D	50	100	Fz	0,019	0,026	0,032	0,037	0,042	0,046	0,054	0,061	
	3	ap max	0,05 x D	50	80	Fz	0,019	0,026	0,032	0,037	0,042	0,046	0,054	0,061	
H	4	ap max	0,05 x D	100	120	Fz	0,026	0,037	0,045	0,052	0,058	0,064	0,074	0,084	
	1	ap max	0,05 x D	160	280	Fz	0,033	0,045	0,054	0,062	0,070	0,077	0,088	0,098	
	2	ap max	0,05 x D	140	240	Fz	0,025	0,034	0,040	0,047	0,052	0,057	0,065	0,071	

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 >12mm diameter.

Application Recommendation for Surface Profiling with HARVI™ III Ball Nose Series

Not all six cutting edges reach the center of the HARVI III series ball nose end mill. Due to this, certain tilt angles will engage different numbers of cutting edges and can alter the required cutting parameters. This will also be altered by the depths of cut, which will change the contact area and resulting number of edges engaged.

When surface profiling with any ball nose end mill, optimum performance will be achieved by tilting away from the center of the tool if possible. This is due to the fact that at the tip of the tool only the center cutting edges exist (two in the case of HARVI III series), and also the fact that the rotational velocity is zero in the center. Therefore, Kennametal recommends tilting the end mill to engage more cutting edges and avoid the zero-speed condition.

As the HARVI III series ball nose end mills do have two center cutting edges, it is possible to machine without tilting if the application requires this. Just factor in the reduced number of cutting edges into the cutting parameter calculations.



At the tip of the tool, only the center cutting edges exist.
The rotational velocity is zero in the center.



When surface profiling with any ball nose end mill, optimum performance will be achieved by tilting away from the center of the tool if possible.

HARVI III Ball Nose & HARVI III Taper Ball Nose



15°

For tilt angles less than 15° and shallow profiling depths, only two cutting edges will be typically engaged. As the end mill is tilted above this, the next two edges will engage.



22°

After reaching a tilt angle of at least 22°, then all six edges will at least be partially engaged.

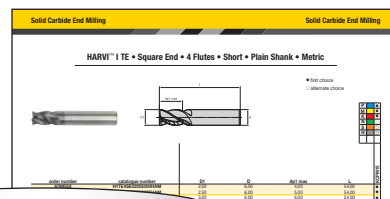


40°-45°

For maximum profiling performance, a tilt angle of 40°-45° will result in full engagement of all edges with a wide range of cutting depths.

HARVI™ • KOR™ • PCD • Catalog Numbering System

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.



H1TE4SE1200S016HAM

H1TE	4	SE	1200	S	016	HA			M
Series	Number of Flutes	Front End Style	Cutting Diameter D1	Flute Section Style	Length of Cut Ap1 max	Shank Style	Radius	Specific Features	Standard
H1TE = HARVI I TE HA2L = HARVI II Long HA3R = HARVI III HA3A = HARVI III Aero RSMF = RSM II KOR = KOR ALCB = Basic PCD end mill with carbide body ALCC = Complex PCD end mill carbide body ALCR = Roughing PCD end mill with carbide body ALSB = Basic PCD end mill with steel body ALSR = Basic PCD end mill with steel body	1 = 1-Flute 2 = 2-Flute 3 = 3-Flute 4 = 4-Flute 5 = 5-Flute 6 = 6-Flute 7 = 7-Flute 8 = 8-Flute 9 = 9-Flute M = Multi-flute	SE = Sharp Edge CH = Chamfer RA = Radius BN = Ball Nose TB = Taper Ball Nose TO = Torroid	Metric = D1 in mm Inch = D1 in decimal inch	N = Neck E = Extended Neck S = Short Without Neck R = Regular Without Neck L = Long Without Neck X = Extra Long Without Neck	Metric = Ap1 Max in mm Inch = Ap1 Max in decimal inch	HA = Plain HB = Weldon® SL = Safe-Lock™ DL = DUO-LOCK™		C = Chip Splitter I = Internal Coolant O = Coolant Grooves in Shank P = Polished Flutes	M = Metric Blank = Inch

