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KENNAMETAL®

MASTER CATALOGUE 2018

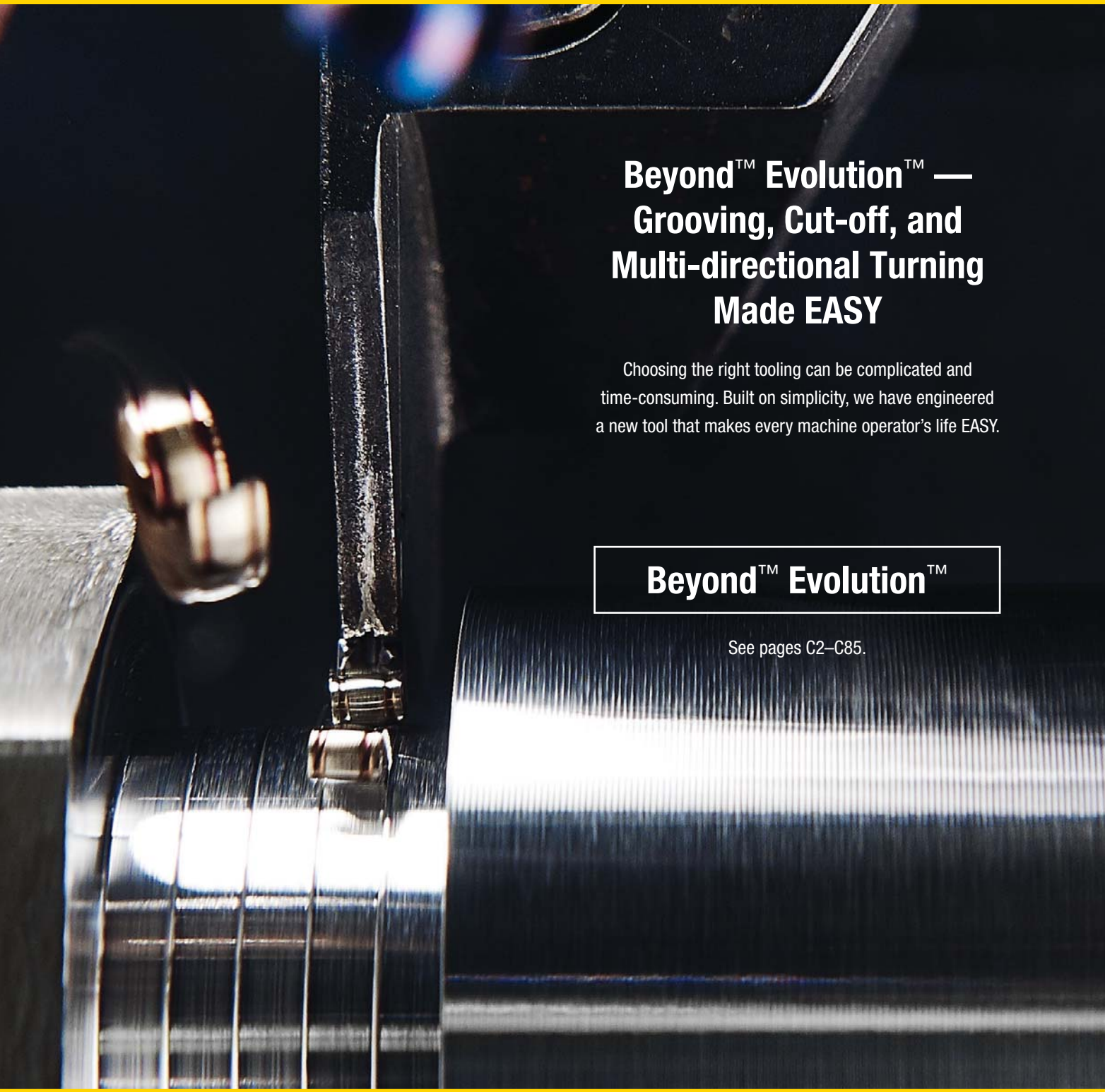
VOLUME ONE | **TURNING** TOOLS





ISO TURNING | GROOVING & CUT-OFF | THREADING | APPLICATION SPECIFIC

KENNAMETAL



Beyond™ Evolution™ — Grooving, Cut-off, and Multi-directional Turning Made EASY

Choosing the right tooling can be complicated and time-consuming. Built on simplicity, we have engineered a new tool that makes every machine operator's life EASY.

Beyond™ Evolution™

See pages C2–C85.

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

These 900+ pages bring you the latest in turning products and superior services — specifically engineered to enhance overall productivity, even in the most challenging metalworking applications.

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

Visit us at **kennametal.com**.

POWERED BY NOVO™

Volume I • Turning Tools

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

Turning Tools

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Turning

PRODUCT HIGHLIGHTS

BEYOND™ EVOLUTION™

See section C for more details.

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

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



beyond™ EVOLUTION™

BEYOND™ DRIVE™

See section B for more details.

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



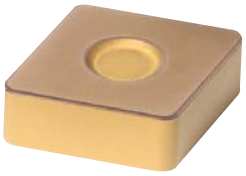
beyond™ DRIVE™



CAST IRON TURNING WITH KBK45™

See section B for more details.

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



HARD TURNING WITH KBH20™

See section B for more details.

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

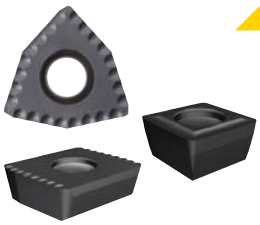
KBH20 grade is a new substrate for applications like case-hardened components, including gears, shafts, and other drive-train components.

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



Holemaking

PRODUCT HIGHLIGHTS



DRILL FIX™ DFSP™

INDEXABLE DRILLS WITH DS AND LP INSERTS

See section J (Volume II) for more details.

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

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

KENTIP™ FS

THE PERFECT FUSION OF A SOLID CARBIDE AND AN INDEXABLE DRILL

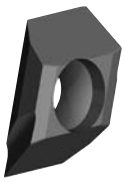
See section H (Volume II) for more details.

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

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







COUNTERFIX MICRO

SMALL INSERTS THAT MAKE A BIG DIFFERENCE!

See section H (Volume II) for more details.

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

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

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

NEW SGL DRILLS WITH THROUGH COOLANT FOR STAINLESS STEEL

See section G (Volume II) for more details.

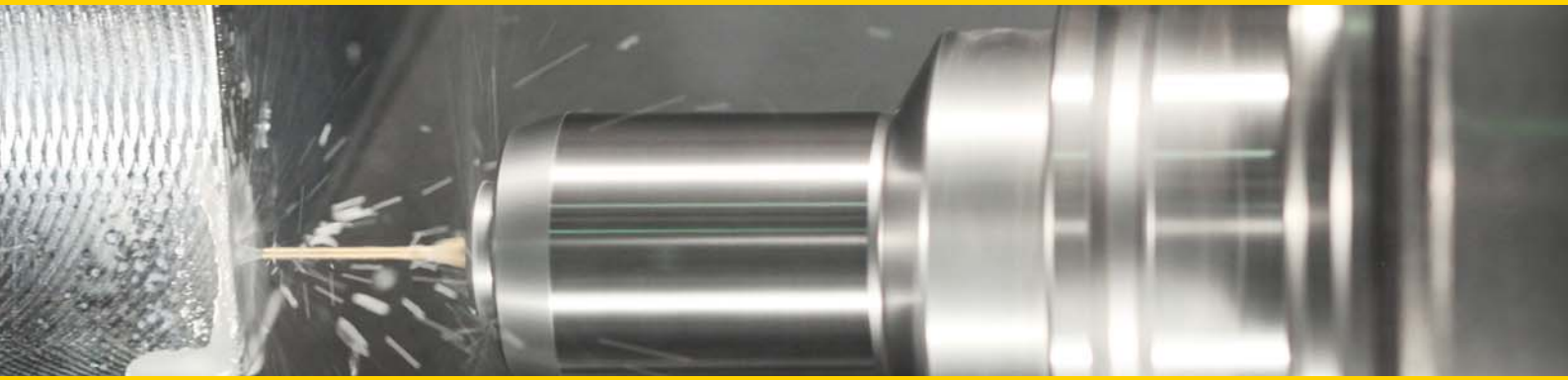
The all-new B21_SGL series solid carbide drills are designed specifically for stainless steel applications, offering high performance and long tool life in high-temperature alloys and regular steel, also.

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

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









NEW KMH DRILLS FOR HARD MATERIALS

See section G (Volume II) for more details.

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

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



RMR™ AND RHR™ DISC-STYLE REAMERS

See section K (Volume II) for more details.

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

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



GOTAP™

MULTIPURPOSE HSS-E TAPS

See section M (Volume II) for more details.

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

Solid End Milling

PRODUCT HIGHLIGHTS

DUO-λOCK®

See section O (Volume II) for more details.

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

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



DUO-λOCK®
by HAIMER® and Kennametal



HARVI™ III FAMILY

See section P (Volume II) for more details.

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

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

beyond™



BEYOND™ EADE SOLID CERAMIC END MILLS

See section P (Volume II) for more details.

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

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



beyond



GOMILL™ GP PLATFORM

See section Q (Volume II) for more details.

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

— Roughing and finishing with one tool.

— Excellent cost-benefit ratio.

— Multilayer KC633M™ grades for longer tool life.

Indexable Milling

PRODUCT HIGHLIGHTS

MILL 4-11™ AND MILL 4-15™

See section T (Volume II) for more details.

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

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





MILL 16™

See section S (Volume II) for more details.

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



KCSM40™

NEW MILLING GRADE FOR TITANIUM MACHINING

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

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





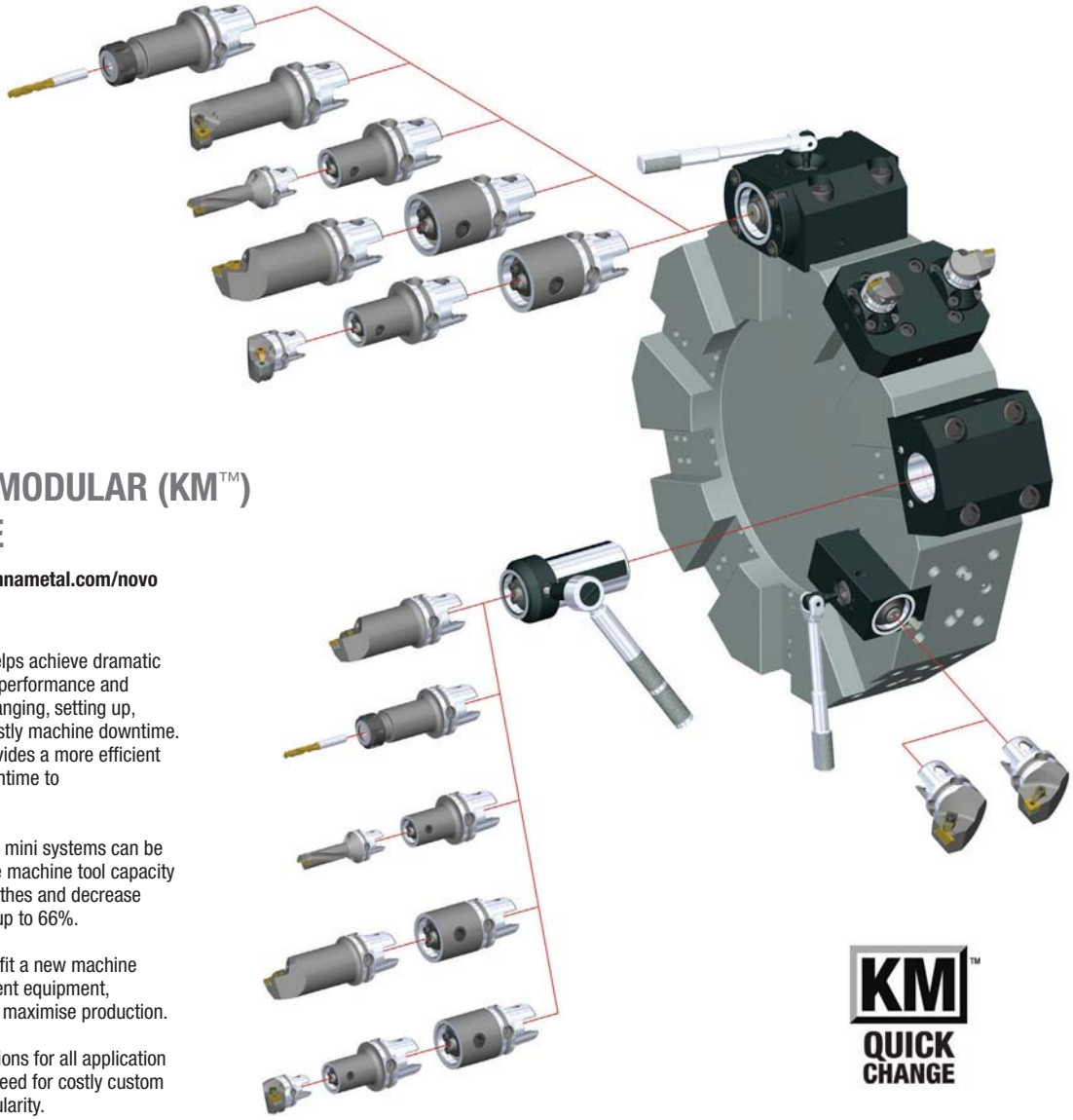
STELLRAM® 7792VX HIGH-FEED SERIES

See section V (Volume II) for more details.

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

Tooling Systems

PRODUCT HIGHLIGHTS



KENNAMETAL MODULAR (KM™) QUICK CHANGE

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

KM™ quick-change tooling helps achieve dramatic improvements in cutting tool performance and machine output. Frequent changing, setting up, and gaging of tools create costly machine downtime. KM quick-change tooling provides a more efficient process that can reduce downtime to increase productivity.

In addition, KM micro and KM mini systems can be used to considerably increase machine tool capacity on automatic and universal lathes and decrease indexing and setup times by up to 66%.

Whether you're looking to outfit a new machine or improve the output of current equipment, KM quick-change tooling can maximise production.

The KM portfolio includes options for all application requirements and limits the need for costly custom solutions due to system modularity.

KM™ QUICK CHANGE



KM4X™

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

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

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





DRIVEN TOOLING AND STATIC TOOL BLOCKS

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

Turn your CNC lathe into a multi-task solution provider with turret-adapted driven clamping units for rotating applications and static tool blocks for maximum quick change flexibility. Whether it's for milling, drilling, tapping, boring, or non-rotating applications, you can maximise machine utilisation by employing Kennametal tooling and solutions. Available in multiple KM™ format sizes to allow for versatility and productivity.

- 0 and 90° options available as standard.
- Up to 12,000 RPM speeds for high metal removal rates.
- 1:1 and 1:2 gear ratios available for added speed or torque.
- Standard configurations for multiple manufactures and customisable to fit most turrets.
- Quick change solutions for static and rotating applications to maximise machine effectiveness.

TUNABLE BORING

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

Kennametal tunable boring bars can increase productivity and solve chatter and other issues in long-boring operations.

Several key improvements to our current tunable boring bar portfolio include:

- Enhanced tuning process at the manufacturing plant ensures accurate tuning at the maximum overhang.
- Nitriding of steel tunable boring bars eliminates the effects of chip wash.
- Elimination of flats on tunable boring bars enhances stability and proper toolholding.
- Addition of a small flat on the connection collar enables the use of a centre-height tool.
- Enhanced assembly process.



Kennametal on the Web

kennametal.com

FIND THE LATEST PRODUCT INFORMATION

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

Find information about our most current campaigns and catalogues.

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



CONTACT US

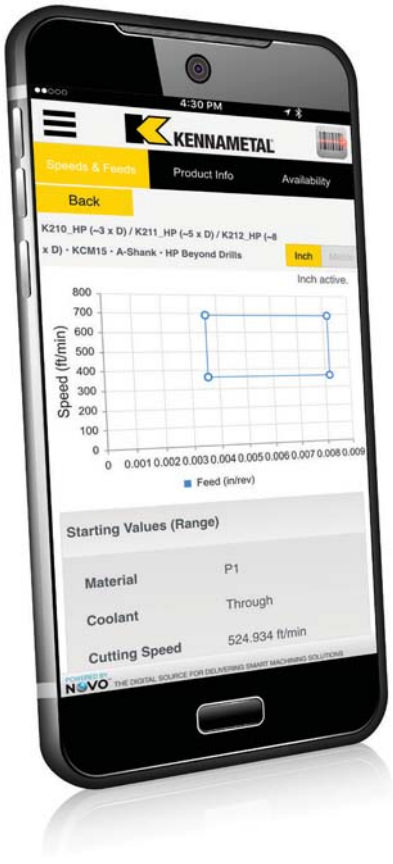
Our customers are important to us. We want to provide you the best customer service in the industry. If you have a comment or question, please send it to us. We strive to respond to all inquiries within 24 hours.

FIND A LOCAL AUTHORISED DISTRIBUTOR IN YOUR AREA

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

Mobile App

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



FEATURES

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

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

View product availability at global locations.

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

View tech tips for helpful solutions to common machining questions.

Contact Customer Support directly from the app.

MACHINING CALCULATORS

View data for milling and drilling applications.

Inch and metric values calculated.

ORDERING

Login using your Konnect credentials to complete a purchase.

WHERE TO FIND IT

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

ANDROID APP ON Google play

Available on the App Store

Service and Support

Customer Application Support (CAS)

Get Fast and Reliable Answers to Your Toughest Metalcutting Problems

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

Easy Access to Proven Metalworking Expertise!

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

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



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New Zealand	English	0800 450 941	ap-kmt.techsupport@kennametal.com
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Poland	Polish	0080 04411887	eu.techsupport@kennametal.com
Russia (landline)	Russian	8800 5556394	eu.techsupport@kennametal.com
Russia (cell phone)	Russian	+7 8005556394	eu.techsupport@kennametal.com
Singapore	English	1800 6221031	ap-kmt.techsupport@kennametal.com
South Africa	English	0800 981643	na.techsupport@kennametal.com
Sweden	English	020799246	na.techsupport@kennametal.com
Taiwan	English	0800 666 197	ap-kmt.techsupport@kennametal.com
Thailand	English	1800 4417820	ap-kmt.techsupport@kennametal.com
UK	English	0800 032 8339	na.techsupport@kennametal.com
Ukraine	Russian	0800502664	eu.techsupport@kennametal.com
USA	English	800 835 3668	na.techsupport@kennametal.com

Numbers shown only serve the originating country listed.

NOVO KNOWS SEARCH

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

ADVISE

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

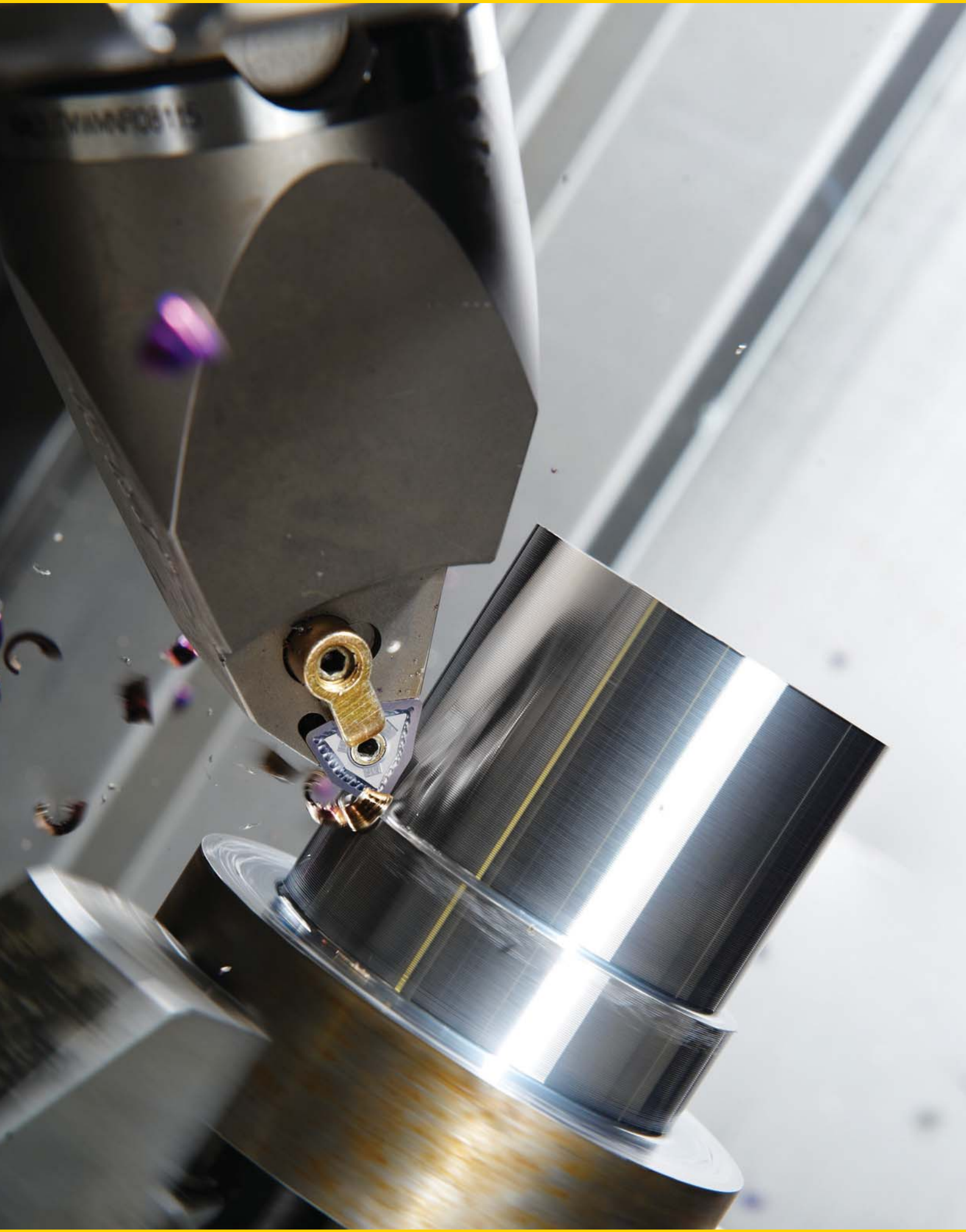
- Define Machining Feature (face milling, slotting, blind hole, etc.)
- Apply Constraint Requirements (geometric, material, tolerance, etc.)
- Set Machining Sequence (single or multi-step operations, rough then finish, etc.)
- Receive Ranked Results

SELECT

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

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

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



Turning

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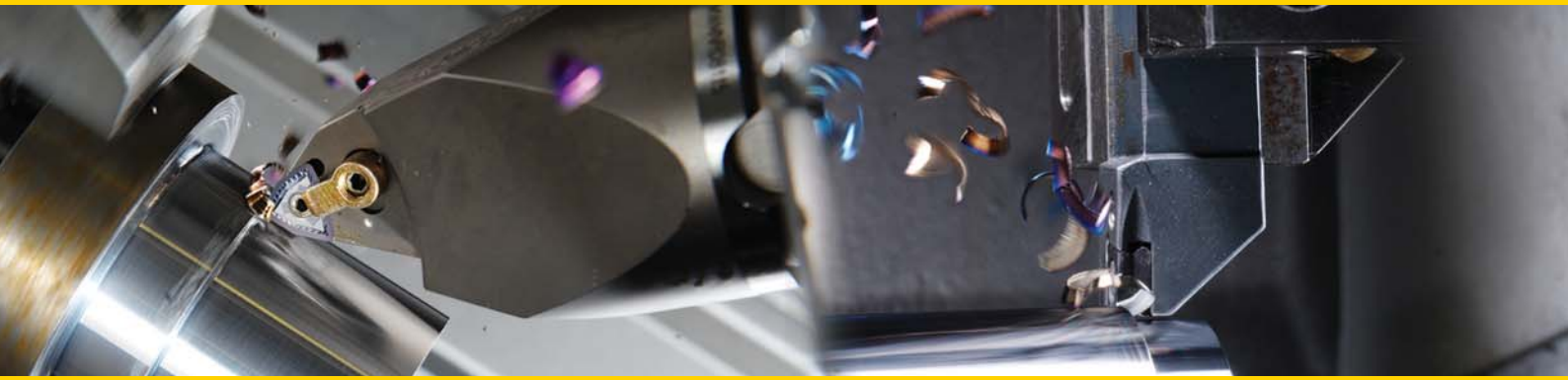
Threading..... D1–D110

Application Specific..... E1–E65



Turning Products

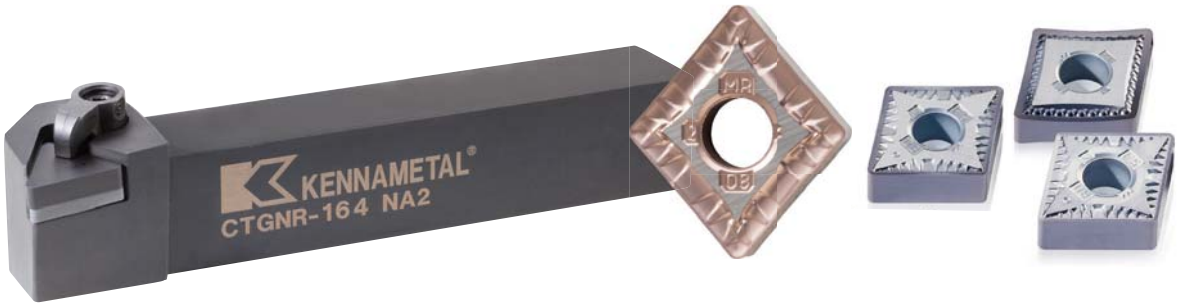
Our latest Metalcutting Innovations are designed to deliver higher productivity, longer tool life, and increased application versatility.

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

ISO TURNING

See Section B for more details.

- Negative-style inserts.
- Toolholders, boring bars, cartridges, and bolt-on heads for negative-style inserts.
- Positive-style inserts.
- Toolholders, boring bars, cartridges, and bolt-on heads for positive-style inserts.
- Advanced material inserts for machining:
  - — Cast iron
  - — Hardened steels
  - — High-temperature alloys
- PCD inserts.
- Toolholders, boring bars, cartridges, and bolt-on heads for use with advanced material inserts.
- Tunable bars.



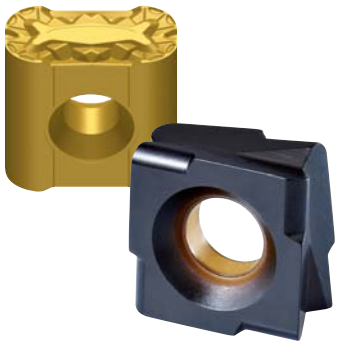


THREADING, GROOVING, AND CUT-OFF

See Sections C and D for more details.

- Beyond™ Evolution™ Grooving, Cut-Off, and Side Turning
- A4™ Grooving and Side Turning
- Top Notch™ Grooving
- Top Notch Threading
- Laydown Threading





APPLICATION SPECIFIC

See Section E for more details.

- Fix-Perfect™ Turning
- Top Notch Profiling
- Tools for Railroad and Wheel Machining
- K-Lock™





ISO Turning

Kennametal Insert Selection System **B2–B21**

Kennametal Grades and Grade Descriptions/Application Areas **B22–B29**

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- Advanced Materials for Cast Iron Machining B278–B300
- Advanced Materials for Hard Turning B302–B324
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Tunable Bars **B380–B387**

Mobile Apps

The Kennametal mobile app provides easy access to product information and calculators on both iPhone® and Android™ devices. We've highlighted a few of the key features...

There's an app for that.

SPEEDS & FEEDS

View speeds and feeds information for metalworking products.

PRODUCT AVAILABILITY

Check global availability of products. View available quantities by providing your Konnect login credentials.

CALCULATORS

Utilise our machining calculators for milling and drilling applications.



By just scanning the bar code on the insert packet, you can find the most productive cutting conditions for tool life, process time, and chip control.

NOTE: The app is currently only available in the English-language version. We have plans to translate the app in different languages with future releases.

Google play | Available on the App Store

ISO Turning Inserts, Toolholders, and Boring Bars

Modern CNC machines and flexible production facilities require tools with application versatility. Kennametal high-performance inserts, toolholders, and boring bars are designed to handle any turning application. Whether you're cutting steel or titanium, or doing light finishing or heavy roughing, we have the tooling solution to meet your needs.

Features and Benefits

Beyond™ Drive™ Inserts

- Designed for increased productivity.
- Post-coat treatment reduces stress, improves coating adhesion.
- Excellent toughness and wear resistance.
- Better insert wear detection.

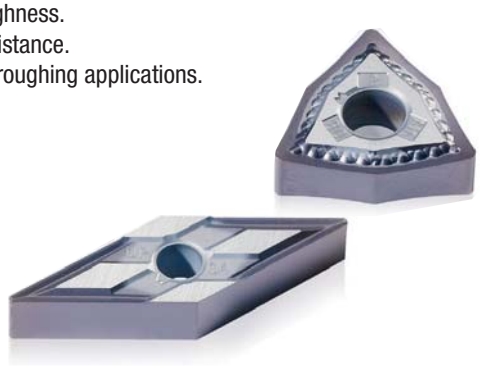
Beyond™ PVD Grades

KCU10™ Grade

- Superior wear resistance and faster cutting speeds at higher temperatures.
- Ideal for stainless steels and high-temp alloys.
- Improved depth-of-cut notch resistance.
- Use in finishing to medium applications.

KCU25™ Grade

- Superior edge toughness.
- Excellent wear resistance.
- Use in medium to roughing applications.



Kennametal Turning Solutions by Material

P	Steel	Carbide or Cermet Inserts
M	Stainless Steel	Carbide Inserts
K	Cast Iron	Carbide, Ceramic, or PcBN Inserts
N	Non-Ferrous	Carbide or PCD Inserts
S	High-Temp Alloys	Carbide, Ceramic, PcBN, or PCD Inserts
H	Hardened Materials	Ceramic or PcBN Inserts

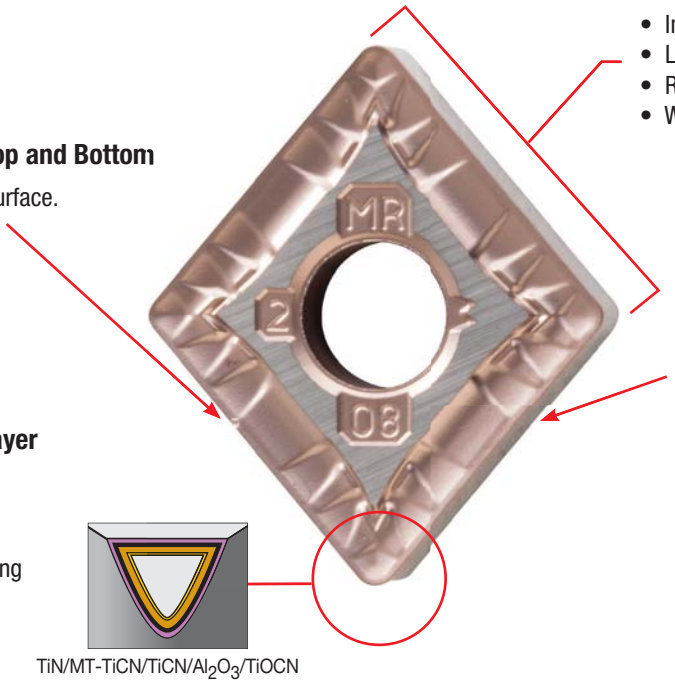
Beyond™ Drive™ Inserts • Technology Details

Post-Coat Treatment

- Improves edge toughness.
- Long predictable tool life.
- Reduces depth-of-cut notching.
- Wide range of applications.

Post-Coat Grinding — Top and Bottom

- Provides secure seating surface.



Micro-Polished Edges

- Improves edge toughness.
- Provides smooth outer surface to reduce forces, friction, and workpiece sticking.

Fine-Grained Alumina Layer

- Provides coating integrity at elevated speeds.
- Higher productivity and dependability at high-cutting temperatures.

TiN/MT-TiCN/TiCN/Al_2O_3/TiOCN

Toolholders, Boring Bars, and Cartridges



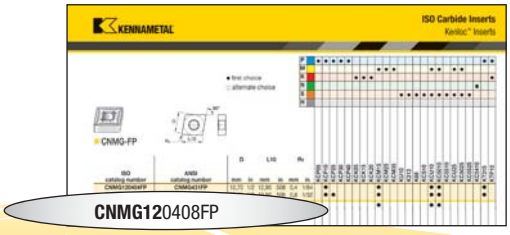






How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



C — Insert Shape

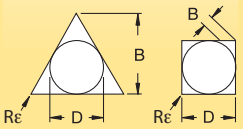
H	Hexagon	120°
O	Octagon	135°
P	Pentagon	108°
R	Round	—
S	Square	90°
T	Triangular	60°
C	Rhomboid	80°
D		55°
E		75°
M		86°
V		35°
W	Trigon	80° with enlarged corner angles
L	Rectangular	90°
A	Parallelogram	85°
B		82°
N/K		55°

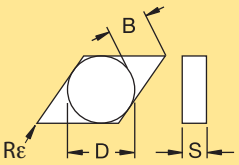
N — Insert Clearance Angle

A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Indicated for other clearance angles requiring descriptions.

M — Tolerance Class

Tolerances apply prior to edge prep and coating





D = Theoretical diameter of the insert inscribed circle
S = Thickness
B = See figures below

G — Insert Features

N	
R	
F	
A	
M	
G	
W	
T	
Q	
U	
B	
H	
C	
J	
X	Special Design

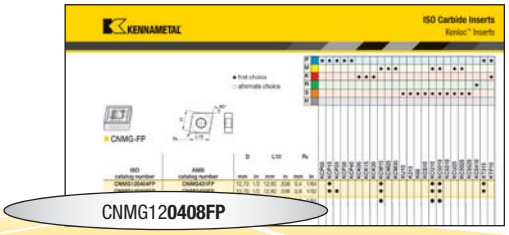
12 — Size

Code for inch cutting edge length "L10"

"D" mm	C	D	R	S	T	V	W
3,97	S4	04	03	03	06	—	—
4,76	04	05	04	04	08	08	S3
5,56	05	06	05	05	09	09	03
6,00	—	—	06	—	—	—	—
6,35	06	07	06	06	11	11	04
7,94	08	09	07	07	13	13	05
8,00	—	—	08	—	—	—	—
9,52	09	11	09	09	16	16	06
10,00	—	—	10	—	—	—	—
11,11	11	13	11	11	19	19	07
12,00	—	—	12	—	—	—	—
12,70	12	15	12	12	22	22	08
14,29	14	17	14	14	24	24	09
15,88	16	19	15	15	27	27	10
16,00	—	—	16	—	—	—	—
17,46	17	21	17	17	30	30	11
19,05	19	23	19	19	33	33	13
20,00	—	—	20	—	—	—	—
22,22	22	27	22	22	38	38	15
25,00	—	—	25	—	—	—	—
25,40	25	31	25	25	44	44	17
31,75	32	38	31	31	54	54	21
32,00	—	—	32	—	—	—	—

tolerance class	tolerance on "D"	tolerance on "B"	tolerance on "S"
C	±0,025	±0,013	±0,025
H	±0,013	±0,013	±0,025
E	±0,025	±0,025	±0,025
G	±0,025	±0,025	±0,013
M	See tables on next page		±0,013
U	See tables on next page		±0,013

By referencing this easy-to-use guide, you can identify the correct product to meet your needs.



04	08			FP
Thickness S	Corner Radius "Rε"	Hand of Insert *(optional)*	Cutting Edge *(optional)*	Chipbreaker *(optional)*

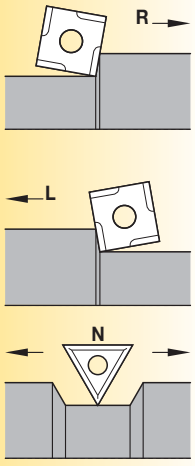
symbol	thickness
mm	mm
—	0,79
T0	1,00
01	1,59
T1	1,98
02	2,38
03	3,18
T3	3,97
04	4,76
05	5,56
06	6,35
07	7,94
9	9,52
11	11,11
12	12,70

symbol	corner radius
mm	mm
X0	0,04
01	0,1
02	0,2
04	0,4
08	0,8
12	1,2
16	1,6
20	2,0
24	2,4
28	2,8
32	3,2
00	round insert
M0	round insert
—	round insert

R = Right hand

L = Left hand

N = Neutral



F	Sharp
E	Rounded
T	Chamfered
S	Chamfered and Rounded
K	Double-Chamfered
P	Double-Chamfered and Rounded

F	=	Sharp
FF	=	Fine Finishing
FN	=	Finishing Negative
MN	=	Medium Negative
MR	=	Medium Roughing
RN	=	Roughing Negative
UN	=	Universal Medium
FP	=	Finishing Positive
MP	=	Medium Positive
RP	=	Roughing Positive
RM	=	Roughing Medium
RH	=	Roughing Heavy
FW	=	Finishing Wiper
MW	=	Medium Wiper
FS	=	Finishing Sharp
MS	=	Medium Sharp
RW	=	Roughing Wiper
HP	=	High Positive
UP	=	Universal Positive
K	=	Light-Feed Chip Control
UF	=	Ultra-Fine Finishing
LF	=	Light Finishing
MF	=	Medium Finishing
E	=	Hone Only
T	=	Negative Land
S	=	Negative Land Plus Hone
MP-K	=	Medium Positive
MG-P	=	Medium Positive

	± Tolerance on "D"				± Tolerance on "B"			
	Class M Tolerance			Class U Tolerance	Class M Tolerance			Class U Tolerance
"D"	Shapes S, T, C, R, & W	Shape D	Shape V	Shapes S, T, & C	Shapes S, T, C, R, & W	Shape D	Shape V	Shapes S, T, & C
mm	mm	mm	mm	mm	mm	mm	mm	mm
3,97	0,05	–	–	–	0,08	–	–	–
4,76	0,05	–	–	0,08	0,08	–	–	0,13
5,56	0,05	0,05	0,05	0,08	0,08	0,11	–	0,13
6,35	0,05	0,05	0,05	0,08	0,08	0,11	–	0,13
7,94	0,05	0,05	0,05	0,08	0,08	0,11	–	0,13
9,52	0,05	0,05	0,05	0,08	0,08	0,11	0,18	0,13
11,11	0,08	0,08	0,08	0,13	0,13	0,15	–	–
12,70	0,08	0,08	0,08	0,13	0,13	0,15	0,25	0,20
14,29	0,08	0,08	0,08	0,13	0,13	0,15	–	–
15,88	0,10	0,10	0,10	0,18	0,15	0,18	–	0,27
17,46	0,10	0,10	0,10	0,18	0,15	0,18	–	0,27
19,05	0,10	0,10	0,10	0,18	0,15	0,18	–	0,27
22,22	0,13	–	–	0,25	0,15	–	–	0,38
25,40	0,13	–	–	0,25	0,18	–	–	0,38
31,75	0,15	–	–	0,25	0,20	–	–	0,38

A system of grades, geometries, and application guidelines to provide optimal solutions for your metalcutting needs. It's easy to determine which Kennametal chip-control cutting tool will work best in your specific workpiece materials and applications!

Grade • Beyond™ • Beyond™ Drive™

K	C	P	M	25	B
Brand	Insert Material	Primary Workpiece Material *(ISO 513)*	Secondary Workpiece Material *(optional)*	Application Range	Future Upgrades *(optional)*

K = Kennametal

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

Blank	=	Carbide, uncoated
C	=	Carbide, coated
T	=	Cermet
Y	=	Ceramic
D	=	PCD
B	=	PcBN

Hardest

5	fine finishing
10	finishing
15 **20**	medium to roughing
25 **30** **35**	roughing
40 **45** **50**	heaviest roughing

Toughest

B	=	Beyond™ Drive™
C	=	Generation 3

etc.

NOTE: Application range does not apply to PcBN grades.

Positive Inserts



Screw-On Inserts

- Screw-On inserts are your first choice for I.D. turning of all materials and O.D. turning on small to medium lathes.
- Available in flat-top and chip-control geometries with both moulded and ground peripheries. Suitable for all workpiece materials.

See pages:
Carbide: B175–B273
Advanced Materials: B284–B351



Kendex™ and V-Bottom Inserts

- Kendex positive and V-bottom inserts are your first choice for productive machining of high-temperature alloys on medium to large lathes.
- Available in flat-top geometries with ground periphery.

See pages:
Carbide: B166–B168
Advanced Materials: B284–B351



Top Notch™ Profiling Inserts

- First choice for high-production profiling.
- Unique insert clamping design offers superior rigidity.
- Available in chip-control geometries with both moulded and ground peripheries. Suitable for all workpiece materials.

See pages E20–E43 for product listing.



K-Lock™ Inserts

- K-Lock inserts are ideal for deep grooving and profiling.
- A unique insert clamping system allows for unimpeded chip flow.
- Available in moulded and ground peripheries.

See page E62–E65 for product listing.

Negative Inserts



Kenloc™ Inserts

- Kenloc inserts are your first choice for general machining of all materials on medium to large lathes.
- Kenloc inserts offer the best economy for high metal removal rates.
- Available in flat-top and chip-control geometries with both moulded and ground peripheries. Suitable for all workpiece materials.

See pages:
Carbide: B46–B165
Advanced Materials: B284–B351



Kendex Inserts

- Ceramic Kendex inserts are a great choice for productive machining of high-temp alloys.
- Kendex negative rake inserts are also recommended for the machining of hardened materials and cast irons.
- Available in flat-top geometries with moulded and ground peripheries.
- Wide selection of standard toolholders are offered.

See pages B284–B351 for product listing.



Top Notch Turning Inserts

- Ceramic Top Notch turning inserts are your first choice for high-speed roughing and finishing of cast iron parts.
- Available in flat-top geometries with moulded and ground peripheries.

See pages B284–B351 for product listing.



Fix-Perfect™ Inserts

- Tangential design and rigid clamping system.

See pages E2–E18 for product listing.



Railroad Inserts

- Designed for the machining of railway wheels and axles.

See pages E44–E61 for product listing.

Insert Selection System

How to Use

The Kennametal three-step insert selection system makes choosing and applying the most productive tool as easy as 1, 2, 3. Tool recommendations are based on six workpiece material groups, optimising selection accuracy.

Example:
Six workpiece material groups

Step 1 • Select the insert geometry

Given: depths of cut = 1mm
feed = 0,4mm
Unknown: insert geometry
Solution: -MN

Step 2 • Select the grade

Given: cutting conditions:
lightly interrupted cut



Geometry: -MN
Unknown: grade
Solution: KCP25B

Step 3 • Select the cutting speed

Given: grade KCP25B
cutting conditions



material CK15
Unknown: cutting speed
Solution: 280 m/min

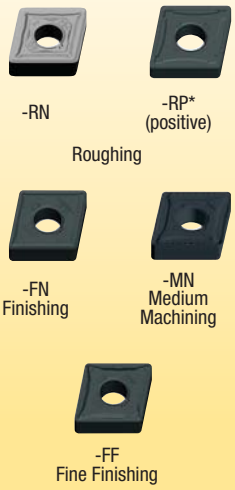
Need help in selecting a product?
Additional information can be obtained by contacting
The Kennametal Customer Application Support Team.
Go to kennametal.com for your country's phone number.

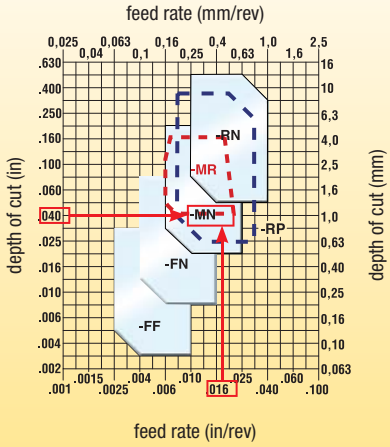
Step 1 • Select the insert geometry

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

beyond™ beyond™ DRIVE™

Negative Inserts





*-RP – Supplemental geometry for high-strength materials

Step 2 • Select the grade

cutting condition	-FF	-FN	-MN	-RN	-RP	-11	-UF	-LF	-FP	-MF	-MP
heavily interrupted cut	KCP10B/ KCP10	KCP25B/ KCP25	KCP30B/ KCP30	KCP30B/ KCP30/ KCP40B/ KCP40	KCP30B/ KCP30/ KCP40B/ KCP40	–	KCU10/ KCP25B/ KCP25	KCP25B/ KCP25	KCU25/ KCP25B/ KCP25	KCP40B/ KCP40B	KCP40B/ KCP40B
lightly interrupted cut	KCP10B/ KCP10	KCP25B/ KCP25	KCP25B/ KCP25	KCP30B/ KCP30/ KCP40B/ KCP40	KCP30B/ KCP30/ KCP40B/ KCP40	–	KCU10/ KCP25B/ KCP25	KCP25B/ KCP25	KCP25B/ KCP25	KCP25B/ KCP25	KCP25B/ KCP25
varying depth of cut, casting, or forging skin	KCP05B/ KCP05/ KT315	KCP10B/ KCP10	KCP10B/ KCP10	KCP30B/ KCP30/ KCP40B/ KCP40	KCP30B/ KCP30/ KCP40B/ KCP40	KT315	KCP10B/ KCP10	KCP10B/ KCP10	KCP10B/ KCP10	KCP10B/ KCP10	KCP10B/ KCP10

Step 3 • Selecting the cutting speed

Low-Carbon (<0,3% C) and Free-Machining Steel — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	135 (450)	180 (600)	225 (800)	275 (900)	320 (1050)	360 (1200)	410 (1350)	455 (1500)	495 (1650)	m/min	SFM
P1	KCP05B/KCP05/KTP10							◁▷			435	1450
	KCP10B/KCP10							◁▷			395	1320
	KCP25B/KCP25				◁▷						275	925
	KCP30B/KCP30/KCP40B/KCP40			◁▷							210	700

New Beyond™ Material Group Selection Guide:

To optimise speed recommendations, Beyond material subgroups have been added to each of the six workpiece material groups.

material	material group ISO code	number of material subgroups
steel	P	1–6
stainless steel	M	1–3
cast iron	K	1–3
non-ferrous materials	N	1–8
high-temp alloys	S	1–4
hardened materials	H	1

Step 1 • Select the insert geometry

Negative Wiper Inserts



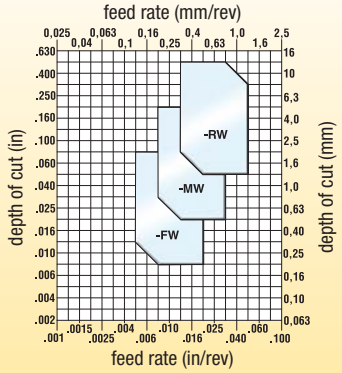
-RW
Rough Wiper



-MW
Medium Wiper



-FW
Finishing Wiper



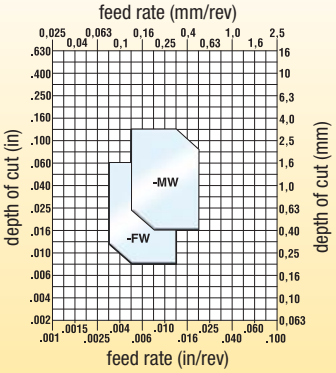
Positive Wiper Inserts



-MW
Medium Wiper



-FW
Finishing Wiper



Step 2 • Select the grade

cutting condition		Negative Insert Geometry -FW	-MW	-RW	Positive Insert Geometry -FW	-MW
heavily interrupted cut		–	–	KCP25B/KCP25	–	KCP25B/KCP25
lightly interrupted cut		KCP10B/KCP10	KCP25B/KCP25	KCP25B/KCP25	KCP25B/KCP25	KCP25B/KCP25
varying depth of cut, casting, or forging skin		KCP05B/KCP05/ KT315	KCP10B/KCP10	KCP10B/KCP10	KCP10B/KCP10/ KCK20B/KCK20	KCP10B/KCP10
smooth cut, pre-turned surface		KCP05B/KCP05/ KT315	KCP05B/KCP05	KCP10B/KCP10	KCP10B/KCP10/ KT315	KT315

Step 1 • Select the insert geometry

Negative Inserts



-RN



-RP*
(positive)



-MR
Medium
Roughing



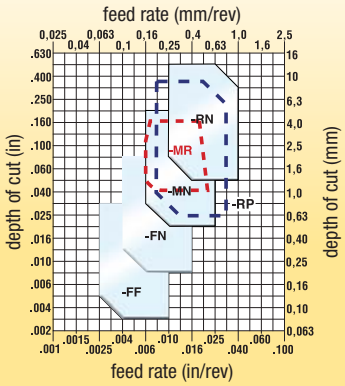
-MN
Medium
Machining



-FN
Finishing



-FF
Fine Finishing



*-RP – Supplemental geometry for high-strength materials

Positive Inserts



-MF



-MP
Positive

Medium Machining



-LF



-FP
Positive

Finishing

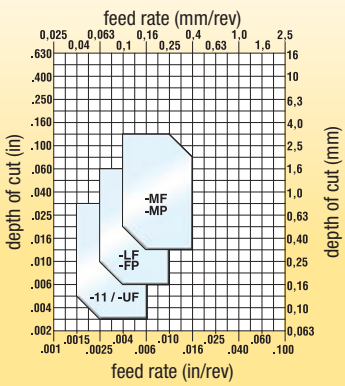


-11



-UF

Fine Finishing



Step 2 • Select the grade

cutting condition		Negative Insert Geometry -FF	-FN	-MN	-MR	-RN	-RP	-11	Positive Insert Geometry -UF	-LF	-FP	-MF	-MP
heavily interrupted cut		KCP10B/ KCP10	KCP25B/ KCP25	KCP30B/ KCP30	–	KCP30B/ KCP40B	KCP30B/ KCP40B	–	KCU10/ KCP25B/ KCP25	KCP25B/ KCP25	KCP25B/ KCP25	KCP40B/ KCP40	KCM25B/ KCM25
lightly interrupted cut		KCP10B/ KCP10	KCP25B/ KCP25	KCP25B/ KCP25	KCP25B/ KCP25	KCP25B/ KCP25	KCP25B/ KCP25	–	KCU10/ KCP25B/ KCP25	KCP25B/ KCP25	KCP25B/ KCP25	KCP25B/ KCP25	KCP25B/ KCP25
varying depth of cut, casting, or forging skin		KCP05B/ KCP05/ KT315	KCP10B/ KCP10	KCP10B/ KCP10	KCP10B/ KCP10	KCP10B/ KCP10	KCP10B/ KCP10	KT315	KCP10B/ KCP10	KCP10B/ KCP10	KCP10B/ KCP10	KCP10B/ KCP10	KCP10B/ KCP10
smooth cut, pre-turned surface		KCP05B/ KCP05/ KT315	KCP05B/ KCP05	KCP05B/ KCP05	KCP10B/ KCP10/ KCK15B	KCP05B/ KCP10	KCP05B/ KCP10	KT315	KCP05B/ KCP05	KCP05B/ KCP05/ KT315	KCP05B/ KCP05/ KTP10	KCP05B/ KCP05	KCP05B/ KCP05

Step 3 • Selecting the cutting speed

Low-Carbon (<0,3% C) and Free-Machining Steel — speed — m/min (SFM) — Starting Conditions

material group	grade	135 (450)	180 (600)	225 (800)	275 (900)	320 (1050)	360 (1200)	410 (1350)	455 (1500)	495 (1650)	m/min	SFM
P0/P1	KCP05B/KCP05/KCPK05							◇			435	1450
	KCP10B/KCP10						◇				395	1320
	KCP25B/KCP25				◇						275	925
	KCP30B/KCP30/KCP40B/KCP40		◇								210	700
	KT315/KTP10							◇			440	1450
	KCU10			◇							280	925

Medium- and High-Carbon Steels (>0,3% C) — speed — m/min (SFM) — Starting Conditions

material group	grade	135 (450)	180 (600)	225 (800)	275 (900)	320 (1050)	360 (1200)	410 (1350)	455 (1500)	495 (1650)	m/min	SFM
P2	KCP05B/KCP05/KCPK05				◇						240	800
	KCP10B/KCP10			◇							265	880
	KCP25B/KCP25		◇								195	650
	KCP30B/KCP30/KCP40B/KCP40		◇								150	500
	KT315/KTP10				◇						270	880
	KCU10	◇									200	650

Alloy Steels and Tool Steels (≤330 HB) (≤35 HRC) — speed — m/min (SFM) — Starting Conditions

material group	grade	135 (450)	180 (600)	225 (800)	275 (900)	320 (1050)	360 (1200)	410 (1350)	455 (1500)	495 (1650)	m/min	SFM
P3	KCP05B/KCP05/KCPK05			◇							205	680
	KCP10B/KCP10		◇								190	630
	KCP25B/KCP25		◇								155	510
	KCP30B/KCP30/KCP40B/KCP40	◇									120	400
	KT315/KTP10			◇							210	680
	KCU10		◇								155	510

Alloy Steels and Tool Steels (340–450 HB) (36–48 HRC) — speed — m/min (SFM) — Starting Conditions

material group	grade	60 (200)	90 (300)	120 (400)	150 (500)	180 (600)	210 (700)	240 (800)	270 (900)	300 (1000)	m/min	SFM
P4	KCP05B/KCP05/KCPK05				◇						160	530
	KCP10B/KCP10				◇						145	480
	KCP25B/KCP25			◇							105	360
	KCP30B/KCP30/KCP40B/KCP40		◇								95	325
	KT315/KTP10					◇					210	530
	KCU10			◇							110	360

Ferritic, Martensitic, and PH Stainless Steels (≤330 HB) (≤35 HRC) — speed — m/min (SFM) — Starting Conditions

material group	grade	120 (400)	150 (500)	180 (600)	210 (700)	240 (800)	270 (900)	300 (1000)	330 (1100)	360 (1200)	m/min	SFM
P5	KCP05B/KCP05/KCPK05					◇					240	800
	KCP10B/KCP10				◇						215	720
	KCP25B/KCP25				◇						195	650
	KCP30B/KCP30/KCP40B/KCP40		◇								135	450
	KT315/KTP10					◇					250	800
	KCU10				◇						200	660

Ferritic, Martensitic, and PH Stainless Steels (340–450 HB) (36–48 HRC) — speed — m/min (SFM) — Starting Conditions

material group	grade	105 (350)	135 (450)	165 (550)	195 (650)	225 (750)	255 (850)	285 (950)	315 (1050)	345 (1150)	m/min	SFM
P6	KCP05B/KCP05/KCPK05				◇						200	660
	KCP10B/KCP10				◇						180	600
	KCP25B/KCP25			◇							150	500
	KCP30B/KCP30/KCP40B/KCP40	◇									105	350
	KT315/KTP10				◇						200	660
	KCU10			◇							150	500

Step 1 • Select the insert geometry

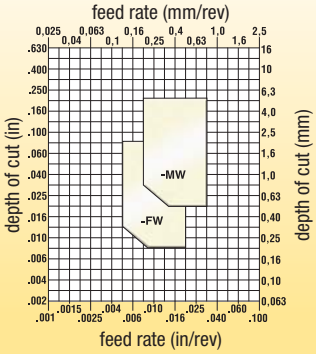
Negative Wiper Inserts



-MW
Medium Wiper



-FW
Finishing Wiper



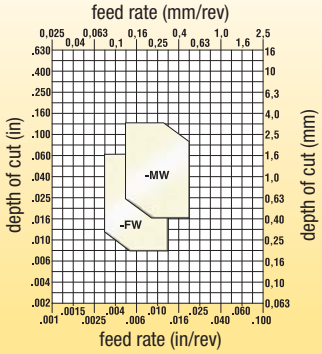
Positive Wiper Inserts



-MW
Medium Wiper



-FW
Finishing Wiper



Step 2 • Select the grade

cutting condition		Negative Insert Geometry -FW	Negative Insert Geometry -MW	Positive Insert Geometry -FW	Positive Insert Geometry -MW
heavily interrupted cut		–	–	–	–
lightly interrupted cut		KCM15B/KCM15	KCM25B/KCM25	KCM15B/KCM15	KCM15B/KCM15
varying depth of cut, casting, or forging skin		KCM15B/KCM15/ KCU10	KCM15B/KCM15	KCU10	KCU10
smooth cut, pre-turned surface		KCM15B/KCM15/ KT315	KCM15B/KCM15	KT315	KT315

Step 1 • Select the insert geometry

Negative Inserts



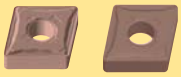
-RP -P
Roughing



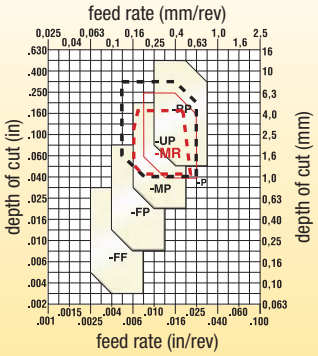
-MR
Medium Roughing



-MP -UP
Medium Machining



-FP -FF
Finishing



Positive Inserts



-MP
Medium Machining



-LF



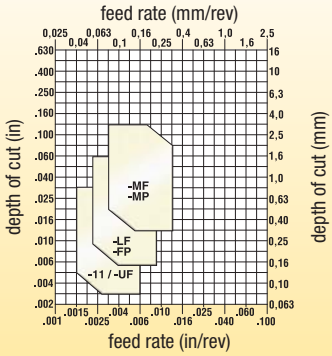
..GT-LF
Finishing



-11



-UF
Fine Finishing



Step 2 • Select the grade

cutting condition		Negative Insert Geometry -FF	-FP	-MP/-UP	-P/-RP	-MR
heavily interrupted cut		KCU10	KCM15B/KCM15	KCM35B/KCM35	KCM35B/KCM35	KCM35B/KCM35
lightly interrupted cut		KCU10	KCM15B/KCM15	KCM25B/KCM25	KCM25B/KCM25	KCM25B/KCM25
varying depth of cut, casting, or forging skin		KT315	KCM15B/KCM15/ KCU10	KCM15B/KCM15	KCM15B/KCM15/ KCM25B/KCM25	KCM15B/KCM15
smooth cut, pre-turned surface		KT315	KCM15B/KCM15/ KT315	KCM15B/KCM15/ KCU10	KCU10	KCM15B/KCM15

(continued)

Step 2 • Select the grade *(continued)*

cutting condition		Positive Insert Geometry -11	-UF	-LF	-MP/-MF	-FP	..GT-LF
heavily interrupted cut		–	KCU25	KCM35B/KCM35	KCM25B/KCM25	KCU25/KCM25B/ KCM25	KCU25
lightly interrupted cut		–	KCU10	KCM25B/KCM25	KCM25B/KCM25	KCM15B/KCM15	KCU25
varying depth of cut, casting, or forging skin		KT315	–	KCM15B/KCU10	KCM15B/KCM15	KCU10	KCU10
smooth cut, pre-turned surface		KT315	–	KCM15B/KCM15/ KT315	KCM15B/KCM15	KTP10	KCU10

Step 3 • Selecting the cutting speed

Austenitic Stainless Steel — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	90 (300)	135 (450)	180 (600)	225 (800)	270 (900)	315 (1050)	360 (1200)	405 (1350)	450 (1500)	m/min	SFM
M1	KCM15B/KCM15			◁▷							180	600
	KCM25B/KCM25		◁▷								150	500
	KCM35B/KCM35	◁▷									120	400
	KT315				◁▷						230	750
	KCU10			◁▷							215	700
	KCU25		◁▷								180	550

Austenitic Stainless Steel — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	90 (300)	135 (450)	180 (600)	225 (800)	270 (900)	315 (1050)	360 (1200)	405 (1350)	450 (1500)	m/min	SFM
M2	KCM15B/KCM15			◁▷							165	550
	KCM25B/KCM25		◁▷								140	450
	KCM35B/KCM35	◁▷									105	350
	KT315				◁▷						215	700
	KCU10			◁▷							200	650
	KCU25		◁▷								165	500

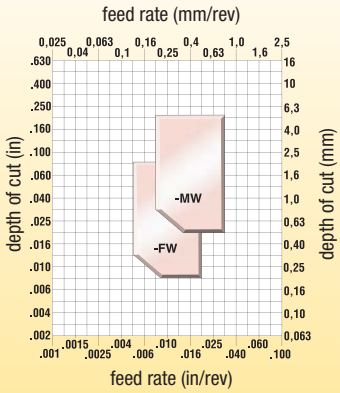
Austenitic Stainless Steel: Duplex (Ferritic and Austenitic Mixture) — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	90 (300)	135 (450)	180 (600)	225 (800)	270 (900)	315 (1050)	360 (1200)	405 (1350)	450 (1500)	m/min	SFM
M3	KCM15B/KCM15			◁▷							150	500
	KCM25B/KCM25		◁▷								120	400
	KCM35B/KCM35	◁▷									90	300
	KT315				◁▷						200	650
	KCU10			◁▷							185	600
	KCU25		◁▷								150	450

Step 1 • Select the insert geometry

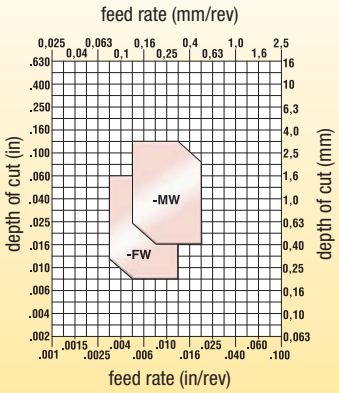
Negative Wiper Inserts





Positive Wiper Inserts





Step 2 • Select the grade

Grey Iron

		Negative Insert Geometry			Positive Insert Geometry	
cutting condition		**-FW**	**-T-20FW**	**-S...MW...**	**-FW**	**-MW**
heavily interrupted cut		–	KY3500	KB1345	–	KCK15B/KCK15/ KCK20B/KCK20
lightly interrupted cut		KCK15B/KCK15	KY3500	KB1345	KCK20B/KCK20	KCK15B/KCK15/ KCK20B/KCK20
varying depth of cut, casting, or forging skin		KCK05B/KCK05/ KT315	KYK10	KB1345	KCK20B/KCK20	KCK15B/KCK15/ KCK20B/KCK20
smooth cut, pre-turned surface		KCK05B/KCK05/ KT315	KYK25	KB1345	KCK20B/ KT315	KCK15B/KCK15/ KCK20B/KCK20/KT315

Ductile Iron

		Negative Insert Geometry		Positive Insert Geometry	
cutting condition		**-FW**	**-T-20FW**	**-FW**	**-MW**
heavily interrupted cut		–	–	–	–
lightly interrupted cut		KCK15B/ KCK15	KY3500	KCK20B/ KCK20	KCK20B/ KCK20
varying depth of cut, casting, or forging skin		KCK05B/KCK05/ KT315	KYK10	KCK20B/ KCK20	KCK20B/ KCK20
smooth cut, pre-turned surface		KCK05B/KCK05/ KT315	KYK25	KCK20B/KCK20/ KT315	KCK20B/KCK20/ KT315

Step 3 • Selecting the cutting speed

Grey Cast Iron — speed — m/min (SFM) — Starting Conditions

material group	grade	60 (200)	150 (500)	240 (800)	330 (1100)	420 (1400)	510 (1700)	600 (2000)	690 (2300)	780 (2600)	m/min	SFM
K1	KCK05B/KCK05					◁▷					450	1500
	KCK15B/KCK15				◁▷						360	1200
	KCK20B/KCK20/KCPK05				◁▷						300	1000
	KT315				◁▷						275	900

Ductile, Compacted Graphite, and Malleable Cast Irons (<80 KSI tensile strength) — speed — m/min (SFM) — Starting Conditions

material group	grade	60 (200)	150 (500)	240 (800)	330 (1100)	420 (1400)	510 (1700)	600 (2000)	690 (2300)	780 (2600)	m/min	SFM
K2	KCK05B/KCK05				◁▷						360	1200
	KCK15B/KCK15			◁▷							270	900
	KCK20B/KCK20/KCPK05			◁▷							240	800
	KT315				◁▷						275	900

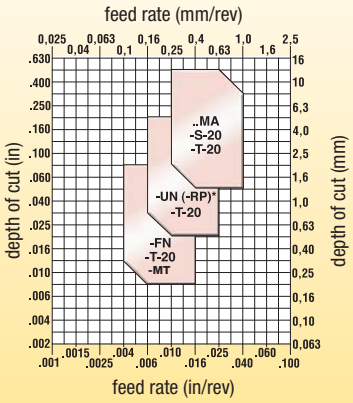
Ductile, Compacted Graphite, and Malleable Cast Irons (>80 KSI tensile strength) — speed — m/min (SFM) — Starting Conditions

material group	grade	60 (200)	150 (500)	240 (800)	330 (1100)	420 (1400)	510 (1700)	600 (2000)	690 (2300)	780 (2600)	m/min	SFM
K3	KCK05B/KCK05			◁▷							240	800
	KCK15B/KCK15			◁▷							215	725
	KCK20B/KCK20/KCPK05		◁▷								210	700
	KT315			◁▷							230	750

Step 1 • Select the insert geometry

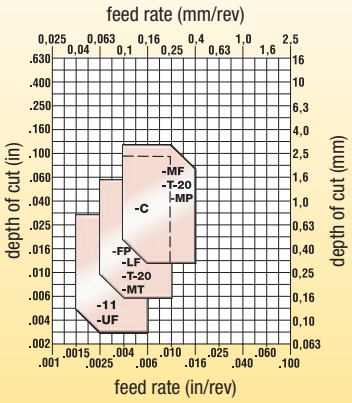
Negative Inserts





Positive Inserts





*Geometry can be used in medium machining operations to reduce tool pressure in high-strength metals.

Step 2 • Select the grade

Grey Iron

		Negative Insert Geometry				Positive Insert Geometry			
cutting condition		**-FN**	**-MR**	**-UN(-RP)**	**-MA**	**-LF**	**-FP**	**-MF**	**-MP**
heavily interrupted cut		KCK15B/ KCK15	KCP25B/ KCP25/ KCP10B/KCP10	KCK20B/ KCK20	KCK20B/ KCK20	KCK20B/ KCK20	KCK20B/ KCK20	KCK20B/ KCK20	KCK20B/ KCK20
lightly interrupted cut		KCK15B/ KCK15	KCP10B/ KCP10/ KCP25B/KCP25	KCK20B/ KCK20	KCK20B/ KCK20	KCK20B/ KCK20	KCK20B/ KCK20	KCK20B/ KCK20	KCK20B/ KCK20
varying depth of cut, casting, or forging skin		KCK05B/ KCK05/ KT315	KCK15B/ KCK15	KCK15B/ KCK15	KCK15B/ KCK15	KCK15B/ KCK15	KCK20B/ KCK20	KCK15B/ KCK15	KCK20B/ KCK20
smooth cut, pre-turned surface		KCK05B/ KCK05/ KT315	KCK15B/ KCK15	KCK05B/ KCK05	KCK05B/ KCK05	KCK05B/ KCK05	KCK20B/ KCK20	KCK15B/ KCK15	KCK20B/ KCK20

Ductile Iron

		Negative Insert Geometry				Positive Insert Geometry			
cutting condition		**-FN**	**-UN(-RP)**	**-MA**	**-11/-UF**	**-LF**	**-MF**	**-FP**	**-MP**
heavily interrupted cut		KCK15B/ KCK15	KCK20B/ KCK20	KCK20B/ KCK20	–	KCK20B/ KCK20	KCK20B/ KCK20	KCK20B/ KCK20	KCK20B/ KCK20
lightly interrupted cut		KCK15B/ KCK15	KCK20B/ KCK20	KCK20B/ KCK20	KCU10	KCK20B/ KCK20	KCK20B/ KCK20	KCK20B/ KCK20	KCK20B/ KCK20
varying depth of cut, casting, or forging skin		KCK05B/ KCK05/ KT315	KCK15B/ KCK15	KCK15B/ KCK15	KCU10	KCK15B/ KCK15	KCK15B/ KCK15	KCK20B/ KCK20	KCK20B/ KCK20
smooth cut, pre-turned surface		KCK05B/ KCK05/ KT315	KCK05B/ KCK05	KCK05B/ KCK05	KT315	KCU10	KCK15B/ KCK15	KCK20B/ KCK20	KCK20B/ KCK20

(continued)

Step 3 • Selecting the cutting speed *(continued)* (Optimal speed depends on casting quality and disposition.)

Grey Cast Iron — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	60 (200)	180 (600)	305 (1000)	430 (1400)	550 (1800)	675 (2200)	800 (2600)	920 (3000)	1040 (3400)	1160 (3800)	m/min	SFM
K1	KT315		◁▷									275	900
	KB1340/KB1345							◁▷				760	2500
	KCK05B/KCK05			◁▷								450	1500
	KCK15B/KCK15			◁▷								360	1200
	KCK20B/KCK20/KCPK05			◁▷								300	1000

Ductile, Compacted Graphite, and Malleable Cast Irons (<600 MPa tensile strength) — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	90 (300)	135 (450)	180 (600)	225 (750)	275 (900)	320 (1050)	360 (1200)	410 (1350)	460 (1500)	500 (1650)	550 (1800)	600 (1950)	m/min	SFM
K2	KT315					◁▷								275	900
	KCU10			◁▷										200	650
	KCK05B/KCK05						◁▷							360	1200
	KCK15B/KCK15					◁▷								270	900
	KCK20B/KCK20/KCPK05				◁▷									240	800

Ductile, Compacted Graphite, and Malleable Cast Irons (>600 MPa tensile strength) — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	90 (300)	135 (450)	180 (600)	225 (750)	275 (900)	320 (1050)	360 (1200)	410 (1350)	460 (1500)	500 (1650)	550 (1800)	600 (1950)	m/min	SFM
K3	KT315				◁▷									230	750
	KCU10			◁▷										150	500
	KCK05B/KCK05				◁▷									240	800
	KCK15B/KCK15			◁▷										215	725
	KCK20B/KCK20/KCPK05		◁▷											210	700

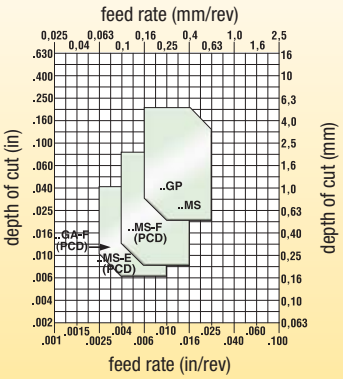
Step 1 • Select the insert geometry

Negative Inserts



..GP ..MS

Medium Finishing



Positive Inserts



..GT-HP

Medium Finishing

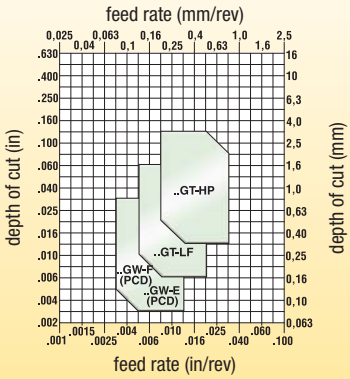


..GT-LF

Finishing



..GW-F (PCD) ..GW-E (PCD)



Step 2 • Select the grade

		Negative Insert Geometry		Positive Insert Geometry	
cutting condition		**..GP**	**..MS**	**..GT-LF**	**..GT-HP**
heavily interrupted cut		**KC5410/K313**	**KC5410**	**–**	**KC5410**
lightly interrupted cut		**KC5410/K313**	**KC5410**	**KC5410**	**KC5410**
varying depth of cut, casting, or forging skin		**KC5410/K313**	**KC5410**	**KC5410**	**KC5410**
smooth cut, pre-turned surface		**KC5410/K313**	**KC5410**	**KC5410**	**KC5410**

Step 3 • Selecting the cutting speed

Low-Silicon Aluminium Alloys (hypoeutectic <12.2% Si) and Magnesium Alloys

speed — m/min (SFM)

Starting Conditions ◁▷

material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	1250 (4000)	1500 (4800)	1750 (5600)	2000 (6400)	2250 (7200)	2500 (8000)	m/min	SFM
N1	**KC5410**		◁▷									550	1800

Additional cutting speed recommendations for miscellaneous workpiece materials

Copper-, Brass-, Zinc-Based on a Machinability Index Range of 70–100 — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	m/min	SFM
N4	KC5410	◁▷				275	900
	K313	◁▷				260	850

Nylon, Plastics, Rubbers, Phenolics, Resins, Fibreglass, and Glass — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	m/min	SFM
N5	KC5410	◁▷				170	550

Carbon and Graphite Composites: Brush Alloys, Kevlar, and Graphite (280–400 HB) (30–43 HRC) — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	m/min	SFM
N6	KC5410	◁▷				200	650

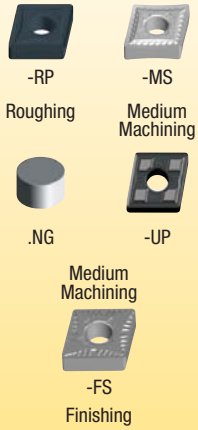
Tin Alloys, Cast: ASTM 823, Alloys 1, 2, 3, 11 — speed — m/min (SFM) — Starting Conditions ◁▷

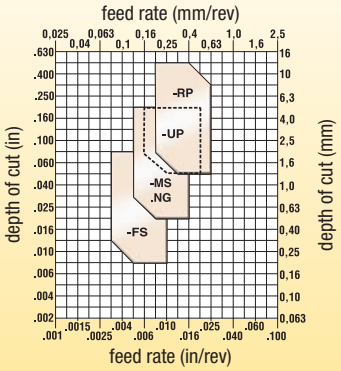
material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	m/min	SFM
N8	KC5410	◁▷				215	700
	K313	◁▷				180	600

Step 1 • Select the insert geometry

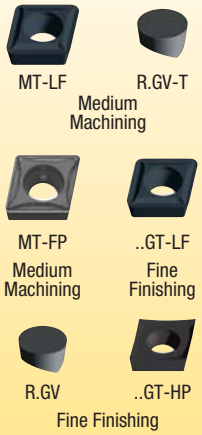
beyond DRIVE™

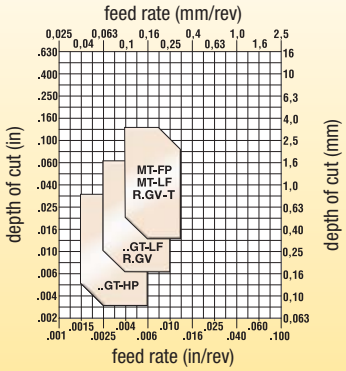
Negative Inserts





Positive Inserts





Step 2 • Select the grade

		Negative Insert Geometry			
cutting condition		**-FS**	**-MS**	**-UP**	**-RP**
heavily interrupted cut		**KCU25**	**KCU25**	**KCM35B**	**KCM25B/ KCM35B**
lightly interrupted cut		**KCU10**	**KCU25**	**KCM25B**	**KCM15B**
varying depth of cut, casting, or forging skin		**KCU10**	**KCU10**	**KCM15B**	**KCU25**
smooth cut, pre-turned surface		**KCU10/K313**	**KCU10/K313**	**KCU10**	**KCU10**

		Positive Insert Geometry			
cutting condition		**MT-FP**	**..GT-HP**	**MT-LF**	**..GT-LF**
heavily interrupted cut		**KCU25**	**–**	**KCU25**	**KCU25**
lightly interrupted cut		**KCU25**	**KCU25**	**KCU25**	**KCU25**
varying depth of cut, casting, or forging skin		**KCU10/KU10**	**KCU10**	**KCU10**	**KCU10**
smooth cut, pre-turned surface		**KCU10/KU10**	**KCU10/K313**	**KCU10/K313**	**KCU10/K313**

Step 3 • Select the cutting speed

Iron-Based, Heat-Resistant Alloys (135–320 HB) (≤34 HRC) — speed — m/min (SFM) — Starting Conditions

material group	grade	15 (50)	45 (150)	75 (250)	105 (350)	140 (450)	170 (550)	200 (650)	230 (750)	260 (850)	290 (950)	310 (1050)	350 (1150)	380 (1250)	m/min	SFM
S1	K313/KU10		◁▷												30	100
	KCU10			◁▷											55	180
	KCU25		◁▷												40	125
	KCM15B/KCM15			◁▷											55	180
	KCM25B/KCM25/KCM35B/KCM35		◁▷												40	125

Cobalt-Based, Heat-Resistant Alloys (150–425 HB) (≤45 HRC) — speed — m/min (SFM) — Starting Conditions

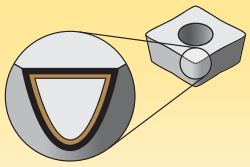
material group	grade	15 (50)	45 (150)	75 (250)	105 (350)	140 (450)	170 (550)	200 (650)	230 (750)	260 (850)	290 (950)	310 (1050)	350 (1150)	380 (1250)	m/min	SFM
S2	K313/KU10		◁▷												35	110
	KCU10			◁▷											60	195
	KCU25		◁▷												30	100
	KCM15B/KCM15			◁▷											60	195
	KCM25B/KCM25/KCM35B/KCM35		◁▷												30	100

Nickel-Based, Heat-Resistant Alloys (140–475 HB) (≤48 HRC) — speed — m/min (SFM) — Starting Conditions

material group	grade	15 (50)	45 (150)	75 (250)	105 (350)	140 (450)	170 (550)	200 (650)	230 (750)	260 (850)	290 (950)	310 (1050)	350 (1150)	380 (1250)	m/min	SFM
S3	K313/KU10		◁▷												40	125
	KCU10			◁▷											70	225
	KCU25		◁▷												40	125
	KCM15B/KCM15			◁▷											70	225
	KCM25B/KCM25/KCM35B/KCM35		◁▷												40	125

Titanium and Titanium Alloys (110–450 HB) (≤48 HRC) — speed — m/min (SFM) — Starting Conditions

material group	grade	15 (50)	45 (150)	75 (250)	105 (350)	140 (450)	170 (550)	200 (650)	230 (750)	260 (850)	290 (950)	310 (1050)	350 (1150)	380 (1250)	m/min	SFM
S4	K313/KU10		◁▷												45	150
	KCU10			◁▷											70	225
	KCU25		◁▷												55	175
	KCM15B/KCM15			◁▷											70	225
	KCM25B/KCM25/KCM35B/KCM35		◁▷												55	175

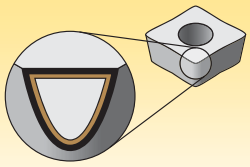


Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

wear resistance ← → toughness

	Coating		Grade Description		05	10	15	20	25	30	35	40	45
Uncoated Carbide Grades	K313	—	**Composition:** A hard, low binder content, unalloyed WC/Co fine-grain grade. **Application:** Exceptional edge wear resistance combined with very high strength for machining titanium, cast irons, austenitic stainless steels, non-ferrous metals, non-metals, and most high-temp alloys. Superior thermal deformation and depth-of-cut notch resistance. The grain structure is well controlled for minimal pits and flaws, which contributes to long, reliable service.	M									
				K									
				N									
				S									
	K68	—	**Composition:** A hard, low binder content, alloyed grade WC/Co fine-grain grade. **Application:** The K68 grade has excellent abrasion resistance for machining cast irons, austenitic stainless steels, non-ferrous metals, non-metals, and as an alternative to the K313 grade on high-temperature alloys. Use as a general-purpose grade for non-ferrous materials.	M									
				K									
				N									
				S									
PVD-Coated Carbide Grades	KCS10	—	**Composition:** An advanced PVD-AlTiN coated, fine-grained tungsten carbide grade. **Application:** The KCS10 grade specifically engineered for the productive machining of high-temperature alloys. The fine-grained tungsten carbide substrate has excellent toughness and deformation resistance while the advanced PVD coating allows metalcutting speeds double those of conventional PVD-coated cutting tools.	P									
				M									
				K									
				N									
				S									
				H									
	KCU10	—	**Composition:** An advanced multilayer PVD coating over a very deformation-resistant unalloyed carbide substrate. The new and improved coating improves edge stability with wide range speed and feed capabilities. **Application:** The KCU10™ grade is ideal for finishing to general machining of most workpiece materials at a wide range of speed and feed capabilities. Excellent for machining most steels, stainless steels, cast irons, non-ferrous materials, and high-temp alloys with improved edge toughness, notch resistance, and higher cutting speed/feed capability. beyond	P									
				M									
				K									
				N									
				S									
				H									

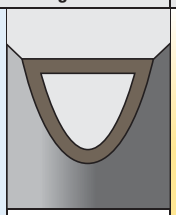
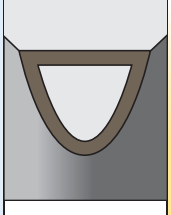
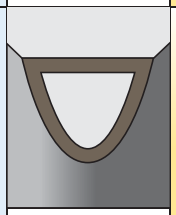
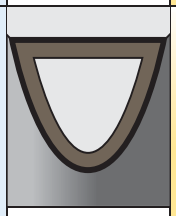


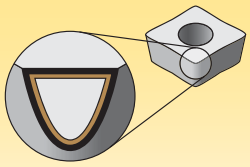
Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

wear resistance ← → toughness

PVD-Coated Carbide Grades

Coating	Grade Description		05	10	15	20	25	30	35	40	45
KCU25  —	**Composition:** An advanced PVD grade with hard AlTiN coating and fine-grain unalloyed substrate. The new and improved coating improves edge stability with wide range speed and feed capabilities. **Application:** The KCU25™ grade is ideal for general machining of most steels, stainless steels, high-temp alloys, titanium, irons, and non-ferrous materials in a wide range of speeds and feeds with improved edge toughness for interrupted cut and high feed rates. beyond	P									
		M									
		K									
		N									
		S									
KC5010  —	**Composition:** An advanced PVD AlTiN coating over a very deformation-resistant unalloyed carbide substrate. **Application:** The KC5010™ grade is ideal for finishing to general machining of most workpiece materials at higher speeds. Excellent for machining most steels, stainless steels, cast irons, non-ferrous materials, and high-temp alloys under stable conditions. It also performs well machining hardened and short chipping materials.	P									
		M									
		K									
		N									
		S									
		H									
KC5025  —	**Composition:** An advanced PVD-AlTiN-coated grade with a tough, ultra-fine-grain unalloyed substrate. **Application:** For general-purpose machining of most steels, stainless steels, high-temp alloys, titanium, irons, and non-ferrous materials. Speeds may vary from low to medium and will handle interruptions and high feed rates.	P									
		M									
		K									
		N									
		S									
KC5410  —	**Composition:** A PVD TiB_2 coating over a very deformation-resistant unalloyed substrate. **Application:** Designed for roughing, semi-finishing, and finishing of free machining (hypoeutectic <12.2% Si) aluminium, aluminium alloys, and magnesium alloys. The TiB_2 coating is harder than TiN and TiAlN coatings and has an extremely smooth surface, resulting in reduced surface friction, speedy chip flow, and outstanding wear resistance. Built-up edge is prevented because this coating has a very low affinity for aluminium. The substrate is unalloyed and fine grained and offers sharp edges, smooth surfaces, and excellent thermal deformation resistance and edge integrity. Inserts with a ground periphery are polished before coating and have a sharp edge. Moulded inserts have a light hone.										
		N									



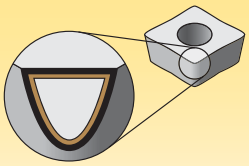
Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

wear resistance ⟷ toughness

CVD-Coated Carbide Grades

Coating	Grade Description		05	10	15	20	25	30	35	40	45
KCP05B	**Composition:** An innovative, highly deformation-resistant, cobalt-enriched substrate with a specially designed, adherent MTCVD TiCN-Al_2O_3-TiOCN coating. **Application:** For finishing to semi-finishing of most steels, ferritic, martensitic, and PH stainless steels and cast irons. Provides excellent combination of deformation resistance and insert edge strength. The new coating combined with a state-of-the-art post-coat treatment provides high-productivity with long predictable tool life and superior workpiece surface finish. beyond™ DRIVE™	P	■	■	■						
—		K					■	■	■		
KCP05	**Composition:** An innovative, highly deformation-resistant, cobalt-enriched substrate with a specially designed, adherent MTCVD TiCN-Al_2O_3 coating. **Application:** For finishing to semi-finishing of most steels, ferritic, martensitic, and PH stainless steels and cast irons. Provides excellent combination of deformation resistance and insert edge strength. The new coating combined with a state-of-the-art post-coat treatment provides high-productivity with long predictable tool life and superior workpiece surface finish. beyond	P	■	■	■						
—		K					■	■	■		
KCPK05	**Composition:** A deformation-resistant, cobalt-enriched substrate combined with thick MTCVD TiCN-Al_2O_3 coating. **Application:** For high productivity turning of steels and PH stainless steels in continuous to lightly interrupted cuts. This grade provides excellent combination of toughness and high speed wear resistance allowing the fastest steel part production. Its unique combination of substrate and coating also make it an ideal roughing grade for cast iron where chipping resistance is required. beyond	P	■	■	■						
—		K					■	■	■		
KCP10B	**Composition:** A specially engineered cobalt-enriched carbide grade with thick MTCVD TiCN-Al_2O_3-TiOCN coating for maximum wear resistance. **Application:** An excellent finishing to medium machining grade for a variety of workpiece materials, including most steels, ferritic, martensitic, and PH stainless steels, and cast irons. The cobalt-enriched substrate offers a balanced combination of deformation resistance and edge toughness, while the thick coating layers offer outstanding abrasion resistance and crater wear resistance for high-speed machining. Smooth coating provides resistance to edge build-up and microchipping and produces excellent surface finishes. beyond™ DRIVE™	P		■	■	■					
—		K					■	■	■		
KCP10	**Composition:** A specially engineered cobalt-enriched carbide grade with thick MTCVD TiCN-Al_2O_3 coating for maximum wear resistance. **Application:** An excellent finishing to medium machining grade for a variety of workpiece materials, including most steels, ferritic, martensitic, and PH stainless steels, and cast irons. The cobalt-enriched substrate offers a balanced combination of deformation resistance and edge toughness, while the thick coating layers offer outstanding abrasion resistance and crater wear resistance for high-speed machining. Smooth coating provides resistance to edge build-up and microchipping and produces excellent surface finishes. beyond	P		■	■	■					
—		K					■	■	■		

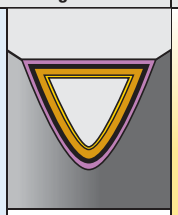
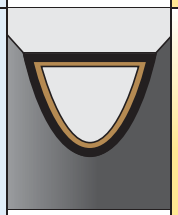
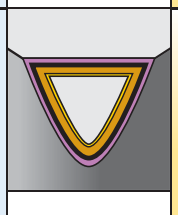
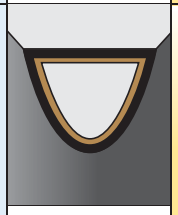


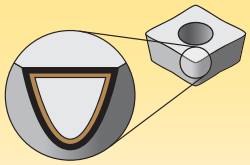
Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

wear resistance ← → toughness

CVD-Coated Carbide Grades

Coating	Grade Description	05	10	15	20	25	30	35	40	45
KCP25B  —	**Composition:** A tough cobalt-enriched carbide grade with a multilayer MTCVD TiCN-Al_2O_3-TiOCN coating with superior interlayer adhesion. **Application:** Best general-purpose turning grade for most steels and ferritic and martensitic stainless steels. The substrate design ensures adequate deformation resistance with excellent insert edge strength. Coating layers offer good wear resistance over a wide range of machining conditions and the post-coat treatment minimises microchipping and improves coating adhesion to substrate leading to long tool life and improved workpiece finishes. beyond DRIVE™	P				■	■	■			
		K					■	■	■	
KCP25  —	**Composition:** A tough cobalt-enriched carbide grade with a multilayer MTCVD TiCN-Al_2O_3 coating with superior interlayer adhesion. **Application:** Best general-purpose turning grade for most steels and ferritic and martensitic stainless steels. The substrate design ensures adequate deformation resistance with excellent insert edge strength. Coating layers offer good wear resistance over a wide range of machining conditions and the post-coat treatment minimises microchipping and improves coating adhesion to substrate leading to long tool life and improved workpiece finishes. beyond™	P				■	■	■			
		K					■	■	■	
KCP30B  —	**Composition:** A tough cobalt-enriched carbide grade with an advanced multilayer MTCVD TiCN-Al_2O_3-TiOCN coating. **Application:** For medium to rough machining of all carbon, alloy, and stainless steels. The substrate design provides superior insert strength that is required for this application, and the multilayer coating adds wear resistance to the insert resulting in long tool life. beyond DRIVE™	P					■	■	■	
		M				■	■				
KCP30  —	**Composition:** A tough cobalt-enriched carbide grade with an advanced multilayer MTCVD TiCN-Al_2O_3 coating. **Application:** For medium to rough machining of all carbon, alloy, and stainless steels. The substrate design provides superior insert strength that is required for this application, and the multilayer coating adds wear resistance to the insert resulting in long tool life. beyond™	P					■	■	■	
		M				■	■				



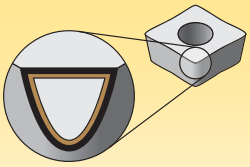
Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

wear resistance ⟷ toughness

CVD-Coated Carbide Grades

Coating	Grade Description	05	10	15	20	25	30	35	40	45
KCP40B	**Composition:** A tough carbide grade with a thin MTCVD TiCN-Al_2O_3-TiOCN coating. **Application:** For heavy roughing of carbon, alloy, and stainless steels. The substrate-coating combination provides unbelievable toughness and operational security allowing high metal removal rates even in most demanding interrupted cuts. beyond DRIVE™									
KCP40	**Composition:** A tough carbide grade with a thin MTVCVD TiCN-Al_2O_3 coating. **Application:** For heavy roughing of carbon, alloy, and stainless steels. The substrate-coating combination provides unbelievable toughness and operational security allowing high metal removal rates even in most demanding interrupted cuts. beyond									
KCK05B	**Composition:** A multilayered coating with moderately thick MTCVD TiCN-Al_2O_3-TiOCN layers over a highly deformation-resistant carbide substrate. **Application:** Designed for high-speed machining of grey and ductile irons. The substrate and coating architecture together with post-coat treatment ensure a tremendous tool life advantage, especially when cutting higher tensile strength ductile and grey irons where workpiece size consistency and reliability of tool life are critical. Excellent both in continuous cuts and varied depths of cut. beyond DRIVE™									
KCK05	**Composition:** A multilayered coating with moderately thick MTCVD TiCN-Al_2O_3 layers over a highly deformation-resistant carbide substrate. **Application:** Designed for high-speed machining of grey and ductile irons. The substrate and coating architecture together with post-coat treatment ensure a tremendous tool life advantage, especially when cutting higher tensile strength ductile and grey irons where workpiece size consistency and reliability of tool life are critical. Excellent both in continuous cuts and varied depths of cut. beyond									
KCK15B	**Composition:** A multilayered coating with thick MTCVD TiCN-Al_2O_3-TiOCN layers applied over a carbide substrate specifically engineered for cast irons. **Application:** Delivers consistent performance in high-speed machining of grey and ductile irons. The substrate design permits the insert to stay in the cut for a long time at high speeds with minimum deformation. The thick CVD coating and post-coat treatment provide superior wear resistance ensuring long and consistent tool life. Can be applied both in continuous and lightly interrupted cuts. beyond DRIVE™									



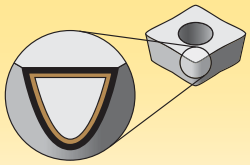
Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

wear resistance ⟷ toughness

CVD-Coated Carbide Grades

Coating	Grade Description	05	10	15	20	25	30	35	40	45
KCK15 —	**Composition:** A multilayered coating with thick MTCVD TiCN-Al_2O_3 layers applied over a carbide substrate specifically engineered for cast irons. **Application:** Delivers consistent performance in high-speed machining of grey and ductile irons. The substrate design permits the insert to stay in the cut for a long time at high speeds with minimum deformation. The thick CVD coating and post-coat treatment provide superior wear resistance ensuring long and consistent tool life. Can be applied both in continuous and lightly interrupted cuts. beyond	P	P							
		K	K	K	K					
KCK20B —	**Composition:** A specially toughened MTCVD TICN-Al_2O_3-TiOCN coating over a wear-resistant substrate. **Application:** Specifically engineered to maximise coating adhesion and edge strength making this grade ideal in wet interrupted cutting of grey and ductile irons. It can be used in a wide range of applications from finishing to roughing to maximise productivity wherever strength and reliability are needed. beyond DRIVE	P	P	P						
		K		K	K	K	K			
KCK20 —	**Composition: A** specially toughened MTCVD TICN-Al_2O_3 coating over a wear-resistant substrate. **Application:** Specifically engineered to maximise coating adhesion and edge strength making this grade ideal in wet interrupted cutting of grey and ductile irons. It can be used in a wide range of applications from finishing to roughing to maximise productivity wherever strength and reliability are needed. beyond	P	P	P						
		K		K	K	K	K			
KCM15B —	**Composition:** A multilayer MTCVD TiCN-Al_2O_3 coated carbide grade. **Application:** An excellent finishing to medium machining grade for austenitic stainless steels at higher speeds and covers a broad range of steel applications in the P20–P25 range. KCM15B grade in combination with unique geometries have been designed to resist depth-of-cut notching and minimise bur formation. The post-coat treatment reduces coating stresses, improves coating adhesion, minimises microchipping and edge build-up, and improves workpiece finish. beyond DRIVE	P				P	P			
		M	M	M	M					



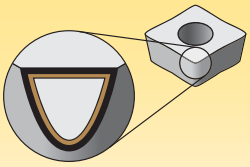
Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

wear resistance ⟷ toughness

CVD-Coated Carbide Grades

Coating	Grade Description	05	10	15	20	25	30	35	40	45
KCM15 —	**Composition:** A multilayer MTCVD TiCN-Al_2O_3 coated carbide grade. **Application:** An excellent finishing to medium machining grade for austenitic stainless steels at higher speeds and covers a broad range of steel applications in the P20–P25 range. KCM15 grade in combination with unique geometries have been designed to resist depth-of-cut notching and minimise bur formation. The post-coat treatment reduces coating stresses, improves coating adhesion, minimises microchipping and edge build-up, and improves workpiece finish. beyond	P									
		M									
KCM25B —	**Composition:** A multilayer MTCVD TiCN-Al_2O_3-TiOCN coated carbide grade. **Application:** This CVD-coated grade is designed for general-purpose machining of austenitic stainless steels at moderate speeds and feeds. This grade offers an extraordinary combination of toughness, built-up edge resistance, and wear resistance in stainless steel applications. beyond DRIVE	P									
		M									
KCM25 —	**Composition:** A multilayer CVD coating comprised of MTCVD TiCN-Al_2O_3 layers over a tough, cobalt-enriched carbide substrate. **Application:** This CVD-coated grade is designed for general-purpose machining of austenitic stainless steels at moderate speeds and feeds. This grade offers an extraordinary combination of toughness, built-up edge resistance, and wear resistance in stainless steel applications. beyond	P									
		M									
KCM35B —	**Composition:** A multilayer MTCVD TiCN-Al_2O_3-TiOCN coating over a super-tough substrate. **Application:** Engineered to take on the most brutal cast stainless steel machining applications. The substrate withstands heavy interruptions, while the coating provides the wear resistance needed for long tool life. The polished surface resists edge build-up, even at slow cutting speeds. Available in insert sizes and geometries appropriate for heavy feeds and large depths of cut. beyond DRIVE	P									
		M									
KCM35 —	**Composition:** A multilayer MTCVD TiCN-Al_2O_3 coating over a super-tough substrate. **Application:** Engineered to take on the most brutal cast stainless steel machining applications. The substrate withstands heavy interruptions, while the coating provides the wear resistance needed for long tool life. The polished surface resists edge build-up, even at slow cutting speeds. Available in insert sizes and geometries appropriate for heavy feeds and large depths of cut. beyond	P									
		M									

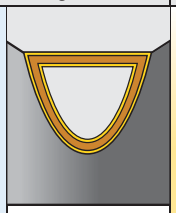
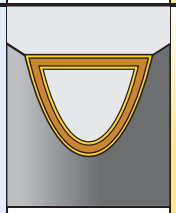


Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

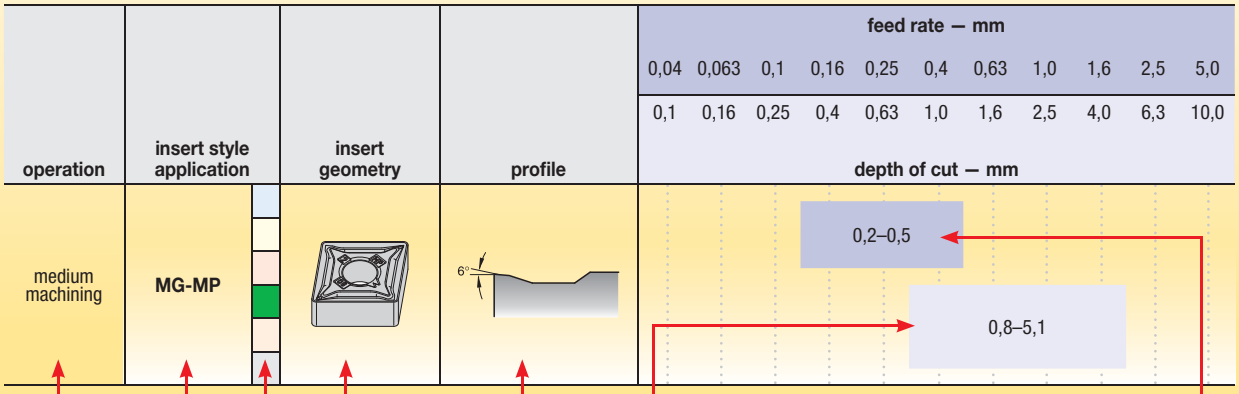
wear resistance ← → toughness

PVD-Coated Cermet Grades

Coating	Grade Description		05	10	15	20	25	30	35	40	45
KT315  —	**Composition:** A multilayer PVD TiN/TiCN/TiN-coated cermet turning grade. **Application:** Ideal for high-speed finishing to medium machining of most carbon and alloy steels and stainless steels. Performs very well in cast and ductile iron applications, too. Provides long and consistent tool life and will produce excellent workpiece finishes.	P									
		M									
		K									
KTP10  —	**Composition:** A multilayer PVD TiN/TiCN/TiN-coated cermet turning grade. **Application:** Ideal for high-speed finishing to medium machining of most carbon and alloy steels and stainless steels. Performs very well in cast and ductile iron applications, too. Provides long and consistent tool life and will produce excellent workpiece finishes.	P									
		M									
		K									

Select the geometry — based on feed rate and depth of cut

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



Feed Rate Range —
for best results, use the centre 60% of the range

Depth-of-Cut Range —
for all inserts in the programme, select smaller inserts for lighter cuts and larger inserts for heavy cuts

Pictorial View of Insert

Chipbreaker Geometry —
section is through nose radius of insert

Primary Workpiece Material Group

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

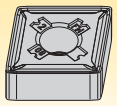
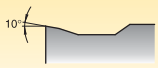
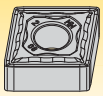
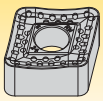
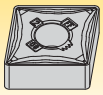
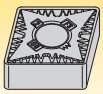
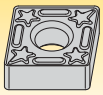
Chip Control Geometry Designation —
example: MG-MP = CNMG-432MP

Machining Operation —
for what the insert geometry is designed

NOTE: For detailed grade and geometry recommendations, reference the Kennametal Beyond™ Selection System on pages B8–B21.

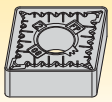
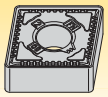
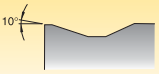
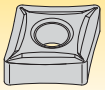
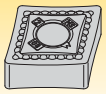
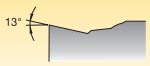
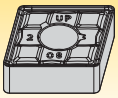
Select the geometry – based on feed rate and depth of cut

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

operation	insert style application	insert geometry	profile	feed rate – mm: 0,04 / 0,063 / 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 5,0 depth of cut – mm: 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 4,0 / 6,3 / 10,0
wiper finishing	**MG-FW**			0,2–0,4 0,25–2,0
wiper medium machining	**MG-MW**			0,3–0,6 0,8–5,1
wiper roughing	**MM-RW**			0,3–1,3 1,3–12,7
fine finishing	**MG-FF**			0,05–0,25 0,08–2,0
finishing sharp	**GG-FS** precision ground			0,07–0,25 0,20–2,0
finishing	**GG-LF** precision ground			0,1–0,5 0,5–3,0

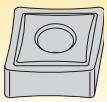
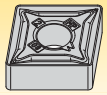
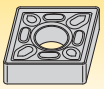
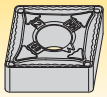
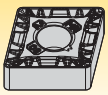
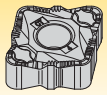
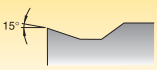
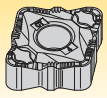
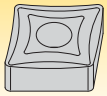
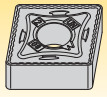
Select the geometry — based on feed rate and depth of cut

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

operation	insert style application	insert geometry	profile	feed rate — mm: 0,04 / 0,063 / 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 5,0 depth of cut — mm: 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 4,0 / 6,3 / 10,0
finishing	MG-FP			0,1–0,3 0,25–2,5
	MG-FN			0,1–0,3 0,3–2,5
	MP-K			0,1–0,3 0,2–2,5
medium sharp	MG-MS			0,12–0,35 0,76–5,0
medium machining	MG-UP			0,2–0,6 1–6,4

Select the geometry — based on feed rate and depth of cut

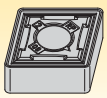
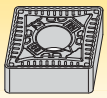
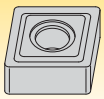
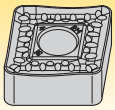
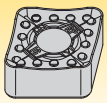
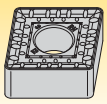
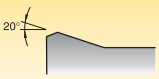
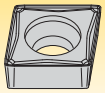
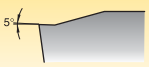
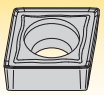
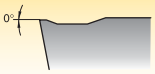
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

operation	insert style application	insert geometry	profile	feed rate — mm: 0,04 / 0,063 / 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 5,0 depth of cut — mm: 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 4,0 / 6,3 / 10,0
medium machining	_GP*			0,3–0,5 0,5–3,2
	MG-MP			0,15–0,5 0,8–5,1
	MG-P			0,15–0,5 0,75–5,0
	MG-MN			0,15–0,5 0,5–5,1
	MG-MR			0,15–0,55 1,5–6,3
	MG-CT O.D. turning			0,13–0,5 1,0–3,0
	MG-CT outward facing			0,25–0,5 0,25–1,0
	-MS single sided			0,15–0,4 0,6–2,3
	MG-UN			0,2–0,5 0,8–3,8

*35° and 55° geometries are single sided.