Radius Metric	Radius Inch
R020 = 0,2mm	R010 = .010"
R025 = 0,25mm	R015 = .015"
R030 = 0,3mm	R030 = .030"
R040 = 0,4mm	R060 = .060"
R050 = 0,5mm	R090 = .090"
R075 = 0,75mm	R120 = .120"
R100 = 1,0mm	R160 = .160"
R125 = 1,25mm	R250 = .250"
R150 = 1,5mm	R190 = .190"
R200 = 2,0mm	R375 = .375"
R250 = 2,5mm	R045 = .045"
R300 = 3,0mm	
R400 = 4,0mm	
R500 = 5,0mm	
R600 = 6,0mm	

Holemaking

			wear resistance ← → toughness									
Coating	Grade Description			05	10	15	20	25	30	35	40	45
KCPK10		Composition: Advanced CVD TiCN-Al ₂ O 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 ₂ O ₃ coating combined with a tough carbide substrate. Application: First choice for 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									
			K									
KCU40		Composition: Multilayered PVD TiN-TiAlN coated submicron 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 universal grade it withstands interruptions and provides high wear resistance for long tool life. It covers steel, stainless steel, and cast iron.	P									
			M									
			K									
KCMS35		Composition: PVD AlTiN coated submicron grain carbide. Application: First choice for stainless steel, high-temp alloys, and long chipping steel. This grade combines superior edge toughness with good wear resistance for long tool life in long chipping materials.	P									
			M									
			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 a perfect choice for demanding machining conditions offering excellent tool life.	P									
			M									
KCMS40		Composition: PVD AlTiN coated medium grain carbide with high toughness. Application: Best suited for machining of stainless steel, high-temp alloys, and long chipping steel. The tough substrate combined with its smooth built-up edge reducing coating make it the perfect choice for long chipping materials and challenging applications.	P									
			M									
			S									
KCU10™		Composition: Multilayered PVD AlCrN-based coated submicron grain carbide with superior surface finish. Application: This grade is used for micro tooling. This grade can be applied in all material groups utilizing a versatile PVD coating. The coating surface is enhanced to improve chipflow and to prevent tool breakage.	P									
			M									
			K									
			N									
			S									
KCK10A		Composition: Multilayered PVD AlTiN-based coated submicron grain carbide with superior surface finish. Application: First choice for cast iron. This grade utilizes a newly developed coating combined with a state-of-the-art surface condition to offer extraordinary wear resistance in abrasive materials at elevated cutting conditions with improved performance consistency.										
			K									

Indexable Milling

Grades

Coating		Grade Description	wear resistance ← → toughness										
				05	10	15	20	25	30	35	40	45	
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										
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, reduces burrs, and generates excellent surface finishes. The grade is best suited for aluminum with <10% silicon and other non-ferrous materials.											
			N										
KC522M		Coated carbide grade with a AlTiN (PVD) coating. KC522M is engineered to provide better performance in general machining of steel, stainless steel, cast iron, and high-temperature alloys. KC522M resists breakage and offers improved wear resistance and increased strength.	P										
			M										
			K										
			S										
KC725M		Coated carbide grade with an advanced PVD TiAlN coating. KC725M is a high-performance grade for milling steel, stainless steel, and high-temperature alloys. 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										
KCK15		Coated carbide grade with CVD multilayer coating (TiN/MT TiCN/Al ₂ O 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										
KCPK30		Coated carbide grade with CVD multilayer (TiN/TiCN/Al ₂ O 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										
KCKP10		Submicron substrate with latest TiAlN/TiN coating technology (PVD). KCKP10 is highly wear-resistant grade. First choice for finishing and semi roughing of all cast iron materials, suitable for finishing of steel as well. This grade can be used dry or wet.	P										
			K										
KCK20B		Coated carbide grade with an advanced PVD TiAlN/TiN coating. Fine grained substrate combines high toughness and wear resistance for cast iron roughing and semi-roughing applications. High thermal shock resistance of the substrate and coating makes this grade ideal for wet and dry machining. First choice for roughing and challenging cutting conditions.											
			K										