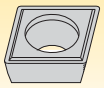
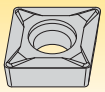
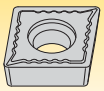
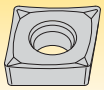
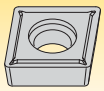
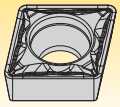
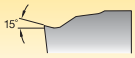
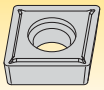
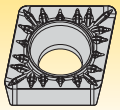
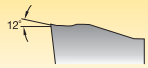
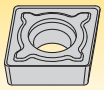
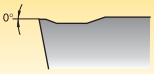
Select the geometry — based on feed rate and depth of cut

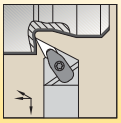
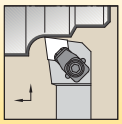
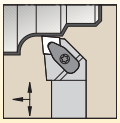
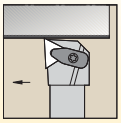
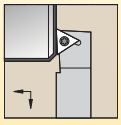
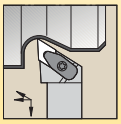
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

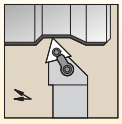
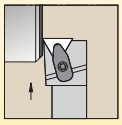
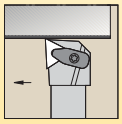
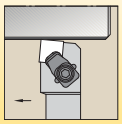
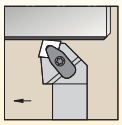
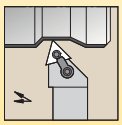
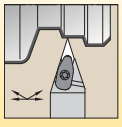
operation	insert style application	insert geometry	profile	feed rate — mm: 0,04 / 0,063 / 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 5,0 depth of cut — mm: 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 4,0 / 6,3 / 10,0
roughing	**MG-RP**			0,2–0,6 1,1–6,4
heavy roughing	**MG-RN**			0,3–0,63 1,1–5,7
	MG			0,3–0,8 1,1–5,7
	MM-RM single sided			0,3–1,0 1,3–12,7
	MM-RP single sided			0,2–1,0 1,3–10,0
	MM-RH single sided			0,4–1,3 1,3–12,7
wiper finishing	**MT-FW**			0,08–0,35 0,2–1,5
wiper, medium finishing	**MT-MW**			0,12–0,5 0,4–3,3

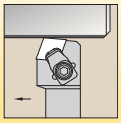
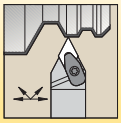
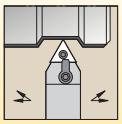
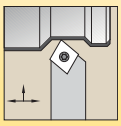
Select the geometry — based on feed rate and depth of cut

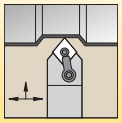
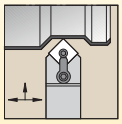
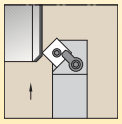
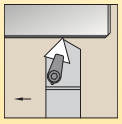
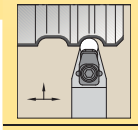
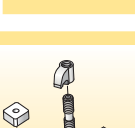
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

operation	insert style application	insert geometry	profile	feed rate — mm: 0,04 / 0,063 / 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 5,0 — depth of cut — mm: 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 4,0 / 6,3 / 10,0
fine finishing	_GM precision ground			0,05–0,2 0,2–1,0
	MT-11			0,08–0,25 0,2–1,3
	.MT-UF			0,05–0,25 0,1–1,3
finishing	GT-HP precision ground			0,2–0,4 0,6–2,3
	GT-LF precision ground			0,2–0,4 0,8–2,3
	MT-FP			0,063–0,25 0,16–1,6
	MT-LF			0,2–0,4 0,8–2,3
medium machining	MT-MP			0,15–0,4 0,4–2,3
	MT-MF			0,2–0,4 1,1–2,3

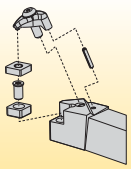
tool path	insert shape	clamping style	Turning	Profiling	Facing	Plunging	Chamfering	page(s)
117,5° Lead Angle								
	V 35°	Kenloc™	●	●	●			B151
		Kenclamp™	●		●			B150
107,5° Lead Angle								
	D 55°	Screw-On	●	●				B213
		TNT	●	●		●		B151
	V 35°	Screw-On	●	●				B265
97,5° Lead Angle								
	E 75°	MTS	●		●			–
95° Lead Angle								
	C 80°	Kenloc	●	●	●			B62
		Kenclamp	●	●	●			B59
		Kenlever™	●	●	●			B65
		Screw-On	●	●	●			B180, B193
		MTS	●	●	●			B358
	W 80°	Kenloc	●	●	●			B162
		Kenclamp	●	●	●			B161
		Kenlever	●	●	●			B163
		Screw-On	●	●	●			B271
		MTS	●	●	●			B369
		Wedgelock™	●	●	●			B162
93° Lead Angle								
	D 55°	Kenloc	●	●				B86
		Kenclamp	●	●				B85
		Kenlever	●	●				B87
		Screw-On	●	●				B210
		MTS	●	●				B360
	V 35°	Kenloc	●	●				B151
		Kenclamp	●	●				B149
		Screw-On	●	●				B267
	T 60°	Wedgelock	●	●				B133

tool path	insert shape	clamping style	Turning	Profiling	Facing	Plunging	Chamfering	page(s)
90° Lead Angle								
	C 80°	Screw-on	●	●	●			B179
	D 55°	Screw-on	●	●	●			B209
	V 35°	Screw-on	●	●	●			B266
	T 60°	Kenloc	●	●	●	●		B133
		Kenclamp	●	●	●			B132
		Kenlever	●	●	●			B135
		Screw-on	●	●	●			B247
		TNT	●	●	●			–
		Wedgelock	●	●	●			B133
85° Lead Angle								
	S 90°	MTS	●		●			B366
75° Lead Angle								
	C 80°	Kenloc	●	●	●			B61
		Kenclamp	●	●	●			B58
		Kenlever	●		●			B64
		TNT	●	●				–
		Screw-On	●		●			B180
		MTS	●					B356
	S 90°	Kenloc	●		●			B108
		Kenclamp	●		●			B105
		Kenlever	●	●	●			B111
		Screw-On	●	●	●			B233
		MTS	●	●	●			B364
72,5° Lead Angle								
	V 35°	Kenloc	●	●				B152
		Kenclamp		●				B150
		Screw-On	●	●				B268

tool path	insert shape	clamping style	Turning	Profiling	Facing	Plunging	Chamfering	page(s)
70° Lead Angle								
	E 75°	**Kenloc™**	●	●				–
63° Lead Angle								
	D 55°	**Kenloc**	●	●				B85
62,5° Lead Angle								
	D 55°	**Kenloc**	●	●	●			B86
		Kenlever	●	●	●			B88
		Screw-On	●	●				B211
60° Lead Angle								
 	T 60°	**Kenloc**	●	●	●			B133

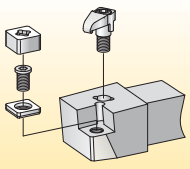
tool path	insert shape	clamping style	Turning	Profiling	Facing	Plunging	Chamfering	page(s)
50° Lead Angle								
	V 80°	**Kenloc**	●	●	●			B63
45° Lead Angle								
	C 80°	**Kenloc**	●	●	●			B60
		Kendex™	●	●	●			B66
		Screw-On	●	●	●			B192
  	S 90°	**Kenloc**	●	●	●			B109
		Kenclamp	●	●	●			B105
		Kenlever™	●	●	●			B111
		Kendex	●	●	●			–
		Screw-On	●	●	●			B233
		MTS	●	●	●			B213
	T 60°	**Kenlever**	●	●	●			B86
 	R	**Kenloc**	●	●	●			B95
		Kenclamp	●	●	●			–
		Fix-Perfect™	●	●	●			–
		Screw-On	●	●	●			B227
		MTS	●	●	●			B365

Clamping Styles



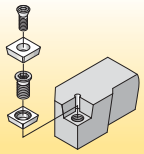
Kenclamp Style

- Uses Kenloc negative style inserts.
- Unique clamp design provides rigid clamping.
- Ensures insert repeatability and seating.
- Reduced chatter and improved tool life.



MTS Style Modular Tooling System

- Proven superior system in holding ceramic inserts rigidly in turning and profiling operations.
- Uses standard insert sizes — 80°, 75°, 55°, square, and trigon.
- This system offers the added versatility of using optional hardware to hold standard Kendex and Kenloc inserts.

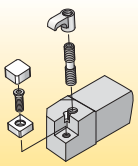


Screw-On Style

- Top clamping by screw for Screw-On inserts.

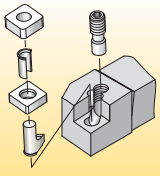
Kenloc Style

- Uses Kenloc negative style inserts.
- Lock pin and top clamp provide rigid clamping.
- Wide variety of insert styles may be used.
- Tools may be used with or without clamp.



Kendex Style

- Uses Kendex inserts.
- Chipbreaker option available for ceramic inserts.
- Wide variety of insert styles may be used.

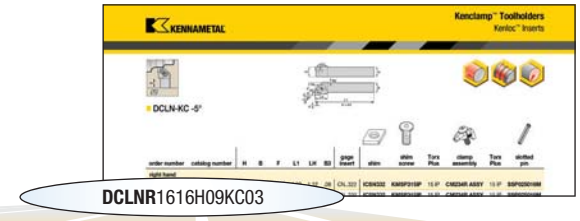


Kenlever Style

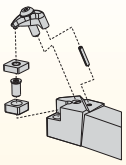
- Proven superior system for holding ceramic inserts rigidly in turning and profiling operations.
- Can be used on Kendex or Kenloc inserts using optional hardware.

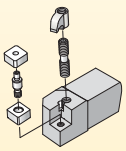
How Do Catalogue Numbers Work?

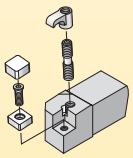
Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



D — Insert Holding Method

D

Kenclamp™

M

Kenloc™

C

Kendex™

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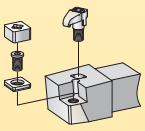
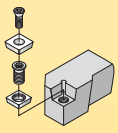
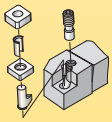

Top Notch™ Profiling

S

Screw-On

P

Kenlever™

C — Insert Shape

A	85°
B	82°
C	80°
D	55°
E	75°
H	120°
K	55°
L	90°
M	86°
O	135°
P	108°
R	
S	90°
T	60°
V	35°
W	80°

L — Tool Style or Lead Angle

A	90°	L	95°
B	15°	M	50°
C	90°	P	107,5°
D	45°	Q	107,5°
E	60°	R	75°
F	90°	S	45°
G	90°	U	93°
H	107,5°	V	72,5°
J	93°	Y	85°
K	75°		

N — Insert Clearance Angle

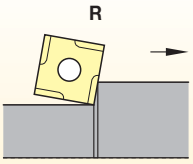
N	0°
B	5°
C	11°
P	11°
D	15°
E	20°
F	25°

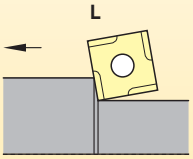
R — Hand of Tool

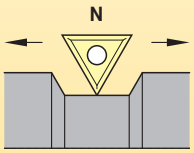
R =
Right hand

L =
Left hand

N =
Neutral







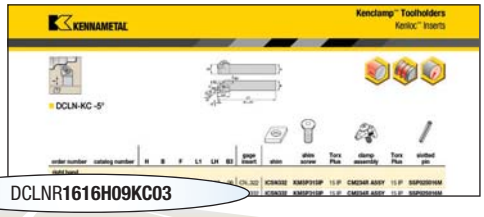
Additional Information

C =
Deep pocket for ceramic insert

S =
Single pocket locating wall

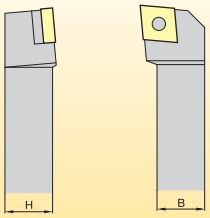
F =
Straight shank, no offset

By referencing this easy-to-use guide, you can identify the correct product to meet your needs.



DCLNR**1616H09KC03**

16	16	H	09	KC	03
Shank Dimensions		Tool Length	Insert Size	Additional Information	Insert Thickness *(optional)*



The seventh and eighth position shall be a significant two-digit number that indicates the holder cross section.

- If the dimension for the width "B" or the height "H" is represented by a one-digit number, a 0 (zero) will be used in front of it.

Example: 8,0mm = 08

L1	ISO
32	A
40	B
50	C
60	D
70	E
80	F
90	G
100	H
110	J
125	K
140	L
150	M
160	N
170	P
180	Q
200	R
250	S
300	T
350	U
400	V
450	W
500	Y
Special Design	X

KC =
Kenclamp™

H4 =
Wedgelock™ clamping system

M =
MTS clamping system for ceramic and PcBN inserts

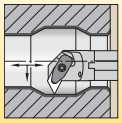
04 = 4,76mm

06 = 6,35mm

Cutting Edge Length L10

H	Hexagon 120°	
O	Octagon 135°	
P	Pentagon 108°	
S	Square 90°	
T	Triangular 60°	
R	Round —	
C	Rhomboid 80°	
D	55°	
E	75°	
M	86°	
V	35°	
W	Trigon 80° with enlarged corner angles	
L	Rectangular 90°	
A	Parallelogram 85°	
B	82°	
K	55°	

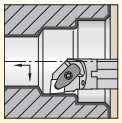
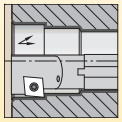
117,5° Lead Angle

tool path	insert shape	clamping style	Boring	Back Boring	Profiling	page(s)
	D 55°	Kenclamp™	•		•	B89

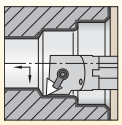
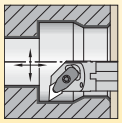
107,5° Lead Angle

tool path	insert shape	clamping style	Boring	Back Boring	Profiling	page(s)
	D 55°	Kenclamp	•	•	•	B89
		Screw-On	•	•		B212, B217
	V 35°	Screw-On	•	•	•	B268

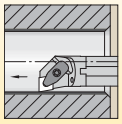
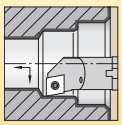
95° Lead Angle

tool path	insert shape	clamping style	Boring	Back Boring	Profiling	page(s)
	C 80°	Kenloc™	•		•	B67
		Kenclamp	•		•	B66
		Screw-on	•		•	B182, B196
		Kenlever™	•		•	B68
		MTS	•		•	B372
	E 75°	MTS	•		•	–
	T 60°	Screw-On	•		•	B250
	W 80°	Kenloc	•			B164
		Kenclamp	•		•	B163
		Kenlever	•		•	B165
		Screw-on	•		•	B271
		MTS	•		•	B374

93° Lead Angle

tool path	insert shape	clamping style	Boring	Back Boring	Profiling	page(s)
	C 55°	Kenloc	•	•	•	B90
		Kenclamp	•	•	•	B90
		Screw-on	•		•	B212, B217
		MTS	•		•	–
	V 35°	Kenloc	•		•	B153
		Kenclamp	•	•		B152
		Screw-on	•	•	•	B269
	T 60°	Kendex™	•		•	B371
	W 80°	Screw-On	•		•	B272

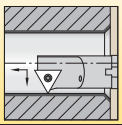
90° Lead Angle

tool path	insert shape	clamping style	Boring	Back Boring	Profiling	page(s)
	C 80°	Screw-On	•		•	B182, B194
	T 60°	Kenloc	•			B137
		Kenclamp	•		•	B137
		Kenlever	•		•	B138
		Kendex	•		•	–
		Screw-On	•			B248, B257

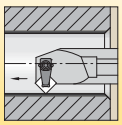
75° Lead Angle

tool path	insert shape	clamping style	Boring	Back Boring	Profiling	page(s)
	C 80°	Screw-On	•			B195
	S 90°	Kenloc	•			B114
		Kenclamp	•			B113
		Kenlever	•			B114
		Kendex	•			–
		Screw-On	•			B233
	T 60°	MTS	•			–
		Kendex	•			–

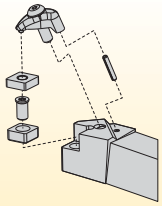
60° Lead Angle

tool path	insert shape	clamping style	Boring	Back Boring	Profiling	page(s)
	T 60°	Screw-On	•		•	–

45° Lead Angle

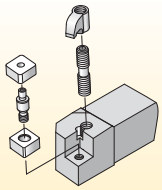
tool path	insert shape	clamping style	Boring	Back Boring	Profiling	page(s)
	S 90°	MTS	•			B373

Clamping Styles



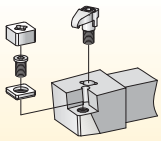
Kenclamp™ Style

- Uses Kenloc™ negative style inserts.
- Unique clamp design provides rigid clamping.
- Ensures insert repeatability and seating.
- Reduced chatter and improved tool life.



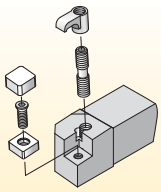
Kenloc™ Style

- Uses Kenloc™ negative style inserts.
- Lock pin and top clamp provide rigid clamping.
- Wide variety of insert styles may be used.
- Tools may be used with or without clamp.



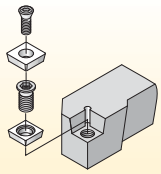
MTS Style

- Proven superior system in holding ceramic inserts rigidly in turning and profiling operations.
- Uses standard insert sizes — 80°, 75°, 55°, square, and trigon.
- This system offers the added versatility of using optional hardware to hold standard Kendex and Kenloc inserts.



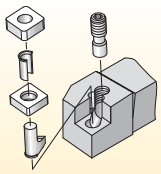
Kendex™ Style

- Uses Kendex inserts.
- Chipbreaker option available for ceramic inserts.
- Wide variety of insert styles may be used.



Screw-On Style

- Top clamping by screw for Screw-On inserts.

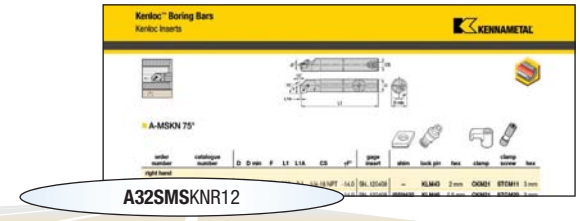


Kenlever™ Style

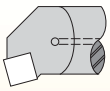
- Proven superior system for holding ceramic inserts rigidly in turning and profiling operations.
- Can be used on Kendex or Kenloc inserts using optional hardware.

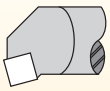
How Do Catalogue Numbers Work?

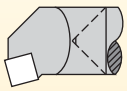
Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.

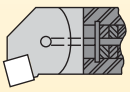


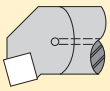
A — Bar Type

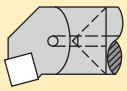
A 
Steel bar with coolant

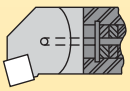
S 
Steel bar without coolant

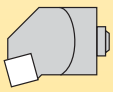
C 
Carbide bar

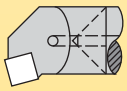
D 
DeVibrator bar with coolant

D 
Tunable bar with coolant

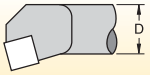
E 
Carbide bar with coolant

B 
DeVibrator

H 
Interchangeable head

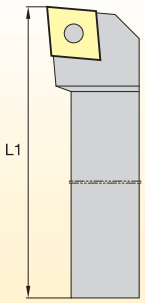
L 
Heavy metal bar with coolant

32 — Bar Diameter



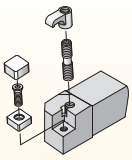
Metric:
A two-digit number indicates the bar diameter in mm.
If the diameter is represented by a one digit number, a 0 (zero) will be used in front of it.
Example: 8mm = 08

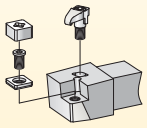
S — Bar Length**

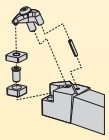


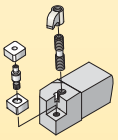
L1		ISO
32	=	A
40	=	B
50	=	C
60	=	D
70	=	E
80	=	F
90	=	G
100	=	H
110	=	J
125	=	K
140	=	L
150	=	M
160	=	N
170	=	P
180	=	Q
200	=	R
250	=	S
300	=	T
350	=	U
400	=	V
450	=	W
500	=	Y
Special Length	=	X

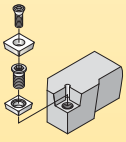
M — Insert Holding Method

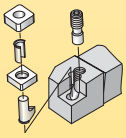
C 
Kendex™

N 
Top Notch™ Profiling

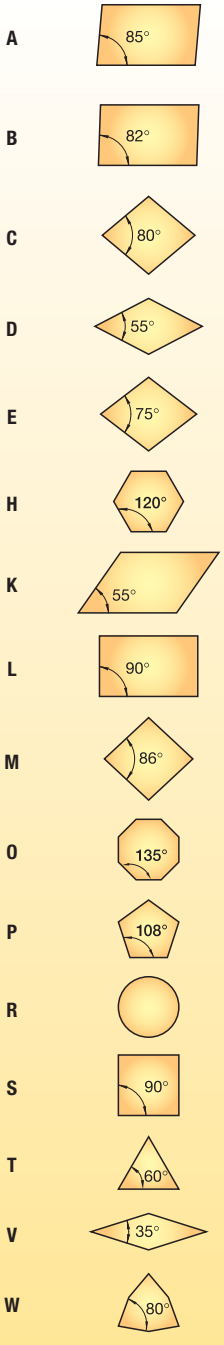
D 
Kenclamp™

M 
Kenloc™

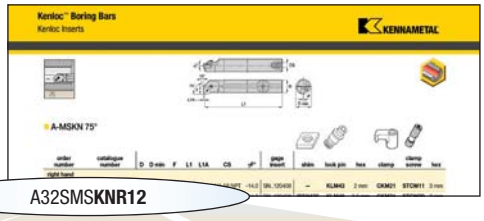
S 
Screw-On

P 
Kenlever™

S — Insert Shape



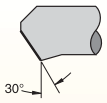
By referencing this easy-to-use guide, you can identify the correct product to meet your needs.



A32SMS**KNR12**

K	**N**	**R**	**12**	
Bar Style or Lead Angle	Insert Clearance Angle	Hand of Tool	Insert Size Cutting Edge Length L10	Additional Information

K – Bar Style or Lead Angle

E


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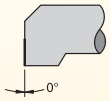
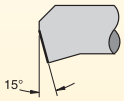
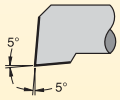
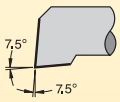


K


L


(E-style inserts)

L


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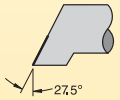

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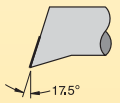

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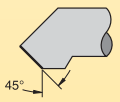

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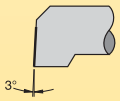
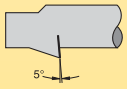
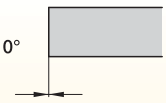
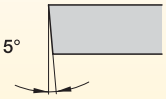
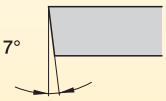


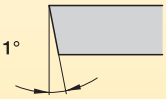
X


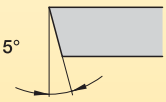
N – Insert Clearance Angle

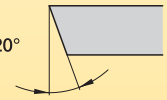
N 0°


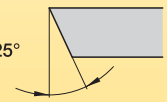
B 5°


C 7°


P 11°


D 15°


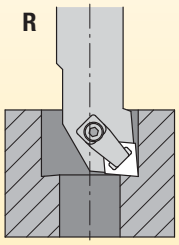
E 20°


F 25°


R – Hand of Tool

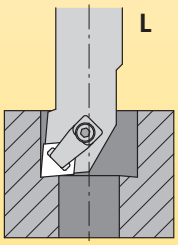
R =

Right-hand boring bar



L =

Left-hand boring bar



12 – Insert Size Cutting Edge Length L10

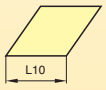
H


O

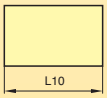

P

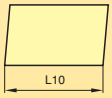

S


T


CDE M V


W


L


A B K


R


Additional Information

M... =

TNT/MTS clamping systems for ceramic and PcBN inserts

D =

Dual pocket

AP5 =

Axial positive

KC =

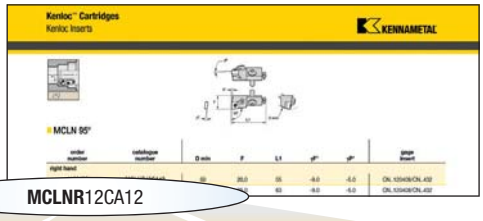
Kenclamp™

+ =

Insert Thickness

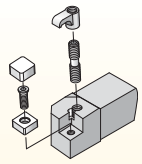
How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



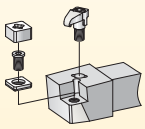
M
Insert Clamping System

C



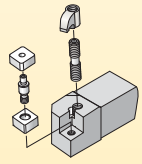
Kendex™

N



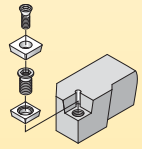
Top Notch™ Profiling

M



Kenloc™

S



Screw-On

C
Insert Shape

C 80°

D 55°

R

S 90°

T 60°

W 80°

L
Tool Style or Lead Angle

A 0°

B 15°

C 0°

D 45°

E 30°

F 0°

G 0°

H 50°

J 3°

K 15°

L 5° 5°

M 40°

P 27.5°

Q 27.5°

R 15°

S 45°

U 3°

V 17.5°

Y 5°

N
Insert Clearance Angle

N 0°

B 5°

C 7°

P 11°

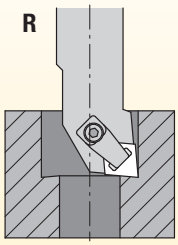
D 15°

E 20°

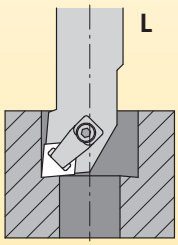
F 25°

R
Hand of Tool

R =
Right-hand boring bar



L =
Left-hand boring bar



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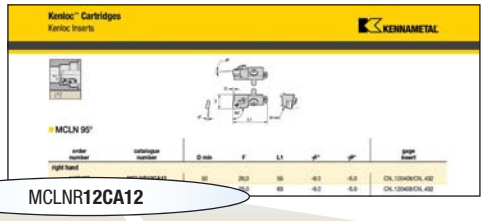
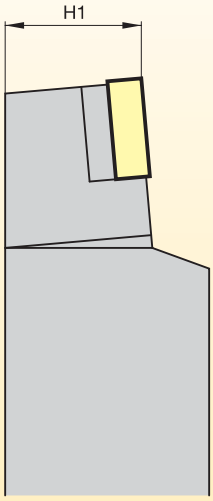


MCLNR**12CA12**

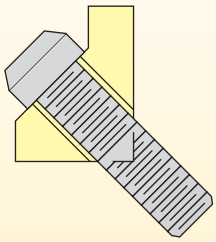
12	C	A	12
Cartridge Size	Identifying Code of Cartridge	Mounting Design of Cartridge	Insert Size

H1 = Cutting edge height of cartridge, in millimetres



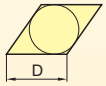
C = Cartridge

A = Angular acc. ISO 5611



Cutting edge length D

C


D


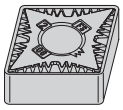
R

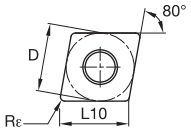

S


T


W

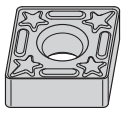

● first choice
○ alternate choice

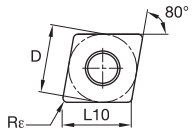




CNGG-FS

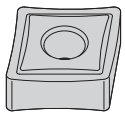
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
				P ●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
				M								○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
				K ○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
				N																							●	●	●	●	●	●	●	
				S																							●	●	●	●	●	●		
				H																														
CNGG120401FS	12,70	12,90	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–
CNGG120402FS	12,70	12,90	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–
CNGG120404FS	12,70	12,90	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
CNGG120408FS	12,70	12,90	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–

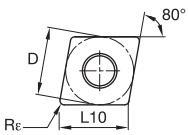




CNGG-LF

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNGG120401LF	12,70	12,90	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
CNGG120402LF	12,70	12,90	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
CNGG120404LF	12,70	12,90	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
CNGG120408LF	12,70	12,90	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
CNGG120412LF	12,70	12,90	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–



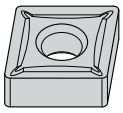


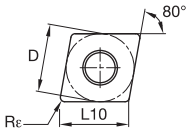
CNGP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNGP120401	12,70	12,90	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–
CNGP120402	12,70	12,90	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–
CNGP120404	12,70	12,90	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	–	●	–
CNGP120408	12,70	12,90	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	–	●	–
CNGP120412	12,70	12,90	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–	●	–
CNGP120416	12,70	12,90	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–

NOTE: Indexable Inserts for P-clamping.

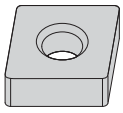
● first choice
○ alternate choice

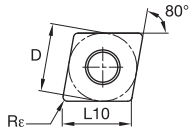




CNGP-K

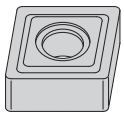
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
CNGP120408K	12,70	12,90	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
CNGP160612K	15,88	16,12	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–

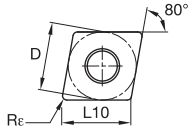




CNMA

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMA120404	12,70	12,90	0,4	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMA120408	12,70	12,90	0,8	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
CNMA120412	12,70	12,90	1,2	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMA120416	12,70	12,90	1,6	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMA160608	15,88	16,12	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMA160612	15,88	16,12	1,2	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMA160616	15,88	16,12	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMA190612	19,05	19,34	1,2	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMA190616	19,05	19,34	1,6	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

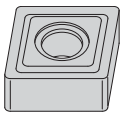


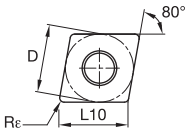


CNMG

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG120404B	12,70	12,90	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
CNMG120408	12,70	12,90	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	●	–	–	–
CNMG120412	12,70	12,90	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
CNMG190612	19,05	19,34	1,2	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
CNMG190616	19,05	19,34	1,6	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG250924	25,40	25,79	2,4	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

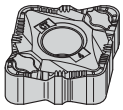
● first choice
○ alternate choice

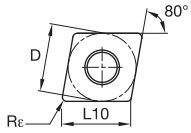




CNMG-33

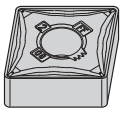
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG12040833	12,70	12,90	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●

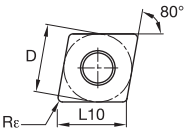




CNMG-CT

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG120408CT	12,70	12,90	0,8	–	●	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
CNMG120412CT	12,70	12,90	1,2	–	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120416CT	12,70	12,90	1,6	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

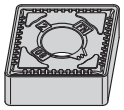


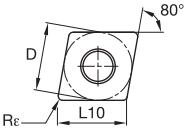


CNMG-FF

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG090304FF	9,53	9,67	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
CNMG090308FF	9,53	9,67	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
CNMG120404FF	12,70	12,90	0,4	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	●	–	–	●
CNMG120408FF	12,70	12,90	0,8	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	●	–	–	●

● first choice
○ alternate choice

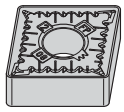


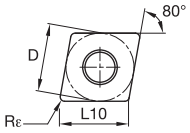


CNMG-FN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG090304FN	9,53	9,67	0,4	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●
CNMG090308FN	9,53	9,67	0,8	–	–	●	●	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120402FN	12,70	12,90	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●
CNMG120404FN	12,70	12,90	0,4	–	●	●	●	●	●	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●
CNMG120408FN	12,70	12,90	0,8	–	●	●	●	●	●	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●
CNMG120412FN	12,70	12,90	1,2	–	–	●	–	●	●	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●
CNMG120416FN	12,70	12,90	1,6	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

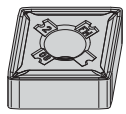
NOTE: Indexable Inserts for P-clamping.

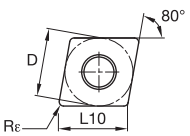




CNMG-FP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG120404FP	12,70	12,90	0,4	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	●	–	●	–	–	●
CNMG120408FP	12,70	12,90	0,8	–	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	●	–	●	–	–	●
CNMG120412FP	12,70	12,90	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	●	–	–	–	–	–

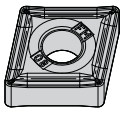


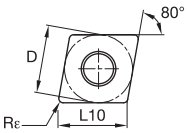


CNMG-FW

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG120404FW	12,70	12,90	0,4	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●
CNMG120408FW	12,70	12,90	0,8	●	●	●	●	–	–	–	–	–	–	–	–	●	–	–	–	●	–	–	–	–	–	–	–	–	●	–	●	–	–	●
CNMG120412FW	12,70	12,90	1,2	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●

● first choice
○ alternate choice

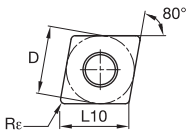




CNMG-FM

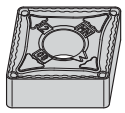
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
CNMG120412FM	12,70	12,90	1,2	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

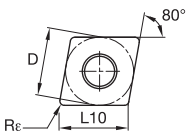




CNMG-LF

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG120402LF	12,70	12,90	0,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120404LF	12,70	12,90	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120408LF	12,70	12,90	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



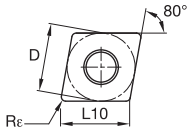


CNMG-MN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG090304MN	9,53	9,67	0,4	–	–	–	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG090308MN	9,53	9,67	0,8	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG090312MN	9,53	9,67	1,2	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120404MN	12,70	12,90	0,4	–	–	●	●	●	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120408MN	12,70	12,90	0,8	●	●	●	●	●	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
CNMG120412MN	12,70	12,90	1,2	–	●	●	●	●	●	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120416MN	12,70	12,90	1,6	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160608MN	15,88	16,12	0,8	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160612MN	15,88	16,12	1,2	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160616MN	15,88	16,12	1,6	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG190608MN	19,05	19,34	0,8	–	–	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG190612MN	19,05	19,34	1,2	–	–	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG190616MN	19,05	19,34	1,6	–	–	●	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG190624MN	19,05	19,34	2,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

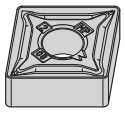
● first choice
○ alternate choice

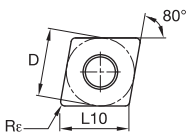




CNMU-MN

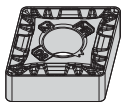
				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
ISO catalogue number	D	L10	Rε																															
CNMU120612MN	12,70	12,90	1,2	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMU120616MN	12,70	12,90	1,6	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

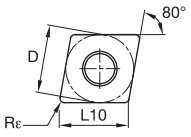




CNMG-MP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG090308MP	9,53	9,67	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–	–	–	–	●	–	●	–	–	–
CNMG120404MP	12,70	12,90	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	●	–	–	–	●	–	●	–	–	–
CNMG120408MP	12,70	12,90	0,8	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	●	–	–	–	●	●	●	●	–	–
CNMG120412MP	12,70	12,90	1,2	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	●	–	–	–	●	●	●	–	–	–
CNMG120416MP	12,70	12,90	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	●	–	–	–
CNMG160608MP	15,88	16,12	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	●	–	–	–	●	–	●	–	–	–
CNMG160612MP	15,88	16,12	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	●	●	●	–	–	–
CNMG160616MP	15,88	16,12	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	–	–
CNMG190608MP	19,05	19,34	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–	–	–	–	–	●	–	–	–
CNMG190612MP	19,05	19,34	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–	–	●	●	●	–	–	–
CNMG190616MP	19,05	19,34	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	●	–	–	–

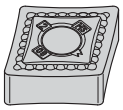


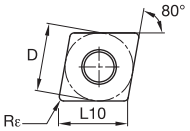


CNMG-MR

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG120404MR	12,70	12,90	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120408MR	12,70	12,90	0,8	–	–	●	–	●	–	●	–	–	●	–	–	●	–	–	–	●	●	●	●	–	●	●	–	–	●	–	–	–	–	–
CNMG120412MR	12,70	12,90	1,2	–	–	●	–	●	–	–	–	–	–	–	–	●	–	–	–	●	●	●	●	–	●	●	–	–	●	–	–	–	–	–
CNMG120416MR	12,70	12,90	1,6	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160608MR	15,88	16,12	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160612MR	15,88	16,12	1,2	–	–	●	–	●	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160616MR	15,88	16,12	1,6	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
CNMG190612MR	19,05	19,34	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–
CNMG190616MR	19,05	19,34	1,6	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

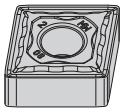
● first choice
○ alternate choice

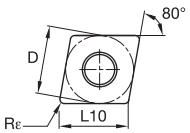




CNMG-MS

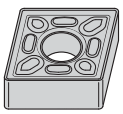
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
CNMG120401MS	12,70	12,90	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
CNMG120402MS	12,70	12,90	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
CNMG120404MS	12,70	12,90	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
CNMG120408MS	12,70	12,90	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
CNMG120412MS	12,70	12,90	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
CNMG120416MS	12,70	12,90	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
CNMG160608MS	15,88	16,12	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
CNMG160612MS	15,88	16,12	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
CNMG190608MS	19,05	19,34	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
CNMG190612MS	19,05	19,34	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
CNMG190616MS	19,05	19,34	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–

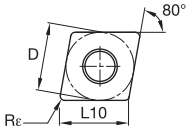




CNMG-MW

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG120408MW	12,70	12,90	0,8	–	●	●	●	●	●	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120412MW	12,70	12,90	1,2	–	●	●	●	●	●	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–

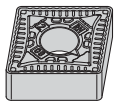


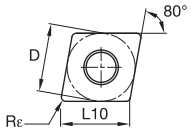


CNMG-P

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG120404P	12,70	12,90	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
CNMG120408P	12,70	12,90	0,8	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	●	–	●	–	●	–	–	–
CNMG120412P	12,70	12,90	1,2	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
CNMG190612P	19,05	19,34	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–

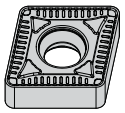
● first choice
○ alternate choice

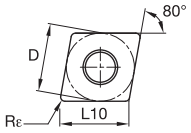




CNMG-RN

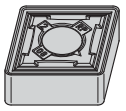
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
CNMG120408RN	12,70	12,90	0,8	–	●	●	●	●	●	●	●	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120412RN	12,70	12,90	1,2	–	–	●	●	●	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
CNMG120416RN	12,70	12,90	1,6	–	–	●	●	●	●	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160608RN	15,88	16,12	0,8	–	–	●	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160612RN	15,88	16,12	1,2	–	–	●	●	●	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
CNMG160616RN	15,88	16,12	1,6	–	–	●	●	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
CNMG190608RN	19,05	19,34	0,8	–	–	●	–	●	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG190612RN	19,05	19,34	1,2	–	–	●	●	●	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG190616RN	19,05	19,34	1,6	–	–	●	–	●	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
CNMG190624RN	19,05	19,34	2,4	–	–	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

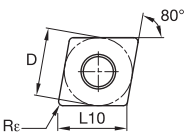




CNMU-RN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMU120412RN	12,70	12,90	1,2	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

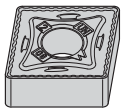


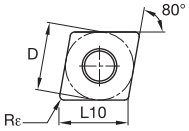


CNMG-RP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG120404RP	12,70	12,90	0,4	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	●	●	●	●	–	–
CNMG120408RP	12,70	12,90	0,8	●	●	●	●	●	●	●	●	–	●	–	●	●	●	●	●	●	●	●	●	●	●	–	–	●	●	●	●	–	–
CNMG120412RP	12,70	12,90	1,2	–	●	●	●	●	●	●	●	●	●	–	●	●	●	●	●	●	–	●	●	●	●	●	–	–	●	●	●	●	–	–
CNMG120416RP	12,70	12,90	1,6	–	–	●	●	●	●	–	–	–	–	–	–	–	●	–	●	–	–	●	●	–	●	–	–	–	●	●	●	–	–	–
CNMG160608RP	15,88	16,12	0,8	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	●	●	–	●	–	–
CNMG160612RP	15,88	16,12	1,2	–	–	●	●	●	●	–	●	●	●	–	●	–	●	●	●	●	–	●	●	●	●	●	–	–	●	●	●	●	–	–
CNMG160616RP	15,88	16,12	1,6	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	●	–	–	●	●	–	–	●	–	–	–	●	–	●	–	–
CNMG190612RP	19,05	19,34	1,2	–	–	●	–	●	●	–	●	●	–	–	–	–	●	–	–	–	–	●	●	–	●	–	–	–	●	●	●	●	–	–
CNMG190616RP	19,05	19,34	1,6	–	–	–	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	●	●	–	●	●	–	–	●	●	–	–	–	–

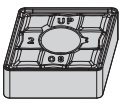
● first choice
○ alternate choice

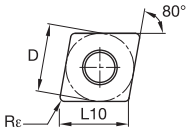




CNMG-UN

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
			P	●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
			M									○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
			K	○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
			N																								●	●	●	●	●	●	●	
			S																								●	●	●	●	●	●		
			H																															
ISO catalogue number	D	L10	Rε																															
CNMG120404UN	12,70	12,90	0,4	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120408UN	12,70	12,90	0,8	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120412UN	12,70	12,90	1,2	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120416UN	12,70	12,90	1,6	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160608UN	15,88	16,12	0,8	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160612UN	15,88	16,12	1,2	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160616UN	15,88	16,12	1,6	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG190608UN	19,05	19,34	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG190612UN	19,05	19,34	1,2	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG190616UN	19,05	19,34	1,6	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

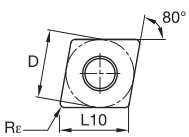




CNMG-UP

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	D	L10	Rε																															
CNMG120404UP	12,70	12,90	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–	–	–	–	–	●	–	–	–
CNMG120408UP	12,70	12,90	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	●	–	–	–	●	–	●	–	–	–
CNMG120412UP	12,70	12,90	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–	–	–	–	●	–	–	–
CNMG160608UP	15,88	16,12	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–
CNMG160612UP	15,88	16,12	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–	–	–	●	–	–	–	–	–
CNMG190612UP	19,05	19,34	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–
CNMG190616UP	19,05	19,34	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–

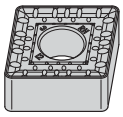


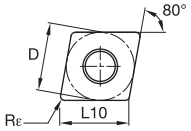


CNMM-MR

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	D	L10	Rε																															
CNMM120408MR	12,70	12,90	0,8	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM160612MR	15,88	16,12	1,2	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM160616MR	15,88	16,12	1,6	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM190616MR	19,05	19,34	1,6	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

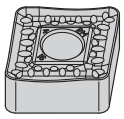
● first choice
○ alternate choice

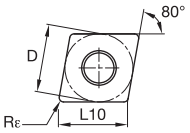




CNMM-RH

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
				P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ●	P ●	P ●	P ●	P ●	P ●	P ●	P	P ●
				M	M	M	M	M	M	M	M	M ○	M ○	M	M	M	M	M	M	M ●	M ●	M ●	M ●	M ●	M ●	M	M ●	M ●	M ●	M ●	M ●	M ●	M	M ●
				K ○	K ○	K ○	K ○	K ○	K ○	K	K	K	K	K ●	K ●	K ●	K ●	K ●	K ●	K	K	K	K	K	K	K ●	K ●	K ●	K ●	K ●	K ●	K ●	K	K ●
				N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N ●	N ●	N ●	N ●	N ●	N ●	N ●	N
				S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S ●	S ●	S ●	S ●	S ●	S ●	S	S
				H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H
CNMM190612RH	19,05	19,34	1,2	–	–	–	–	–	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM190616RH	19,05	19,34	1,6	–	–	●	–	●	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM190624RH	19,05	19,34	2,4	–	–	●	●	●	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM250924RH	25,40	25,79	2,4	–	–	–	●	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

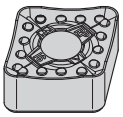


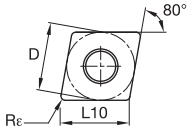


CNMM-RM

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMM120408RM	12,70	12,90	0,8	–	–	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM120412RM	12,70	12,90	1,2	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM160612RM	15,88	16,12	1,2	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM160616RM	15,88	16,12	1,6	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM160624RM	15,88	16,12	2,4	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM190612RM	19,05	19,34	1,2	–	–	–	●	●	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM190616RM	19,05	19,34	1,6	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM190624RM	19,05	19,34	2,4	–	–	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM250924RM	25,40	25,79	2,4	–	–	–	●	●	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

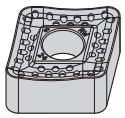
● first choice
○ alternate choice

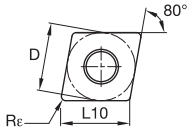




CNMM-RP

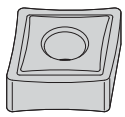
				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
ISO catalogue number	D	L10	Rε																															
CNMM120408RP	12,70	12,90	0,8	–	●	–	●	●	–	–	–	–	●	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–
CNMM120412RP	12,70	12,90	1,2	–	–	●	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM120416RP	12,70	12,90	1,6	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM160608RP	15,88	16,12	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM160612RP	15,88	16,12	1,2	–	–	●	●	–	●	–	–	–	●	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
CNMM160616RP	15,88	16,12	1,6	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–
CNMM160624RP	15,88	16,12	2,4	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM190612RP	19,05	19,34	1,2	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
CNMM190616RP	19,05	19,34	1,6	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
CNMM190624RP	19,05	19,34	2,4	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
CNMM250924RP	25,40	25,79	2,4	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

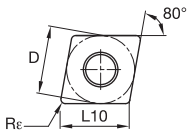




CNMM-RW

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	D	L10	Rε																															
CNMM190624RW	19,05	19,34	2,4	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMM250924RW	25,40	25,79	2,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

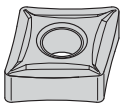


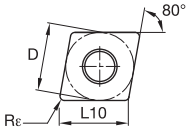


CNMP

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	D	L10	Rε																															
CNMP120404	12,70	12,90	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	●	–
CNMP120408	12,70	12,90	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	●	–
CNMP120412	12,70	12,90	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
CNMP160608	15,88	16,12	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMP190612	19,05	19,34	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–

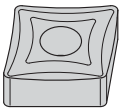
● first choice
○ alternate choice

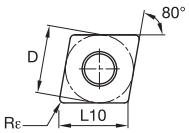




CNMP-K

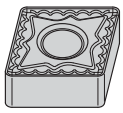
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
CNMP120404K	12,70	12,90	0,4	–	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMP120408K	12,70	12,90	0,8	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

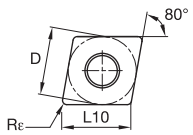




CNMS

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMS120408	12,70	12,90	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●	–
CNMS160608	15,88	16,12	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–
CNMS190608	19,05	19,34	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●	–
CNMS190612	19,05	19,34	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

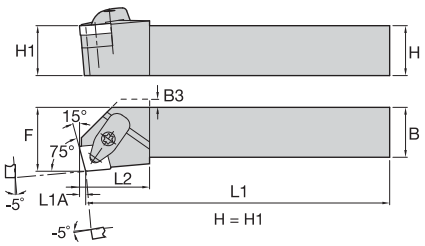


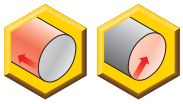


CNMG-MG

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
CNMG120408MG	12,70	12,90	0,8	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
CNMG120412MG	12,70	12,90	1,2	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG120416MG	12,70	12,90	1,6	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160612MG	15,88	16,12	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG160616MG	15,88	16,12	1,6	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG190612MG	19,05	19,34	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



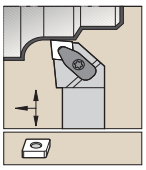


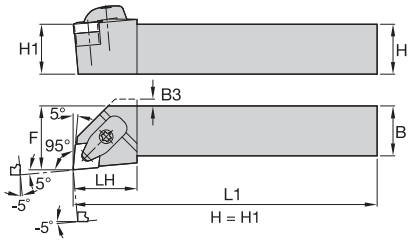


DCKN-KC 75°



order number	catalogue number	H	B	F	L1	LH	L1A	B3	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand																
2273083	**DCKNR2020K12KC04**	20	20	25,0	125	32,0	3,1	6,0	CN..120408	**ICSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**
1875200	**DCKNR2525M12KC04**	25	25	32,0	150	32,0	3,1	–	CN..120408	**ICSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**
2273084	**DCKNR3225P12KC04**	32	25	32,0	170	32,0	3,1	–	CN..120408	**ICSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
2273085	**DCKNR3232P16KC06**	32	32	40,0	170	32,0	3,8	–	CN..160612	**ICSN543**	**KMSP515IP**	15 IP	**CM209R ASSY**	15 IP	**SSP025016M**	**KLM58L15IP**
left hand																
2273087	**DCKNL2020K12KC04**	20	20	25,0	125	32,0	3,1	6,0	CN..120408	**ICSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**
1875204	**DCKNL2525M12KC04**	25	25	32,0	150	32,0	3,1	–	CN..120408	**ICSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**
2273088	**DCKNL3225P12KC04**	32	25	32,0	170	32,0	3,1	–	CN..120408	**ICSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**





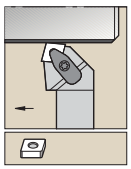
DCLN-KC 95°

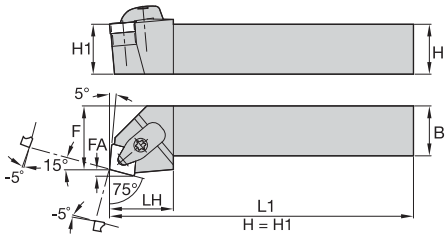


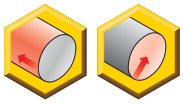




order number	catalogue number	H	B	F	L1	LH	B3	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand															
2417296	**DCLNR1616H09KC03**	16	16	20,0	100	30,0	6,0	CN..090308	**ICSN332**	**KMSP315IP**	9 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
1875199	**DCLNR2020K12KC04**	20	20	25,0	125	32,0	4,0	CN..120408	**ICSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**
1875193	**DCLNR2525M12KC04**	25	25	32,0	150	32,0	—	CN..120408	**ICSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
1875212	**DCLNR2525M16KC06**	25	25	32,0	150	33,0	—	CN..160612	**ICSN543**	**KMSP515IP**	15 IP	**CM209R ASSY**	15 IP	**SSP025016M**	**KLM58L15IP**
1875223	**DCLNR3225P12KC04**	32	25	32,0	170	32,0	—	CN..120408	**ICSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
1875232	**DCLNR3225P16KC06**	32	25	32,0	170	33,0	—	CN..160612	**ICSN543**	**KMSP515IP**	15 IP	**CM209R ASSY**	15 IP	**SSP025016M**	**KLM58L15IP**
1875224	**DCLNR3232P16KC06**	32	32	40,0	170	33,0	—	CN..160612	**ICSN543**	**KMSP515IP**	15 IP	**CM209R ASSY**	15 IP	**SSP025016M**	**KLM58L15IP**
2273091	**DCLNR3232P19KC06**	32	32	40,0	170	40,0	—	CN..190612	**ICSN643**	**KMSP625IP**	25 IP	**CM210R ASSY**	25 IP	**SSP025016M**	**KLM68L25IP**
2273092	**DCLNR4040S19KC06**	40	40	50,0	250	40,0	—	CN..190612	**ICSN643**	**KMSP625IP**	25 IP	**CM210R ASSY**	25 IP	**SSP025016M**	**KLM68L25IP**
left hand															
1875194	**DCLNL2020K12KC04**	20	20	25,0	125	32,0	4,0	CN..120408	**ICSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**
1875196	**DCLNL2525M12KC04**	25	25	32,0	150	32,0	—	CN..120408	**ICSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
1875205	**DCLNL2525M16KC06**	25	25	32,0	150	33,0	—	CN..160612	**ICSN543**	**KMSP515IP**	15 IP	**CM209R ASSY**	15 IP	**SSP025016M**	**KLM58L15IP**
1875231	**DCLNL3225P12KC04**	32	25	32,0	170	32,0	—	CN..120408	**ICSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
1875230	**DCLNL3225P16KC06**	32	25	32,0	170	33,0	—	CN..160612	**ICSN543**	**KMSP515IP**	15 IP	**CM209R ASSY**	15 IP	**SSP025016M**	**KLM58L15IP**
1875225	**DCLNL3232P16KC06**	32	32	40,0	170	33,0	—	CN..160612	**ICSN543**	**KMSP515IP**	15 IP	**CM209R ASSY**	15 IP	**SSP025016M**	**KLM58L15IP**
2273093	**DCLNL3232P19KC06**	32	32	40,0	170	40,0	—	CN..190612	**ICSN643**	**KMSP625IP**	25 IP	**CM210R ASSY**	25 IP	**SSP025016M**	**KLM68L25IP**
2273094	**DCLNL4040S19KC06**	40	40	50,0	250	40,0	—	CN..190612	**ICSN643**	**KMSP625IP**	25 IP	**CM210R ASSY**	25 IP	**SSP025016M**	**KLM68L25IP**





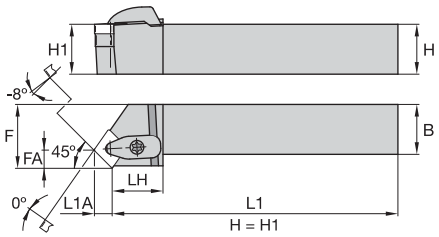


DCRN-KC 75°



order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand															
1875226	DCRNR2020K12KC04	20	20	25,0	125	32,0	3,3	CN..120408	ICSN433	KMSP415IP	15 IP	CM234R ASSY	15 IP	SSP025016M	KLM4615IP
1875201	DCRNR2525M12KC04	25	25	32,0	150	32,0	3,3	CN..120408	ICSN443	KMSP415IP	15 IP	CM234R ASSY	15 IP	SSP025016M	KLM46L15IP
2273095	DCRNR3225P12KC04	32	25	32,0	170	32,0	3,3	CN..120408	ICSN443	KMSP415IP	15 IP	CM234R ASSY	15 IP	SSP025016M	KLM46L15IP
2273097	DCRNR3232P19KC06	32	32	40,0	170	38,0	4,9	CN..190612	ICSN643	KMSP625IP	25 IP	CM210R ASSY	25 IP	SSP025016M	KLM68L25IP
left hand															
1875206	DCRNL2525M12KC04	25	25	32,0	150	32,0	3,3	CN..120408	ICSN443	KMSP415IP	15 IP	CM234R ASSY	15 IP	SSP025016M	KLM46L15IP
2273099	DCRNL3232P16KC06	32	32	40,0	170	38,0	4,1	CN..160612	ICSN543	KMSP515IP	15 IP	CM209R ASSY	15 IP	SSP025016M	KLM58L15IP



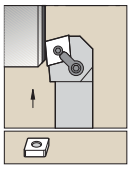


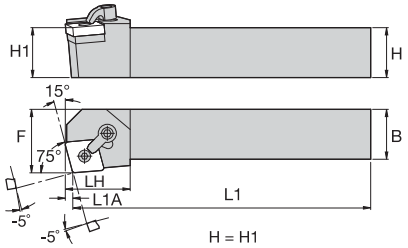


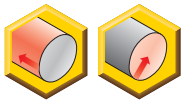
DCSN-KC 45°



order number	catalogue number	H	B	F	L1	LH	FA	L1A	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand																
2273101	DCSNR2020K12KC04	20	20	25,0	125	35,0	8,2	8,5	CN..120408	ICSN433	KMSP415IP	15 IP	CM234R ASSY	15 IP	SSP025016M	KLM4615IP
2273102	DCSNR2525M12KC04	25	25	32,0	150	35,0	8,2	8,5	CN..120408	ICSN443	KMSP415IP	15 IP	CM234R ASSY	15 IP	SSP025016M	KLM46L15IP
left hand																
2273104	DCSNL2525M12KC04	25	25	32,0	150	35,0	8,2	8,5	CN..120408	ICSN443	KMSP415IP	15 IP	CM234R ASSY	15 IP	SSP025016M	KLM46L15IP



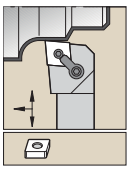


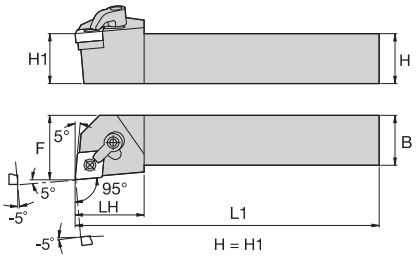


MCKN 75°



order number	catalogue number	H	B	F	L1	LH	L1A	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand														
1102236	**MCKNR2525M12**	25	25	32,0	150	32,0	3,1	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1102237	**MCKNR3225P12**	32	25	32,0	170	32,0	3,1	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1102240	**MCKNR3225P16**	32	25	32,0	170	33,0	3,6	CN..160612	**ICSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
left hand														
1102729	**MCKNL2525M12**	25	25	32,0	150	32,0	3,1	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1099253	**MCKNL3225P16**	32	25	32,0	170	33,0	3,6	CN..160612	**ICSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1102728	**MCKNL3232P19**	32	32	40,0	170	38,0	4,4	CN..190612	**ICSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm



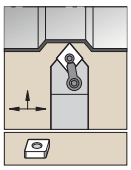


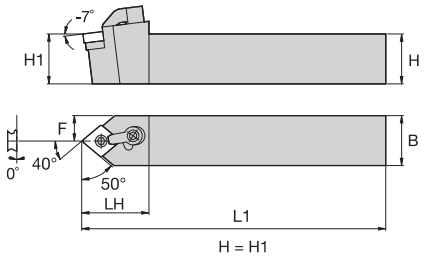


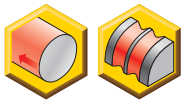
MCLN 95°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand													
1100939	**MCLNR1616H09**	16	16	20,0	100	25,0	CN..090308	–	**KLM33**	2 mm	**CKM6**	**STCM5**	2.5 mm
1101710	**MCLNR1616H12**	16	16	20,0	100	32,0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1099132	**MCLNR2020K09**	20	20	25,0	125	25,0	CN..090308	**ICSN332**	**KLM34L**	2 mm	**CKM6**	**STCM5**	2.5 mm
1099133	**MCLNR2020K12**	20	20	25,0	125	32,0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1100943	**MCLNR2525M09**	25	25	32,0	150	25,0	CN..090308	**ICSN332**	**KLM34L**	2 mm	**CKM6**	**STCM5**	2.5 mm
1101711	**MCLNR2525M12**	25	25	32,0	150	32,0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1101641	**MCLNR2525M16**	25	25	32,0	150	33,0	CNMA160612	**ICSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1101704	**MCLNR2525M19**	25	25	32,0	150	38,0	CN..190612	**ICSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
1101712	**MCLNR3225P12**	32	25	32,0	170	32,0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1101642	**MCLNR3225P16**	32	25	32,0	170	33,0	CN..160612	**ICSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1101705	**MCLNR3225P19**	32	25	32,0	170	38,0	CN..190612	**ICSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
3595785	**MCLNR3232P12**	32	32	40,5	171	32,0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
3595787	**MCLNR3232P16**	32	32	40,5	171	33,0	CN..160612	**ICSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1101706	**MCLNR3232P19**	32	32	40,0	170	38,0	CN..190612	**ICSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
1101707	**MCLNR4040R19**	40	40	50,0	200	38,0	CN..190612	**ICSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
left hand													
1100938	**MCLNL1616H09**	16	16	20,0	100	25,0	CN..090308	–	**KLM33**	2 mm	**CKM6**	**STCM5**	2.5 mm
1102539	**MCLNL1616H12**	16	16	20,0	100	32,0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1102540	**MCLNL2020K12**	20	20	25,0	125	32,0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1102541	**MCLNL2525M12**	25	25	32,0	150	32,0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1102440	**MCLNL2525M16**	25	25	32,0	150	33,0	CNMA160612	**ICSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1102534	**MCLNL2525M19**	25	25	32,0	150	38,0	CN..190612	**ICSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
1102542	**MCLNL3225P12**	32	25	32,0	170	32,0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1102442	**MCLNL3225P16**	32	25	32,0	170	33,0	CN..160612	**ICSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1102535	**MCLNL3225P19**	32	25	32,0	170	38,0	CN..190612	**ICSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
3595786	**MCLNL3232P12**	32	32	40,5	171	32,0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
3595788	**MCLNL3232P16**	32	32	40,5	171	33,0	CN..160612	**ICSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1102536	**MCLNL3232P19**	32	32	40,0	170	38,0	CN..190612	**ICSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
1102537	**MCLNL4040R19**	40	40	50,0	200	38,0	CN..190612	**ICSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm



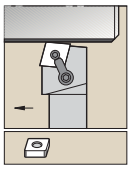


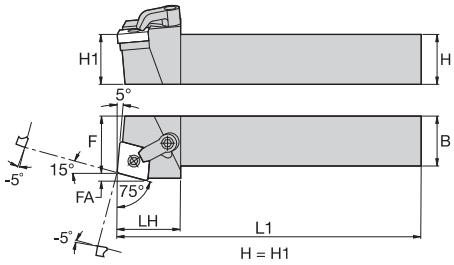


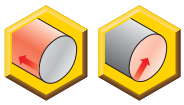
MCMN 50°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
1101708	MCMNN2020K12	61	20	10,0	125	32,0	CN..120408	ICSN432	KLM46	2.5 mm	CKM21	STCM20	3 mm
1101709	MCMNN2525M12	86	25	12,9	150	32,0	CN..120408	ICSN432	KLM46	2.5 mm	CKM21	STCM20	3 mm
1102538	MCMNN3225P16	94	32	12,9	170	38,0	CN..160612	ICSN533	KLM58	3 mm	CKM21	STCM20	3 mm
1102239	MCMNN4040R19	117	40	20,0	200	42,0	CN..190612	ICSN633	KLM68	4 mm	CKM12	STCM4	4 mm



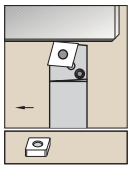


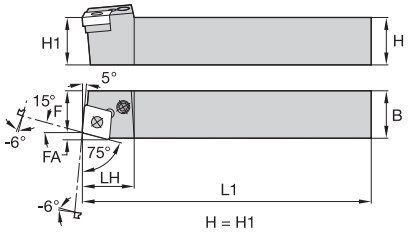


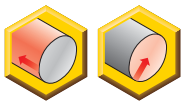
MCRN 75°



order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand														
1101638	MCRNR2020K12	20	20	25,0	125	32,0	3,3	CN..120408	ICSN432	KLM46	2.5 mm	CKM21	STCM20	3 mm
1101639	MCRNR2525M12	25	25	32,0	150	32,0	3,3	CN..120408	ICSN432	KLM46	2.5 mm	CKM21	STCM20	3 mm
1101640	MCRNR3225P12	32	25	32,0	170	32,0	3,3	CN..120408	ICSN432	KLM46	2.5 mm	CKM21	STCM20	3 mm
1102732	MCRNR3232P16	32	32	32,0	170	33,0	4,2	CN..160612	ICSN533	KLM58	3 mm	CKM21	STCM20	3 mm
1101643	MCRNR3232P19	32	32	40,0	170	38,0	4,6	CN..190612	ICSN633	KLM68	4 mm	CKM12	STCM4	4 mm
left hand														
1102437	MCRNL2525M12	25	25	32,0	150	32,0	3,3	CN..120408	ICSN432	KLM46	2.5 mm	CKM21	STCM20	3 mm
1102439	MCRNL3225P12	32	25	32,0	170	32,0	3,3	CN..120408	ICSN432	KLM46	2.5 mm	CKM21	STCM20	3 mm
1102241	MCRNL3232P16	32	32	32,0	170	33,0	4,2	CN..160612	ICSN533	KLM58	3 mm	CKM21	STCM20	3 mm
1102443	MCRNL3232P19	32	32	40,0	170	38,0	4,6	CN..190612	ICSN633	KLM68	4 mm	CKM12	STCM4	4 mm



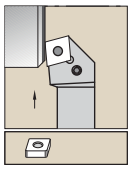


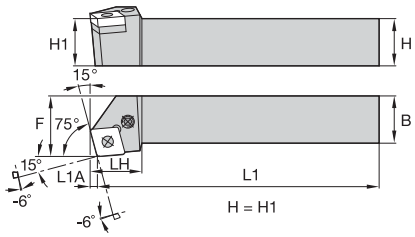


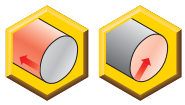
PCBN 75°



order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim pin	punch pin	lever	lever screw	Torx Plus
right hand														
1244779	**PCBNR2525M12**	25	25	22,0	150	26,0	3,1	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244635	**PCBNR2525M16**	25	25	22,0	150	28,0	4,2	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244636	**PCBNR3225P12**	32	25	22,0	170	28,0	3,1	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244637	**PCBNR3225P16**	32	25	22,0	170	28,0	4,2	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244638	**PCBNR3232P16**	32	32	27,0	170	38,0	4,2	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244795	**PCBNR3232P19**	32	32	27,0	170	38,0	4,6	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
1192373	**PCBNR4040S19**	40	40	35,0	250	38,0	4,6	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
left hand														
1244630	**PCBNL2020K12**	20	20	17,0	125	26,0	3,1	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244859	**PCBNL2525M12**	25	25	22,0	150	26,0	3,1	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244631	**PCBNL2525M16**	25	25	22,0	150	28,0	4,2	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244794	**PCBNL3232P16**	32	32	27,0	170	38,0	4,2	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244633	**PCBNL3232P19**	32	32	27,0	170	38,0	4,6	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
1192372	**PCBNL4040S19**	40	40	35,0	250	38,0	4,6	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP



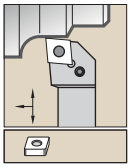


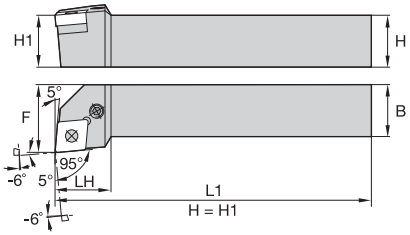


PCKN 75°



order number	catalogue number	H	B	F	L1	LH	L1A	gage insert	shim	shim pin	punch pin	lever	lever screw	Torx Plus
right hand														
1244649	**PCKNR2020K12**	20	20	25,0	125	23,0	3,1	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244797	**PCKNR2525M12**	25	25	32,0	150	23,0	3,1	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244775	**PCKNR2525M16**	25	25	32,0	150	30,0	3,8	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244650	**PCKNR3225P12**	32	25	32,0	170	26,0	3,1	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244776	**PCKNR3225P16**	32	25	32,0	170	30,0	3,8	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244798	**PCKNR3232P19**	32	32	40,0	170	37,5	4,6	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
left hand														
1244646	**PCKNL2020K12**	20	20	25,0	125	23,0	3,1	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244780	**PCKNL2525M12**	25	25	32,0	150	23,0	3,1	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244647	**PCKNL3225P12**	32	25	32,0	170	26,0	3,1	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244777	**PCKNL3225P16**	32	25	32,0	170	30,0	3,8	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244648	**PCKNL3232P19**	32	32	40,0	170	37,5	4,6	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP



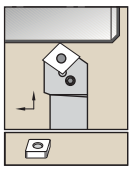


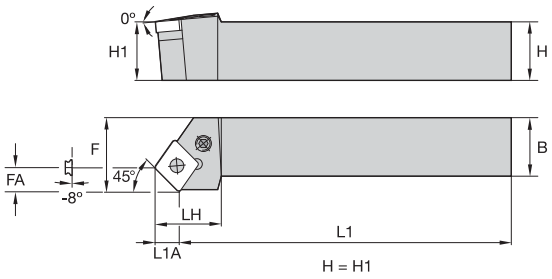


PCLN 95°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim pin	punch pin	lever	lever screw	Torx Plus
right hand													
1244809	**PCLNR1616H12**	16	16	20,0	100	26,0	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244810	**PCLNR2020K12**	20	20	25,0	125	26,0	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1108097	**PCLNR2525M12**	25	25	32,0	150	26,0	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1192378	**PCLNR2525M16**	25	25	32,0	150	28,0	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244652	**PCLNR2525M19**	25	25	32,0	150	36,0	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
1244811	**PCLNR3225P12**	32	25	32,0	170	26,0	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244812	**PCLNR3225P16**	32	25	32,0	170	38,0	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244653	**PCLNR3225P19**	32	25	32,0	170	38,0	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
1236864	**PCLNR3232P16**	32	32	40,0	170	36,0	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244813	**PCLNR3232P19**	32	32	40,0	170	36,0	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
1192379	**PCLNR4040S19**	40	40	50,0	250	36,0	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
left hand													
1244799	**PCLNL1616H12**	16	16	20,0	100	26,0	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1156962	**PCLNL2020K12**	20	20	25,0	125	26,0	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1192375	**PCLNL2525M12**	25	25	32,0	150	26,0	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1192376	**PCLNL2525M16**	25	25	32,0	150	28,0	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244800	**PCLNL2525M19**	25	25	32,0	150	36,0	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
1244858	**PCLNL3225P12**	32	25	32,0	170	26,0	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244802	**PCLNL3225P16**	32	25	32,0	170	38,0	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244803	**PCLNL3225P19**	32	25	32,0	170	38,0	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
1244804	**PCLNL3232P16**	32	32	40,0	170	36,0	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244805	**PCLNL3232P19**	32	32	40,0	170	36,0	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
1192377	**PCLNL4040S19**	40	40	50,0	250	36,0	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP





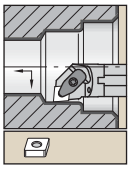


PCSN 45°

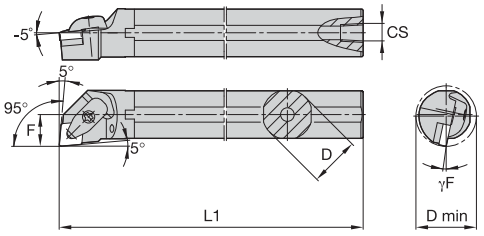


order number	catalogue number	H	B	F	L1	LH	FA	L1A	gage insert	shim	shim pin	punch pin	lever	lever screw	Torx Plus
right hand															
1244656	**PCSNR2020K12**	20	20	25,0	125	26,0	8,3	8,5	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244818	**PCSNR2525M12**	25	25	32,0	150	28,0	8,3	8,5	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244657	**PCSNR3225P12**	32	25	32,0	170	29,0	8,3	8,5	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244819	**PCSNR3232P19**	32	32	40,0	170	37,5	12,5	12,7	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
left hand															
1244654	**PCSNL2020K12**	20	20	25,0	125	26,0	8,3	8,5	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244655	**PCSNL2525M12**	25	25	32,0	150	28,0	8,3	8,5	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1284109	**PCSNL3225P12**	32	25	32,0	170	29,0	8,3	8,5	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244817	**PCSNL3232P19**	32	32	40,0	170	37,5	12,5	12,7	CN..190612	**512.123**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP

Kenclamp™ Boring Bars



Steel shank with through coolant.

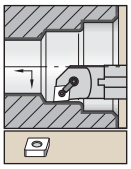




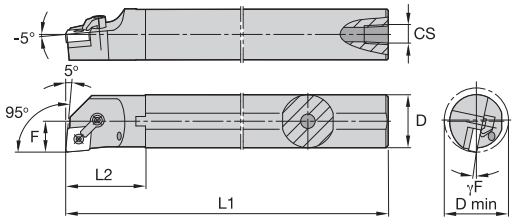
A-DCLN-KC 95°



order number	catalogue number	D	D min	F	L1	CS	γF°	gage insert	shim	shim screw	Torx Plus	clamp assembly	slotted pin	Torx Plus
right hand														
2441867	**A25RDCLNR12KC04**	25	32,0	17,0	200	1/4-18 NPT	-12.0	CN.120408	**–**	**–**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441931	**A32SDCLNR12KC04**	32	40,0	22,0	250	1/4-18 NPT	-12.0	CN.120408	**ICSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441933	**A40TDCLNR12KC04**	40	50,0	27,0	300	1/4-18 NPT	-9.0	CN..120408	**ICSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
left hand														
2441930	**A25RDCLNL12KC04**	25	32,0	17,0	200	1/4-18 NPT	-12.0	CN.120408	**–**	**–**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441932	**A32SDCLNL12KC04**	32	40,0	22,0	250	1/4-18 NPT	-12.0	CN.120408	**ICSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441934	**A40TDCLNL12KC04**	40	50,0	27,0	300	1/4-18 NPT	-9.0	CN.120408	**ICSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441938	**A40TDCLNL16KC06**	40	50,0	27,0	300	1/4-18 NPT	-12.0	CN..160612	**ICSN533**	**KMSP515IP**	15 IP	**CM209R ASSY**	**SSP025018M**	15 IP



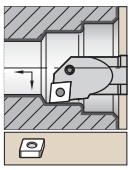
Steel shank with through coolant.



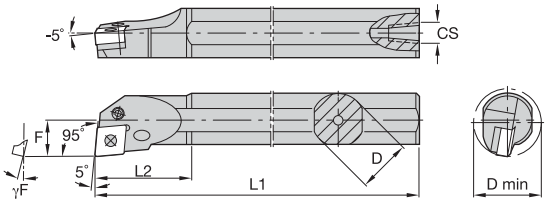
A-MCLN 95°



order number	catalogue number	D	D min	F	L1	L2	CS	γF°	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand															
1098767	**A25RMCLNR09**	25	32,0	17,0	200	40,0	1/4-18 NPT	-12.0	CN..090308	**–**	**KLM33**	2 mm	**CKM6**	**STCM5**	2.5 mm
1098088	**A25RMCLNR12**	25	32,0	17,0	200	33,0	1/4-18 NPT	-12.0	CN..120408	**–**	**KLM43**	2 mm	**CKM21**	**STCM11**	3 mm
1098090	**A32SMCLNR12**	32	40,0	22,0	250	–	1/4-18 NPT	-12.0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1098092	**A40TMCLNR12**	40	50,0	27,0	300	–	1/4-18 NPT	-12.0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1098096	**A40TMCLNR16**	40	50,0	27,0	300	–	1/4-18 NPT	-11.0	CN..160612	**ICSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1098094	**A50UMCLNR12**	50	63,0	35,0	350	–	1/4-18 NPT	-12.0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1098098	**A50UMCLNR16**	50	63,0	35,0	350	–	1/4-18 NPT	-12.0	CN..160608	**ICSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1098100	**A50UMCLNR19**	50	63,0	35,0	350	–	1/4-18 NPT	-12.0	CN..190608	**ICSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
left hand															
1098089	**A25RMCLNL12**	25	32,0	17,0	200	33,0	1/4-18 NPT	-12.0	CN..120408	**–**	**KLM43**	2 mm	**CKM21**	**STCM11**	3 mm
1098091	**A32SMCLNL12**	32	40,0	22,0	250	–	1/4-18 NPT	-12.0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1098093	**A40TMCLNL12**	40	50,0	27,0	300	–	1/4-18 NPT	-12.0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1098097	**A40TMCLNL16**	40	50,0	27,0	300	–	1/4-18 NPT	-11.0	CN..160608	**ICSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1098095	**A50UMCLNL12**	50	63,0	35,0	350	–	1/4-18 NPT	-7.0	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1098099	**A50UMCLNL16**	50	63,0	35,0	350	–	1/4-18 NPT	-12.0	CN..160608	**ICSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1098101	**A50UMCLNL19**	50	63,0	35,0	350	–	1/4-18 NPT	-12.0	CN..190608	**ICSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm



Steel shank with through coolant.



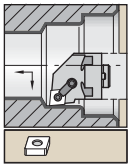


A-PCLN 95°

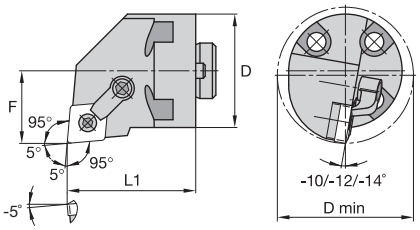


order number	catalogue number	D	D min	F	L1	L2	CS	γF°	gage insert	shim	shim pin	pin	toggle lever	lever screw	Torx Plus
right hand															
2447150	**A25TPCLNR12**	25	32,0	17,0	300	40	1/4-18 NPT	-12.0	CN..120408	–	–	–	**511.022**	**514.122**	10 IP
2447152	**A32UPCLNR12**	32	40,0	22,0	350	50	1/4-18 NPT	-10.0	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
2447476	**A32UPCLNR16**	32	50,0	22,0	350	50	1/4-18 NPT	-10.0	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
2447533	**A40VPCLNR12**	40	50,0	27,0	400	55	1/4-18 NPT	-10.0	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
2447478	**A40VPCLNR16**	40	50,0	27,0	400	55	1/4-18 NPT	-11.0	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
left hand															
2447151	**A25TPCLNL12**	25	32,0	17,0	300	40	1/4-18 NPT	-12.0	CN..120408	–	–	–	**511.022**	**514.122**	10 IP
2447473	**A32UPCLNL12**	32	40,0	22,0	350	50	1/4-18 NPT	-10.0	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
2447534	**A40VPCLNL12**	40	50,0	27,0	400	55	1/4-18 NPT	-10.0	CN..120408	**512.112**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
2447479	**A40VPCLNL16**	40	50,0	27,0	400	55	1/4-18 NPT	-11.0	CN..160612	**512.117**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP

Kenloc™ Boring Heads



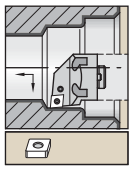
With through coolant.



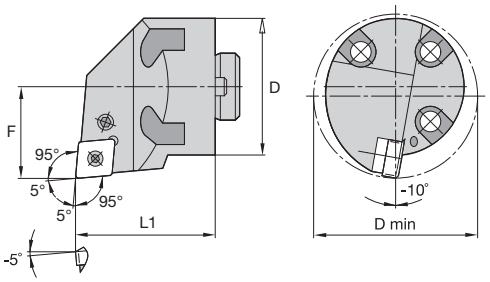
H-MCLN 95°



order number	catalogue number	D	D min	F	L1	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand												
3612156	**H32MCLNR12**	32	40,0	22,0	41	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
3612178	**H50MCLNR12**	50	63,0	35,0	41	CN..120408	**ICSN432**	**KLM46**	2.5 mm	**CKM20**	**STCM20**	3 mm
1099102	**H50MCLNR19**	50	63,0	35,0	41	CN..190612	**ICSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm



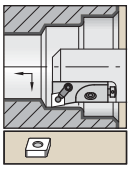
With through coolant.

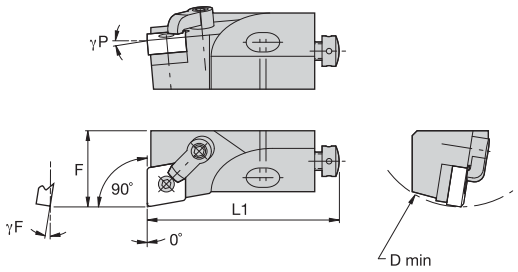


H-PCLN 95°



order number	catalogue number	D	D min	F	L1	gage insert	shim	shim pin	lever	punch pin	lever lock screw	hex
right hand												
1861493	**H32PCLNR12**	32	40,0	22,0	41	CN..120408	**512.112**	**513.023**	**514.123**	**515.018**	**514.123**	15 IP
1861500	**H40PCLNR12**	40	50,0	27,0	41	CN..120408	**512.112**	**513.023**	**514.123**	**515.018**	**514.123**	15 IP
1861517	**H50PCLNR12**	50	63,0	35,0	41	CN..120408	**512.112**	**513.023**	**514.123**	**515.018**	**514.123**	15 IP
left hand												
1861501	**H40PCLNL12**	40	50,0	27,0	41	CN..120408	**512.112**	**513.023**	**514.123**	**515.018**	**514.123**	15 IP
1861518	**H50PCLNL12**	50	63,0	35,0	41	CN..120408	**512.112**	**513.023**	**514.123**	**515.018**	**514.123**	15 IP

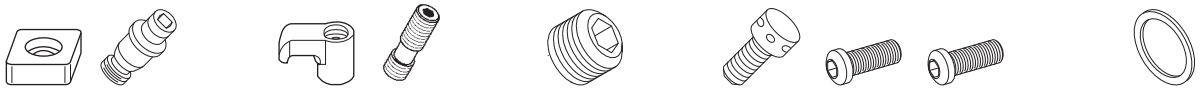




MCFN 90°

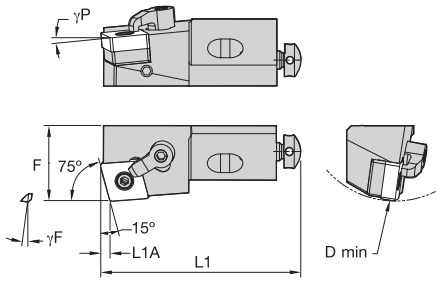
order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
3331146	**MCFNR10CA09**	40	14,0	50	-9.0	-9.0	CN..090308/CN..322
3346236	**MCFNR12CA12**	50	20,0	55	-9.0	-5.0	CN..120408/CN..432
2074433	**MCFNR16CA12**	60	25,0	63	-9.0	-5.0	CN..120408/CN..432
3330195	**MCFNR20CA12**	70	25,0	70	-9.0	-5.0	CN..120408\CN..432
left hand							
3331145	**MCFNL10CA09**	40	14,0	50	-9.0	-9.0	CN..090308/CN..322
1906272	**MCFNL12CA12**	50	20,0	55	-9.0	-5.0	CN..120408/CN..432

Spare Parts



D min	shim	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	hex	washer
40	–	**KLM33**	2 mm	**CKM36**	**STCM38**	2 mm	**KUAM28**	2 mm	**KUAM30**	**191.405**	–	4 mm	**CSWM 060 050**
50	–	**KLM43**	2 mm	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	–	**191.406**	4 mm	**CSWM 060 050**
60	**ICSN432**	**KLM46S**	2.5 mm	**CKM34**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	–	**191.407**	5 mm	**CSWM 080 050**
70	**ICSN432**	**KLM46**	2.5 mm	**CKM34**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	–	**191.407**	5 mm	**CSWM 080 050**





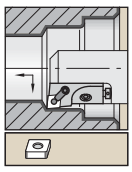
MCKN 75°

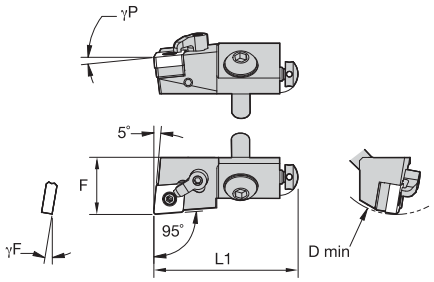
order number	catalogue number	D min	F	L1	L1A	γF°	γP°	gage insert
right hand								
3346238	MCKNR12CA12	50	20,0	55	3	-9.0	-5.0	CN..120408/CN..432
3330222	MCKNR16CA12	60	25,0	63	3	-9.0	-5.0	CN..120408/CN..432
left hand								
3346237	MCKNL12CA12	50	20,0	55	3	-9.0	-5.0	CN..120408/CN..432

Spare Parts



D min	shim	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	–	KLM43	2 mm	CKM34	STCM38	2 mm	KUAM22	2 mm	KUAM31	191.406	4 mm	CSWM 060 050
60	ICSN432	KLM46S	2.5 mm	CKM34	STCM9	2.5 mm	KUAM25	2.5 mm	KUAM32	191.407	5 mm	CSWM 080 050





MCLN 95°

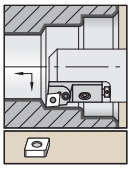
order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1100493	**MCLNR12CA12**	50	20,0	55	-9.0	-5.0	CN..120408/CN..432
1282100	**MCLNR16CA12**	60	25,0	63	-9.0	-5.0	CN..120408/CN..432
3330197	**MCLNR20CA12**	70	25,0	70	-9.0	-5.0	CN..120408/CN..432
3332803	**MCLNR25CA12**	100	32,0	100	-9.0	-5.0	CN..120408/CN..432
3332804	**MCLNR25CA16**	100	32,0	100	-9.0	-5.0	CN..160612/CN..543
3332805	**MCLNR25CA19**	100	32,0	100	-9.0	-5.0	CN..190612/CN..643
left hand							
2077947	**MCLNL12CA12**	50	20,0	55	-9.0	-5.0	CN..120408/CN..432
3330273	**MCLNL16CA12**	60	25,0	63	-9.0	-5.0	CN..120408/CN..432
3330196	**MCLNL20CA12**	70	25,0	70	-9.0	-5.0	CN..120408/CN..432
3332362	**MCLNL25CA19**	100	32,0	100	-9.0	-5.0	CN..190612/CN..643

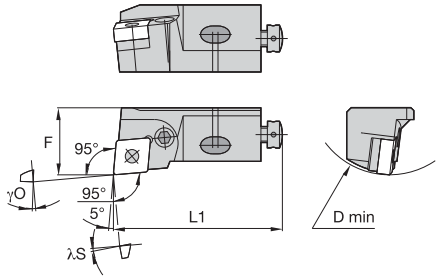
NOTE: Select spare parts based off of D min and the insert size selected.

Spare Parts



D min	shim	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	hex	washer
50	**–**	**KLM43**	2 mm	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	**191.406**	**–**	4 mm	**CSWM 060 050**
60	**ICSN432**	**KLM46S**	2.5 mm	**CKM34**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	**191.407**	**–**	5 mm	**CSWM 080 050**
70	**ICSN432**	**KLM46**	2.5 mm	**CKM34**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	**191.407**	**–**	5 mm	**CSWM 080 050**
100	**ICSN633**	**KLM68**	4 mm	**CKM35**	**STCM8**	4 mm	**KUAM27**	4 mm	**KUAM32**	**–**	**MS364**	8 mm	**CSWM 100 080**
100	**ICSN432**	**KLM46**	2.5 mm	**CKM37**	**STCM40**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	**–**	**MS364**	8 mm	**CSWM 100 080**
100	**ICSN533**	**KLM58**	3 mm	**CKM41**	**STCM20**	3 mm	**KUAM26**	3 mm	**KUAM32**	**–**	**MS364**	8 mm	**CSWM 100 080**
100	**ICSN633**	**KLM68**	4 mm	**CKM35**	**STCM8**	4 mm	**KUAM27**	4 mm	**KUAM32**	**–**	**MS364**	8 mm	**CSWM 100 080**





PCLN 95°

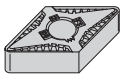
order number	catalogue number	D min	F	L1	λS°	γO°	gage insert
right hand							
1244444	**PCLNR12CA-12**	50	20,0	55	-6.0	-9.0	CN..120408/CN..432
1244496	**PCLNR16CA-12**	60	25,0	63	-6.0	-7.0	CN..120408/CN..432
left hand							
1244443	**PCLNL16CA-12**	60	25,0	63	-6.0	-7.0	CN..120408/CN..432

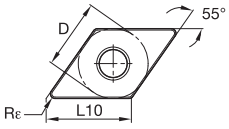
Spare Parts



D min	shim	shim pin	toggle lever	lever screw	wrench size lever screw	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	–	–	**511.022**	**514.122**	10 IP	**KUAM28**	2 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**
60	**512.112**	**513.023**	**511.023**	**514.123**	15 IP	**KUAM23**	2.5 mm	**KUAM32**	**191.407**	5 mm	**CSWM 080 050**

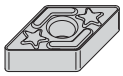
● first choice
○ alternate choice

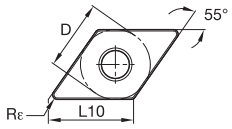




DNGG-FS

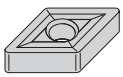
				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	**D**	**L10**	**Rε**																															
DNGG110402FS	9,53	11,63	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
DNGG110404FS	9,53	11,63	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
DNGG110408FS	9,53	11,63	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
DNGG150401FS	12,70	15,50	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
DNGG150402FS	12,70	15,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
DNGG150404FS	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–
DNGG150604FS	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
DNGG150408FS	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–
DNGG150608FS	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
DNGG150412FS	12,70	15,50	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–

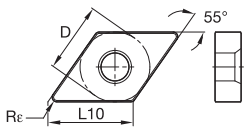




DNGG-LF

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	**D**	**L10**	**Rε**																															
DNGG150402LF	12,70	15,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
DNGG150404LF	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
DNGG150408LF	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–

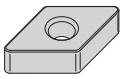


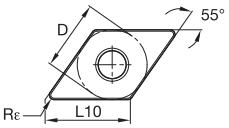


DNGP

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	**D**	**L10**	**Rε**																															
DNGP150401	12,70	15,50	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
DNGP150402	12,70	15,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–
DNGP150404	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–	●	–
DNGP150604	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	●	–
DNGP150408	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–	●	–
DNGP150608	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–

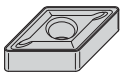
● first choice
○ alternate choice

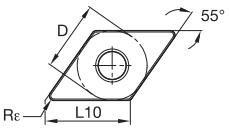




DNMA

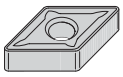
				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	**D**	**L10**	**Rε**																															
DNMA110408	9,53	11,63	0,8	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMA150408	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMA150608	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMA150412	12,70	15,50	1,2	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMA150612	12,70	15,50	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMA150416	12,70	15,50	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

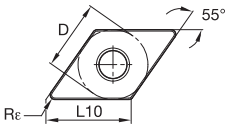




DNMG

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	**D**	**L10**	**Rε**																															
DNMG150408B	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–



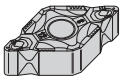


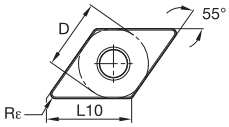
DNMG-33

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	**D**	**L10**	**Rε**																															
DNMG11040433	9,53	11,63	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●
DNMG11040833	9,53	11,63	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●
DNMG15060433	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●
DNMG15060833	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●

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

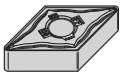
● first choice
○ alternate choice

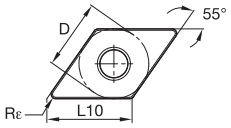




DNMG-CT

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG110412CT	9,53	11,62	1,2	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG110408CT	9,53	11,63	0,8	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150604CT	12,70	15,50	0,3	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150404CT	12,70	15,50	0,4	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
DNMG150408CT	12,70	15,50	0,8	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
DNMG150608CT	12,70	15,50	0,8	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150412CT	12,70	15,50	1,2	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
DNMG150612CT	12,70	15,50	1,2	●	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–

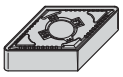


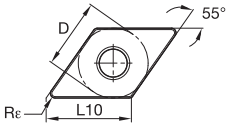


DNMG-FF

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG110404FF	9,53	11,63	0,4	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●
DNMG110408FF	9,53	11,63	0,8	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●
DNMG150404FF	12,70	15,50	0,4	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	●	–	–	●
DNMG150604FF	12,70	15,50	0,4	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●
DNMG150408FF	12,70	15,50	0,8	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●
DNMG150608FF	12,70	15,50	0,8	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●

● first choice
○ alternate choice

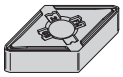


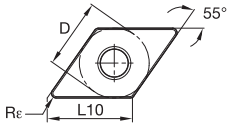


DNMG-FN

| | | |

● first choice
○ alternate choice

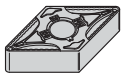


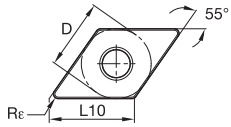


DNMG-FW

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

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG110404FW	9,53	11,63	0,4	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●
DNMG110408FW	9,53	11,63	0,8	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	–	–	–	●
DNMG150404FW	12,70	15,50	0,4	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●
DNMG150408FW	12,70	15,50	0,4	–	●	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●
DNMG150604FW	12,70	15,50	0,4	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
DNMG150608FW	12,70	15,50	0,4	–	●	●	●	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–

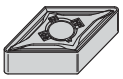


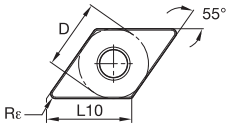


DNMG-MN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG110404MN	9,53	11,63	0,4	–	●	●	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG110408MN	9,53	11,63	0,8	–	●	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG110412MN	9,53	11,63	1,2	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150404MN	12,70	15,50	0,4	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150604MN	12,70	15,50	0,4	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150408MN	12,70	15,50	0,8	●	–	●	●	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
DNMG150608MN	12,70	15,50	0,8	●	–	●	●	●	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150412MN	12,70	15,50	1,2	–	●	●	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150612MN	12,70	15,50	1,2	–	–	●	●	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150616MN	12,70	15,50	1,6	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG190612MN	15,88	19,38	1,2	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

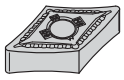
● first choice
○ alternate choice

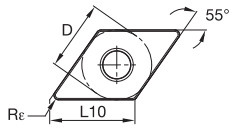




DNMG-MP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG110408MP	9,53	11,63	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–	–	●	–	●	–	–	–
DNMG110412MP	9,53	11,63	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150404MP	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	●	–	–	–	●	–	●	–	–	–
DNMG150604MP	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	●	–	–	–	●	–	●	–	–	–
DNMG150408MP	12,70	15,50	0,8	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	●	–	–	–	●	–	●	–	–	–
DNMG150608MP	12,70	15,50	0,8	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	●	–	–	–	●	●	●	–	–	–
DNMG150412MP	12,70	15,50	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	●	–	–	–
DNMG150612MP	12,70	15,50	1,2	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	●	●	●	–	–	–

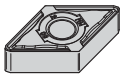


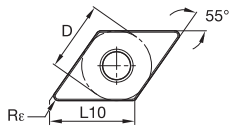


DNMG-MS

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG110408MS	9,53	11,63	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
DNMG150401MS	12,70	15,50	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
DNMG150402MS	12,70	15,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–
DNMG150404MS	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
DNMG150604MS	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
DNMG150408MS	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
DNMG150608MS	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
DNMG150412MS	12,70	15,50	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–
DNMG150612MS	12,70	15,50	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–	–

● first choice
○ alternate choice

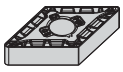


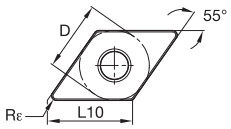


DNMG-MW

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

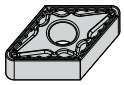
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG150408MW	12,70	15,50	0,4	–	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150608MW	12,70	15,50	0,4	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
DNMG150412MW	12,70	15,50	0,8	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150612MW	12,70	15,50	0,8	–	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

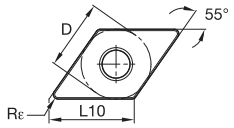




DNMG-MR

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG110408MR	9,53	11,63	0,8	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150408MR	12,70	15,50	0,8	–	–	●	–	●	–	●	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	●	–	–	●	–	–	–	–	–	–
DNMG150608MR	12,70	15,50	0,8	–	–	●	–	●	–	–	–	–	–	–	–	●	–	–	–	●	–	●	●	–	–	–	–	–	●	–	–	–	–	–	–
DNMG150412MR	12,70	15,50	1,2	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–
DNMG150612MR	12,70	15,50	1,2	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150616MR	12,70	15,50	1,6	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

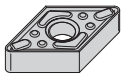


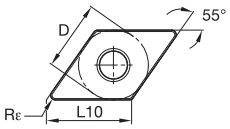


DNMG-MG

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG150612MG	12,70	15,50	1,2	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150616MG	12,70	15,50	1,6	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

● first choice
○ alternate choice

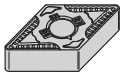


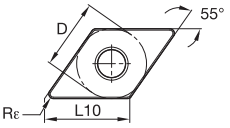


DNMG-P

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

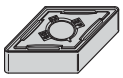
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG150404P	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
DNMG150408P	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
DNMG150608P	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–

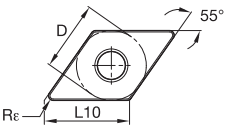




DNMG-RN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG150408RN	12,70	15,50	0,8	–	●	●	●	●	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150608RN	12,70	15,50	0,8	–	●	●	●	●	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150412RN	12,70	15,50	1,2	–	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
DNMG150612RN	12,70	15,50	1,2	–	●	●	●	●	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
DNMG150416RN	12,70	15,50	1,6	–	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150616RN	12,70	15,50	1,6	–	–	–	●	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG190608RN	15,88	19,38	0,8	–	–	●	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG190612RN	15,88	19,38	1,2	–	–	●	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

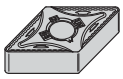


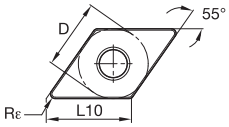


DNMG-RP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG110408RP	9,53	11,63	0,8	–	–	–	●	●	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	●	●	●	–	–	–
DNMG110412RP	9,53	11,63	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150408RP	12,70	15,50	0,8	–	–	●	●	●	●	–	–	–	–	–	●	–	–	●	●	–	●	●	●	–	●	–	–	–	●	●	●	●	–	–
DNMG150608RP	12,70	15,50	0,8	–	●	●	●	●	●	–	●	–	–	–	–	●	–	–	●	–	●	●	●	–	–	–	–	–	●	●	●	●	–	–
DNMG150412RP	12,70	15,50	1,2	–	–	●	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	●	●	–	–	–	–
DNMG150612RP	12,70	15,50	1,2	–	–	●	●	●	●	–	–	–	–	–	●	–	●	●	●	–	–	–	●	●	–	–	–	–	●	●	–	–	–	–
DNMG150416RP	12,70	15,50	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
DNMG150616RP	12,70	15,50	1,6	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–

● first choice
○ alternate choice

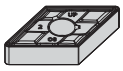


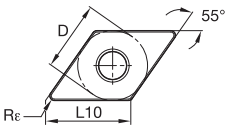


DNMG-UN

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

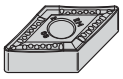
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG110408UN	9,53	11,63	0,8	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG110412UN	9,53	11,63	1,2	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150408UN	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150608UN	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150412UN	12,70	15,50	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150612UN	12,70	15,50	1,2	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150416UN	12,70	15,50	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG150616UN	12,70	15,50	1,6	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

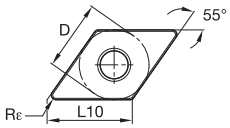




DNMG-UP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMG110408UP	9,53	11,63	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–
DNMG150404UP	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	●	–	–	–	–	–
DNMG150604UP	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–
DNMG150408UP	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	–	–	–	●	–	●	–	–	–
DNMG150608UP	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	●	–	●	–	–	–

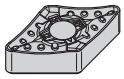


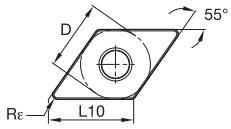


DNMM-RM

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMM150408RM	12,70	15,50	0,8	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMM150608RM	12,70	15,50	0,8	–	–	–	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMM150412RM	12,70	15,50	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMM150612RM	12,70	15,50	1,2	–	–	–	●	●	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMM150616RM	12,70	15,50	1,6	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

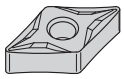
● first choice
○ alternate choice

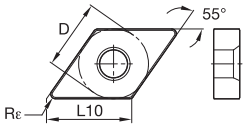




DNMM-RP

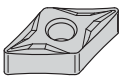
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
DNMM150608RP	12,70	15,50	0,8	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMM150612RP	12,70	15,50	1,2	–	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMM150616RP	12,70	15,50	1,6	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

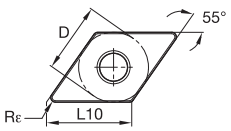




DNMP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMP150404	12,70	15,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
DNMP150408	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
DNMP150412	12,70	15,50	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

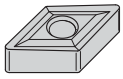


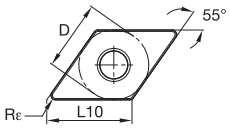


DNMP-K

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
DNMP110408K	9,53	11,63	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMP150404K	12,70	15,50	0,4	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMP150604K	12,70	15,50	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMP150408K	12,70	15,50	0,8	–	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMP150608K	12,70	15,50	0,8	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMP150412K	12,70	15,50	1,2	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

● first choice
○ alternate choice





DNMS

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
				P		●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
				M										○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
				K		○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
				N																							●	●	●	●	●	●	●		
				S																							●	●	●	●	●	●			
				H																														
DNMS150408	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●	–

Mobile Apps

The Kennametal mobile app provides easy access to product information and calculators on both iPhone® and Android™ devices. We've highlighted a few of the key features...

There's an app for that.

SPEEDS & FEEDS

View speeds and feeds information for metalworking products.

PRODUCT AVAILABILITY

Check global availability of products. View available quantities by providing your Konnect login credentials.

CALCULATORS

Utilise our machining calculators for milling and drilling applications.

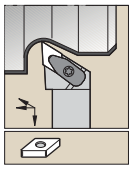


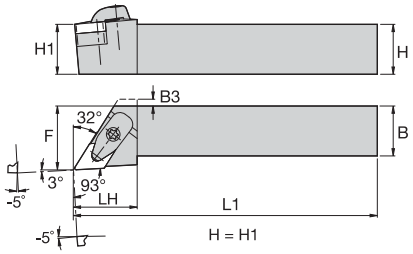
By just scanning the bar code on the insert packet, you can find the most productive cutting conditions for tool life, process time, and chip control.

NOTE: The app is currently only available in the English-language version. We have plans to translate the app in different languages with future releases.