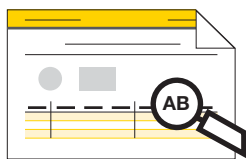
Indexable Milling

		wear resistance ← → toughness									
Coating		Grade Description									
			05	10	15	20	25	30	35	40	45
Grades	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							
Grades	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							
Grades	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							
Grades	KY3500		A ceramic cutting material based on micro-grain Si₃N₄ primarily for use in light to general machining of gray cast iron and ferritic ductile cast iron. Dry machining is recommended.								
				K							

Solid Carbide End Milling

		wear resistance ← → toughness									
Coating		Grade Description									
			05	10	15	20	25	30	35	40	45
Grade	KCSM15A		Composition: PVD AlCrN/TiSiN coated submicron grain carbide. Application: First choice for high-temperature alloys and stainless steel. The proprietary coating technology combines a high-hardness top layer with a stress-optimized base layer taking the wear resistance and performance reliability to the next level.								
				M							
				S							

Key to Product Table Column Headings



You may notice a slight change in the appearance of our product tables and specification charts. In this catalog, Kennametal introduces a set of short-name codes to improve the readability of tables and drawings. These codes replace full-text descriptions. The full list of codes and their definitions can be found below.

Short-Name Code	Full Text Description
Ap1 max	Maximum Cutting Depth
BS	Corner Facet Length
CS	Coolant Supply Size
D	Adaptor/Shank Diameter
D	Insert: Insert IC Size
D1	Insert: Insert Hole Size
D1	Holemaking: Drill Diameter
D1	Milling: Cutter Diameter
D1 max	Maximum Drill Diameter
D1 max	Maximum Cutting Diameter
D3	Neck Diameter
D4	Bolt Circle Diameter
D41	Bolt Circle 2 Diameter
D6	Hub Diameter
DPM	Pilot Diameter Machine Side
G3X	Connection Thread Size External
hm	Average Chip Thickness
KRA	Lead Angle
L	Overall Length
L1	Holemaking: Tool Length
L1	Milling: Gage Length
L10	Insert Cutting Edge Length
L2	Milling: Head Length
L3	Drill Flute Length
L3	Milling: Maximum Depth
L4 max	Maximum Drill Depth
L5	Drill Point Length
lbs	Weight Pounds
LS	Shank Length
max RPM	Maximum Revolutions Per Minute
R _c	Corner Radius
R	Profile or Ball Nose Radii
S	Insert Thickness
W	Cutting Edge Width or Slot Width
WF	Milling: Width of Flat
Z	Number of Inserts