Google play

Available on the App Store

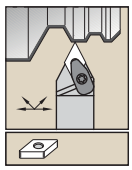


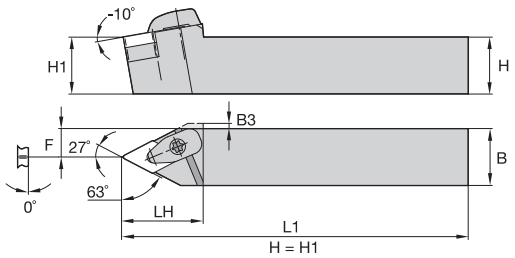


DDJN-KC 93°



order number	catalogue number	H	B	F	L1	LH	B3	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand															
2273105	**DDJNR2020K11KC04**	20	20	25,0	125	30,0	2,0	DN..110408	**IDSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
1875197	**DDJNR2020K15KC06**	20	20	25,0	125	32,0	4,0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
2273106	**DDJNR2525M11KC04**	25	25	32,0	150	30,0	–	DN..110408	**IDSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
1875191	**DDJNR2525M15KC06**	25	25	32,0	150	32,0	–	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
1875208	**DDJNR3225P15KC06**	32	25	32,0	170	32,0	–	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
1875227	**DDJNR3232P15KC06**	32	32	40,0	170	32,0	–	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
left hand															
2273107	**DDJNL2020K11KC04**	20	20	25,0	125	30,0	2,0	DN..110408	**IDSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
1875198	**DDJNL2020K15KC06**	20	20	25,0	125	32,0	4,0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
2273108	**DDJNL2525M11KC04**	25	25	32,0	150	30,0	–	DN..110408	**IDSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
1875192	**DDJNL2525M15KC06**	25	25	32,0	150	32,0	–	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
1875207	**DDJNL3225P15KC06**	32	25	32,0	170	32,0	–	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
1875209	**DDJNL3232P15KC06**	32	32	40,0	171	32,0	–	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**

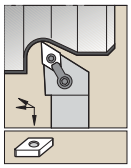


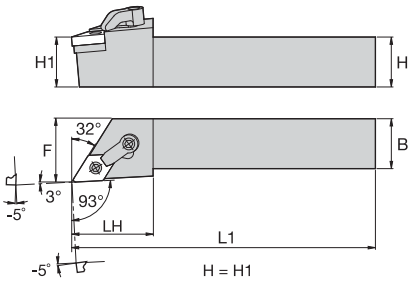


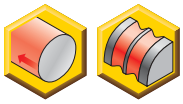
DDNN-KC 63°



order number	catalogue number	H	B	F	L1	LH	B3	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand															
2273111	**DDNNR2020K15KC06**	20	20	10,0	125	40,0	2,5	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
2273112	**DDNNR2525M15KC06**	25	25	13,0	150	40,0	–	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**



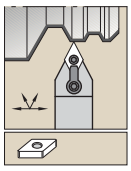


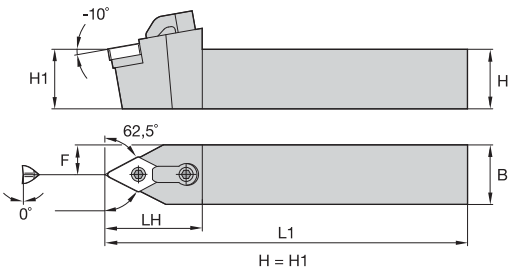


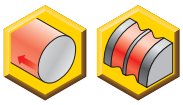
MDJN 93°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand													
1100936	**MDJNR1616H11**	16	16	20,0	100	32,0	DN..110408	**IDSN322**	**KLM34L**	2 mm	**CKM7**	**STCM5**	2.5 mm
1101286	**MDJNR2020K11**	20	20	25,0	125	32,0	DN..110408	**IDSN322**	**KLM34L**	2 mm	**CKM7**	**STCM5**	2.5 mm
1101356	**MDJNR2020K15**	20	20	25,0	125	36,0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
1101288	**MDJNR2525M11**	25	25	32,0	150	32,0	DN..110408	**IDSN322**	**KLM34L**	2 mm	**CKM7**	**STCM5**	2.5 mm
1101357	**MDJNR2525M15**	25	25	32,0	150	36,0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
1101358	**MDJNR3225P15**	32	25	32,0	170	36,0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
3638550	**MDJNR3232P15**	32	32	40,5	173	32,0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
left hand													
1101285	**MDJNL2020K11**	20	20	25,0	125	32,0	DN..110408	**IDSN322**	**KLM34L**	2 mm	**CKM7**	**STCM5**	2.5 mm
1101287	**MDJNL2525M11**	25	25	32,0	150	32,0	DN..110408	**IDSN322**	**KLM34L**	2 mm	**CKM7**	**STCM5**	2.5 mm
1102316	**MDJNL2525M15**	25	25	32,0	150	36,0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
1102317	**MDJNL3225P15**	32	25	32,0	170	32,0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
3638551	**MDJNL3232P15**	32	32	40,5	173	32,0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm



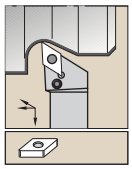


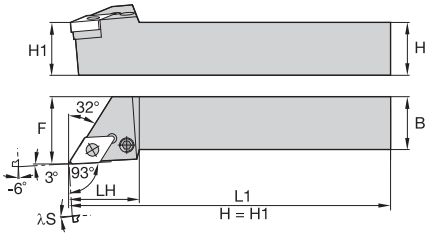


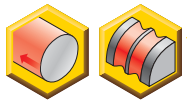
MDNN 62,5°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand													
1101636	**MDNNR2525M15**	68	25	12,5	150	41,0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
1101637	**MDNNR3225P15**	88	32	12,5	170	41,0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
left hand													
1102434	**MDNNL2525M15**	68	25	12,5	150	41,0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
1102435	**MDNNL3225P15**	88	32	12,5	170	41,0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm



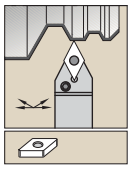


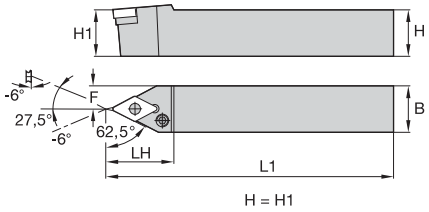


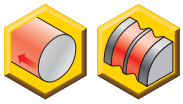
PDJN 93°



order number	catalogue number	H	B	F	L1	LH	λS°	gage insert	shim	shim pin	punch pin	lever	lever screw	Torx Plus
right hand														
1244752	PDJNR1616H11	16	16	20,0	100	24,0	-6.0	DN..110408	512.060	513.060	515.018	511.060	514.118	10 IP
1192382	PDJNR2020K11	20	20	25,0	125	30,0	-7.0	DN..110408	512.060	513.060	515.018	511.060	514.118	10 IP
1192383	PDJNR2020K15	20	20	25,0	125	36,0	-7.0	DN..150608	512.153	513.023	515.018	511.024	514.128	15 IP
1192384	PDJNR2525M11	25	25	32,0	150	30,0	-7.0	DN..110408	512.060	513.060	515.018	511.060	514.118	10 IP
1192385	PDJNR2525M15	25	25	32,0	150	36,0	-7.0	DN..150608	512.153	513.023	515.018	511.024	514.128	15 IP
1156969	PDJNR3225P15	32	25	32,0	170	36,0	-7.0	DN..150608	512.153	513.023	515.018	511.024	514.128	15 IP
1236865	PDJNR3232P15	32	32	40,0	170	36,0	-7.0	DN..150608	512.153	513.023	515.018	511.024	514.128	15 IP
1244784	PDJNR4025R15	40	25	32,0	200	36,0	-7.0	DN..150608	512.153	513.023	515.018	511.024	514.128	15 IP
left hand														
1244751	PDJNL1616H11	16	16	20,0	100	24,0	-6.0	DN..110408	512.060	513.060	515.018	511.060	514.118	10 IP
1244658	PDJNL2020K11	20	20	25,0	125	30,0	-7.0	DN..110408	512.060	513.060	515.018	511.060	514.118	10 IP
1244820	PDJNL2020K15	20	20	25,0	125	36,0	-7.0	DN..150608	512.153	513.023	515.018	511.024	514.128	15 IP
1192380	PDJNL2525M11	25	25	32,0	150	30,0	-7.0	DN..110408	512.060	513.060	515.018	511.060	514.118	10 IP
1156968	PDJNL2525M15	25	25	32,0	150	36,0	-7.0	DN..150608	512.153	513.023	515.018	511.024	514.128	15 IP
1244781	PDJNL3225P15	32	25	32,0	170	36,0	-7.0	DN..150608	512.153	513.023	515.018	511.024	514.128	15 IP
1244821	PDJNL3232P15	32	32	40,0	170	36,0	-7.0	DN..150608	512.153	513.023	515.018	511.024	514.128	15 IP
1192381	PDJNL4025R15	40	25	32,0	200	36,0	-7.0	DN..150608	512.153	513.023	515.018	511.024	514.128	15 IP



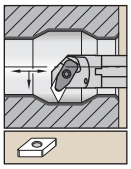




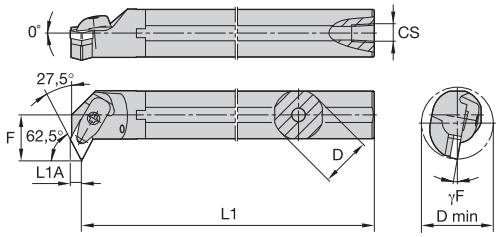
PDNN 62,5°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim pin	punch pin	lever	lever screw	Torx Plus
right hand													
1244756	**PDNNR2020K11**	20	20	10,0	125	24,0	DN..110408	**512.060**	**513.060**	**515.018**	**511.060**	**514.118**	10 IP
1244824	**PDNNR2020K15**	20	20	10,0	125	36,0	DN..150608	**512.153**	**513.023**	**515.018**	**511.024**	**514.128**	15 IP
1244773	**PDNNR2525M15**	25	25	12,5	150	36,0	DN..150608	**512.153**	**513.023**	**515.018**	**511.024**	**514.128**	15 IP
1244825	**PDNNR4025M15**	40	25	12,5	150	36,0	DN..150608	**512.153**	**513.023**	**515.018**	**511.024**	**514.128**	15 IP
left hand													
1244754	**PDNNL2020K11**	20	20	10,0	125	24,0	DN..110408	**512.060**	**513.060**	**515.018**	**511.060**	**514.118**	10 IP
1244822	**PDNNL2020K15**	20	20	10,0	125	36,0	DN..150608	**512.153**	**513.023**	**515.018**	**511.024**	**514.128**	15 IP
1244659	**PDNNL2525M11**	25	25	12,5	150	30,0	DN..110408	**512.060**	**513.060**	**515.018**	**511.060**	**514.118**	10 IP
1244785	**PDNNL2525M15**	25	25	12,5	150	36,0	DN..150608	**512.153**	**513.023**	**515.018**	**511.024**	**514.128**	15 IP
1244823	**PDNNL4025M15**	40	25	12,5	150	36,0	DN..150608	**512.153**	**513.023**	**515.018**	**511.024**	**514.128**	15 IP



Steel shank with through coolant.

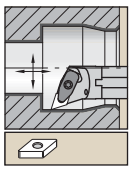




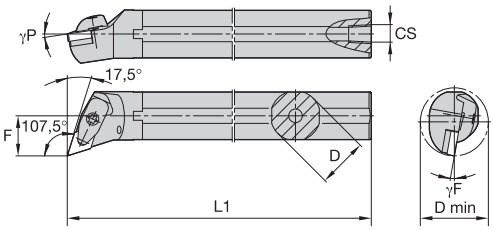
A-DDPN-KC 117,5°



order number	catalogue number	D	D min	F	L1	L1A	CS	γF°	gage insert	shim	shim screw	Torx Plus	clamp assembly	slotted pin	Torx Plus
right hand															
2441957	**A25RDDPNR11KC04**	25	37,0	22,0	200	4,8	1/4-18 NPT	-10.0	DN..110408	**IDSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441959	**A32SDDPNR15KC06**	32	45,0	27,0	250	6,5	1/4-18 NPT	-12.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441961	**A40TDDPNR15KC06**	40	52,0	30,0	300	6,6	1/4-18 NPT	-10.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
left hand															
2441960	**A32SDDPNL15KC06**	32	45,0	27,0	250	—	1/4-18 NPT	-12.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441962	**A40TDDPNL15KC06**	40	52,0	30,0	300	6,6	1/4-18 NPT	-10.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP



Steel shank with through coolant.

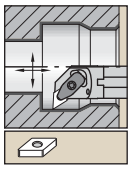




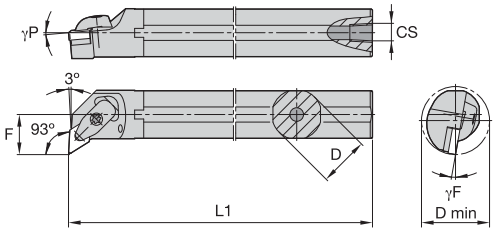
A-DDQN-KC 107,5°



order number	catalogue number	D	D min	F	L1	CS	γF°	γP°	gage insert	shim	shim screw	Torx Plus	clamp assembly	slotted pin	Torx Plus
right hand															
2441951	**A25RDDQNR11KC04**	25	32,0	17,0	200	1/4-18 NPT	-11.0	-7.0	DN..110408	—	—	—	**CM234R ASSY**	**SSP025016M**	15 IP
2441953	**A32SDDQNR15KC06**	32	40,0	22,0	250	1/4-18 NPT	-12.0	-10.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441955	**A40TDDQNR15KC06**	40	50,0	27,0	300	1/4-18 NPT	-10.0	-10.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
left hand															
2441952	**A25RDDQNL11KC04**	25	32,0	17,0	200	1/4-18 NPT	-11.0	-7.0	DN..110408	—	—	—	**CM234R ASSY**	**SSP025016M**	15 IP
2441954	**A32SDDQNL15KC06**	32	40,0	22,0	250	1/4-18 NPT	-12.0	-10.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441956	**A40TDDQNL15KC06**	40	50,0	27,0	300	1/4-18 NPT	-10.0	-10.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP



Steel shank with through coolant.

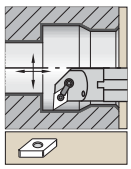




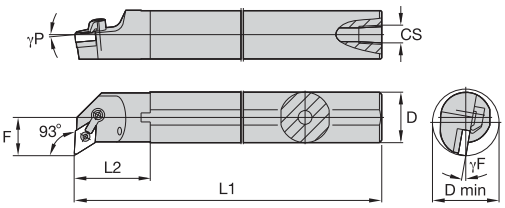
A-DDUN-KC 93°



order number	catalogue number	D	D min	F	L1	CS	γF°	γP°	gage insert	shim	shim screw	Torx Plus	clamp assembly	slotted pin	Torx Plus
right hand															
2441939	**A25RDDUNR11KC04**	25	32,0	17,0	200	1/4-18 NPT	-12.0	-5.0	DN..110408	–	–	–	**CM234R ASSY**	**SSP025016M**	15 IP
2441941	**A32SDDUNR11KC04**	32	40,0	22,0	250	1/4-18 NPT	-12.0	-5.0	DN..110408	**IDSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441945	**A32SDDUNR15KC06**	32	40,0	22,0	250	1/4-18 NPT	-12.0	-6.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441947	**A40TDDUNR15KC06**	40	50,0	27,0	300	1/4-18 NPT	-9.0	-5.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441949	**A50UDDUNR15KC06**	50	63,0	35,0	350	1/4-18 NPT	-7.0	-5.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
left hand															
2441940	**A25RDDUNL11KC04**	25	32,0	17,0	200	1/4-18 NPT	-12.0	-5.0	DN..110408	–	–	–	**CM234R ASSY**	**SSP025016M**	15 IP
2441942	**A32SDDUNL11KC04**	32	40,0	22,0	250	1/4-18 NPT	-12.0	-5.0	DN..110408	**IDSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441946	**A32SDDUNL15KC06**	32	40,0	22,0	250	1/4-18 NPT	-12.0	-6.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441948	**A40TDDUNL15KC06**	40	50,0	27,0	300	1/4-18 NPT	-9.0	-5.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441950	**A50UDDUNL15KC06**	50	63,0	35,0	350	1/4-18 NPT	-7.0	-5.0	DN..150608	**IDSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP



Steel shank with through coolant.





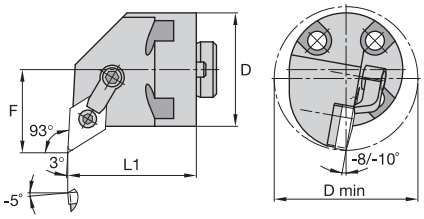
A-MDUN 93°



order number	catalogue number	D	D min	F	L1	L2	CS	γF°	γP°	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand																
1098769	**A25RMDUNR11**	25	32,0	17,0	200	40,0	1/4-18 NPT	-14.0	-5.0	DN..110408	–	**KLM33L**	2 mm	**CKM7**	**STCM5**	2.5 mm
1098102	**A25RMDUNR15**	25	32,0	17,0	200	–	1/4-18 NPT	-14.0	-5.0	DN..150408	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM11**	3 mm
1098770	**A32SMDUNR11**	32	40,0	22,0	250	50,0	1/4-18 NPT	-12.0	-5.0	DN..110408	**IDSN322**	**KLM34L**	2 mm	**CKM7**	**STCM5**	2.5 mm
1098104	**A32SMDUNR15**	32	40,0	22,0	250	–	1/4-18 NPT	-12.0	-6.0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
1098106	**A40TMDUNR15**	40	50,0	27,0	300	–	1/4-18 NPT	-9.0	-5.0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
1098108	**A50UMDUNR15**	50	63,0	35,0	350	–	1/4-18 NPT	-7.0	-5.0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
left hand																
1098779	**A25RMDUNL11**	25	32,0	17,0	200	40,0	1/4-18 NPT	-14.0	-5.0	DN..110408	–	**KLM33L**	2 mm	**CKM7**	**STCM5**	2.5 mm
1098103	**A25RMDUNL15**	25	32,0	17,0	200	–	1/4-18 NPT	-14.0	-5.0	DN..150408	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM11**	3 mm
1098780	**A32SMDUNL11**	32	40,0	22,0	250	50,0	1/4-18 NPT	-12.0	-5.0	DN..110408	**IDSN322**	**KLM34L**	2 mm	**CKM7**	**STCM5**	2.5 mm
1098105	**A32SMDUNL15**	32	40,0	22,0	250	–	1/4-18 NPT	-12.0	-6.0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
1098107	**A40TMDUNL15**	40	50,0	27,0	300	–	1/4-18 NPT	-9.0	-5.0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
1098109	**A50UMDUNL15**	50	63,0	35,0	350	–	1/4-18 NPT	-7.0	-5.0	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm



With through coolant.

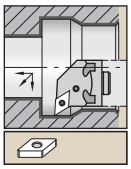


H-MDUN 93°

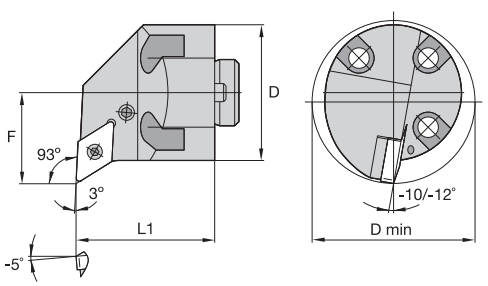


order number	catalogue number	D	D min	F	L1	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand												
1099094	**H40MDUNR15**	40	50,0	27,0	41	DN..150608	**IDSN432**	**KLM46L**	2.5 mm	**CKM22**	**STCM20**	3 mm
left hand												
3612192	**H50MDUNL19**	50	63,0	35,0	41	DN..190612	**IDSN533**	**KLM58**	3 mm	**CKM12**	**STCM4**	4 mm

Kenlever™ Boring Heads



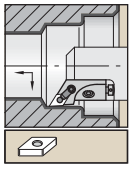
With through coolant.

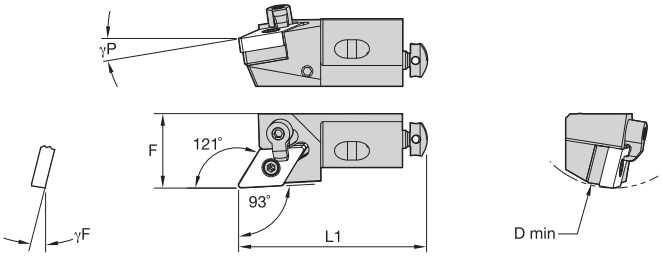


H-PDUN 93°



order number	catalogue number	D	D min	F	L1	gage insert	shim	shim pin	pin	toggle lever	lever screw	Torx Plus
right hand												
1861496	**H32PDUNR15**	32	43,0	25,0	41	DN..150608	**512.153**	**513.023**	**515.018**	**511.024**	**514.128**	15 IP
1861519	**H50PDUNR15**	50	63,0	35,0	41	DN..150608	**512.153**	**513.023**	**515.018**	**511.024**	**514.128**	15 IP
left hand												
1861520	**H50PDUNL15**	50	63,0	35,0	41	DN..150608	**512.153**	**513.023**	**515.018**	**511.024**	**514.128**	15 IP





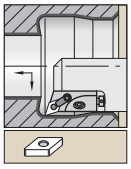
MDJN 93°

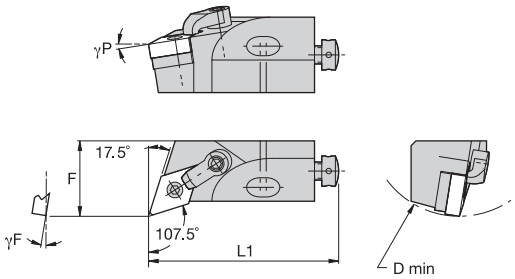
order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
3346241	**MDJNR12CA11**	50	20,0	55	-9.0	-9.0	DN..110408/DN..322
3330275	**MDJNR16CA15**	60	25,0	63	-9.0	-9.0	DN..150408/DN..432
3330199	**MDJNR20CA15**	70	25,0	70	-8.5	-8.5	DN..150408/DN..3.532
left hand							
3346240	**MDJNL12CA11**	50	20,0	55	-9.0	-9.0	DN..110408/DN..322
3330274	**MDJNL16CA15**	60	25,0	63	-9.0	-9.0	DN..150408/DN..432

Spare Parts



D min	shim	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	–	**KLM33L**	2 mm	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**
60	**IDSN432**	**KLM46S**	2.5 mm	**CKM36**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	**191.407**	5 mm	**CSWM 080 050**
70	**IDSN432**	**KLM46**	2.5 mm	**CKM41**	**STCM40**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	**191.407**	5 mm	**CSWM 080 050**





MDQN 107,5°

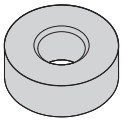
order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
3330277	**MDQNR16CA15**	60	25,0	63	-9.0	-6.0	DN..150408/DN..432
3330201	**MDQNR20CA15**	70	25,0	70	-9.0	-8.0	DN..150408/DN..432
left hand							
3330276	**MDQNL16CA15**	60	25,0	63	-9.0	-6.0	DN..150408/DN..432
3330200	**MDQNL20CA15**	70	25,0	70	-9.0	-8.0	DN..150408/DN..432

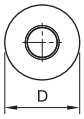
Spare Parts



D min	shim	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
60	**IDSN432**	**KLM46S**	2.5 mm	**CKM36**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	**191.407**	5 mm	**CSWM 080 050**
70	**IDSN432**	**KLM46**	2.5 mm	**CKM34**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	**191.407**	5 mm	**CSWM 080 050**

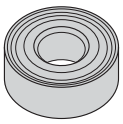
● first choice
○ alternate choice

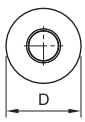




RNMA

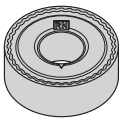
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
RNMA120400	12,70	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
RNMA150600	15,88	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

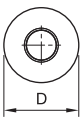




RNMG

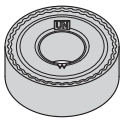
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
RNMG190600	19,05	–	–	–	–	–	–	–	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–

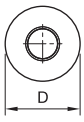




RNMG-RN

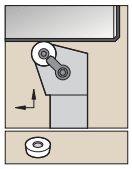
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
RNMG090300RN	9,53	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RNMG120400RN	12,70	–	–	–	–	●	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
RNMG150600RN	15,88	–	–	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RNMG190600RN	19,05	–	–	–	–	–	–	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
RNMG250900RN	25,40	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

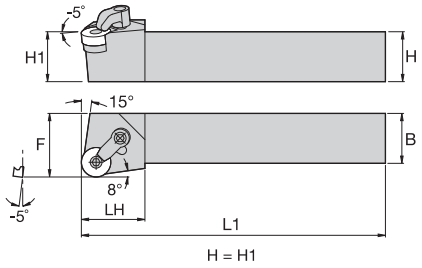




RNMG-UN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
RNMG120400UN	12,70	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–





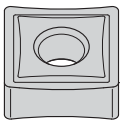


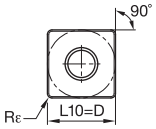
MRGN



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand													
1102086	**MRGNR2525M12**	25	25	32,0	150	32,0	RN..120400	**IRSN43**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
left hand													
1102699	**MRGNL2525M12**	25	25	32,0	150	32,0	RN..120400	**IRSN43**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm

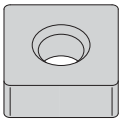
● first choice
○ alternate choice

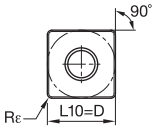




SNGP

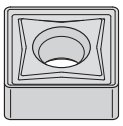
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
SNGP120404	12,70	12,70	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–
SNGP120408	12,70	12,70	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–

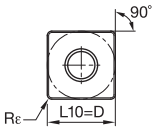




SNMA

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMA120408	12,70	12,70	0,8	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
SNMA120412	12,70	12,70	1,2	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMA150612	15,88	15,88	1,2	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMA190612	19,05	19,05	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
SNMA190616	19,05	19,05	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

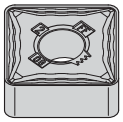


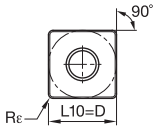


SNMG

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMG120408	12,70	12,70	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–
SNMG120412	12,70	12,70	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
SNMG190612	19,05	19,05	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
SNMG190616	19,05	19,05	1,6	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG250924	25,40	25,40	2,4	–	–	–	–	–	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–

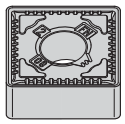
● first choice
○ alternate choice

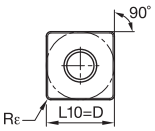




SNMG-FF

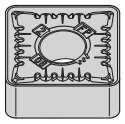
				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
ISO catalogue number	D	L10	Rε																															
SNMG090304FF	9,53	9,53	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
SNMG090308FF	9,53	9,53	0,8	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●
SNMG120408FF	12,70	12,70	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–

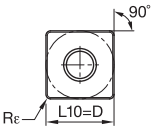




SNMG-FN

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	D	L10	Rε																															
SNMG090308FN	9,53	9,53	0,8	–	–	–	●	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120404FN	12,70	12,70	0,4	–	●	●	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120408FN	12,70	12,70	0,8	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●
SNMG120412FN	12,70	12,70	1,2	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120416FN	12,70	12,70	1,6	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

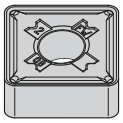


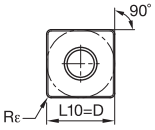


SNMG-FP

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	D	L10	Rε																															
SNMG120404FP	12,70	12,70	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	●	–	–	–	–	–
SNMG120408FP	12,70	12,70	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	●	–	–	–	–	–

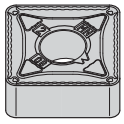
● first choice
○ alternate choice

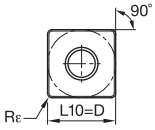




SNMG-FW

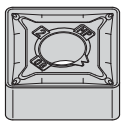
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
				P ●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
				M								○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
				K ○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
				N																							●	●	●	●	●	●	●	
				S																							●	●	●	●	●	●		
				H																														
SNMG120408FW	12,70	12,70	0,8	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120412FW	12,70	12,70	1,2	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●

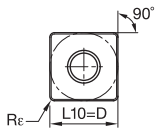




SNMG-MN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMG090308MN	9,53	9,53	0,8	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG090312MN	9,53	9,53	1,2	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120404MN	12,70	12,70	0,4	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120408MN	12,70	12,70	0,8	–	–	●	●	●	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120412MN	12,70	12,70	1,2	–	–	●	●	●	●	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120416MN	12,70	12,70	1,6	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG150612MN	15,88	15,88	1,2	–	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG150616MN	15,88	15,88	1,6	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG190612MN	19,05	19,05	1,2	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG190616MN	19,05	19,05	1,6	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

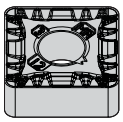


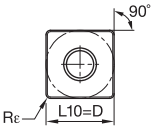


SNMG-MP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMG120408MP	12,70	12,70	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–	–	–	●	–	●	–	–	–
SNMG120412MP	12,70	12,70	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	–	–	–	●	●	●	–	–	–
SNMG120416MP	12,70	12,70	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
SNMG150608MP	15,88	15,88	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–
SNMG150612MP	15,88	15,88	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–	–	●	–	●	–	–	–
SNMG150616MP	15,88	15,88	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–
SNMG190612MP	19,05	19,05	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–
SNMG190616MP	19,05	19,05	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–

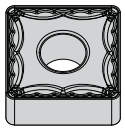
● first choice
○ alternate choice

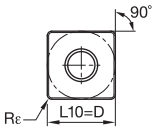




SNMG-MR

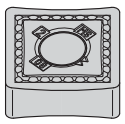
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
SNMG120408MR	12,70	12,70	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	●	–	–	–	–	–
SNMG120412MR	12,70	12,70	1,2	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–
SNMG150612MR	15,88	15,88	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–	–	–

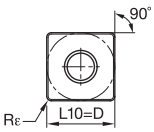




SNMG-MG

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMG120416MG	12,70	12,70	1,6	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

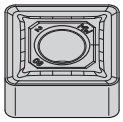


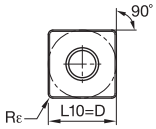


SNMG-MS

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMG120408MS	12,70	12,70	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
SNMG120412MS	12,70	12,70	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–
SNMG150608MS	15,88	15,88	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
SNMG150612MS	15,88	15,88	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
SNMG190612MS	19,05	19,05	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–

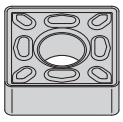
● first choice
○ alternate choice

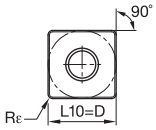




SNMG-MW

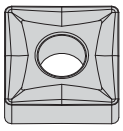
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMG120408MW	12,70	12,70	0,8	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120412MW	12,70	12,70	1,2	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

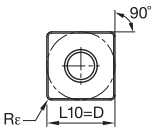




SNMG-P

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMG120412P	12,70	12,70	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–

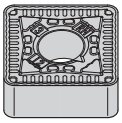


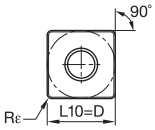


SNMG-RM

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMG250924RM	25,40	25,40	2,4	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–

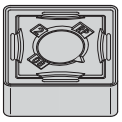
● first choice
○ alternate choice

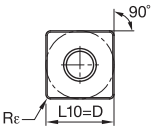




SNMG-RN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
SNMG090412RN	9,53	9,53	1,2	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120408RN	12,70	12,70	0,8	–	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120412RN	12,70	12,70	1,2	–	–	●	●	●	●	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
SNMG120416RN	12,70	12,70	1,6	–	–	●	–	●	●	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG150608RN	15,88	15,88	0,8	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG150612RN	15,88	15,88	1,2	–	–	●	–	●	●	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
SNMG150616RN	15,88	15,88	1,6	–	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
SNMG190608RN	19,05	19,05	0,8	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG190612RN	19,05	19,05	1,2	–	–	●	–	●	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG190616RN	19,05	19,05	1,6	–	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
SNMG190624RN	19,05	19,05	2,4	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG250924RN	25,40	25,40	2,4	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

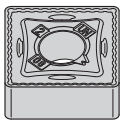


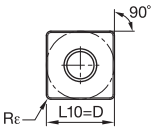


SNMG-RP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMG120408RP	12,70	12,70	0,8	–	●	–	●	●	●	–	–	–	–	–	–	–	–	●	●	–	–	–	●	–	●	–	–	–	●	●	●	●	–	–
SNMG120412RP	12,70	12,70	1,2	–	●	●	●	●	●	–	●	–	●	–	●	●	●	–	●	–	–	●	●	–	–	–	–	–	●	●	●	●	–	–
SNMG120416RP	12,70	12,70	1,6	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–
SNMG150612RP	15,88	15,88	1,2	–	–	●	–	●	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	●	●	–	–	–	–
SNMG150616RP	15,88	15,88	1,6	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	●	–	–	–	–
SNMG190612RP	19,05	19,05	1,2	–	–	–	●	●	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	–	●	–	–	–	●	●	●	●	–	–
SNMG190616RP	19,05	19,05	1,6	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	●	–	–	●	●	–	–	●	–	–	●	●	–	●	–	–

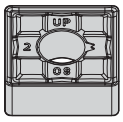
● first choice
○ alternate choice

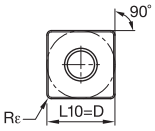




SNMG-UN

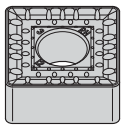
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
SNMG120408UN	12,70	12,70	0,8	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120412UN	12,70	12,70	1,2	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG120416UN	12,70	12,70	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG150612UN	15,88	15,88	1,2	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG150616UN	15,88	15,88	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG190612UN	19,05	19,05	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG190616UN	19,05	19,05	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

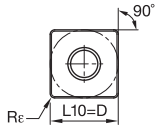




SNMG-UP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMG120408UP	12,70	12,70	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–
SNMG120412UP	12,70	12,70	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–
SNMG150612UP	15,88	15,88	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	●	–	–	–	–	–

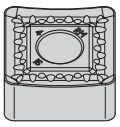


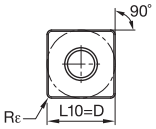


SNMM-RH

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMM190612RH	19,05	19,05	1,2	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM190616RH	19,05	19,05	1,6	–	–	–	●	●	●	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM190624RH	19,05	19,05	2,4	–	–	–	●	●	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM250724RH	25,40	25,40	2,4	–	–	●	●	●	●	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM250924RH	25,40	25,40	2,4	–	–	●	●	●	●	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

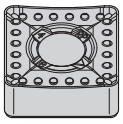
● first choice
○ alternate choice

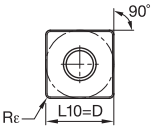




SNMM-RM

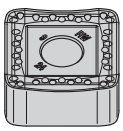
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
				P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ●	P ●	P ●	P ●	P ●	P ●	P ●		P ●
				M	M	M	M	M	M	M	M	M ○	M ○	M	M	M	M	M	M	M ●	M ●	M ●	M ●	M ●	M ●	M	M ●	M ●	M ●	M ●	M ●	M ●		M ●
				K ○	K ○	K ○	K ○	K ○	K ○	K	K	K	K	K ●	K ●	K ●	K ●	K ●	K ●	K	K	K	K	K	K	K ●	K ●	K ●	K ●	K ●	K ●	K ●		K ●
				N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N ●	N ●	N ●	N ●	N ●	N ●	N ●	
				S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S ●	S ●	S ●	S ●	S ●	S ●		
				H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H
SNMM120408RM	12,70	12,70	0,8	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM120412RM	12,70	12,70	1,2	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM150612RM	15,88	15,88	1,2	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM150616RM	15,88	15,88	1,6	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM190612RM	19,05	19,05	1,2	–	–	–	●	●	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM190616RM	19,05	19,05	1,6	–	–	–	●	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM190624RM	19,05	19,05	2,4	–	–	–	–	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM250724RM	25,40	25,40	2,4	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM250924RM	25,40	25,40	2,4	–	–	–	–	–	●	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

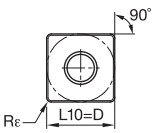




SNMM-RP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMM120408RP	12,70	12,70	0,8	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–
SNMM120412RP	12,70	12,70	1,2	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–
SNMM150612RP	15,88	15,88	1,2	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM150616RP	15,88	15,88	1,6	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–
SNMM190612RP	19,05	19,05	1,2	–	–	–	–	–	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM190616RP	19,05	19,05	1,6	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–
SNMM190624RP	19,05	19,05	2,4	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–
SNMM250724RP	25,40	25,40	2,4	–	–	–	–	–	●	–	–	–	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–
SNMM250924RP	25,40	25,40	2,4	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–

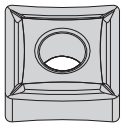


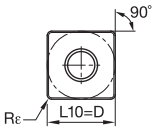


SNMM-RW

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMM190624RW	19,05	19,05	2,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMM250724RW	25,40	25,40	2,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

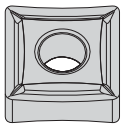
● first choice
○ alternate choice

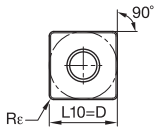




SNMP

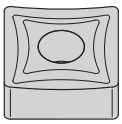
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
SNMP190612	19,05	19,05	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–

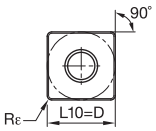




SNMP-K

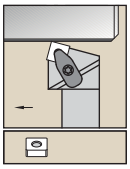
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMP120408K	12,70	12,70	0,8	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

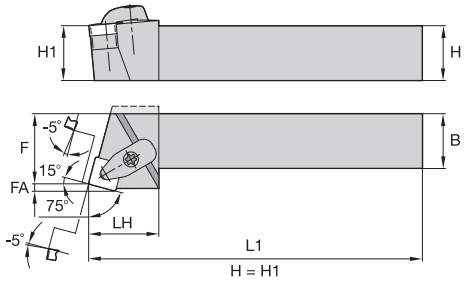


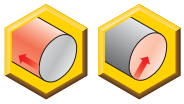


SNMS

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
SNMS120408	12,70	12,70	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
SNMS190612	19,05	19,05	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●	–







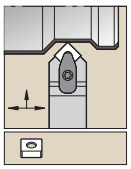
DSBN-KC 75°

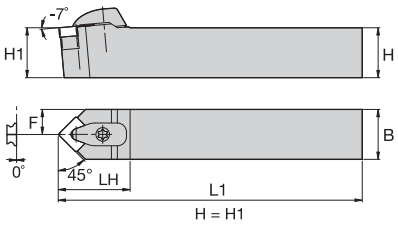






order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
left hand															
1875215	DSBNL2525M12KC04	25	25	22,0	150	32,0	3,0	SN..120408	ISSN443	KMSP415IP	15 IP	CM234R ASSY	15 IP	SSP025016M	KLM46L15IP







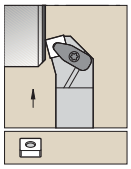
DSDN-KC 45°

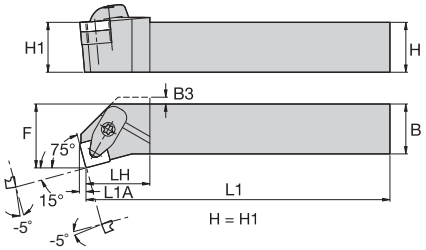


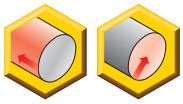




order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
1875210	DSDNN2020K12KC04	20	20	10,0	125	36,0	SN..120408	ISSN433	KMSP415IP	15 IP	CM234R ASSY	15 IP	SSP025016M	KLM4615IP
1875211	DSDNN2525M12KC04	25	25	12,0	150	36,0	SN..120408	ISSN443	KMSP415IP	15 IP	CM234R ASSY	15 IP	SSP025016M	KLM46L15IP
1875216	DSDNN2525M15KC06	25	25	12,0	150	42,0	SN..150612	ISSN543	KMSP515IP	15 IP	CM209R ASSY	15 IP	SSP025016M	KLM58L15IP
2273139	DSDNN3232P19KC06	32	32	15,5	170	44,0	SN..190612	ISSN643	KMSP625IP	25 IP	CM210R ASSY	25 IP	SSP025016M	KLM68L25IP
2456320	DSDNN4040S25KC09	40	40	19,5	250	59,0	SN..250924	ISSN846	KMSP825IP	25 IP	CM236R ASSY	25 IP	SSP025018M	KLM81025IP







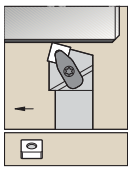
DSKN-KC 75°

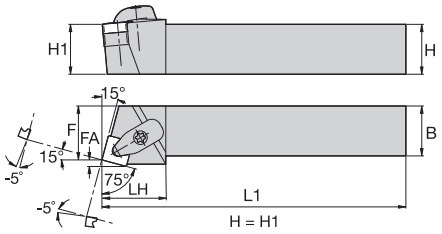


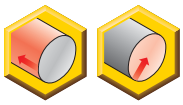




order number	catalogue number	H	B	F	L1	LH	L1A	B3	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand																
1875219	**DSKNR2525M12KC04**	25	25	32,0	150	32,0	3,1	4,0	SN..120408	**ISSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
left hand																
1875220	**DSKNL2525M12KC04**	25	25	32,0	150	32,0	3,1	4,0	SN..120408	**ISSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**







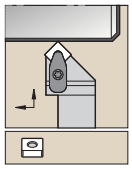
DSRN-KC 75°

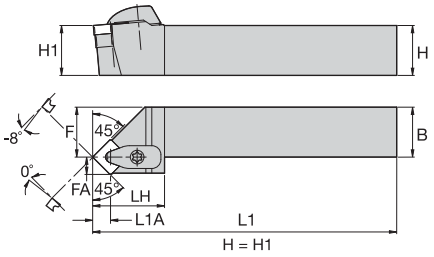






order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand															
1875228	**DSRNR2525M12KC04**	25	25	27,0	150	32,0	3,3	SN..120408	**ISSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
2456321	**DSRNR4040S25KC09**	40	40	43,0	250	52,0	6,1	SN..250924	**ISSN846**	**KMSP825IP**	25 IP	**CM236R ASSY**	25 IP	**SSP025018M**	**KLM81025IP**
left hand															
2456322	**DSRNL4040S25KC09**	40	40	43,0	250	52,0	6,1	SN..250924	**ISSN846**	**KMSP825IP**	25 IP	**CM236R ASSY**	25 IP	**SSP025018M**	**KLM81025IP**



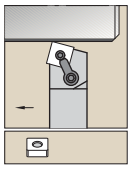


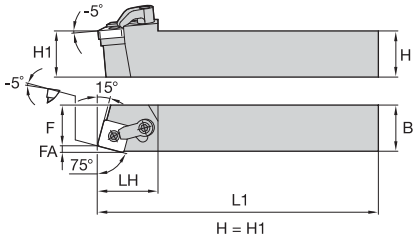


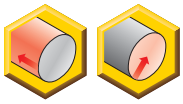
DSSN-KC 45°



order number	catalogue number	H	B	F	L1	LH	FA	L1A	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand																
1875202	**DSSNR2020K12KC04**	20	20	25,0	125	36,0	8,4	8,7	SN..120408	**ISSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**
1875195	**DSSNR2525M12KC04**	25	25	32,0	150	36,0	8,4	9,6	SN..120408	**ISSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
2273156	**DSSNR3225P12KC04**	32	25	32,0	170	35,4	8,4	8,7	SN..120408	**ISSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
left hand																
1875203	**DSSNL2525M12KC04**	25	25	32,0	150	36,0	8,4	8,7	SN..120408	**ISSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**



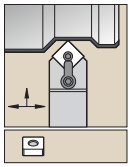


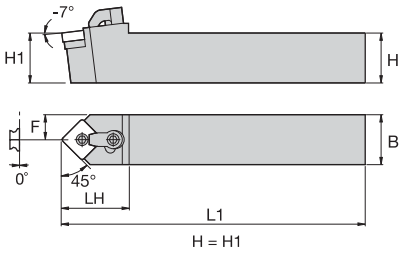


MSBN 75°



order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand														
1101893	**MSBNR3232P19**	32	32	27,0	170	40,0	4,6	SN..190612	**ISSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
1101954	**MSBNR4040R19**	40	40	35,0	200	40,0	4,6	SN..190612	**ISSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
1100937	**MSBNR2020K12**	61	20	17,0	125	32,0	3,1	SN..120408	**ISSN433**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1101359	**MSBNR2525M15**	80	25	22,0	150	35,0	3,8	SN..150612	**ISSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1100941	**MSBNR2525M12**	86	25	22,0	150	32,0	3,1	SN..120408	**ISSN433**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1101361	**MSBNR3232P15**	100	32	27,0	170	35,0	3,8	SN..150612	**ISSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1101289	**MSBNR3225P12**	106	32	22,0	170	32,0	3,1	SN..120408	**ISSN433**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
left hand														
1102640	**MSBNL3232P19**	32	32	27,0	170	40,0	4,6	SN..190612	**ISSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
1099148	**MSBNL4040R19**	40	40	35,0	200	40,0	4,6	SN..190612	**ISSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
1102242	**MSBNL2020K12**	61	20	17,0	125	32,0	3,1	SN..120408	**ISSN433**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1102318	**MSBNL2525M15**	80	25	22,0	150	35,0	3,8	SN..150612	**ISSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1102243	**MSBNL2525M12**	86	25	22,0	150	32,0	3,1	SN..120408	**ISSN433**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1102319	**MSBNL3232P15**	100	32	27,0	170	35,0	3,8	SN..150612	**ISSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1102314	**MSBNL3225P12**	106	32	22,0	170	32,0	3,1	SN..120408	**ISSN433**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm



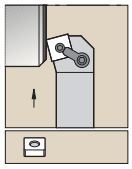


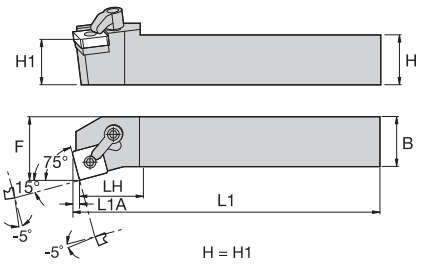


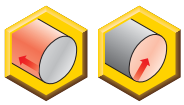
MSDN 45°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
1101891	**MSDNN2525M12**	25	25	12,0	150	32,0	SN..120408	**ISSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1101889	**MSDNN1616H09**	44	16	8,0	100	28,0	SN..090308	**ISSN332**	**KLM34L**	2 mm	**CKM19**	**STCM9**	2.5 mm
1101890	**MSDNN2020K12**	61	20	10,0	125	32,0	SN..120408	**ISSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1101892	**MSDNN2525M15**	80	25	12,5	150	35,0	SN..150612	**ISSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1101888	**MSDNN3232P19**	86	32	16,0	170	42,0	SN..190612	**ISSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
1101713	**MSDNN3225P12**	106	32	12,5	170	32,0	SN..120408	**ISSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm



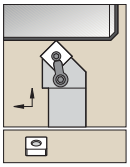


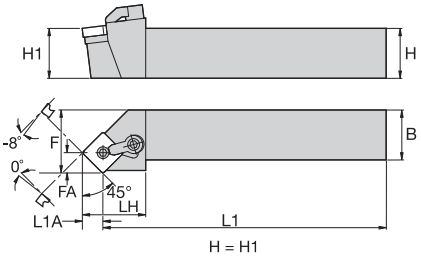


MSKN 75°



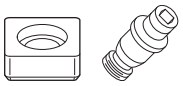
order number	catalogue number	H	B	F	L1	LH	L1A	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand														
1101886	**MSKNR2525M12**	25	25	32,0	150	32,0	3,1	SN..120408	**ISSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1101957	**MSKNR3232P19**	32	32	40,0	170	40,0	4,6	SN..190612	**ISSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
left hand														
1102637	**MSKNL2525M12**	25	25	32,0	150	32,0	3,1	SN..120408	**ISSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1102638	**MSKNL3225P12**	32	25	32,0	170	32,0	3,1	SN..120408	**ISSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1099158	**MSKNL3232P15**	32	32	40,0	170	35,0	3,7	SN..150612	**ISSN533**	**KLM58**	3 mm	**CKM21**	**STCM20**	3 mm
1102641	**MSKNL3232P19**	32	32	40,0	170	40,0	4,6	SN..190612	**ISSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm

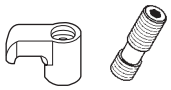




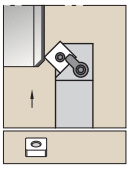


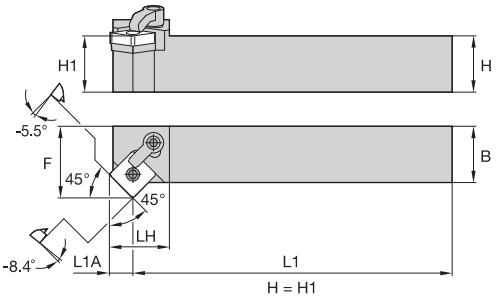
MSSN 45°





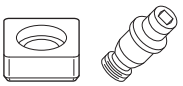
order number	catalogue number	H	B	F	L1	LH	FA	L1A	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand															
1102166	**MSSNR3232P19**	32	32	40,0	170	40,0	12,5	12,5	SN..190612	**ISSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
1102164	**MSSNR2020K12**	71	20	25,0	125	32,0	8,4	9,6	SN..120408	**ISSN433**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1102165	**MSSNR2525M12**	96	25	32,0	150	32,0	8,4	9,6	SN..120408	**ISSN433**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
left hand															
1102717	**MSSNL2020K12**	20	20	25,0	125	32,0	8,4	8,3	SN..120408	**ISSN433**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1102719	**MSSNL3232P19**	32	32	40,0	170	40,0	12,5	12,5	SN..190612	**ISSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
1102718	**MSSNL2525M12**	96	25	32,0	150	32,0	8,4	9,6	SN..120408	**ISSN433**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm

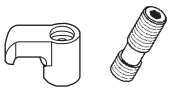




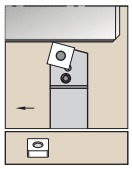


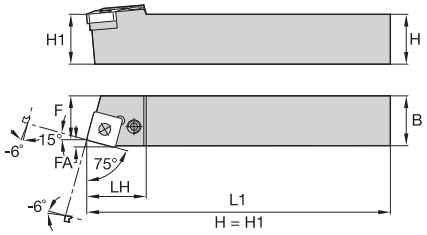
MSZN 45°





order number	catalogue number	H	B	F	L1	LH	L1A	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand														
1101884	**MSZNR2525M12**	25	25	32,0	150	25,0	8,5	SN..120408	**ISSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
left hand														
1102634	**MSZNL2525M12**	25	25	32,0	150	25,0	8,5	SN..120408	**ISSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm

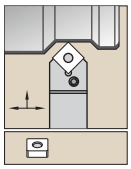


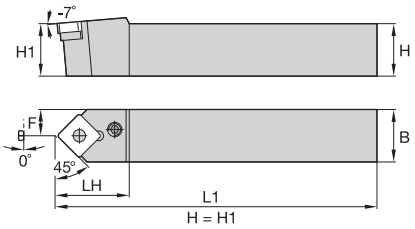


PSBN 75°

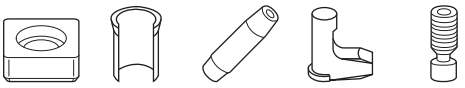


order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim pin	punch pin	lever	lever screw	Torx Plus
right hand														
1244833	PSBNR2020K12	20	20	17,0	125	26,0	3,1	SN..120408	512.063	513.023	515.018	511.023	514.123	15 IP
1244677	PSBNR2525M12	25	25	22,0	150	26,0	3,1	SN..120408	512.063	513.023	515.018	511.023	514.123	15 IP
1244834	PSBNR2525M15	25	25	22,0	150	36,0	3,8	SN..150608	512.025	513.025	515.022	511.025	514.125	15 IP
1244678	PSBNR3225P12	32	25	22,0	170	26,0	3,1	SN..120408	512.063	513.023	515.018	511.023	514.123	15 IP
1244680	PSBNR3232P15	32	32	27,0	170	33,0	3,8	SN..150608	512.025	513.025	515.022	511.025	514.125	15 IP
1244681	PSBNR3232P19	32	32	27,0	170	40,0	4,6	SN..190612	512.083	513.033	515.022	511.033	514.133	25 IP
1244682	PSBNR4040S19	40	40	35,0	250	38,0	4,6	SN..190612	512.083	513.033	515.022	511.033	514.133	25 IP
1244683	PSBNR4040S25	40	40	35,0	250	47,0	5,9	SN..250724	512.092	513.038	515.028	511.038	514.138	30 IP
left hand														
1244774	PSBNL2020K12	20	20	17,0	125	26,0	3,1	SN..120408	512.063	513.023	515.018	511.023	514.123	15 IP
1244668	PSBNL2525M12	25	25	22,0	150	26,0	3,1	SN..120408	512.063	513.023	515.018	511.023	514.123	15 IP
1244669	PSBNL2525M15	25	25	22,0	150	36,0	3,8	SN..150608	512.025	513.025	515.022	511.025	514.125	15 IP
1244672	PSBNL3232P15	32	32	27,0	170	33,0	3,8	SN..150608	512.025	513.025	515.022	511.025	514.125	15 IP
1244673	PSBNL3232P19	32	32	27,0	170	40,0	4,6	SN..190612	512.083	513.033	515.022	511.033	514.133	25 IP
1244674	PSBNL4040S19	40	40	35,0	250	38,0	4,6	SN..190612	512.083	513.033	515.022	511.033	514.133	25 IP
1244675	PSBNL4040S25	40	40	35,0	250	47,0	5,9	SN..250724	512.092	513.038	515.028	511.038	514.138	30 IP

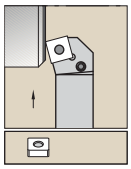


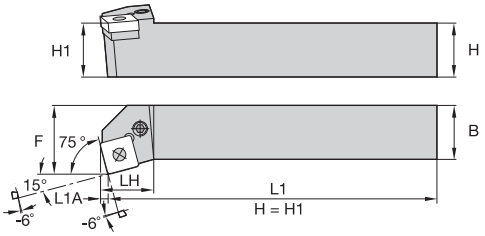


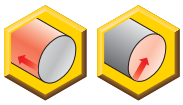
PSDN 45°



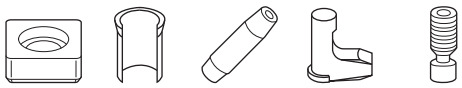
order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim pin	punch pin	lever	lever screw	Torx Plus
1244686	PSDNN1616H09	16	16	8,0	100	22,0	SN..090308	512.053	513.019	515.018	511.018	514.118	10 IP
1244863	PSDNN2020K12	20	20	10,0	125	26,0	SN..120408	512.063	513.023	515.018	511.023	514.123	15 IP
1156970	PSDNN2525M12	25	25	12,5	150	26,0	SN..120408	512.063	513.023	515.018	511.023	514.123	15 IP
1244687	PSDNN3225P12	32	25	12,5	170	28,0	SN..120408	512.063	513.023	515.018	511.023	514.123	15 IP
1244688	PSDNN3225P19	32	25	12,5	170	40,0	SN..190612	512.083	513.033	515.022	511.033	514.133	25 IP
1244835	PSDNN3232P19	32	32	16,0	170	40,0	SN..190612	512.083	513.033	515.022	511.033	514.133	25 IP
1147356	PSDNN4040S25	40	40	20,0	250	50,0	SN..250724	512.092	513.038	515.028	511.038	514.138	30 IP



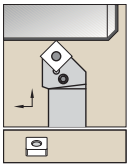


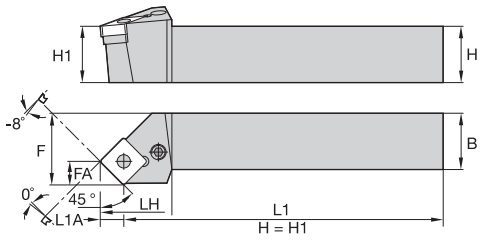


PSKN 75°



order number	catalogue number	H	B	F	L1	LH	L1A	gage insert	shim	shim pin	punch pin	lever	lever screw	Torx Plus
right hand														
1244699	**PSKNR2020K12**	20	20	25,0	125	23,0	3,1	SN..120408	**512.063**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244836	**PSKNR2525M12**	25	25	32,0	150	23,0	3,1	SN..120408	**512.063**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244701	**PSKNR3232P15**	32	32	40,0	170	32,0	3,8	SN..150608	**512.025**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244702	**PSKNR3232P19**	32	32	40,0	170	37,5	4,6	SN..190612	**512.083**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
left hand														
1244690	**PSKNL2525M12**	25	25	32,0	150	23,0	3,1	SN..120408	**512.063**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244693	**PSKNL3232P19**	32	32	40,0	170	37,5	4,6	SN..190612	**512.083**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP



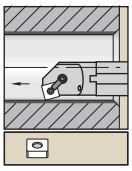




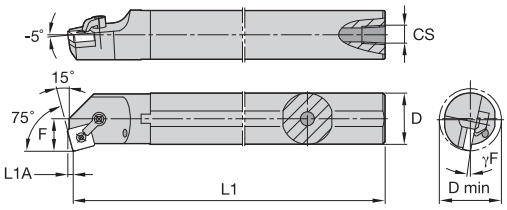
PSSN 45°



order number	catalogue number	H	B	F	L1	LH	FA	L1A	gage insert	shim	shim pin	punch pin	lever	lever screw	Torx Plus
right hand															
1244718	**PSSNR2020K09**	20	20	25,0	125	26,0	6,1	6,1	SN..090308	**512.053**	**513.019**	**515.018**	**511.018**	**514.118**	10 IP
1244837	**PSSNR2020K12**	20	20	25,0	125	28,0	8,3	8,3	SN..120408	**512.063**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1156961	**PSSNR2525M12**	25	25	32,0	150	28,0	8,3	8,3	SN..120408	**512.063**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244719	**PSSNR2525M15**	25	25	32,0	150	32,0	10,2	10,2	SN..150608	**512.025**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244720	**PSSNR3225P12**	32	25	32,0	170	29,0	8,3	8,3	SN..120408	**512.063**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244722	**PSSNR3232P15**	32	32	40,0	170	32,0	10,0	11,5	SN..150612	**512.025**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244838	**PSSNR3232P19**	32	32	40,0	170	37,5	12,5	12,5	SN..190612	**512.083**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
1244723	**PSSNR4040S19**	40	40	50,0	250	37,5	12,5	12,5	SN..190612	**512.083**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
left hand															
1244709	**PSSNL2020K12**	20	20	25,0	125	28,0	8,3	8,3	SN..120408	**512.063**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244789	**PSSNL2525M12**	25	25	32,0	150	28,0	8,3	8,3	SN..120408	**512.063**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244710	**PSSNL2525M15**	25	25	32,0	150	32,0	10,2	10,2	SN..150608	**512.025**	**513.025**	**515.022**	**511.025**	**514.125**	15 IP
1244711	**PSSNL3225P12**	32	25	32,0	170	29,0	8,3	8,3	SN..120408	**512.063**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244714	**PSSNL3232P19**	32	32	40,0	170	37,5	12,5	12,5	SN..190612	**512.083**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP
1244715	**PSSNL4040S19**	40	40	50,0	250	37,5	12,5	12,5	SN..190612	**512.083**	**513.033**	**515.022**	**511.033**	**514.133**	25 IP



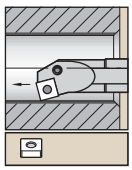
Steel shank with through coolant.



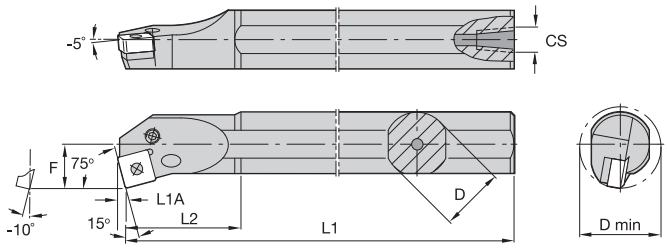
A-MSKN 75°



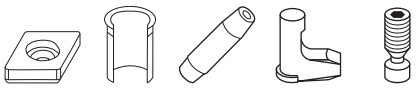
order number	catalogue number	D	D min	F	L1	L1A	CS	γF°	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand															
1098116	**A40TMSKNR12**	40	50,0	27,0	300	3,1	1/4-18 NPT	-10.0	SN..120408	**ISSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1098120	**A50UMSKNR19**	50	63,0	35,0	350	4,6	1/4-18 NPT	-12.0	SN..190608	**ISSN633**	**KLM68**	4 mm	**CKM12**	**STCM4**	4 mm
left hand															
1098115	**A32SMSKNL12**	32	40,0	22,0	250	3,1	1/4-18 NPT	-14.0	SN..120408	**ISSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm
1098117	**A40TMSKNL12**	40	50,0	27,0	300	3,1	1/4-18 NPT	-10.0	SN..120408	**ISSN432**	**KLM46**	2.5 mm	**CKM21**	**STCM20**	3 mm



Steel shank with through coolant.

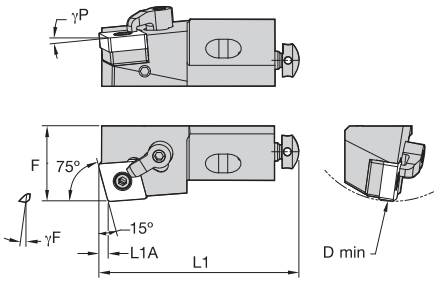


A-PSKN 75°



order number	catalogue number	D	D min	F	L1	L2	L1A	CS	gage insert	shim	shim pin	pin	toggle lever	lever screw	Torx Plus
right hand															
2447480	**A25TPSKNR12**	25	30,0	17,0	300	43	3,0	1/4-18 NPT	SN..120408	–	–	–	**511.022**	**514.122**	10 IP
2447482	**A32UPSKNR12**	32	40,0	22,0	350	52	3,0	1/4-18 NPT	SN..120408	**512.063**	**513.023**	**515.018**	**511.023**	**514.124**	15 IP



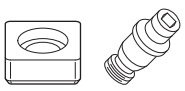
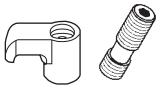


MSKN 75°

order number	catalogue number	D min	F	L1	L1A	γF°	γP°	gage insert
right hand								
2114011	**MSKNR10CA09**	40	14,0	50	2,2	-9.0	-5.0	SN..090308/SN..322
2114013	**MSKNR12CA12**	50	20,0	55	3,0	-9.0	-5.0	SN..120408/SN..432
2074430	**MSKNR16CA12**	60	25,0	63	3,0	-9.0	-5.0	SN..120408/SN..432
2072222	**MSKNR20CA15**	70	25,0	70	3,7	-9.0	-5.0	SN..150612/SN..543
2987166	**MSKNR25CA19**	100	32,0	100	4,6	-9.0	-5.0	SN..190612/SN..543
left hand								
3346242	**MSKNL12CA12**	50	20,0	55	3,0	-9.0	-5.0	SN..120408/SN..432
3330202	**MSKNL20CA15**	70	25,0	70	3,7	-9.0	-5.0	SN..150612/SN..543

NOTE: Select spare parts based off of D min and the insert size selected.

Spare Parts

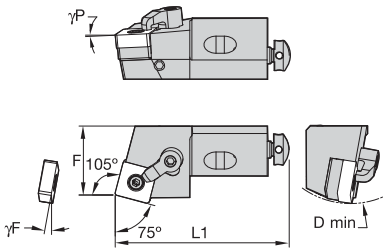






D min	shim	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	mounting screw	hex	washer
40	–	**KLM33**	2 mm	**CKM36**	**STCM38**	2 mm	**KUAM28**	2 mm	**KUAM30**	**191.405**	–	–	4 mm	**CSWM 060 050**
50	–	**KLM43**	2 mm	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	–	**191.406**	–	4 mm	**CSWM 060 050**
60	**ISSN432**	**KLM46S**	2.5 mm	**CKM34**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	–	**191.407**	–	5 mm	**CSWM 080 050**
70	**SKSN566K**	**KLM54**	2.5 mm	**CKM37**	**STCM40**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	–	**191.407**	–	5 mm	**CSWM 080 050**
100	**ISSN633**	**KLM68**	4 mm	**CKM35**	**STCM8**	4 mm	**KUAM27**	4 mm	**KUAM32**	–	–	**MS364**	8 mm	**CSWM 100 080**





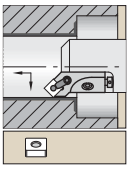
MSRN 75°

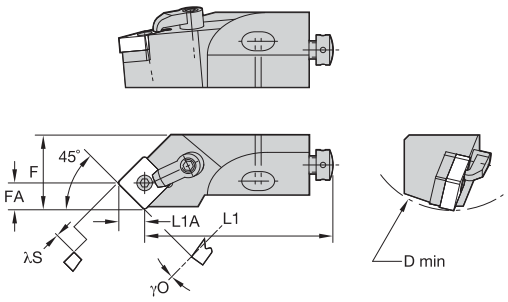
order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098436	**MSRNR10CA09**	40	14,0	50	-9.0	-5.0	SN..090308/SN..322
2078231	**MSRNR12CA12**	50	20,0	55	-9.0	-5.0	SN..120408/SN..432
2074432	**MSRNR16CA12**	60	25,0	63	-9.0	-5.0	SN..120408/SN..432
left hand							
1282803	**MSRNL12CA12**	50	20,0	55	-9.0	-5.0	SN..120408/SN..432
3330279	**MSRNL16CA12**	60	25,0	63	-9.0	-5.0	SN..120408/SN..432
3330203	**MSRNL20CA15**	70	25,0	70	-9.0	-5.0	SN..150612/SN..543

Spare Parts



D min	shim	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	hex	washer
40	–	**KLM33**	2 mm	**CKM36**	**STCM38**	2 mm	**KUAM28**	2 mm	**KUAM30**	**191.405**	–	4 mm	**CSWM 060 050**
50	–	**KLM43**	2 mm	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	–	**191.406**	4 mm	**CSWM 060 050**
60	**ISSN432**	**KLM46S**	2.5 mm	**CKM34**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	–	**191.407**	5 mm	**CSWM 080 050**
70	**SKSN566K**	**KLM54**	2.5 mm	**CKM37**	**STCM40**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	–	**191.407**	5 mm	**CSWM 080 050**





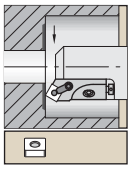
MSSN 45°

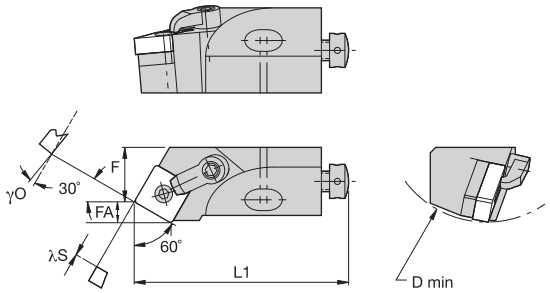
order number	catalogue number	D min	F	L1	L1A	λS°	γO°	gage insert
right hand								
1339367	**MSSNR10CA09**	40	14,0	44	6,1	-13.0	0.0	SN..090308/SN..322
1282807	**MSSNR12CA12**	50	20,0	47	8,3	-13.0	0.0	SN..120408/SN..432
3330281	**MSSNR16CA12**	60	25,0	53	8,3	-13.0	0.0	SN..120408/SN..432
3330206	**MSSNR20CA15**	70	25,0	60	10,3	-13.0	0.0	SN..150612/SN..543
left hand								
2071758	**MSSNL10CA09**	40	14,0	44	6,1	-13.0	0.0	SN..090308/SN..322
2071739	**MSSNL12CA12**	50	20,0	47	8,3	-13.0	0.0	SN..120408/SN..432

Spare Parts



D min	shim	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	hex	washer
40	–	**KLM33**	2 mm	**CKM36**	**STCM38**	2 mm	**KUAM28**	2 mm	**KUAM30**	**191.405**	–	4 mm	**CSWM 060 050**
50	–	**KLM43**	2 mm	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	–	**191.406**	4 mm	**CSWM 060 050**
60	**ISSN432**	**KLM46S**	2.5 mm	**CKM36**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	–	**191.407**	5 mm	**CSWM 080 050**
70	**SKSN566K**	**KLM54**	2.5 mm	**CKM37**	**STCM40**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	–	**191.407**	5 mm	**CSWM 080 050**





MSTN 60°

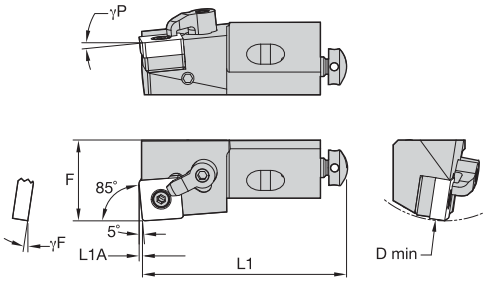
order number	catalogue number	D min	F	L1	FA	λS°	γO°	gage insert
right hand								
3331149	**MSTNR10CA09**	40,0	9,0	50	13,3	-11.0	0.0	SN..090308/SN..322
2074904	**MSTNR12CA12**	50,0	13,0	55	5,9	-11.0	0.0	SN..120408/SN..432

Spare Parts



D min	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	hex	washer
40	**KLM33**	2 mm	**CKM36**	**STCM38**	2 mm	**KUAM28**	2 mm	**KUAM30**	**191.405**	–	4 mm	**CSWM 060 050**
50	**KLM43**	2 mm	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	–	**191.406**	4 mm	**CSWM 060 050**





MSYN 85°

order number	catalogue number	D min	F	L1	L1A	γF°	γP°	gage insert
right hand								
2114015	**MSYNR10CA09**	40	14,0	50	0,8	-9.0	-5.0	SN..090308/SN..322
3346274	**MSYNR12CA12**	50	20,0	55	1,0	-9.0	-5.0	SN..120408/SN..432
3330283	**MSYNR16CA12**	60	25,0	63	1,0	-9.0	-5.0	SN..120408/SN..432
1098465	**MSYNR25CA19**	100	32,0	100	1,5	-9.0	-5.0	SN..190612/SN..643
left hand								
3331150	**MSYNL10CA09**	40	14,0	50	0,8	-9.0	-5.0	SN..090308/SN..322
3346273	**MSYNL12CA12**	50	20,0	55	1,0	-9.0	-5.0	SN..120408/SN..432
1098691	**MSYNL20CA15**	70	25,0	70	1,3	-9.0	-5.0	SN..150612/SN..543

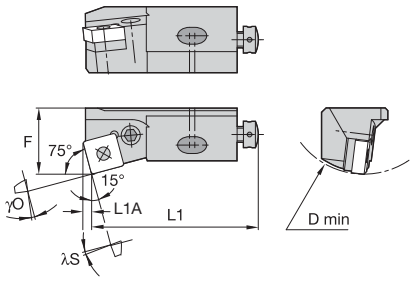
NOTE: Select spare parts based off of D min and insert size selected.

Spare Parts



D min	shim	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	mounting screw	hex	washer
40	–	**KLM33**	2 mm	**CKM36**	**STCM38**	2 mm	**KUAM28**	2 mm	**KUAM30**	**191.405**	–	–	4 mm	**CSWM 060 050**
50	–	**KLM43**	2 mm	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	–	**191.406**	–	4 mm	**CSWM 060 050**
60	**ISSN432**	**KLM46S**	2.5 mm	**CKM36**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	–	**191.407**	–	5 mm	**CSWM 080 050**
70	**SKSN566K**	**KLM54**	2.5 mm	**CKM37**	**STCM40**	2.5 mm	**KUAM25**	2.5 mm	**KUAM33**	–	**191.407**	–	6 mm	**CSWM 080 050**
100	**ISSN633**	**KLM68**	4 mm	**CKM34**	**STCM8**	4 mm	**KUAM27**	4 mm	**KUAM33**	–	–	**MS364**	8 mm	**CSWM 100 080**





PSKN 75°

order number	catalogue number	D min	F	L1	L1A	λS°	γO°	gage insert
right hand								
1188639	**PSKNR12CA-12**	50	20,0	55	3,1	-8.0	-6.0	SN..120408/SN..432

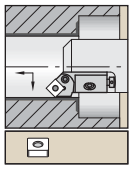
Spare Parts

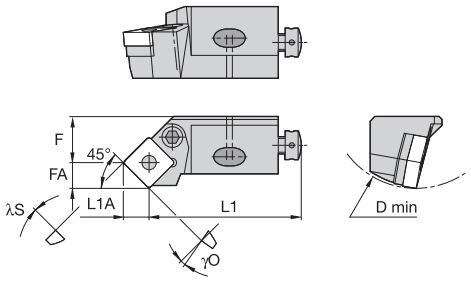







D min	toggle lever	lever screw	wrench size lever screw	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	**511.022**	**514.122**	10 IP	**KUAM28**	2 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**





PSSN 45°

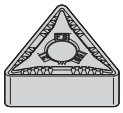
order number	catalogue number	D min	F	L1	FA	L1A	λS°	γO°	γP°	gage insert
right hand										
1244455	**PSSNR12CA-12**	50,0	20,0	47	8,7	8,3	-10.0	0.0	–	SN..120408/SN..432
left hand										
1244452	**PSSNL12CA12**	50,0	11,3	47	8,7	8,3	0.0	0.0	-10.0 deg	SN..120408/SN..432

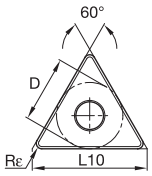
Spare Parts



D min	toggle lever	lever screw	wrench size lever screw	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	**511.022**	**514.122**	10 IP	**KUAM28**	2 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**

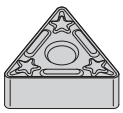
● first choice
○ alternate choice

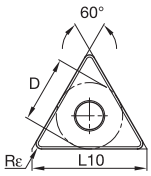




TNGG-FS

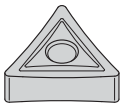
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
				P ●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
				M								○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
				K ○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
				N																							●	●	●	●	●	●	●	
				S																							●	●	●	●	●	●		
				H																														
TNGG160402FS	9,53	16,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
TNGG160404FS	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–
TNGG220408FS	12,70	22,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–

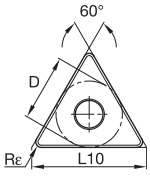




TNGG-LF

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNGG160402LF	9,53	16,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
TNGG160404LF	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
TNGG160408LF	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–



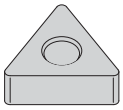


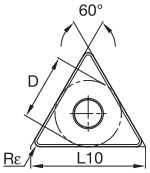
TNGP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNGP160402	9,53	16,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
TNGP160404	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–
TNGP160408	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–

● first choice
○ alternate choice

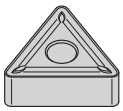
		KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P		●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M										○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K		○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																									●	●	●	●	●	●	●	
S																									●	●	●	●	●	●		
H																																

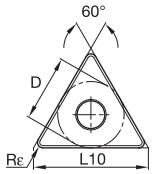




TNMA

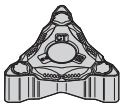
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMA160408	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TNMA160412	9,53	16,50	1,2	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMA160416	9,53	16,50	1,6	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMA220408	12,70	22,00	0,8	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TNMA220412	12,70	22,00	1,2	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMA270616	15,88	27,50	1,6	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

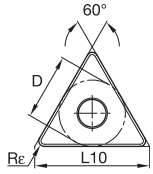




TNMG

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMG220412	12,70	22,00	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TNMG330924	19,05	33,00	2,4	–	–	–	–	–	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

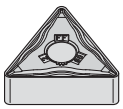


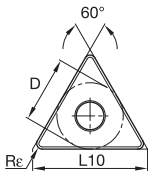


TNMG-CT

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMG160408CT	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–

● first choice
○ alternate choice

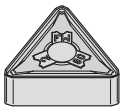


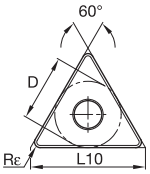


TNMG-FF

| | | |

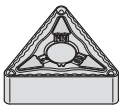
● first choice
○ alternate choice

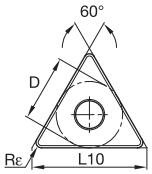




TNMG-FW

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
				P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P	P
				M									○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
				K	○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
				N																							●	●	●	●	●	●	●		
				S																							●	●	●	●	●	●			
				H																														
TNMG160404FW	9,53	16,50	0,2	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●
TNMG160408FW	9,53	16,50	0,4	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●
TNMG160412FW	9,53	16,50	1,2	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●

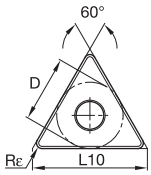




TNMG-MN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMG160404MN	9,53	16,50	0,4	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG160408MN	9,53	16,50	0,8	–	●	●	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG160412MN	9,53	16,50	1,2	–	–	●	–	●	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG220404MN	12,70	22,00	0,4	–	–	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG220408MN	12,70	22,00	0,8	–	–	●	●	●	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG220412MN	12,70	22,00	1,2	–	–	●	–	●	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

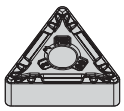


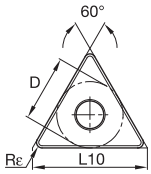


TNMG-MP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMG160404MP	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–	–	–	●	–	●	–	–	–
TNMG160408MP	9,53	16,50	0,8	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	●	–	–	–	●	–	●	–	–	–
TNMG160412MP	9,53	16,50	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–	–	–	–	–	●	–	–	–
TNMG220408MP	12,70	22,00	0,8	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–	–	–	●	–	●	–	–	–
TNMG220412MP	12,70	22,00	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	●	–	–	–
TNMG220416MP	12,70	22,00	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	●	–	–	–

● first choice
○ alternate choice



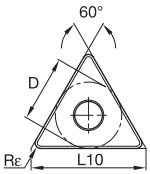


TNMG-MR

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

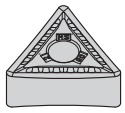
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMG160408MR	9,53	16,50	0,8	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–
TNMG160412MR	9,53	16,50	1,2	–	–	●	–	●	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG220408MR	12,70	22,00	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–
TNMG220412MR	12,70	22,00	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
TNMG270612MR	15,88	27,50	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

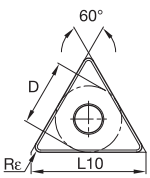




TNMG-MG

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMG160408MG	9,53	16,50	0,8	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



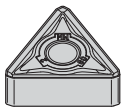


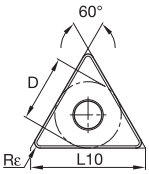
TNMG-MS

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMG160402MS	9,53	16,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
TNMG160404MS	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
TNMG160408MS	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
TNMG220404MS	12,70	22,00	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
TNMG220408MS	12,70	22,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
TNMG220412MS	12,70	22,00	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–
TNMG270608MS	15,88	27,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–
TNMG270616MS	15,88	27,50	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–

● first choice
○ alternate choice

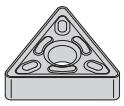
		KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P		●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M										○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K		○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																									●	●	●	●	●	●	●	
S																									●	●	●	●	●	●		
H																																

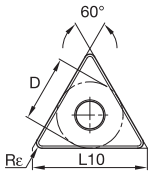




TNMG-MW

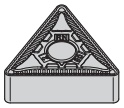
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMG160408MW	9,53	16,50	0,8	–	●	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG160412MW	9,53	16,50	1,2	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

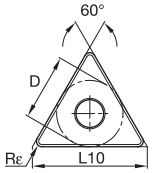




TNMG-P

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMG160404P	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
TNMG160408P	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
TNMG220404P	12,70	22,00	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
TNMG220408P	12,70	22,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
TNMG220412P	12,70	22,00	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–

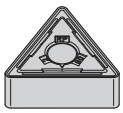


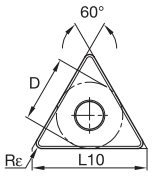


TNMG-RN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMG160408RN	9,53	16,50	0,8	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG160412RN	9,53	16,50	1,2	–	–	●	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG220408RN	12,70	22,00	0,8	–	–	●	–	●	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG220412RN	12,70	22,00	1,2	–	–	●	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG220416RN	12,70	22,00	1,6	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG270608RN	15,88	27,50	0,8	–	–	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG270612RN	15,88	27,50	1,2	–	–	●	●	–	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG270616RN	15,88	27,50	1,6	–	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG330924RN	19,05	33,00	2,4	–	–	●	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

● first choice
○ alternate choice





TNMG-RP

		●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
											○	○							●	●	●	●	●	●	●		●	●	●	●	●	●	●		●
		○	○	○	○	○	○					●	●	●	●	●	●									●	●	●	●	●	●	●		●
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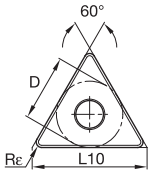
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMG160408RP	9,53	16,50	0,8	–	●	●	●	●	●	–	●	–	–	–	●	–	–	–	●	–	●	–	●	–	–	–	–	–	●	●	●	●	–	–
TNMG160412RP	9,53	16,50	1,2	–	●	●	●	●	●	–	–	–	–	–	–	–	–	–	●	–	–	–	●	–	●	–	–	–	–	●	–	●	–	–
TNMG160416RP	9,53	16,50	1,6	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG220408RP	12,70	22,00	0,8	–	–	●	–	●	●	–	–	●	–	–	–	–	–	●	–	–	–	●	●	–	–	–	–	–	●	●	●	●	–	–
TNMG220412RP	12,70	22,00	1,2	–	–	–	●	●	–	–	–	–	●	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	●	●	–	–	–	–
TNMG220416RP	12,70	22,00	1,6	–	–	–	●	●	–	–	–	–	–	–	–	–	●	–	–	–	–	●	–	–	–	–	–	–	–	●	–	–	–	–
TNMG220432RP	12,70	22,00	3,2	–	–	●	–	●	–	–	●	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
TNMG270612RP	15,88	27,50	1,2	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	●	–	–	–	●	●	●	–	–	–
TNMG270616RP	15,88	27,50	1,6	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–
TNMG330924RP	19,05	33,00	2,4	–	–	–	–	–	●	–	–	●	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–



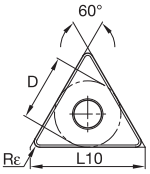


TNMG-UN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMG160408UN	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG160412UN	9,53	16,50	1,2	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG160416UN	9,53	16,50	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG220408UN	12,70	22,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG220412UN	12,70	22,00	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG220416UN	12,70	22,00	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

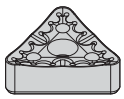
● first choice
○ alternate choice

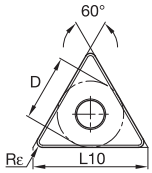




TNMG-UP

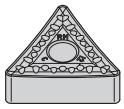
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
TNMG160404UP	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–
TNMG160408UP	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–
TNMG220408UP	12,70	22,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–

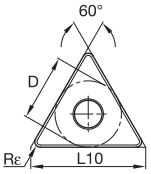




TNMM-MR

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMM330924MR	19,05	33,00	2,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

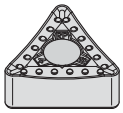


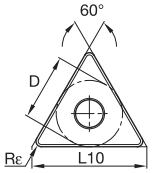


TNMM-RM

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMM160408RM	9,53	16,50	0,8	–	–	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMM160412RM	9,53	16,50	1,2	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMM220408RM	12,70	22,00	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMM220412RM	12,70	22,00	1,2	–	–	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMM220416RM	12,70	22,00	1,6	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMM270612RM	15,88	27,50	1,2	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMM270616RM	15,88	27,50	1,6	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

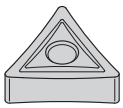
● first choice
○ alternate choice

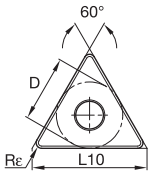




TNMM-RP

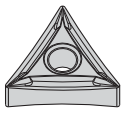
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMM220408RP	12,70	22,00	0,8	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMM220412RP	12,70	22,00	1,2	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
TNMM220416RP	12,70	22,00	1,6	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

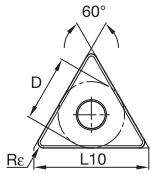




TNMP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMP160404	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–
TNMP160408	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–
TNMP220416	12,70	22,00	1,6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

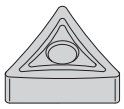


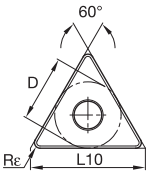


TNMP-K

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
TNMP160404K	9,53	16,50	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMP160408K	9,53	16,50	0,8	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMP220408K	12,70	22,00	0,8	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

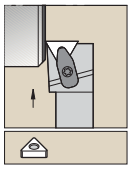
● first choice
○ alternate choice

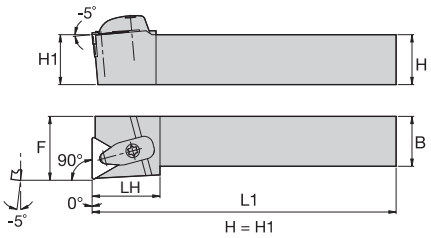


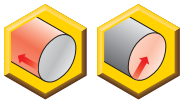


TNMS

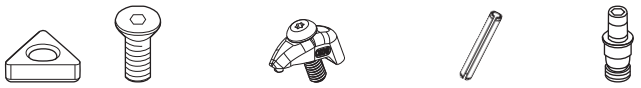
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
				P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ●	P ●	P ●	P ●	P ●	P ●	P ●		P ●
				M	M	M	M	M	M	M	M	M ○	M ○	M	M	M	M	M	M	M ●	M ●	M ●	M ●	M ●	M ●	M	M ●	M ●	M ●	M ●	M ●	M ●		M ●
				K ○	K ○	K ○	K ○	K ○	K ○	K	K	K	K	K ●	K ●	K ●	K ●	K ●	K ●	K	K	K	K	K	K	K ●	K ●	K ●	K ●	K ●	K ●	K ●		K ●
				N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N ●	N ●	N ●	N ●	N ●	N ●	N ●	
				S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S ●	S ●	S ●	S ●	S ●	S ●		
				H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H
TNMS160404	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TNMS160408	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TNMS220408	12,70	22,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●	–



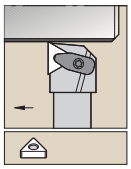


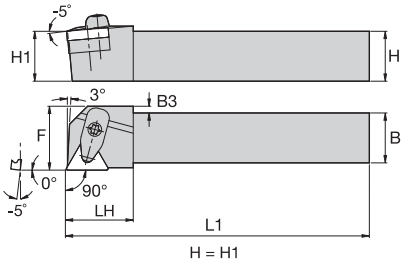


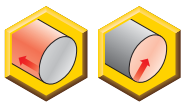
DTFN-KC 90°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand														
2273392	**DTFNR2020K16KC04**	20	20	25,0	125	32,0	TN..160408	**ITSN323**	**KMSP315IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
left hand														
1875233	**DTFNL2525M22KC04**	25	25	32,0	150	34,0	TN..220408	**ITSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**



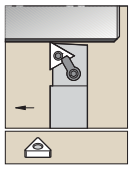


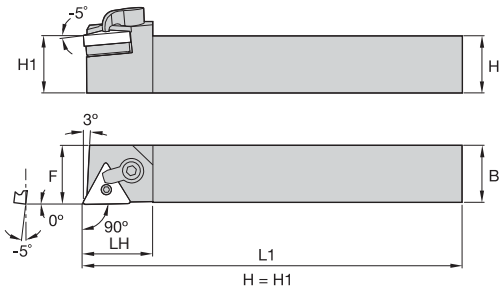


DTGN-KC 90°



order number	catalogue number	H	B	F	L1	LH	B3	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand															
2273440	**DTGNR2020K16KC04**	20	20	25,0	125	25,0	6,5	TN..160408	**ITSN323**	**KMSP315IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
2273441	**DTGNR2525M16KC04**	25	25	32,0	150	25,0	—	TN..160408	**ITSN323**	**KMSP315IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
1875222	**DTGNR2525M22KC04**	25	25	32,0	150	32,0	3,0	TN..220408	**ITSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**
left hand															
1875234	**DTGNL2525M22KC04**	25	25	32,0	150	32,0	3,0	TN..220408	**ITSN443**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM46L15IP**



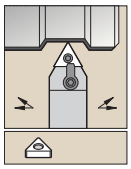


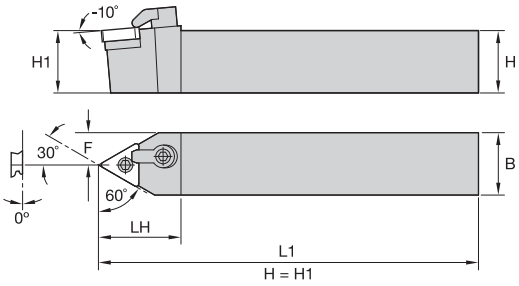


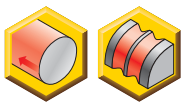
MTAN-S 90°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand													
1102172	**MTANRS2020K16**	20	20	20,5	125	32,0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM21**	**STCM20**	3 mm
1102173	**MTANRS2525M16**	25	25	25,5	150	30,0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM21**	**STCM20**	3 mm
left hand													
1102726	**MTANLS2525M16**	25	25	25,5	150	32,0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM21**	**STCM20**	3 mm



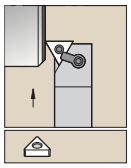


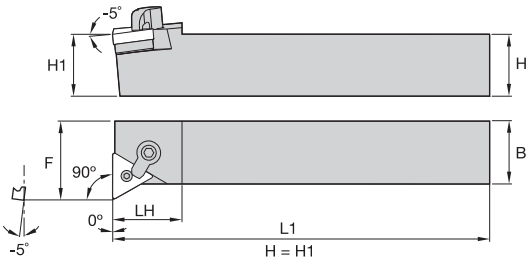


MTEN-S 60°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
1102169	**MTENNS2020K16**	20	20	10,0	125	32,0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM21**	**STCM20**	3 mm
1102170	**MTENNS2525M16**	25	25	12,0	150	32,0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM21**	**STCM20**	3 mm
1102171	**MTENNS2525M22**	25	25	12,0	150	35,0	TN..220408	**ITSN433**	**KLM46**	2.5 mm	**CKM9**	**STCM4**	4 mm
1102168	**MTENNS3225P22**	32	25	12,0	170	35,0	TN..220408	**ITSN433**	**KLM46**	2.5 mm	**CKM9**	**STCM4**	4 mm



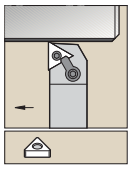


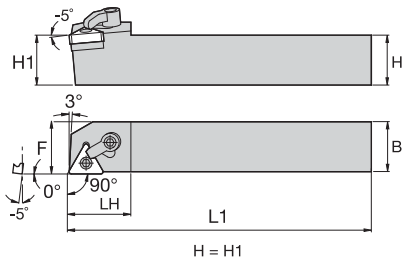


MTFN 90°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand													
1101961	**MTFNR2525M16**	25	25	32,0	150	32,0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM20**	**STCM11**	3 mm
left hand													
1102643	**MTFNL2020K16**	20	20	25,0	125	32,0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM20**	**STCM11**	3 mm
1102694	**MTFNL2525M16**	25	25	32,0	150	32,0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM20**	**STCM11**	3 mm



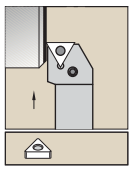


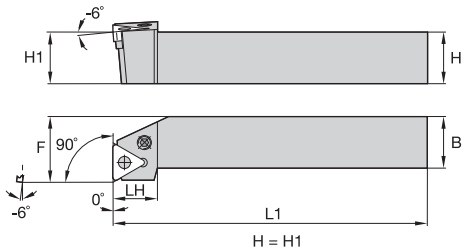


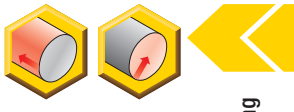
MTGN 90°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand													
1102088	**MTGNR1616H16**	36	25	20,0	100	32,0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM20**	**STCM11**	3 mm
1102090	**MTGNR2525M16**	86	32	32,0	150	32,0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM21**	**STCM20**	3 mm
1102091	**MTGNR2525M22**	86	38	32,0	150	32,0	TN..220408	**ITSN433**	**KLM46**	2.5 mm	**CKM9**	**STCM4**	4 mm
1102093	**MTGNR3232P22**	106	32	40,0	170	32,0	TN..220408	**ITSN433**	**KLM46**	2.5 mm	**CKM9**	**STCM4**	4 mm
left hand													
1102714	**MTGNL2525M16**	86	32	32,0	150	32,0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM21**	**STCM20**	3 mm
1102715	**MTGNL2525M22**	86	38	32,0	150	32,0	TN..220408	**ITSN433**	**KLM46**	2.5 mm	**CKM9**	**STCM4**	4 mm
1102716	**MTGNL3232P22**	106	25	40,0	170	32,0	TN..220408	**ITSN433**	**KLM46**	2.5 mm	**CKM9**	**STCM4**	4 mm



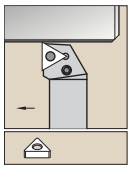


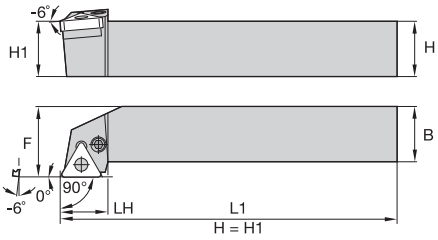


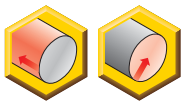
PTFN 90°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim pin	punch pin	lever	lever screw	hex
right hand													
1244843	PTFNR2020K16	20	20	25,0	125	20,0	TN..160408	512.013	513.018	515.018	511.018	514.118	10 IP
1244844	PTFNR2525M16	25	25	32,0	150	20,0	TN..160408	512.013	513.018	515.018	511.018	514.118	10 IP
left hand													
1244839	PTFNL2020K16	20	20	25,0	125	20,0	TN..160408	512.013	513.018	515.018	511.018	514.118	10 IP
1244726	PTFNL2525M16	25	25	32,0	150	20,0	TN..160408	512.013	513.018	515.018	511.018	514.118	10 IP



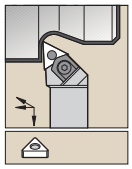


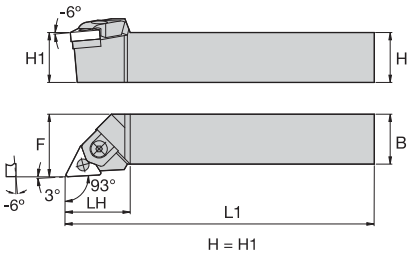


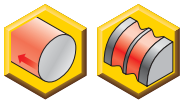
PTGN 90°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim pin	punch pin	lever	lever screw	hex
right hand													
1156972	PTGNR1616H16	16	16	20,0	100	20,0	TN..160408	512.013	513.018	515.018	511.018	514.118	10 IP
1244850	PTGNR2020K16	20	20	25,0	125	20,0	TN..160408	512.013	513.018	515.018	511.018	514.118	10 IP
1192394	PTGNR2525M16	25	25	32,0	150	20,0	TN..160408	512.013	513.018	515.018	511.018	514.118	10 IP
1244851	PTGNR2525M22	25	25	32,0	150	26,0	TN..220408	512.023	513.023	515.018	511.023	514.123	15 IP
left hand													
1244791	PTGNL1616H16	16	16	20,0	100	20,0	TN..160408	512.013	513.018	515.018	511.018	514.118	10 IP
1244848	PTGNL2020K16	20	20	25,0	125	20,0	TN..160408	512.013	513.018	515.018	511.018	514.118	10 IP
1244792	PTGNL2525M16	25	25	32,0	150	20,0	TN..160408	512.013	513.018	515.018	511.018	514.118	10 IP
1244778	PTGNL2525M22	25	25	32,0	150	26,0	TN..220408	512.023	513.023	515.018	511.023	514.123	15 IP







MTJN 93°

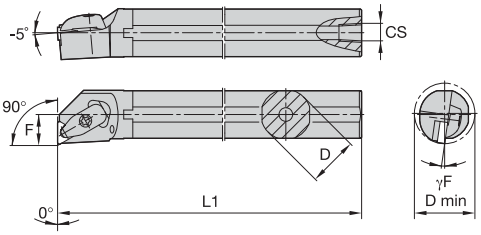




order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim pin	clamp assembly	hex
right hand											
1192350	**MTJNR2020K16H4**	20	20	25,0	125	32,0	TN..160408	**512.125**	**513.125**	**551.125**	3 mm
1192352	**MTJNR2525M16H4**	25	25	32,0	150	32,0	TN..160408	**512.125**	**513.125**	**551.125**	3 mm
1245000	**MTJNR2525M22H4**	25	25	32,0	150	36,0	TN..220408	**512.126**	**513.126**	**551.126**	3 mm
1244998	**MTJNR3225P16H4**	32	25	32,0	170	32,0	TN..160408	**512.125**	**513.125**	**551.125**	3 mm
1244999	**MTJNR3225P22H4**	32	25	32,0	170	36,0	TN..220408	**512.126**	**513.126**	**551.126**	3 mm
left hand											
1244996	**MTJNL2020K16H4**	20	20	25,0	125	32,0	TN..160408	**512.125**	**513.125**	**551.125**	3 mm
1245002	**MTJNL2525M16H4**	25	25	32,0	150	32,0	TN..160408	**512.125**	**513.125**	**551.125**	3 mm
1245001	**MTJNL2525M22H4**	25	25	32,0	150	36,0	TN..220408	**512.126**	**513.126**	**551.126**	3 mm
1244997	**MTJNL3225P16H4**	32	25	32,0	170	32,0	TN..160408	**512.125**	**513.125**	**551.125**	3 mm



Steel shank with through coolant.



A-DTFN-KC 90°

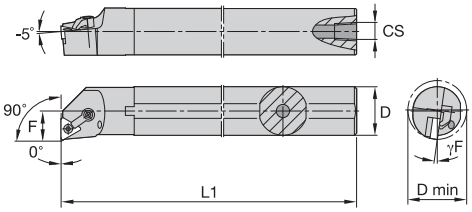


order number	catalogue number	D	D min	F	L1	CS	γF°	gage insert	shim	shim screw	Torx Plus	clamp assembly	slotted pin	Torx Plus
right hand														
2441866	**A25RDTFNR16KC04**	25	32,0	17,0	200	1/4-18 NPT	-14.0	TN..160408	**ITSN323**	**KMSP315IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441870	**A32SDTFNR16KC04**	32	40,0	22,0	250	1/4-18 NPT	-12.0	TN..160408	**ITSN323**	**KMSP315IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
left hand														
2441869	**A25RDTFNL16KC04**	25	32,0	17,0	200	1/4-18 NPT	-14.0	TN..160408	**ITSN323**	**KMSP315IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP

Kenloc™ Boring Bars



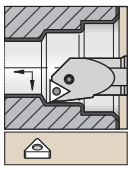
Steel shank with through coolant.



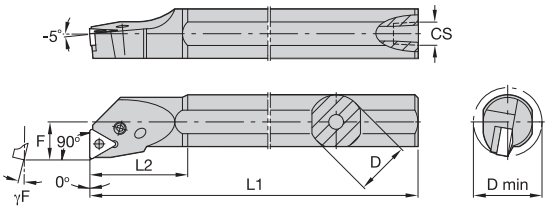
A-MTFN 90°



order number	catalogue number	D	D min	F	L1	CS	γF°	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand														
1098121	**A25RMTFNR16**	25	32,0	17,0	200	1/4-18 NPT	-14.0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM21**	**STCM20**	3 mm
1098123	**A32SMTFNR16**	32	40,0	22,0	250	1/4-18 NPT	-12.0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM21**	**STCM20**	3 mm
1098125	**A40TMTFNR16**	40	50,0	27,0	300	1/4-18 NPT	-9.0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM21**	**STCM20**	3 mm
left hand														
1098122	**A25RMTFNL16**	25	32,0	17,0	200	1/4-18 NPT	-14.0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM21**	**STCM20**	3 mm
1098124	**A32SMTFNL16**	32	40,0	22,0	250	1/4-18 NPT	-12.0	TN..160408	**ITSN322**	**KLM34L**	2 mm	**CKM21**	**STCM20**	3 mm



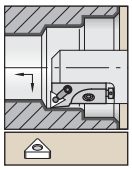
Steel shank with through coolant.

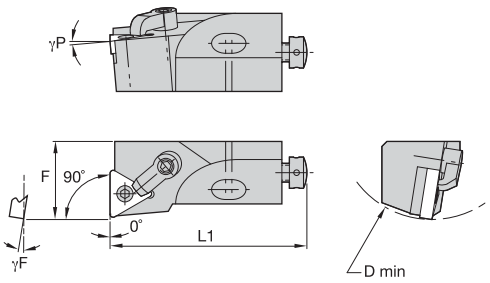


A-PTFN 90°



order number	catalogue number	D	D min	F	L1	L2	CS	γF°	gage insert	shim	shim pin	pin	toggle lever	lever screw	Torx Plus
right hand															
2447535	**A16RPTFNR11**	16	20,0	11,0	200	28	1/8-27 NPT	-14.0	TN..110304	–	–	–	**511.011**	**514.111**	8 IP
2447536	**A20SPTFNR11**	20	25,0	13,0	250	30	1/8-27 NPT	-12.0	TN..110304	–	–	–	**511.011**	**514.111**	8 IP
2447537	**A25TPTFNR16**	25	32,0	17,0	300	40	1/4-18 NPT	-12.0	TN..160408	**512.013**	**513.018**	**515.018**	**511.018**	**514.118**	10 IP
2447539	**A32UPTFNR16**	32	40,0	22,0	350	50	1/4-18 NPT	-10.0	TN..160408	**512.013**	**513.018**	**515.018**	**511.018**	**514.118**	10 IP
2447504	**A40VPTFNR22**	40	48,0	27,0	400	55	1/4-18 NPT	-10.0	TN..220408	**512.023**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
left hand															
2447489	**A20SPTFNL11**	20	25,0	13,0	250	30	1/8-27 NPT	-12.0	TN..110304	–	–	–	**511.011**	**514.111**	8 IP
2447538	**A25TPTFNL16**	25	32,0	17,0	300	40	1/4-18 NPT	-12.0	TN..160408	**512.013**	**513.018**	**515.018**	**511.018**	**514.118**	10 IP
2447503	**A32UPTFNL16**	32	40,0	22,0	350	50	1/4-18 NPT	-10.0	TN..160408	**512.013**	**513.018**	**515.018**	**511.018**	**514.118**	10 IP





MTFN 90°

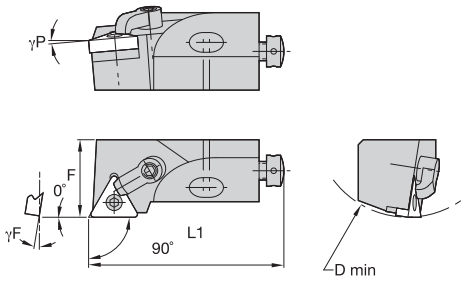
order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
2078236	**MTFNR12CA16**	50	20,0	55	-9.0	-5.0	TN..160408/TN..332
2074429	**MTFNR16CA16**	60	25,0	63	-9.0	-5.0	TN..160408/TN..332
3330208	**MTFNR20CA22**	70	25,0	70	-9.0	-5.0	TN..220408/TN..432
left hand							
2057426	**MTFNL12CA16**	50	20,0	55	-9.0	-5.0	TN..160408/TN..332
2193621	**MTFNL16CA16**	60	25,0	63	-9.0	-5.0	TN..160408/TN..332
3330207	**MTFNL20CA22**	70	25,0	70	-9.0	-5.0	TN..220408/TN..432

Spare Parts



D min	shim	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	–	**KLM33L**	2 mm	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**
60	**ITSN322**	**KLM34L**	2 mm	**CKM34**	**STCM9**	2 mm	**KUAM25**	2 mm	**KUAM32**	**191.407**	5 mm	**CSWM 080 050**
70	**ITSN433**	**KLM46**	2.5 mm	**CKM35**	**STCM37**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	**191.407**	5 mm	**CSWM 080 050**





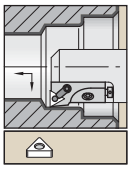
MTGN 90°

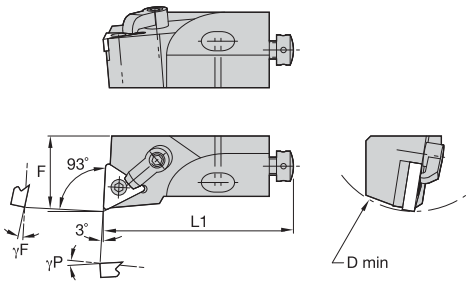
order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
2114041	**MTGNR12CA16**	50	20,0	55	-9.0	-5.0	TN..160408/TN..332
3330285	**MTGNR16CA16**	60	25,0	63	-9.0	-5.0	TN..160408/TN..332
left hand							
3346275	**MTGNL12CA16**	50	20,0	55	-9.0	-5.0	TN..160408/TN..332
3330209	**MTGNL20CA22**	70	25,0	70	-9.0	-5.0	TN..220408/TN..432

Spare Parts



D min	shim	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	**–**	**KLM33L**	2 mm	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**
60	**ITSN322**	**KLM34L**	2 mm	**CKM34**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	**191.407**	5 mm	**CSWM 080 050**
70	**ITSN433**	**KLM46**	2.5 mm	**CKM35**	**STCM37**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	**191.407**	5 mm	**CSWM 080 050**





MTUN 93°

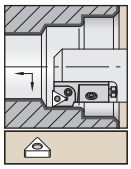
order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098536	**MTUNR20CA22**	70	25,0	70	-9.0	-5.0	TN..220408/TN..432
left hand							
1098529	**MTUNL12CA16**	50	20,0	55	-9.0	-5.0	TN..160408/TN..332
1098535	**MTUNL16CA16**	60	25,0	63	-9.0	-5.0	TN..160408/TN..332

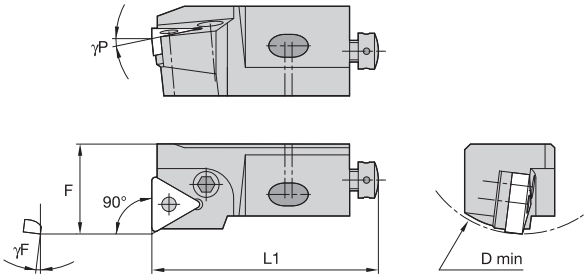
NOTE: Select spare parts based off of D min and the insert size selected.