P	Steel
M	Stainless Steel
K	Cast Iron

N	Non-Ferrous
S	High-Temp Alloys

H	Hardened Materials
C	CFRP Materials

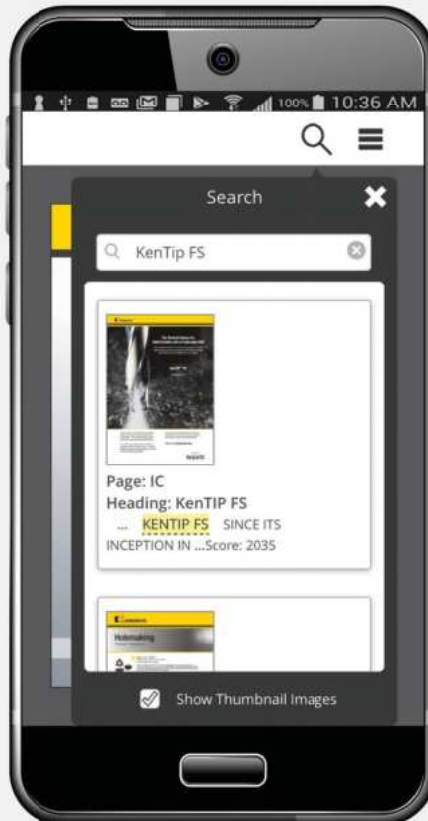
material group	description	content	tensile strength RM (MPa)*	hardness (HB)	hardness (HRC)	material number
P0	Low-Carbon Steels, Long Chipping	C <0,25%	<530	<125	–	–
P1	Low-Carbon Steels, Short Chipping, Free Machining	C <0,25%	<530	<125	–	C15, Ck22, ST37-2, S235JR, 9SMnPb28, GS38
P2	Medium- and High-Carbon Steels	C >0,25%	>530	<220	<25	ST52, S355JR, C35, GS60, Cf53
P3	Alloy Steels and Tool Steels	C >0,25%	600–850	<330	<35	16MnCr5, Ck45, 21CrMoV5-7, 38SMn28
P4	Alloy Steels and Tool Steels	C >0,25%	850–1400	340–450	35–48	100Cr6, 30CrNiMo8, 42CrMo4, C70W2, S6525, X120Mn12
P5	Ferritic, Martensitic, and PH Stainless Steels	–	600–900	<330	<35	100Cr6, 30CrNiMo8, 42CrMo4, C70W2, S6525, X120Mn12
P6	High-Strength Ferritic, Martensitic, and PH Stainless Steels	–	900–1350	350–450	35–48	X102CrMo17, G-X120Cr29
M1	Austenitic Stainless Steel	–	<600	130–200	–	X5CrNi 18 10, X2CrNiMo 17 13 2, G-X25CrNiSi18 9, X15CrNiSi 20 12
M2	High-Strength Austenitic Stainless and Cast Stainless Steels	–	600–800	150–230	<25	X2CrNiMo 13 4, X5NiCr 32 21, X5CrNiNb 18 10, G-X15CrNi 25-20
M3	Duplex Stainless Steel	–	<800	135–275	<30	X8CrNiMo27 5, X2CrNiMoN22 5 3, X20CrNiSi25 4, G-X40CrNiSi27 4
K1	Grey Cast Iron	–	125–500	120–290	<32	GG15, GG25, GG30, GG40, GTW40
K2	Low- and Medium-Strength Ductile Irons (Nodular Irons) and Compacted Graphite Irons (CGI)	–	<600	130–260	<28	GGG40, GTS35
K3	High-Strength Ductile Irons and Austempered Ductile Iron (ADI)	–	>600	180–350	<43	GGG60, GTW55, GTS65
N1	Wrought Aluminum	–	–	–	–	AlMg1, Al99.5, AlCuMg1, AlCuBiPb, AlMgSi1, AlMgSiPb
N2	Low-Silicon Aluminum Alloys and Magnesium Alloys	Si <12,2%	–	–	–	GAISIcu4, GDAISI10Mg
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	–	–	–	–	–

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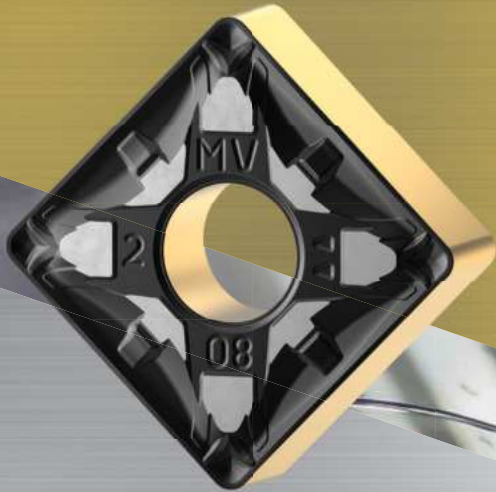


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METALCUTTING SAFETY

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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