Spare Parts



D min	shim	lock pin	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	–	**KLM33L**	2 mm	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**
60	**ITSN322**	**KLM34L**	2 mm	**CKM34**	**STCM9**	2.5 mm	**KUAM25**	2.5 mm	**KUAM32**	**191.407**	5 mm	**CSWM 080 050**
70	**ITSN433**	**KLM46**	–	**CKM35**	**STCM37**	2.5 mm	**KUAM25**	2.5 mm	**KUAM33**	**191.407**	5 mm	**CSWM 080 050**





PTFN 90°

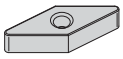
order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1188641	**PTFNR12CA-16**	50	20,0	55	-7.0	-6.0	TN..160408/TN..332
left hand							
1244457	**PTFNL12CA-16**	50	20,0	55	-7.0	-6.0	TN..160408/TN..332

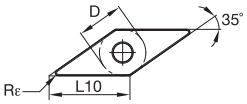
Spare Parts



D min	toggle lever	lever screw	wrench size lever screw	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	**511.030**	**514.112**	8 IP	**KUAM28**	2 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**

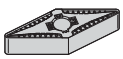
● first choice
○ alternate choice

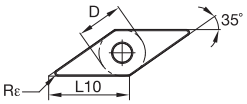




VNGA

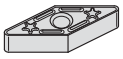
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
VNGA160404	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
VNGA160408	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

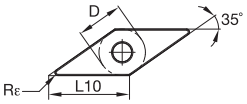




VNGG-FS

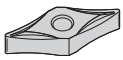
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNGG160401FS	9,53	16,61	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
VNGG160402FS	9,53	16,61	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–
VNGG160404FS	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
VNGG160408FS	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–

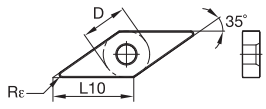




VNGG-LF

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNGG160402LF	9,53	16,61	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
VNGG160404LF	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
VNGG160408LF	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–	–	–
VNGG220408LF	12,70	22,14	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–

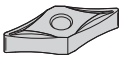


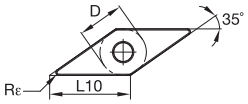


VNGP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNGP160401	9,53	16,61	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–
VNGP160402	9,53	16,61	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–
VNGP220404	12,70	22,14	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
VNGP220408	12,70	22,14	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–	–	–

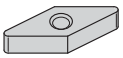
● first choice
○ alternate choice

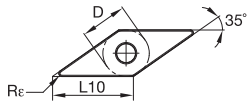




VNGP-K

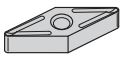
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
VNGP160404K	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	●	–	–
VNGP160408K	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	●	–	–
VPGP443K	12,70	22,14	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–

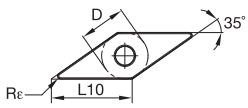




VNMA

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMA160408	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

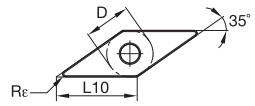




VNMG

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMG160408	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
VNMG160412	9,53	16,61	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
VNMG220408	12,70	22,14	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
VNMG220412	12,70	22,14	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

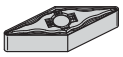


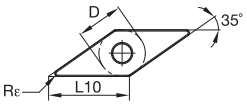


VNMG-LF

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMG160408LF	9,53	16,61	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG220404LF	12,70	22,14	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG220408LF	12,70	22,14	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

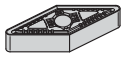
● first choice
○ alternate choice

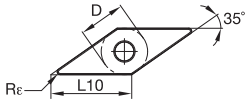




VNMG-FF

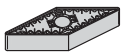
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
VNMG160404FF	9,53	16,61	0,4	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	●	–	●
VNMG160408FF	9,53	16,61	0,8	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●

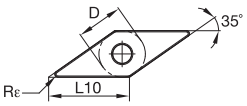




VNMG-FN

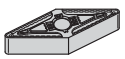
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMG160404FN	9,53	16,61	0,4	–	●	●	●	●	●	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●
VNMG160408FN	9,53	16,61	0,8	–	●	●	●	●	●	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●

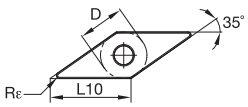




VNMG-FP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMG160404FP	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	●	–	●	–	–	●
VNMG160408FP	9,53	16,61	0,8	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	●	–	●	–	–	●

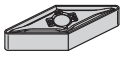


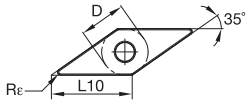


VNMG-MN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMG160404MN	9,53	16,61	0,4	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG160408MN	9,53	16,61	0,8	●	●	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG160412MN	9,53	16,61	1,2	–	–	–	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

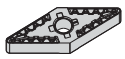
● first choice
○ alternate choice

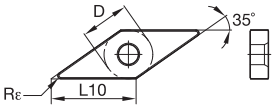




VNMG-MP

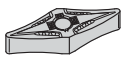
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
VNMG160404MP	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	●	–	–	–	●	–	●	–	–	–
VNMG160408MP	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	●	–	–	–	●	–	●	–	–	–
VNMG160412MP	9,53	16,61	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	●	–	–	–

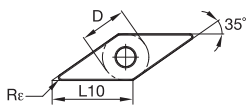




VNMG-MR

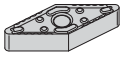
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMG160412MR	9,52	16,61	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG160408MR	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–

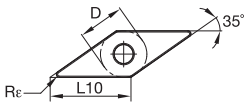




VNMG-MS

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMG160401MS	9,53	16,61	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–	–
VNMG160402MS	9,53	16,61	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
VNMG160404MS	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
VNMG160408MS	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–
VNMG220404MS	12,70	22,14	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–
VNMG220408MS	12,70	22,14	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–

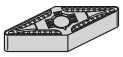


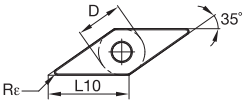


VNMG-P

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMG160404P	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–	–	–
VNMG160408P	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–	–	–

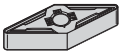
● first choice
○ alternate choice

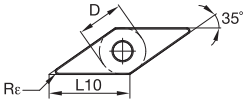




VNMG-RN

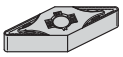
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
VNMG160408RN	9,53	16,61	0,8	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG160412RN	9,53	16,61	1,2	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG220408RN	12,70	22,14	0,8	–	–	●	●	●	●	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG220412RN	12,70	22,14	1,2	–	–	–	●	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

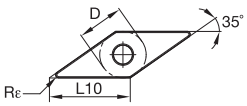




VNMG-RP

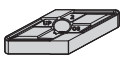
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMG160408RP	9,53	16,61	0,8	–	–	–	●	–	●	–	–	–	–	–	–	–	●	●	–	–	●	–	–	–	–	–	–	–	●	●	●	–	–	–
VNMG160412RP	9,53	16,61	1,2	–	–	–	●	–	●	–	–	–	–	–	–	●	●	–	●	–	–	–	●	–	–	–	–	–	●	●	–	●	–	–

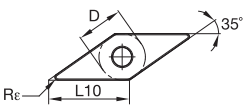




VNMG-UN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMG160404UN	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG160408UN	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

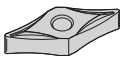


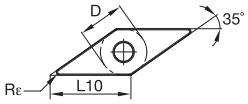


VNMG-UP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMG160404UP	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	●	–	–	–
VNMG160408UP	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	●	–	●	–	–	–
VNMG160412UP	9,53	16,61	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–

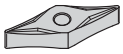
● first choice
○ alternate choice

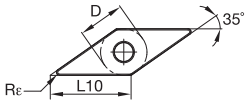




VNMP

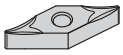
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
VNMP160404	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
VNMP160408	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–

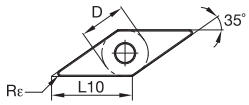




VNMP-K

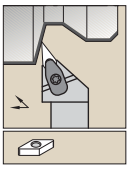
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMP160404K	9,53	16,61	0,4	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
VNMP160408K	9,53	16,61	0,8	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–

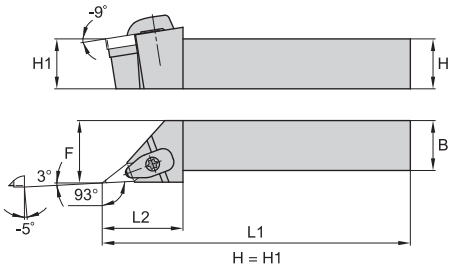


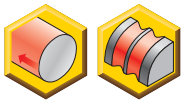


VNMS

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
VNMS160404	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●	–
VNMS160408	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●	–



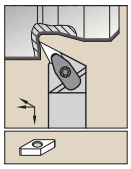


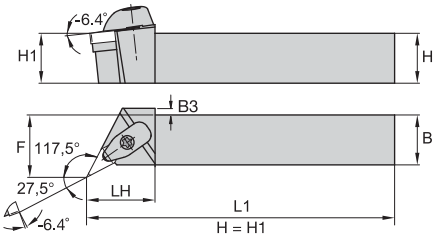


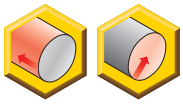
DVJN-KC 93°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand														
2439399	**DVJNR2020K16KC04**	20	20	25,0	125	46,0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
2439401	**DVJNR2525M16KC04**	25	25	32,0	150	46,0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
2439443	**DVJNR3225P16KC04**	32	25	32,0	170	46,0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
left hand														
2439400	**DVJNL2020K16KC04**	20	20	25,0	125	46,0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
2439402	**DVJNL2525M16KC04**	25	25	32,0	150	46,0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
2439444	**DVJNL3225P16KC04**	32	25	32,0	170	46,0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**



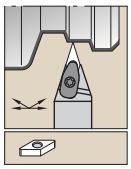


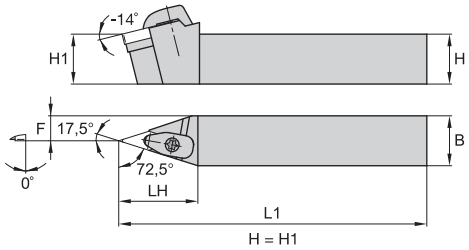


DVON-KC 117,5°



order number	catalogue number	H	B	F	L1	LH	B3	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand															
2439449	**DVONR2020K16KC04**	20	20	27,0	125	38,0	5,0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
2439451	**DVONR2525M16KC04**	25	25	32,0	150	38,0	–	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
2439453	**DVONR3225P16KC04**	32	25	32,0	170	38,0	–	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
left hand															
2439450	**DVONL2020K16KC04**	20	20	27,0	125	38,0	5,0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
2439452	**DVONL2525M16KC04**	25	25	32,0	150	38,0	–	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
2439454	**DVONL3225P16KC04**	32	25	32,0	170	38,0	–	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**



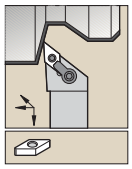


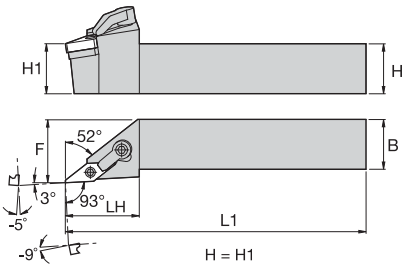


DVVN-KC 72,5°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
2439455	**DVVNN2020K16KC04**	20	20	10,0	150	48,0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
2439456	**DVVNN2525M16KC04**	25	25	12,0	150	48,0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**

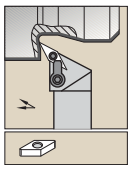


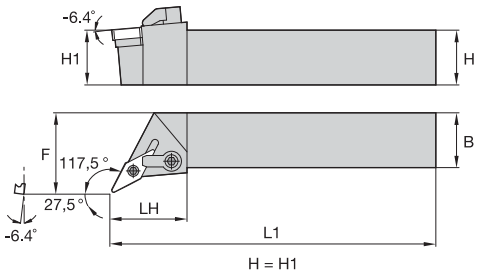


MVJN 93°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand													
1101362	**MVJNR2020K16**	20	20	25,0	125	37,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm
1101634	**MVJNR2525M16**	25	25	32,0	150	37,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm
1101363	**MVJNR3225P16**	32	25	32,0	170	37,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm
1101635	**MVJNR3225P22**	32	25	32,0	170	50,0	VN..220408	**IVSN432**	**KLM46**	2.5 mm	**CKM26**	**STCM4**	4 mm
3612649	**MVJNR3232P16**	32	32	40,5	171	37,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm
left hand													
1102320	**MVJNL2020K16**	20	20	25,0	125	37,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm
1102321	**MVJNL2525M16**	25	25	32,0	150	37,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm
1102322	**MVJNL3225P16**	32	25	32,0	170	37,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm
1102323	**MVJNL3225P22**	32	25	32,0	170	50,0	VN..220408	**IVSN432**	**KLM46**	2.5 mm	**CKM26**	**STCM4**	4 mm
3612650	**MVJNL3232P16**	32	32	40,5	170	37,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm

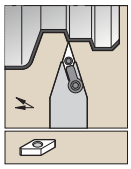


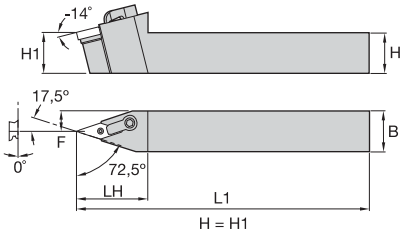


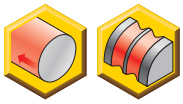
MVON 117,5°



order number	catalogue number	H	B	F	L1	wLH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand													
1102238	**MVONR2525M16**	25	25	32,0	150	30,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM6**	**STCM5**	2.5 mm
left hand													
1102730	**MVONL2525M16**	25	25	32,0	150	30,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM6**	**STCM5**	2.5 mm



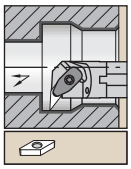




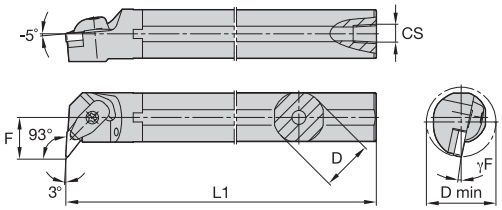
MVVN 72,5°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
1102723	**MVVNN2525M22**	25	25	12,0	150	55,0	VN..220408	**IVSN432**	**KLM46**	2.5 mm	**CKM26**	**STCM4**	4 mm
1102720	**MVVNN2020K16**	42	20	10,0	125	42,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm
1102721	**MVVNN2525M16**	66	25	12,5	150	42,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm
1102722	**MVVNN3225P16**	86	32	12,5	170	42,0	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm



Steel shank with through coolant.

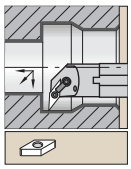




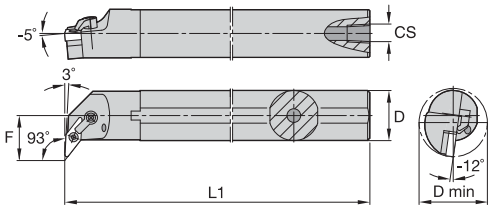
A-DVUN-KC 93°



order number	catalogue number	D	D min	F	L1	CS	γF°	gage insert	shim	shim screw	Torx Plus	clamp assembly	slotted pin	Torx Plus
right hand														
2441916	**A32SDVUNR16KC04**	32	40,0	22,0	250	1/4-18 NPT	-9.0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441918	**A40TDVUNR16KC04**	40	50,0	27,0	300	1/4-18 NPT	-8.0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	**SSP025016M**	15 IP
left hand														
2441917	**A32SDVUNL16KC04**	32	40,0	22,0	250	1/4-18 NPT	-9.0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441919	**A40TDVUNL16KC04**	40	50,0	27,0	300	1/4-18 NPT	-8.0	VN..160408	**IVSN322**	**KMSP315IP**	15 IP	**CM215R ASSY**	**SSP025016M**	15 IP



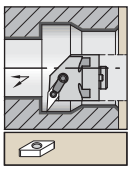
Steel shank with through coolant.



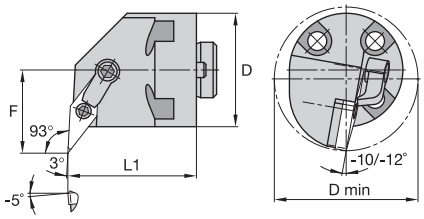
A-MVUN 93°



order number	catalogue number	D	D min	F	L1	CS	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand													
1098128	**A25RMVUNR16**	25	37,0	22,0	200	1/4-18 NPT	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM26**	3 mm
1098130	**A32SMVUNR16**	32	40,0	22,0	250	1/4-18 NPT	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm
left hand													
1098129	**A25RMVUNL16**	25	37,0	22,0	200	1/4-18 NPT	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM26**	3 mm
1098131	**A32SMVUNL16**	32	40,0	22,0	250	1/4-18 NPT	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM31**	**STCM20**	3 mm



With through coolant.

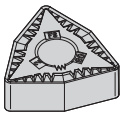


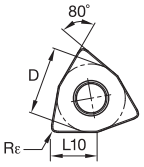
H-MVUN 93°



order number	catalogue number	D	D min	F	L1	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand												
3612215	**H40MVUNR16**	40	50,0	27,0	41	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM22**	**STCM20**	3 mm
3612219	**H50MVUNR16**	50	63,0	35,0	41	VN..160408	**IVSN322**	**KLM34L**	2 mm	**CKM22**	**STCM20**	3 mm

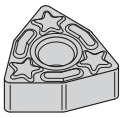
● first choice
○ alternate choice

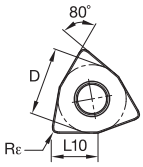




WNGG-FS

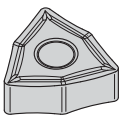
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
WNGG080404FS	12,70	8,69	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
WNGG080408FS	12,70	8,69	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

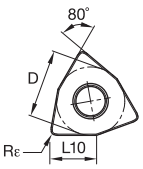




WNGG-LF

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
WNGG080401LF	12,70	8,69	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
WNGG080402LF	12,70	8,69	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
WNGG080404LF	12,70	8,69	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
WNGG080408LF	12,70	8,69	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–



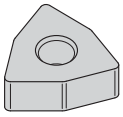


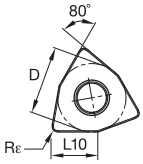
WNGP-K

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
WNGP080408K	12,70	8,69	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–

● first choice
○ alternate choice

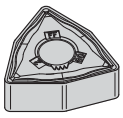
		KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P		●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M										○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K		○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																									●	●	●	●	●	●	●	
S																									●	●	●	●	●	●		
H																																

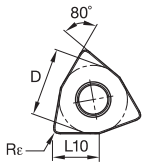




WNMA

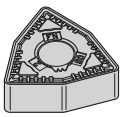
ISO catalogue number	D	L10	Rε
WNMA060408	9,53	6,52	0,8
WNMA060412	9,53	6,52	1,2
WNMA080408	12,70	8,69	0,8
WNMA080412	12,70	8,69	1,2
WNMA080416	12,70	8,69	1,6

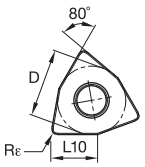




WNMG-FF

ISO catalogue number	D	L10	Rε
WNMG060404FF	9,53	6,52	0,4
WNMG060408FF	9,53	6,52	0,8
WNMG080404FF	12,70	8,69	0,4
WNMG080408FF	12,70	8,69	0,8

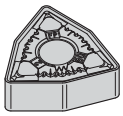


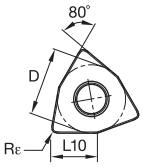


WNMG-FN

ISO catalogue number	D	L10	Rε
WNMG060404FN	9,53	6,52	0,4
WNMG060408FN	9,53	6,52	0,8
WNMG080404FN	12,70	8,69	0,4
WNMG080408FN	12,70	8,69	0,8

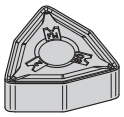
● first choice
○ alternate choice

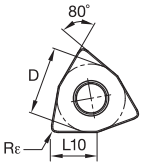




WNMG-FP

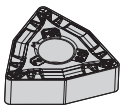
				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
ISO catalogue number	D	L10	Rε																															
WNMG060404FP	9,53	6,52	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	●	–	●	–	–	–
WNMG060408FP	9,53	6,52	0,8	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	●	–	–	–
WNMG080404FP	12,70	8,69	0,4	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	●	–	●	–	–	–
WNMG080408FP	12,70	8,69	0,8	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	●	–	●	–	–	–
WNMG080412FP	12,70	8,69	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	●	–	–	–

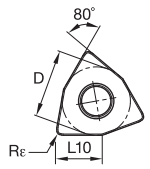




WNMG-FW

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	D	L10	Rε																															
WNMG060404FW	9,53	6,52	0,4	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●
WNMG060408FW	9,53	6,52	0,8	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●
WNMG060412FW	9,53	6,52	1,2	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080404FW	12,70	8,69	0,4	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	–	–	–	●
WNMG080408FW	12,70	8,69	0,8	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●
WNMG080412FW	12,70	8,69	1,2	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



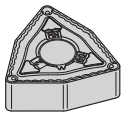


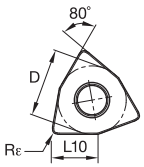


WNMG-MG

				KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
ISO catalogue number	D	L10	Rε																															
WNMG080408MG	12,70	8,69	0,8	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

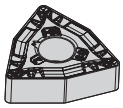
● first choice
○ alternate choice

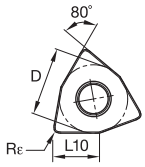




WNMG-MN

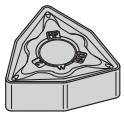
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
P				●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●	●	●
M												○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
K				○	○	○	○	○	○					●	●	●	●	●	●							●	●	●	●	●	●	●		●
N																											●	●	●	●	●	●	●	
S																											●	●	●	●	●	●		
H																																		
WNMG060404MN	9,53	6,52	0,4	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG060408MN	9,53	6,52	0,8	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG060412MN	9,53	6,52	1,2	–	–	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080408MN	12,70	8,69	0,8	–	●	●	●	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080412MN	12,70	8,69	1,2	–	–	●	●	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080416MN	12,70	8,69	1,6	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

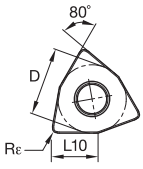




WNMG-MR

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
WNMG060408MR	9,53	6,52	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080408MR	12,70	8,69	0,8	–	–	●	–	●	–	–	–	–	–	–	–	●	–	–	–	●	–	●	–	–	●	●	–	–	●	–	–	–	–	–
WNMG080412MR	12,70	8,69	1,2	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●	●	–	–	–	–	–	–	–	–
WNMG080416MR	12,70	8,69	1,6	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

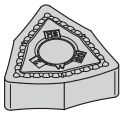


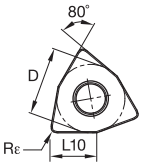


WNMG-MP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
WNMG060404MP	9,53	6,52	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	●	–	●	–	–	–
WNMG060408MP	9,53	6,52	0,8	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	●	–	●	–	–	–
WNMG060412MP	9,53	6,52	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–
WNMG080408MP	12,70	8,69	0,8	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	●	–	–	–	●	–	●	–	–	–
WNMG080412MP	12,70	8,69	1,2	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	●	–	–	–	●	–	●	–	–	–

● first choice
○ alternate choice

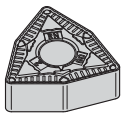


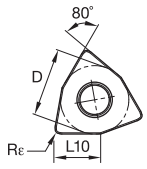


WNMG-MS

| | | |

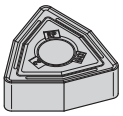
● first choice
○ alternate choice

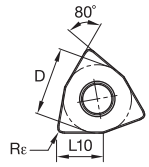




WNMG-RN

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
				P		●	●	●	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●		●
				M										○	○							●	●	●	●	●	●		●	●	●	●	●	●		●
				K		○	○	○	○	○	○	○				●	●	●	●	●	●								●	●	●	●	●	●	●		●
				N																							●	●	●	●	●	●	●	●	
				S																							●	●	●	●	●	●			
				H																															
WNMG060408RN	9,53	6,52	0,8	–	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG060412RN	9,53	6,52	1,2	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080408RN	12,70	8,69	0,8	–	–	●	●	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080412RN	12,70	8,69	1,2	–	●	●	●	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
WNMG080416RN	12,70	8,69	1,6	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

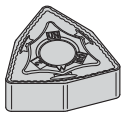


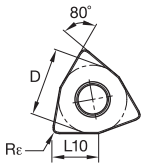


WNMG-RP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
WNMG060408RP	9,53	6,52	0,8	–	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	●	●	●	–	–	–
WNMG060412RP	9,53	6,52	1,2	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080408RP	12,70	8,69	0,8	–	●	●	●	●	●	●	–	●	–	●	●	●	●	●	●	●	●	●	●	●	●	●	–	–	●	●	●	●	–	–
WNMG080412RP	12,70	8,69	1,2	–	●	●	●	●	●	–	●	–	–	–	●	●	●	●	●	–	●	●	●	●	●	●	–	–	●	●	●	–	–	–
WNMG080416RP	12,70	8,69	1,6	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

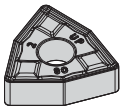
● first choice
○ alternate choice

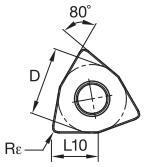




WNMG-UN

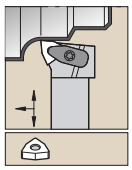
ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
WNMG060408UN	9,53	6,52	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080404UN	12,70	8,69	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080408UN	12,70	8,69	0,8	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080412UN	12,70	8,69	1,2	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080416UN	12,70	8,69	1,6	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

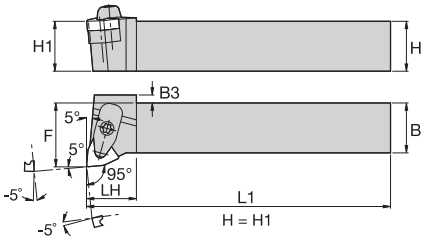




WNMG-UP

ISO catalogue number	D	L10	Rε	KCP05B	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30B	KCP30	KCP40B	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35B	KCM35	KCPK05	K313	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KT315
WNMG060408UP	9,53	6,52	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
WNMG080408UP	12,70	8,69	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–	–	●	–	●	–	–	–
WNMG080412UP	12,70	8,69	1,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	●	–	●	–	–	–



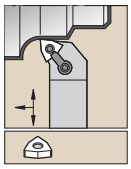


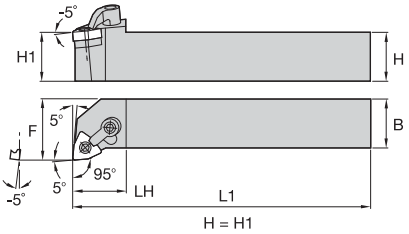


DWLN-KC 95°



order number	catalogue number	H	B	F	L1	LH	B3	gage insert	shim	shim screw	Torx Plus	clamp assembly	Torx Plus	slotted pin	optional lock pin
right hand															
2439476	**DWLNR2020K06KC04**	20	20	25,0	125	31,0	—	WN..060408	**IWSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
2439471	**DWLNR2020K08KC04**	20	20	25,0	125	33,0	—	WN..080408	**IWSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**
2273451	**DWLNR2525M06KC04**	25	25	32,0	150	25,0	—	WN..060408	**IWSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
1908860	**DWLNR2525M08KC04**	25	25	32,0	150	25,0	4,0	WN..080408	**IWSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**
1908862	**DWLNR3232P08KC04**	32	32	40,0	170	25,0	—	WN..080408	**IWSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**
left hand															
2439470	**DWLNL2020K06KC04**	20	20	25,0	125	31,0	—	WN..060408	**IWSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
2439472	**DWLNL2020K08KC04**	20	20	25,0	125	33,0	—	WN..080408	**IWSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**
2273455	**DWLNL2525M06KC04**	25	25	32,0	150	25,0	—	WN..060408	**IWSN322**	**KMSP315IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM34L9IP**
1908861	**DWLNL2525M08KC04**	25	25	32,0	150	25,0	4,0	WN..080408	**IWSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**
1908893	**DWLNL3232P08KC04**	32	32	40,0	170	25,0	—	WN..080408	**IWSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	15 IP	**SSP025016M**	**KLM4615IP**





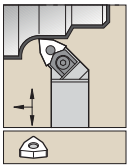


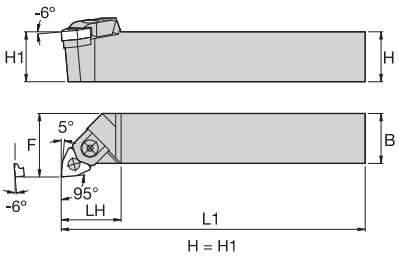
MWLN 95°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand													
1101293	**MWLNR2020K06**	20	20	25,0	125	25,0	WN..060408	**IWSN322**	**KLM34L**	2 mm	**CKM6**	**STCM5**	2.5 mm
1101355	**MWLNR2525M06**	25	25	32,0	150	25,0	WN..060408	**IWSN322**	**KLM34L**	2 mm	**CKM6**	**STCM5**	2.5 mm
3612259	**MWLNR3232P08**	32	32	40,0	170	32,0	WNMA080408	**IWSN433**	**KLM46**	2.5 mm	**CKM7**	**STCM5**	2.5 mm
left hand													
1101292	**MWLNL2020K06**	20	20	25,0	125	25,0	WN..060408	**IWSN322**	**KLM34L**	2 mm	**CKM6**	**STCM5**	2.5 mm
1101354	**MWLNL2525M06**	25	25	32,0	150	25,0	WN..060408	**IWSN322**	**KLM34L**	2 mm	**CKM6**	**STCM5**	2.5 mm
3612260	**MWLNL3232P08**	32	32	40,0	170	32,0	WNMA080408	**IWSN433**	**KLM46**	2.5 mm	**CKM7**	**STCM5**	2.5 mm

Wedgelock™ Toolholders • Wedgelock Inserts



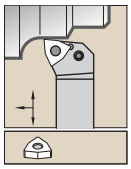


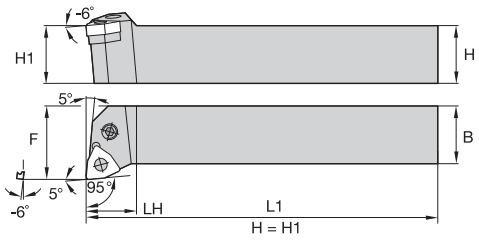


MWLN 95°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	lock pin	set screw	Torx	clamp assembly	hex
right hand													
1244924	**MWLNR2020K08H4**	20	20	25,0	125	32,0	WN..080408	**512.131**	**513.132**	**192.636**	T15	**551.131**	3 mm
1192355	**MWLNR2525M08H4**	25	25	32,0	150	36,0	WN..080408	**512.131**	**513.132**	**192.636**	T15	**551.131**	3 mm
1244925	**MWLNR3225P08H4**	32	25	32,0	170	36,0	WN..080408	**512.131**	**513.132**	**192.636**	T15	**551.131**	3 mm
left hand													
1244921	**MWLNL2020K08H4**	20	20	25,0	125	32,0	WN..080408	**512.131**	**513.132**	**192.636**	T15	**551.131**	3 mm
1244922	**MWLNL2525M08H4**	25	25	32,0	150	36,0	WN..080408	**512.131**	**513.132**	**192.636**	T15	**551.131**	3 mm
1244923	**MWLNL3225P08H4**	32	25	32,0	170	36,0	WN..080408	**512.131**	**513.132**	**192.636**	T15	**551.131**	3 mm





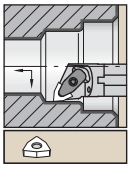


PWLN 95°

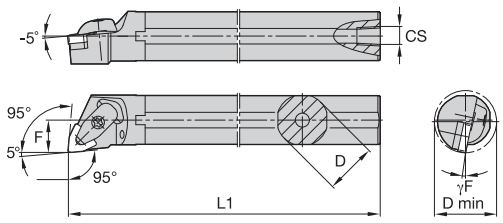


order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim pin	punch pin	lever	lever screw	Torx Plus
right hand													
1244771	**PWLNR1616H06**	16	16	20,0	100	14,0	WN..060404	**512.134**	**513.018**	**515.018**	**511.018**	**514.118**	10 IP
1192397	**PWLNR2020K06**	20	20	25,0	125	14,0	WN..060404	**512.134**	**513.018**	**515.018**	**511.018**	**514.118**	10 IP
1192398	**PWLNR2020K08**	20	20	25,0	125	20,0	WN..080408	**512.135**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1192399	**PWLNR2525M08**	25	25	32,0	150	26,0	WN..080408	**512.135**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244772	**PWLNR3225P08**	32	25	32,0	170	26,0	WN..080408	**512.135**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
left hand													
1192396	**PWLNL1616H06**	16	16	20,0	100	14,0	WN..060404	**512.134**	**513.018**	**515.018**	**511.018**	**514.118**	10 IP
1244767	**PWLNL2020K06**	20	20	25,0	125	14,0	WN..060404	**512.134**	**513.018**	**515.018**	**511.018**	**514.118**	10 IP
1244768	**PWLNL2020K08**	20	20	25,0	125	20,0	WN..080408	**512.135**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244769	**PWLNL2525M08**	25	25	32,0	150	26,0	WN..080408	**512.135**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244770	**PWLNL3225P08**	32	25	32,0	170	26,0	WN..080408	**512.135**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP

Kenclamp™ Boring Bars



Steel shank with through coolant.

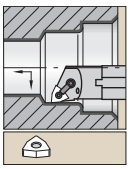




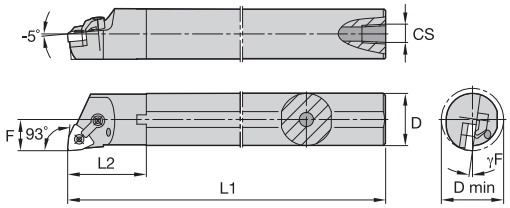
A-DWLN-KC 95°



order number	catalogue number	D	D min	F	L1	CS	γF°	gage insert	shim	shim screw	Torx Plus	clamp assembly	slotted pin	Torx Plus
right hand														
2441921	**A25RDWLNR06KC04**	25	32,0	17,0	200	1/4-18 NPT	-14.0	WN..060408	–	–	–	**CM234R ASSY**	**SSP025016M**	15 IP
2441923	**A25RDWLNR08KC04**	25	32,0	17,0	200	1/4-18 NPT	-12.0	WN..080408	–	–	–	**CM234R ASSY**	**SSP025016M**	15 IP
2441925	**A32SDWLNR08KC04**	32	40,0	22,0	250	1/4-18 NPT	-14.0	WN..080408	**IWSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
2441927	**A40TDWLNR08KC04**	40	50,0	27,0	300	1/4-18 NPT	-14.0	WN..080408	**IWSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP
left hand														
2441922	**A25RDWLNL06KC04**	25	32,0	17,0	200	1/4-18 NPT	-14.0	WN..060408	–	–	–	**CM234R ASSY**	**SSP025016M**	15 IP
2441924	**A25RDWLNL08KC04**	25	32,0	17,0	200	1/4-18 NPT	-12.0	WN..080408	–	–	–	**CM234R ASSY**	**SSP025016M**	15 IP
2441926	**A32SDWLNL08KC04**	32	40,0	22,0	250	1/4-18 NPT	-14.0	WN..080408	**IWSN433**	**KMSP415IP**	15 IP	**CM234R ASSY**	**SSP025016M**	15 IP

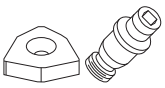


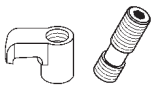
Steel shank with through coolant.



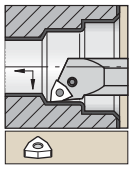


A-MWLN 95°

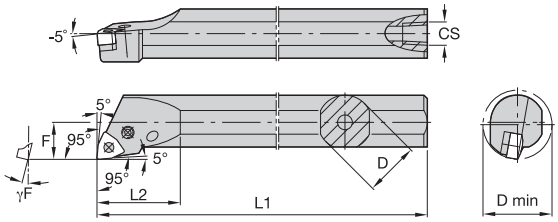




order number	catalogue number	D	D min	F	L1	LH	CS	γF°	gage insert	shim	lock pin	hex	clamp	clamp screw	hex
right hand															
1098771	**A25RMWLNR06**	25	32,0	17,0	200	—	1/4-18 NPT	-12.0	WN..060408	—	**KLM33L**	2 mm	**CKM6**	**STCM5**	2.5 mm
1098773	**A25RMWLNR08**	25	32,0	17,0	200	39,0	1/4-18 NPT	-12.0	WN..080408	—	**KLM43**	2 mm	**CKM20**	**STCM11**	3 mm
1098772	**A32SMWLNR06**	32	40,0	22,0	250	—	1/4-18 NPT	-10.0	WN..060408	**IWSN322**	**KLM34L**	2 mm	**CKM6**	**STCM5**	2.5 mm
1098774	**A32SMWLNR08**	32	40,0	22,0	250	39,7	1/4-18 NPT	-14.0	WN..080408	**IWSN433**	**KLM46**	2.5 mm	**CKM20**	**STCM20**	3 mm
1098775	**A40TMWLNR08**	40	50,0	27,0	300	41,6	1/4-18 NPT	-12.0	WN..080408	**IWSN433**	**KLM46**	2.5 mm	**CKM20**	**STCM20**	3 mm
left hand															
1098783	**A25RMWLNL08**	25	32,0	17,0	200	39,0	1/4-18 NPT	-12.0	WN..080408	—	**KLM43**	2 mm	**CKM20**	**STCM11**	3 mm
1098782	**A32SMWLNL06**	32	40,0	22,0	250	—	1/4-18 NPT	-10.0	WN..060408	**IWSN322**	**KLM34L**	2 mm	**CKM6**	**STCM5**	2.5 mm
1098784	**A32SMWLNL08**	32	40,0	22,0	251	39,7	1/4-18 NPT	-14.0	WN..080408	**IWSN433**	**KLM46**	2.5 mm	**CKM20**	**STCM20**	3 mm
1098785	**A40TMWLNL08**	40	50,0	27,0	300	41,6	1/4-18 NPT	-12.0	WN..080408	**IWSN433**	**KLM46**	2.5 mm	**CKM20**	**STCM20**	3 mm



Steel shank with through coolant.



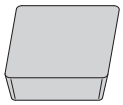
A-PWLN 95°

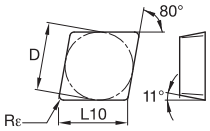


order number	catalogue number	D	D min	F	L1	L2	CS	γF°	gage insert	shim	shim pin	pin	toggle lever	lever screw	Torx Plus
right hand															
1244113	**A16RPWLNR06**	16	27,0	11,0	200	32	1/8-27 NPT	-12.0	WN..060404	**–**	**–**	**–**	**511.030**	**514.112**	–
1244115	**A20SPWLNR06**	20	25,0	13,0	250	–	1/8-27 NPT	-14.0	WN..060408	**–**	**–**	**–**	**511.030**	**514.112**	8 IP
1194440	**A25RPWLNR08**	25	32,0	17,0	200	–	1/4-18 NPT	-12.0	WN..080408	**512.135**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244118	**A32SPWLNR08**	32	40,0	22,0	250	50	1/4-18 NPT	-10.0	WN..080408	**512.135**	**513.023**	**515.018**	**511.023**	**514.123**	–
1244120	**A40TPWLNR08**	40	50,0	27,0	300	54	1/4-18 NPT	-8.0	WN..080408	**512.135**	**513.023**	**515.018**	**511.023**	**514.123**	–
left hand															
1191396	**A16RPWLNL06**	16	27,0	11,0	200	32	1/8-27 NPT	-12.0	WN..060404	**–**	**–**	**–**	**511.030**	**514.112**	–
1244114	**A20SPWLNL06**	20	25,0	13,0	250	–	1/8-27 NPT	-14.0	WN..060408	**–**	**–**	**–**	**511.030**	**514.112**	8 IP
1244116	**A25RPWLNL08**	25	32,0	17,0	200	–	1/4-18 NPT	-12.0	WN..080408	**512.135**	**513.023**	**515.018**	**511.023**	**514.123**	15 IP
1244117	**A32SPWLNL08**	32	40,0	22,0	250	50	1/4-18 NPT	-10.0	WN..080408	**512.135**	**513.023**	**515.018**	**511.023**	**514.123**	–
1244119	**A40TPWLNL08**	40	50,0	27,0	300	54	1/4-18 NPT	-8.0	WN..080408	**512.135**	**513.023**	**515.018**	**511.023**	**514.123**	–

● first choice
○ alternate choice

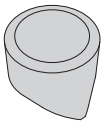
		KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
P		●	○	○	●	●		●	●
M					●	●	●	●	●
K		○	●	●	●	●		●	●
N					●	●		●	●
S					●	●	●	●	●
H									

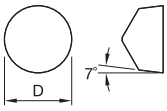




CPGN

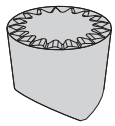
ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
CPGN120304	12,70	12,90	0,4	–	–	–	●	●	–	–	–
CPGN120308	12,70	12,90	0,8	–	–	–	●	●	–	–	–

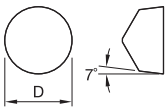




RCGV

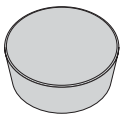
ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
RCGV060400	6,35	—	—	–	–	–	–	–	–	●	●
RCGV090700	9,53	—	—	–	–	–	–	–	–	–	●
RCGV120700	12,70	—	—	–	–	–	●	–	–	–	●

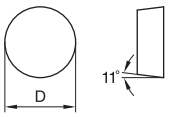




RCGV-MP

ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
RCGX060400MP	6,35	—	—	–	–	–	–	–	●	–	–
RCGX120700MP	12,70	—	—	–	–	–	–	–	●	–	–



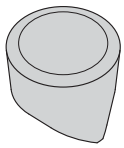


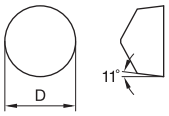
RPGN

ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
RPGN120300	12,70	—	—	–	–	–	●	–	–	–	–

● first choice
○ alternate choice

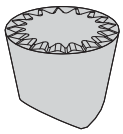
		KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
P		●	○	○	●	●		●	●
M					●	●	●	●	●
K		○	●	●	●	●		●	●
N					●	●		●	●
S					●	●	●	●	●
H									

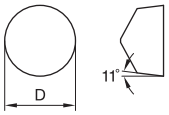




RPGV

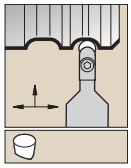
ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
RPGV060400	6,35	–	–	–	–	–	–	–	–	–	●
RPGV090700	9,53	–	–	–	–	–	–	–	–	–	●
RPGV120700	12,70	–	–	–	–	–	–	–	–	–	●

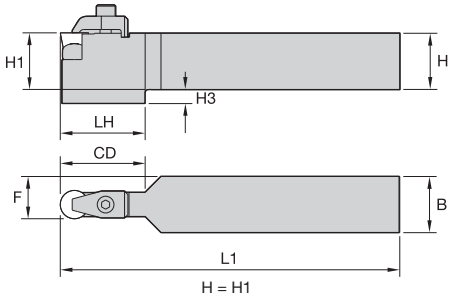




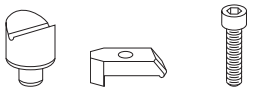
RPGV-MP

ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
RPGX060400MP	6,35	–	–	–	–	–	–	–	●	–	–
RPGX090700MP	9,53	–	–	–	–	–	–	–	●	–	–
RPGV120700MP	12,70	–	–	–	–	–	–	–	–	–	●
RPGX120700MP	12,70	–	–	–	–	–	–	–	●	–	–



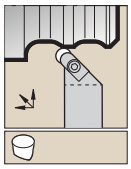


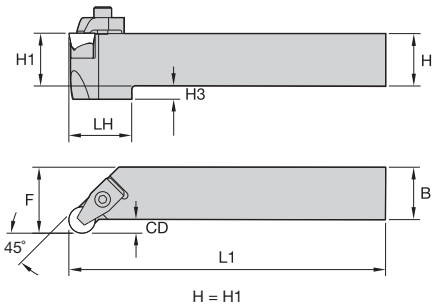
CRDP



order number	catalogue number	H	B	F	L1	LH	H3	CD	gage insert	nest	clamp	clamp screw	hex
3642247	**CRDPN2525M06V**	25	25	12,5	151	—	—	19,0	RPGX060400E	**NST1**	**CM214**	**MS1321**	2.5 mm
3642249	**CRDPN3232P09V**	32	32	16,0	171	—	—	29,0	RPGX090700E	**NST2**	**CM219**	**CS412**	3.5 mm
3642248	**CRDPN2525M09V**	25	25	12,5	151	—	—	29,0	RPGX090700E	**NST2**	**CM219**	**CS412**	3.5 mm
3642251	**CRDPN3232P12V**	32	32	16,0	171	—	—	38,0	RPGX120700E	**NST3**	**CM216**	**CS412**	3.5 mm
3642252	**CRDPN3232P15V**	32	32	16,0	171	38,1	6,4	38,0	RPGX151000	**NST4**	**CM217**	**MS1294**	6 mm

NOTE: CRDP toolholders are able to use RPGX and RCGX insert styles.





CRGP

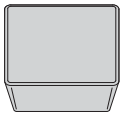


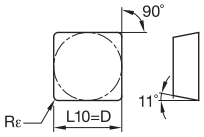
order number	catalogue number	H	B	F	L1	CD	gage insert	nest	clamp	clamp screw	hex
right hand											
3642276	**CRGPR2525M06V**	25	25	32,0	151	7,0	RPGX060400E	**NST1**	**CM214**	**MS1321**	2.5 mm
3642280	**CRGPR3232P09V**	32	32	40,0	171	8,0	RPGX090700E	**NST2**	**CM219**	**CS412**	3.5 mm
left hand											
3642277	**CRGPL2525M06V**	25	25	32,0	151	7,0	RPGX060400E	**NST1**	**CM214**	**MS1321**	2.5 mm
3642281	**CRGPL3232P09V**	32	32	40,0	171	8,0	RPGX090700E	**NST2**	**CM219**	**CS412**	3.5 mm

NOTE: CRGP toolholders are able to use RPGX and RCGX insert styles.

● first choice
○ alternate choice

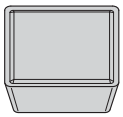
		KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
P		●	○	○	●	●		●	●
M					●	●	●	●	●
K		○	●	●	●	●		●	●
N					●	●		●	●
S					●	●	●	●	●
H									

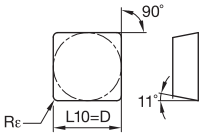




SPGN

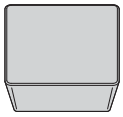
ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
SPGN090304	9,53	9,53	0,4	–	–	–	–	●	–	–	●
SPGN090308	9,53	9,53	0,8	–	–	●	–	●	–	–	●
SPGN120304	12,70	12,70	0,4	–	–	–	–	●	–	●	●
SPGN120308	12,70	12,70	0,8	–	–	–	●	●	–	●	●
SPGN120312	12,70	12,70	1,2	–	–	–	–	●	–	–	–
SPGN120412	12,70	12,70	1,2	–	–	–	–	–	–	●	–
SPGN120316	12,70	12,70	1,6	–	–	–	–	–	–	–	●
SPGN190408	19,05	19,05	0,8	–	–	–	–	●	–	–	–
SPGN190412	19,05	19,05	1,2	–	–	–	●	–	–	●	–

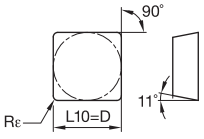




SPGR–K

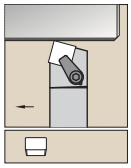
ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
SPGR090308K	9,53	9,53	0,8	–	–	–	–	–	–	●	●
SPGR120308K	12,70	12,70	0,8	●	–	–	–	–	–	–	–

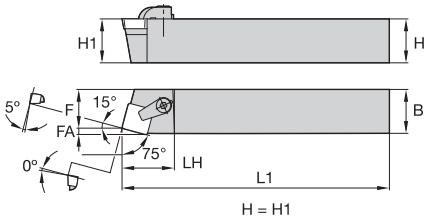




SPUN

ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
SPUN120304	12,70	12,70	0,4	●	–	–	–	●	–	–	–
SPUN120308	12,70	12,70	0,8	●	–	–	–	●	–	–	–
SPUN120312	12,70	12,70	1,2	●	–	–	–	–	–	–	–

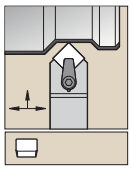


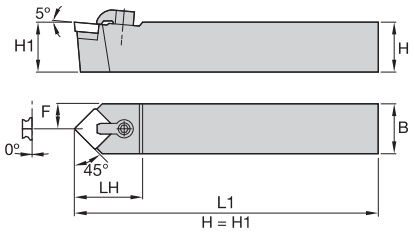


CSBP 75°



order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand														
1097750	**CSBPR2020K12**	20	20	17,0	125	30,0	3,1	SP..120308	**SM840**	**MS111**	2 mm	**CKM10**	**STCM8**	4 mm

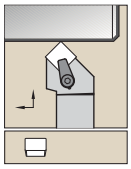


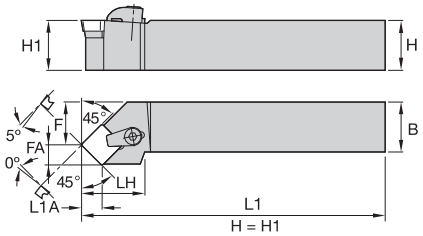


CSDP 45°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
1097754	**CSDPN2020K12**	20	20	10,0	125	32,0	SP..120308	**SM840**	**MS111**	2 mm	**CKM10**	**STCM8**	4 mm
1097755	**CSDPN2525M12**	25	25	12,5	150	32,0	SP..120308	**SM840**	**MS111**	2 mm	**CKM9**	**STCM4**	4 mm

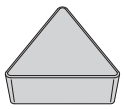


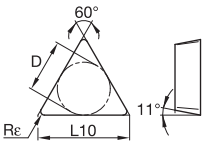


CSSP 45°



order number	catalogue number	H	B	F	L1	LH	FA	L1A	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand															
1244605	**CSSPR2020K12**	20	20	25,0	125	32,0	8,7	8,3	SP..120308	**SM840**	**MS111**	2 mm	**CKM10**	**STCM8**	4 mm
1244606	**CSSPR2525M12**	25	25	32,0	150	32,0	8,7	8,3	SP..120308	**SM840**	**MS111**	2 mm	**CKM9**	**STCM4**	4 mm
left hand															
1244604	**CSSPL2525M12**	25	25	32,0	150	32,0	8,7	8,3	SP..120308	**SM840**	**MS111**	2 mm	**CKM9**	**STCM4**	4 mm



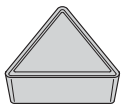


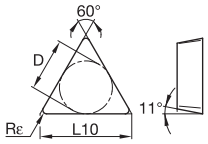
● first choice
○ alternate choice

		KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
P		●	○	○	●	●		●	●
M					●	●	●	●	●
K		○	●	●	●	●		●	●
N					●	●		●	●
S					●	●	●	●	●
H									

TPGN/TPG

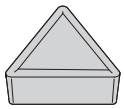
ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
TPGN110304	6,35	11,00	0,4	–	–	–	●	●	–	●	●
TPGN110308	6,35	11,00	0,8	–	–	–	–	●	–	●	●
TPGN160302	9,53	16,50	0,2	–	–	–	●	●	–	–	●
TPGN160304	9,53	16,50	0,4	–	–	–	●	●	–	●	●
TPGN160308	9,53	16,50	0,8	–	–	–	●	●	–	●	●
TPGN160312	9,53	16,50	1,2	–	–	–	●	–	–	–	●
TPGN160316	9,53	16,50	1,6	–	–	–	–	●	–	–	●
TPGN220404	12,70	22,00	0,4	–	–	–	●	●	–	●	●
TPGN220408	12,70	22,00	0,8	●	–	–	●	●	–	●	●
TPGN220412	12,70	22,00	1,2	–	–	–	–	●	–	●	●
TPGN220416	12,70	22,00	1,6	–	–	–	–	●	–	–	●

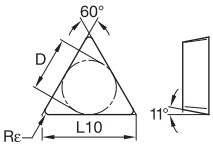




TPGR–K

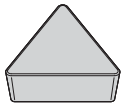
ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
TPGR110304K	6,35	11,00	0,4	–	–	–	–	–	–	–	●
TPGR110308K	6,35	11,00	0,8	–	–	–	–	–	–	●	–
TPGR160304K	9,53	16,50	0,4	–	–	–	–	–	–	●	●
TPGR160308K	9,53	16,50	0,8	●	–	–	–	–	–	●	●
TPGR220404K	12,70	22,00	0,4	–	–	–	–	–	–	●	–
TPGR220408K	12,70	22,00	0,8	–	–	–	–	–	–	●	–

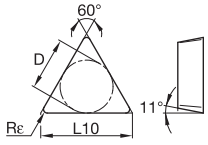




TPMR

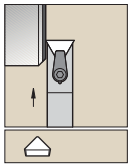
ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
TPMR110304	6,35	11,00	0,4	●	●	–	–	–	–	–	–
TPMR110308	6,35	11,00	0,8	●	–	–	–	–	–	–	–
TPMR160304	9,53	16,50	0,4	●	●	–	–	–	–	–	–
TPMR160308	9,53	16,50	0,8	●	●	–	–	–	–	–	–
TPMR220408	12,70	22,00	0,8	●	–	–	–	–	–	–	–

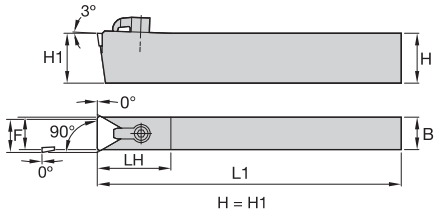




TPUN

ISO catalogue number	D	L10	Rε	KCP25B	KCK15B	KCK15	K313	K68	KCS10	KCU10	KC5010
TPUN110304	6,35	11,00	0,4	–	●	–	–	●	–	–	–
TPUN110308	6,35	11,00	0,8	–	●	–	–	●	–	–	–
TPUN160304	9,53	16,50	0,4	●	●	–	–	●	–	–	–
TPUN160308	9,53	16,50	0,8	●	●	–	–	●	–	–	–
TPUN220408	12,70	22,00	0,8	●	●	–	–	●	–	–	–
TPUN220412	12,70	22,00	1,2	●	●	–	–	●	–	–	–

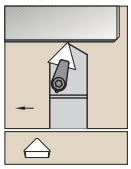


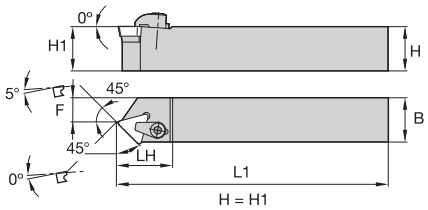


CTCP 90°

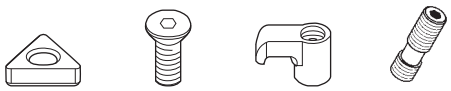


order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
1097775	**CTCPN2510M11**	25	10	10,0	150	26,0	TP..110304	**SM819**	**MS960**	–	**CKM7**	**STCM5**	2.5 mm
1097776	**CTCPN2514M16**	25	14	14,4	150	28,0	TP..160308	**SM841**	**MS111**	2 mm	**CKM13**	**STCM4**	4 mm
1097781	**CTCPN2518M22**	25	18	19,2	150	41,0	TP..220408	**SM837**	**MS125**	2.5 mm	**CKM13**	**STCM4**	4 mm
1097778	**CTCPN2520M22**	25	20	20,2	150	41,0	TP..220408	**SM837**	**MS125**	2.5 mm	**CKM13**	**STCM4**	4 mm

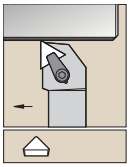


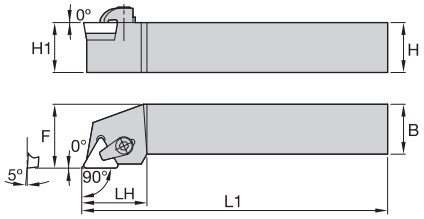


CTDP 45°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	clamp	clamp screw	hex
right hand												
1244613	**CTDPR1212F11**	12	12	6,0	80	22,0	TP..110304	**SM819**	**MS960**	**CKM19**	**STCM9**	2.5 mm

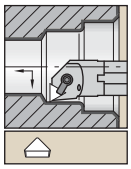




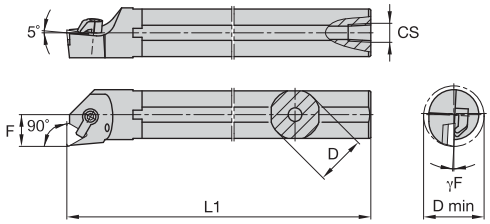
CTGP 90°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand													
1097762	CTGPR1212F11	12	12	16,0	80	20,0	TP..110304	SM819	MS960	–	CKM19	STCM9	2.5 mm
1097763	CTGPR1616H11	16	16	20,0	100	20,0	TP..110304	SM819	MS960	–	CKM19	STCM9	2.5 mm
1244595	CTGPR2020K11	20	20	25,0	125	20,0	TP..110304	SM819	MS960	–	CKM19	STCM9	2.5 mm
1097764	CTGPR2020K16	20	20	25,0	125	26,0	TP..160308	SM841	MS111	2 mm	CKM10	STCM8	4 mm
1097765	CTGPR2525M16	25	25	32,0	150	26,0	TP..160308	SM841	MS111	2 mm	CKM9	STCM4	4 mm
left hand													
1097916	CTGPL1212F11	12	12	16,0	80	20,0	TP..110304	SM819	MS960	–	CKM19	STCM9	2.5 mm
1097918	CTGPL2020K16	20	20	25,0	125	26,0	TP..160308	SM841	MS111	2 mm	CKM10	STCM8	4 mm
1097919	CTGPL2525M16	25	25	32,0	150	26,0	TP..160308	SM841	MS111	2 mm	CKM9	STCM4	4 mm



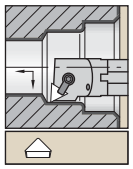
Steel shank with through coolant.



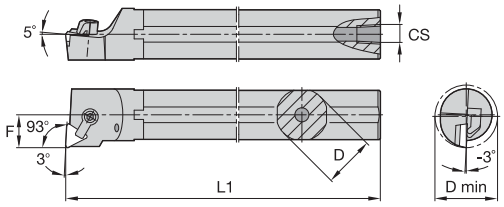
A-CTFP 90°



order number	catalogue number	D	D min	F	L1	CS	γF°	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand														
1886492	**A16RCTFPR11**	16	20,0	11,0	200	1/8-27 NPT	-4.0	TP..110304	**–**	**–**	–	**CKM19**	**STCM9**	2.5 mm
1098051	**A20QCTFPR11**	20	25,0	13,0	180	1/8-27 NPT	0.0	TP..110304	**SM815**	**MS961**	–	**CKM19**	**STCM9**	2.5 mm
1098053	**A25RCTFPR16**	25	32,0	17,0	200	1/4-18 NPT	-3.0	TP..160308	**SM841**	**MS110**	2 mm	**CKM10**	**STCM8**	4 mm
1098055	**A32SCTFPR16**	32	40,0	22,0	250	1/4-18 NPT	-3.0	TP..160308	**SM841**	**MS110**	2 mm	**CKM10**	**STCM8**	4 mm
1886494	**A40VCTFPR16**	40	48,0	27,0	400	1/4-18 NPT	-3.0	TP..160308	**SM841**	**MS110**	2 mm	**CKM10**	**STCM8**	4 mm
left hand														
1098054	**A25RCTFPL16**	25	32,0	17,0	200	1/4-18 NPT	-3.0	TP..160308	**SM841**	**MS110**	2 mm	**CKM10**	**STCM8**	4 mm
1098056	**A32SCTFPL16**	32	40,0	22,0	250	1/4-18 NPT	-3.0	TP..160308	**SM841**	**MS110**	2 mm	**CKM10**	**STCM8**	4 mm



Steel shank with through coolant.



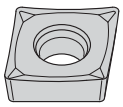
A-CTUP 93°

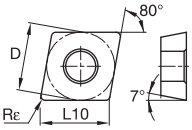


order number	catalogue number	D	D min	F	L1	CS	gage insert	shim	shim screw	clamp	clamp screw	hex
right hand												
1098057	**A16MCTUPR11**	16	20,0	11,0	150	1/8-27 NPT	TP..110304	**SM815**	**MS961**	**CKM19**	**STCM9**	2.5 mm
left hand												
1098058	**A16MCTUPL11**	16	20,0	11,0	150	1/8-27 NPT	TP..110304	**SM815**	**MS961**	**CKM19**	**STCM9**	2.5 mm

● first choice
○ alternate choice

		KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P		●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M								○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K		○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																				●	●	●		●	●	●	●	●		
S																				●	●	●	●	●	●	●	●			
H																														





CCGT-HP

ISO catalogue number	D	L10	Rε
CCGT060202HP	6,35	6,45	0,2
CCGT060204HP	6,35	6,45	0,4
CCGT060208HP	6,35	6,45	0,8
CCGT09T302HP	9,53	9,67	0,2
CCGT09T304HP	9,53	9,67	0,4
CCGT09T308HP	9,53	9,67	0,8
CCGT120402HP	12,70	12,90	0,2
CCGT120404HP	12,70	12,90	0,4
CCGT120408HP	12,70	12,90	0,8

KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	–	●	●	–	–
–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	●	–	–
–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–	–
–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	●	–	–
–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	●	–	–
–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	–	–
–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	●	●	●	–	–
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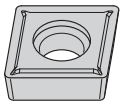

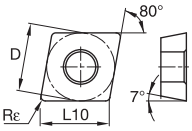

CCGT-LF

ISO catalogue number	D	L10	Rε
CCGT0602X0LF	6,35	6,45	0,0
CCGT060201LF	6,35	6,45	0,1
CCGT060202LF	6,35	6,45	0,2
CCGT060204LF	6,35	6,45	0,4
CCGT060208LF	6,35	6,45	0,8
CCGT09T3X0LF	9,53	9,67	0,0
CCGT09T301LF	9,53	9,67	0,1
CCGT09T302LF	9,53	9,67	0,2
CCGT09T304LF	9,53	9,67	0,4
CCGT09T308LF	9,53	9,67	0,8

KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
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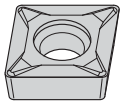
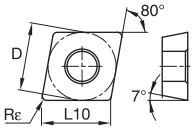
–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	●	●	–	–	–

● first choice
○ alternate choice

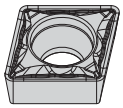


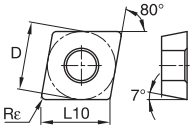


CCMT-11

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
CCMT060202	6,35	6,45	0,2	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	●	●	–	–	–	–	–
CCMT060204	6,35	6,45	0,4	●	●	●	●	●	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	●	●	–	–	–	–	●
CCMT060208	6,35	6,45	0,8	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	●	●	–	–	–	–	●
CCMT09T302	9,53	9,67	0,2	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	●	●	–	–	–	–	●
CCMT09T304	9,53	9,67	0,4	●	●	–	●	●	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	●	●	–	–	–	–	●
CCMT09T308	9,53	9,67	0,8	–	●	●	●	●	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–	–	–	●	●	–	–	–	–	●
CCMT120404	12,70	12,90	0,4	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	●	●	–	–	–	–	–
CCMT120408	12,70	12,90	0,8	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–
CCMT120412	12,70	12,90	1,2	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

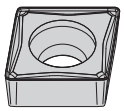
NOTE: Indexable Inserts for S-clamping.

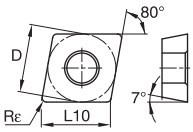




CCMT-FP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
CCMT060202FP	6,35	6,45	0,2	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	●	●	–	–	–	–	–
CCMT060204FP	6,35	6,45	0,4	●	●	●	●	●	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	●	●	–	–	–	–	●
CCMT060208FP	6,35	6,45	0,8	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	●	●	–	–	–	–	●
CCMT09T302FP	9,53	9,67	0,2	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	●	●	–	–	–	–	●
CCMT09T304FP	9,53	9,67	0,4	●	●	–	●	●	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	–	●	●	–	–	–	–	●
CCMT09T308FP	9,53	9,67	0,8	–	●	●	●	●	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–	–	–	●	●	–	–	–	–	●
CCMT120404FP	12,70	12,90	0,4	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	●	●	–	–	–	–	–
CCMT120408FP	12,70	12,90	0,8	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–
CCMT120412FP	12,70	12,90	1,2	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

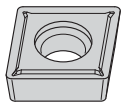


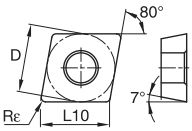


CCMT-FW

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
CCMT060202FW	6,35	6,45	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–
CCMT060204FW	6,35	6,45	0,4	–	–	–	–	●	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●	–
CCMT060208FW	6,35	6,45	0,8	–	–	–	–	●	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–
CCMT09T304FW	9,53	9,67	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●	–
CCMT09T308FW	9,53	9,67	0,8	–	–	–	–	●	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	●	–	●	–	–	●	–

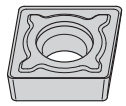
● first choice
○ alternate choice

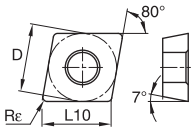




CCMT-LF

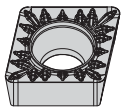
				KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
ISO catalogue number	**D**	**L10**	**Rε**																													
CCMT060202LF	6,35	6,45	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–
CCMT060204LF	6,35	6,45	0,4	–	●	●	●	●	●	–	–	●	●	●	●	●	●	●	●	●	–	●	–	–	–	–	–	●	●	–	●	–
CCMT060208LF	6,35	6,45	0,8	●	–	●	●	●	●	–	●	●	●	●	●	–	●	–	–	●	–	–	–	–	–	–	–	●	●	–	●	–
CCMT09T302LF	9,53	9,67	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	●	–	●	–
CCMT09T304LF	9,53	9,67	0,4	–	●	●	●	●	●	–	–	●	●	●	–	●	●	–	●	●	●	–	●	–	–	–	–	–	●	●	–	●	–
CCMT09T308LF	9,53	9,67	0,8	●	●	●	●	●	●	–	–	●	●	●	●	●	●	–	●	●	●	–	●	–	–	–	–	–	●	–	–	●	–
CCMT120404LF	12,70	12,90	0,4	–	–	●	●	●	●	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–
CCMT120408LF	12,70	12,90	0,8	–	●	●	●	●	●	–	–	–	–	●	●	●	–	–	●	–	●	–	–	–	–	–	–	–	●	●	–	–	–
CCMT120412LF	12,70	12,90	1,2	–	–	●	●	–	–	–	–	–	–	–	●	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–

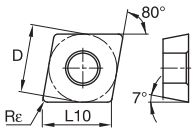




CCMT-MF

				KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
ISO catalogue number	**D**	**L10**	**Rε**																													
CCMT060204MF	6,35	6,45	0,4	–	●	●	●	●	●	–	–	–	–	●	–	●	●	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–
CCMT09T304MF	9,53	9,67	0,4	–	●	–	●	●	●	–	–	–	●	●	●	●	●	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–
CCMT09T308MF	9,53	9,67	0,8	–	●	–	●	●	●	–	–	–	●	●	●	●	●	–	●	●	●	–	–	–	–	–	–	–	●	–	–	–	–
CCMT09T312MF	9,53	9,67	1,2	–	–	●	●	●	–	–	–	–	–	●	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT120408MF	12,70	12,90	0,8	–	●	●	●	●	●	–	–	–	●	●	●	●	●	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–
CCMT120412MF	12,70	12,90	1,2	–	–	–	●	●	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

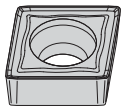


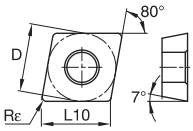


CCMT-MP

				KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
ISO catalogue number	**D**	**L10**	**Rε**																													
CCMT060204MP	6,35	6,45	0,4	–	–	●	–	●	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–	–	●	–	–	–	–	–	–	–	–
CCMT09T304MP	9,53	9,67	0,4	–	–	●	–	●	–	–	–	–	–	–	●	–	●	–	●	●	–	–	–	–	●	–	–	–	–	–	–	–	–
CCMT09T308MP	9,53	9,67	0,8	–	–	●	–	●	–	–	–	–	–	–	●	●	●	–	●	●	–	–	–	–	●	–	–	–	–	–	–	–	–
CCMT09T312MP	9,53	9,67	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●	–	–	–	–	–	–	–	–
CCMT120408MP	12,70	12,90	0,8	–	–	●	–	●	–	–	–	–	–	–	●	●	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–	–	–
CCMT120412MP	12,70	12,90	1,2	–	–	–	–	●	–	–	–	–	–	–	–	●	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–

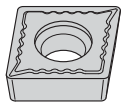
● first choice
○ alternate choice

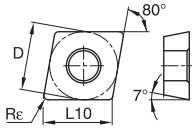




CCMT-MW

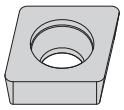
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
CCMT09T304MW	9,53	9,67	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	●	–	–	●	–
CCMT09T308MW	9,53	9,67	0,8	–	–	–	–	●	–	–	–	–	–	–	●	●	●	–	–	–	–	–	–	–	–	●	–	●	–	–	●	–
CCMT120404MW	12,70	12,90	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
CCMT120408MW	12,70	12,90	0,8	–	–	–	–	●	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

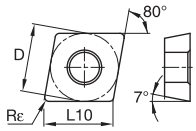




CCMT-UF

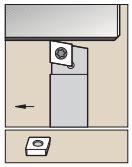
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
CCMT060204UF	6,35	6,45	0,4	●	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
CCMT09T302UF	9,53	9,67	0,2	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
CCMT09T304UF	9,53	9,67	0,4	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
CCMT09T308UF	9,53	9,67	0,8	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

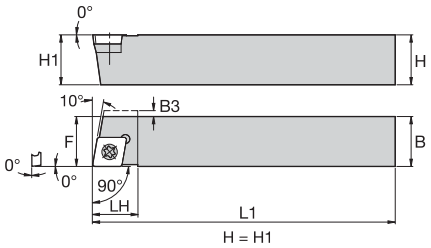


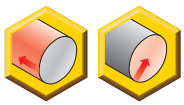


CCMW

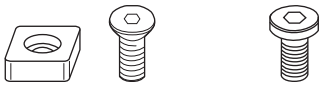
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
CCMW060204	6,35	6,45	0,4	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMW09T308	9,53	9,67	0,8	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMW120408	12,70	12,90	0,8	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMW120412	12,70	12,90	1,2	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



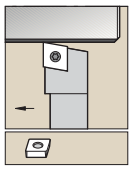


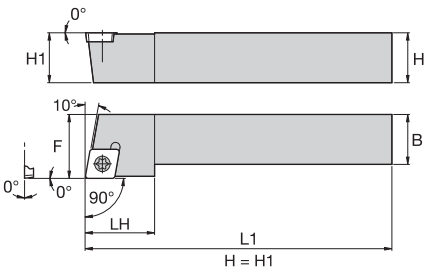


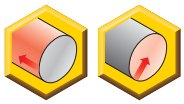
SCAC 90°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	insert screw	hex
right hand												
1097708	**SCACR1010M06Q**	10	10	10,0	150	11,0	CC..060204	–	–	–	**MS1153**	T7
1097710	**SCACR1212M06Q**	12	12	12,0	150	11,0	CC..060204	–	–	–	**MS1153**	T7
1097714	**SCACR1616K09Q**	16	16	16,0	125	16,0	CC..09T308	**SKCP343**	**SRS3**	3.5 mm	**MS1156**	T15



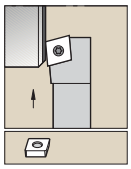


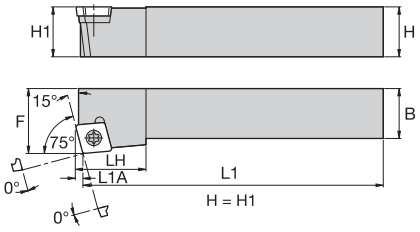


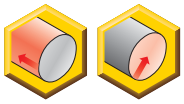
SCGC 90°



order number	catalogue number	H	B	F	L1	LH	gage insert	insert screw	Torx
right hand									
1097824	**SCGCR1010M06**	10	10	12,0	150	11,0	CC..060204	**MS1153**	T7
1097825	**SCGCR1212N09**	12	12	16,0	160	16,0	CC..09T308	**MS1155**	T15
left hand									
1097970	**SCGCL1212N09**	12	12	16,0	160	16,0	CC..09T308	**MS1155**	T15





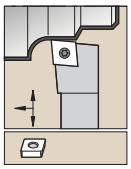


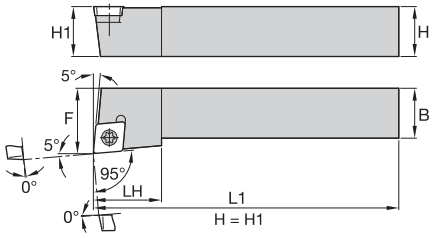
SCKC 75°





order number	catalogue number	H	B	F	L1	LH	L1A	gage insert	shim	shim screw	hex	insert screw	Torx
right hand													
1097840	**SCKCR2020K09**	20	20	25,0	125	16,0	2,3	CC..09T308	**SKCP343**	**SRS3**	3.5 mm	**MS1156**	T15





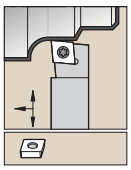


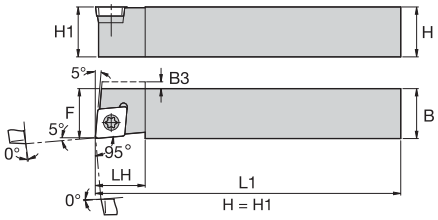
SCLC 95°





order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	insert screw	Torx
right hand												
1097814	**SCLCR0808L06**	8	8	10,0	140	12,0	CC..060204	–	–	–	**MS1153**	T7
1097816	**SCLCR1010M06**	10	10	12,0	150	12,0	CC..060204	–	–	–	**MS1153**	T7
1097818	**SCLCR1212N09**	12	12	16,0	160	16,0	CC..09T308	–	–	–	**MS1155**	T15
1097819	**SCLCR1616H09**	16	16	20,0	100	15,8	CC..09T308	**SKCP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097821	**SCLCR2020K09**	20	20	25,0	125	15,8	CC..09T308	**SKCP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097820	**SCLCR2020K12**	20	20	25,0	125	19,8	CC..120408	**SKCP453**	**SRS4**	4 mm	**MS1158**	T15
1244995	**SCLCR2525M09**	25	25	32,0	150	15,8	CC..09T308	**SKCP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097822	**SCLCR2525M12**	25	25	32,0	150	20,0	CC..120408	**SKCP453**	**SRS4**	4 mm	**MS1158**	T15
left hand												
1097959	**SCLCL0808L06**	8	8	10,0	140	12,0	CC..060204	–	–	–	**MS1153**	T7
1097961	**SCLCL1010M06**	10	10	12,0	150	12,0	CC..060204	–	–	–	**MS1153**	T7
1097963	**SCLCL1212N09**	12	12	16,0	160	16,0	CC..09T308	–	–	–	**MS1155**	T15
1097964	**SCLCL1616H09**	16	16	20,0	100	15,8	CC..09T308	**SKCP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097966	**SCLCL2020K09**	20	20	25,0	125	15,8	CC..09T308	**SKCP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097965	**SCLCL2020K12**	20	20	25,0	125	19,8	CC..120408	**SKCP453**	**SRS4**	4 mm	**MS1158**	T15
1318353	**SCLCL2525M09**	25	25	32,0	150	15,8	CC..09T308	**SKCP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097967	**SCLCL2525M12**	25	25	32,0	150	20,0	CC..120408	**SKCP453**	**SRS4**	4 mm	**MS1158**	T15



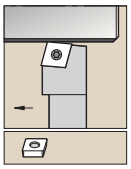


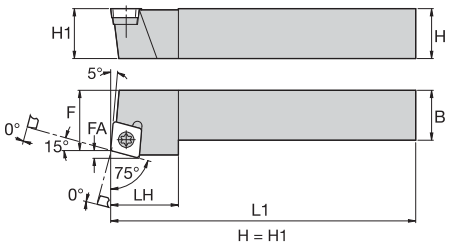


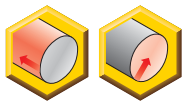
SCLC-F 95°



order number	catalogue number	H	B	F	L1	LH	B3	gage insert	shim	shim screw	hex	insert screw	Torx
right hand													
1772152	SCLCRF0808M06Q	8	8	8,0	150	12,0	1,5	CC..060204	–	–	–	MS1153	T7
1097812	SCLCRF1010M06Q	10	10	10,0	150	11,0	–	CC..060204	–	–	–	MS1153	T7
1097813	SCLCRF1212M06Q	12	12	12,0	150	11,0	–	CC..060204	–	–	–	MS1153	T7
1097817	SCLCRF1616K09Q	16	16	16,0	125	16,0	–	CC..09T308	SKCP343	SRS3	3.5 mm	MS1156	T15



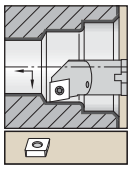




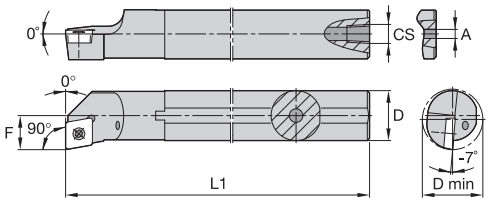
SCRC 75°



order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim screw	hex	insert screw	Torx
right hand													
1097828	SCRCR1212N09	12	12	13,0	160	14,0	2,3	CC..09T308	–	–	–	MS1155	T15
1097829	SCRCR1616H09	16	16	17,0	100	14,0	2,3	CC..09T308	SKCP343	SRS3	3.5 mm	MS1156	T15



Steel shank with through coolant.

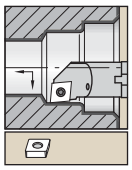




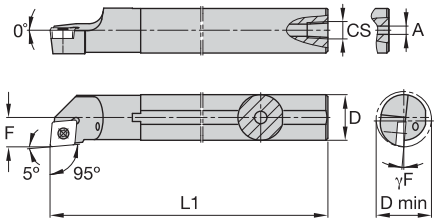
A-SCFC 90°



order number	catalogue number	D	D min	F	L1	CS	gage insert	insert screw	Torx
right hand									
1098266	**A25TSCFCR12**	25	32,0	17,0	300	1/4-18 NPT	CC..120408	**MS1157**	T15
left hand									
1098270	**A25TSCFCL12**	25	32,0	17,0	300	1/4-18 NPT	CC..120408	**MS1157**	T15



Steel shank with through coolant.

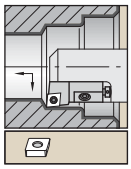


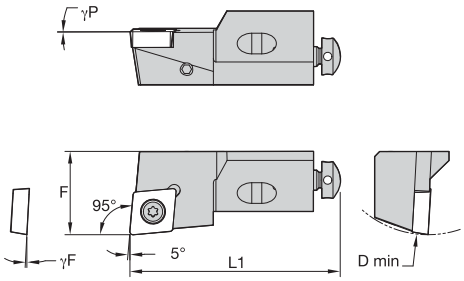


A-SCLC 95°



order number	catalogue number	D	D min	F	L1	A	CS	γF°	gage insert	shim	shim screw	hex	insert screw	Torx
right hand														
1098159	**A08JSCLCR06**	8	11,0	6,0	110	2,4	–	-8.0	CC..060204	–	–	–	**MS1939**	T7
1098168	**A10KSCLCR06**	10	13,0	7,0	125	3,2	–	-7.0	CC..060204	–	–	–	**MS1153**	T7
1098178	**A12MSCLCR06**	12	16,0	9,0	150	4,0	1/16-27 NPT	-6.0	CC..060204	–	–	–	**MS1153**	T7
1098225	**A16RSCLCR09**	16	20,0	11,0	200	4,0	1/8-27 NPT	-7.0	CC..09T308	–	–	–	**MS1155**	T15
1098239	**A20SSCLCR09**	20	25,0	13,0	250	4,0	1/8-27 NPT	-5.0	CC..09T308	–	–	–	**MS1155**	T15
1098268	**A25TSCLCR12**	25	32,0	17,0	300	6,4	1/4-18 NPT	-7.0	CC..120408	–	–	–	**MS1157**	T15
1098280	**A32TSCLCR12**	32	40,0	22,0	300	6,4	1/4-18 NPT	-7.0	CC..120408	**SKCP453**	**SRS4**	4 mm	**MS1158**	T15
left hand														
1098163	**A08JSCLCL06**	8	11,0	6,0	110	2,4	–	-8.0	CC..060204	–	–	–	**MS1939**	T7
1098173	**A10KSCLCL06**	10	13,0	7,0	25	3,2	–	-7.0	CC..060204	–	–	–	**MS1153**	T7
1098183	**A12MSCLCL06**	12	16,0	9,0	150	4,0	1/16-27 NPT	-6.0	CC..060204	–	–	–	**MS1153**	T7
1098231	**A16RSCLCL09**	16	20,0	11,0	200	4,0	1/8-27 NPT	-7.0	CC..09T308	–	–	–	**MS1155**	T15
1098244	**A20SSCLCL09**	20	25,0	13,0	250	4,0	1/8-27 NPT	-5.0	CC..09T308	–	–	–	**MS1155**	T15
1098272	**A25TSCLCL12**	25	32,0	17,0	300	6,4	1/4-18 NPT	-7.0	CC..120408	–	–	–	**MS1157**	T15
1098282	**A32TSCLCL12**	32	40,0	22,0	300	6,4	1/4-18 NPT	-7.0	CC..120408	**SKCP453**	**SRS4**	4 mm	**MS1158**	T15





SCLC 95°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098544	**SCLCR12CA12**	50	20,0	55	-3.0	0.0	CC..120408/CC..432
1098545	**SCLCR16CA12**	60	25,0	63	-3.0	0.0	CC..120408/CC..432
left hand							
1098732	**SCLCL12CA12**	50	20,0	55	-3.0	0.0	CC..120408/CC..432

Spare Parts

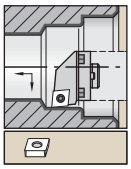




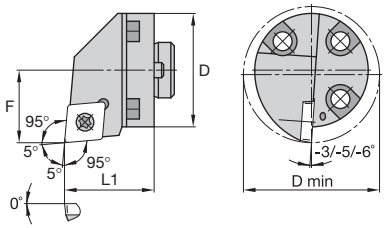


D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	**MS1157**	T15	**KUAM23**	2.5 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**
60	**MS1157**	T15	**KUAM25**	2.5 mm	**KUAM32**	**191.407**	5 mm	**CSWM 080 050**

Screw-On Boring Heads



With through coolant.

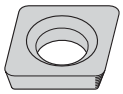


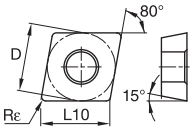
H-SCLC 95°



order number	catalogue number	D	D min	F	L1	gage insert	insert screw	Torx
right hand								
1772253	**H32SCLCR09**	32	40,0	21,9	25	CC..09T308	**MS1155**	T15
3612090	**H40SCLCR12**	40	50,0	27,0	41	CC..120408	**MS1158**	T15

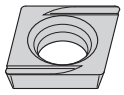
● first choice
○ alternate choice

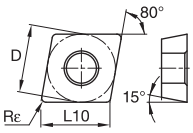




CDHB

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
CDHBS4T0S0	3,97	4,03	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–
CDHBS4T0X0	3,97	4,03	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
CDHBS4T002	3,97	4,03	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	–	●	–
CDHBS4T004	3,97	4,03	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	●	–

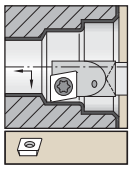




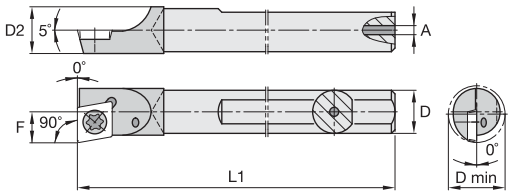
CDHH

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
CDHHS4T002L	3,97	4,03	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	●	–
CDHHS4T002R	3,97	4,03	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	●	–
CDHHS4T004L	3,97	4,03	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–
CDHHS4T004R	3,97	4,03	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–

NOTE: Right-hand insert uses left-hand bars.
Left-hand insert uses right-hand bars.



Carbide shank with through coolant.

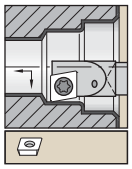




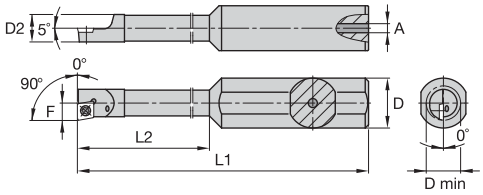
E-SCFD 90°



order number	catalogue number	D	D min	F	L1	A	gage insert	insert screw	Torx
right hand									
1930354	**E05HSCFDRS4**	5	5,9	3,2	101	1,0	CD..S4T002	**CC11**	T6
1930360	**E06HSCFDRS4**	6	7,1	3,7	100	1,2	CD..S4T002	**CC11**	T6



Necked steel shank with through coolant.

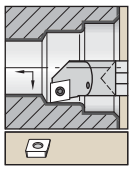




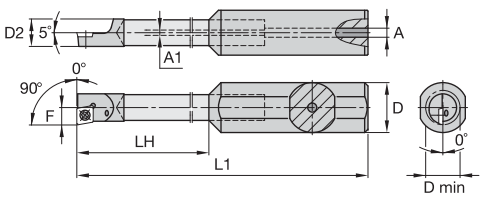
A-SCFD 90° • Stepped



order number	catalogue number	D	D min	D2	F	L1	L2	A	gage insert	insert screw	Torx
right hand											
1930376	**A0510ESCFDRS412**	10	5,9	5,2	3,1	70	12,7	1,0	CD..S4T002	**CC11**	T6
1930380	**A0510ESCFDRS425**	10	5,9	5,2	3,1	70	25,4	1,0	CD..S4T002	**CC11**	T6
1930404	**A0612ESCFDRS431**	12	7,4	6,6	3,9	70	31,8	1,0	CD..S4T002	**CC11**	T6



Necked carbide shank with through coolant.

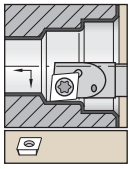




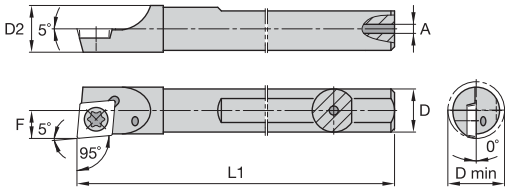
E-SCFD 90° • Stepped



order number	catalogue number	D	D min	D2	F	L1	LH	A	A1	gage insert	insert screw	Torx
right hand												
1930408	**E0512XSCFDRS425**	12	5,9	5,0	3,2	64	10,0	1,0	1,2	CD..S4T002	**CC11**	T6
1930412	**E0512XSCFDRS450**	12	5,9	5,0	3,2	89	10,0	3,2	1,2	CD..S4T002	**CC11**	T6
1930436	**E0616XSCFDRS463**	16	7,4	6,3	3,9	127	12,3	3,2	1,2	CD..S4T002	**CC11**	T6



Steel shank with through coolant.

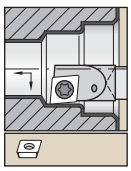




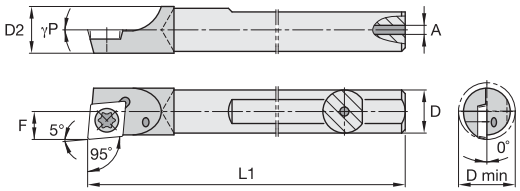
A-SCLD 95°



order number	catalogue number	D	D min	D2	F	L1	A	gage insert	insert screw	Torx
right hand										
1288877	**A04XSCLDRS4**	4	4,6	4,2	2,4	65	1,0	CD..S4T002	**CC09**	T6
1930298	**A05XSCLDRS4**	5	5,8	5,2	3,0	64	1,0	CD..S4T002	**CC09**	T6
1288893	**A06XSCLDRS4**	6	7,1	6,2	3,7	64	1,0	CD..S4T002	**CC11**	T6
1288906	**A08XSCLDRS4**	8	9,0	8,2	4,7	76	1,5	CD..S4T002	**CC11**	T6
left hand										
1288876	**A04XSCLDLS4**	4	4,6	4,2	2,4	65	1,0	CD..S4T002	**CC09**	T6
1930297	**A05XSCLDLS4**	5	5,8	5,2	3,0	64	1,0	CD..S4T002	**CC09**	T6
1288892	**A06XSCLDLS4**	6	7,1	6,2	3,7	64	1,0	CD..S4T002	**CC11**	T6
1288905	**A08XSCLDLS4**	8	9,0	8,2	4,7	76	1,5	CD..S4T002	**CC11**	T6



Carbide shank with through coolant.

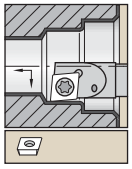




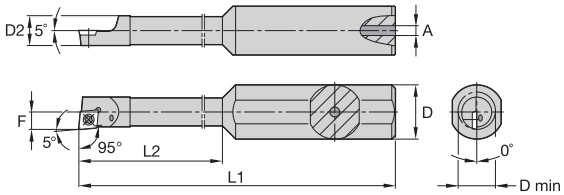
E-SCLD 95°



order number	catalogue number	D	D min	D2	F	L1	A	γP°	gage insert	insert screw	Torx
right hand											
1930300	**E04HSCLDRS4**	4	4,6	4,2	2,4	100	1,0	0.0	CD..S4T002	**CC09**	T6
1270967	**E04MSCLDRS4**	4	4,6	4,2	2,4	152	1,0	0.0	CD..S4T002	**CC09**	T6
1930356	**E05HSCLDRS4**	5	5,9	–	3,0	101	1,0	5.0	CD..S4T002	**CC09**	T6
1930358	**E05MSCLDRS4**	5	5,9	–	3,0	152	1,0	5.0	CD..S4T002	**CC09**	T6
1930362	**E06HSCLDRS4**	6	7,1	–	3,7	100	1,2	5.0	CD..S4T002	**CC11**	T6
1270978	**E06MSCLDRS4**	6	6,9	–	3,7	152	1,2	5.0	CD..S4T002	**CC09**	T6
1270988	**E08MSCLDRS4**	8	9,1	–	4,7	150	2,4	5.0	CD..120605	**CC11**	T6
left hand											
1930299	**E04HSCLDLS4**	4	4,6	4,2	2,4	100	1,0	0.0	CD..S4T002	**CC09**	T6
1270966	**E04MSCLDLS4**	4	4,6	4,2	2,4	152	1,0	0.0	CD..S4T002	**CC09**	T6
1930355	**E05HSCLDLS4**	5	5,9	–	3,0	101	1,0	5.0	CD..S4T002	**CC11**	T6
1930357	**E05MSCLDLS4**	5	5,9	–	3,0	152	1,0	5.0	CD..S4T002	**CC09**	T6
1930361	**E06HSCLDLS4**	6	7,1	–	3,7	100	1,2	5.0	CD..S4T002	**CC11**	T6
1270977	**E06MSCLDLS4**	6	7,1	–	3,7	152	1,2	5.0	CD..S4T002	**CC11**	T6
1270987	**E08MSCLDLS4**	8	9,0	–	4,7	152	2,4	5.0	CD..S4T002	**CC11**	T6



Necked steel shank with through coolant.

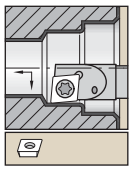




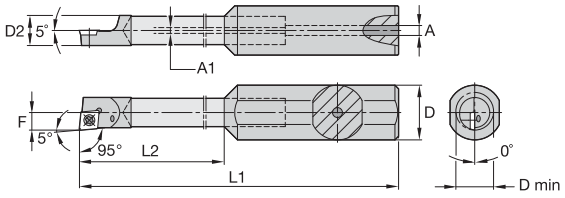
A-SCLD 95° • Stepped



order number	catalogue number	D	D min	F	L1	L2	A	gage insert	insert screw	Torx
right hand										
1930372	**A0410ESCLDRS412**	10	5,2	2,6	70	12,7	1,0	CD..S4T002	**CC09**	T6
1930374	**A0410ESCLDRS425**	10	5,2	2,6	70	25,4	1,0	CD..S4T002	**CC09**	T6
1289129	**A0412ESCLDRS412**	12	5,2	2,6	70	12,7	1,0	CD..S4T002	**CC09**	T6
1289130	**A0412ESCLDRS425**	12	5,2	2,6	70	25,4	1,0	CD..S4T002	**CC09**	T6
1930378	**A0510ESCLDRS412**	10	5,8	3,0	70	12,3	1,0	CD..S4T002	**CC11**	T6
1930382	**A0510ESCLDRS425**	10	5,8	3,0	70	25,0	1,0	CD..S4T002	**CC09**	T6
1098071	**A0510GSCLDRS4**	10	6,0	3,2	90	25,0	3,2	CD..S4T002	**MS1454**	T5
1098073	**A0610HSCLDRS4**	10	7,6	3,8	100	32,0	3,2	CD..S4T002	**MS1454**	T5
1930402	**A0612ESCLDRS419**	12	7,2	3,7	70	19,1	1,0	CD..S4T002	**CC11**	T6



Necked carbide shank with through coolant.



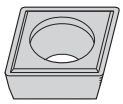


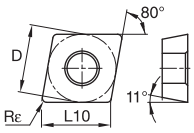
E-SCLD 95° • Stepped



order number	catalogue number	D	D min	D2	F	L1	L2	A	gage insert	insert screw	Torx
right hand											
1930406	**E0412DSCLDRS422**	12	5,3	5,0	2,6	60	22,2	3,2	CD..S4T002	**CC09**	T6
1262129	**E0412XSCLDRS447**	12	5,3	5,0	2,6	86	47,6	3,2	CD..S4T002	**CC09**	T6
1262131	**E0416KSCLDRS447**	16	5,3	5,0	2,6	111	47,6	3,2	CD..S4T002	**CC09**	T6
1930410	**E0512XSCLDRS425**	12	5,9	–	3,0	64	25,4	1,0	CD..S4T002	**CC11**	T6
1930418	**E0612ESCLDRS431**	12	7,2	–	3,7	70	31,8	3,2	CD..S4T002	**CC11**	T6
1262178	**E0612HSCLDRS463**	12	7,2	–	3,7	102	63,5	3,2	CD..S4T002	**CC11**	T6
1930434	**E0616HSCLDRS431**	16	7,2	–	3,7	95	31,8	3,2	CD..S4T002	**CC11**	T6
1262175	**E0616XSCLDRS463**	16	7,2	–	3,7	127	63,5	3,2	CD..120605	**CC11**	T6

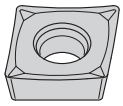
● first choice
○ alternate choice

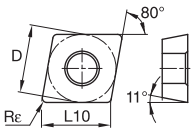




CPGH (T)

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
				P																												
				M																												
				K																												
				N																												
				S																												
				H																												
CPGT060202K	6,35	6,45	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
CPGT060204K	6,35	6,45	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	●	–	–	–	–
CPGH09T301	9,53	9,67	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	●	–
CPGH09T302	9,53	9,67	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	●	–	–	–
CPGH09T304	9,53	9,67	0,4	–	●	–	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	●	–	●	●	●	●	–	●	–
CPGH09T308	9,53	9,67	0,8	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	●	●	●	–	–	–

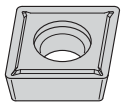


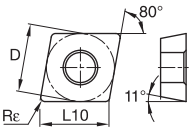


CPGT-HP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
CPGT060202HP	6,35	6,45	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–
CPGT060204HP	6,35	6,45	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–
CPGT060208HP	6,35	6,45	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–	–
CPGT09T302HP	9,53	9,67	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	●	●	●	–	–
CPGT09T304HP	9,53	9,67	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	●	–	–
CPGT09T308HP	9,53	9,67	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	–	–

● first choice
○ alternate choice

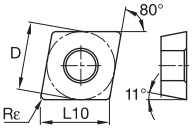




CPGT-LF

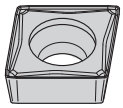
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
				P ●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
				M							○						●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
				K ○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
				N																		●	●	●		●	●	●	●	●		
				S																		●	●	●	●	●	●	●	●			
				H																												
CPGT060201LF	6,35	6,45	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–
CPGT060202LF	6,35	6,45	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–
CPGT060204LF	6,35	6,45	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–
CPGT060208LF	6,35	6,45	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–
CPGT09T302LF	9,53	9,67	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–
CPGT09T304LF	9,53	9,67	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–
CPGT09T308LF	9,53	9,67	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–

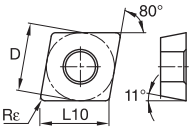




CPMT-FP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
CPMT050202FP	5,56	5,65	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
CPMT050204FP	5,56	5,65	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
CPMT060202FP	6,35	6,45	0,2	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	●	–	–	–	–	●
CPMT060204FP	6,35	6,45	0,4	–	–	●	●	●	–	–	–	–	–	–	–	●	–	–	–	●	–	–	–	–	–	●	●	–	–	–	–	●
CPMT060208FP	6,35	6,45	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●
CPMT09T302FP	9,53	9,67	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–
CPMT09T304FP	9,53	9,67	0,4	–	–	●	●	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	●	●	–	–	–	–	–
CPMT09T308FP	9,53	9,67	0,8	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	●	–	–	–	–	●

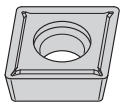


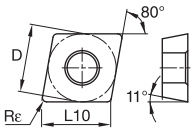


CPMT-FW

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
CPMT060202FW	6,35	6,45	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–
CPMT060204FW	6,35	6,45	0,4	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●	–
CPMT060208FW	6,35	6,45	0,8	–	–	–	–	●	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●	–
CPMT09T304FW	9,53	9,67	0,4	–	–	–	–	●	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–
CPMT09T308FW	9,53	9,67	0,8	–	–	–	–	●	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	●	–	●	–	–	●	–

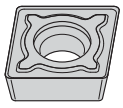
● first choice
○ alternate choice

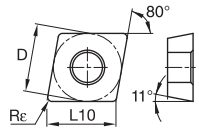




CPMT-LF

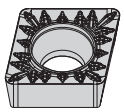
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
				P																												
				M																												
				K																												
				N																												
				S																												
				H																												
CPMT050202LF	5,56	5,65	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
CPMT050204LF	5,56	5,65	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–
CPMT060202LF	6,35	6,45	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–
CPMT060204LF	6,35	6,45	0,4	–	●	●	●	●	–	–	–	●	●	●	–	●	–	●	–	●	–	–	●	●	–	–	–	●	●	–	●	–
CPMT060208LF	6,35	6,45	0,8	–	–	●	●	●	●	–	–	●	–	●	–	–	–	–	–	●	–	–	●	–	–	–	–	●	●	–	●	–
CPMT09T302LF	9,53	9,67	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–
CPMT09T304LF	9,53	9,67	0,4	●	●	●	●	●	●	–	–	●	●	–	●	●	●	●	●	●	–	–	–	–	–	–	–	●	●	–	●	–
CPMT09T308LF	9,53	9,67	0,8	–	●	●	●	●	●	–	–	●	●	●	●	●	–	●	–	●	–	–	–	●	–	–	–	●	●	–	●	–

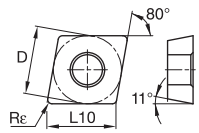




CPMT-MF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
CPMT060208MF	6,35	6,45	0,8	–	●	–	●	–	–	–	–	–	–	●	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–
CPMT09T308MF	9,53	9,67	0,8	–	●	●	●	●	–	–	–	–	●	●	●	●	●	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–
CPMT09T312MF	9,53	9,67	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–

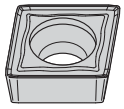


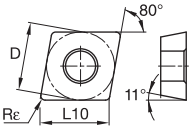


CPMT-MP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
CPMT060208MP	6,35	6,45	0,8	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
CPMT09T308MP	9,53	9,67	0,8	–	–	●	●	●	–	–	–	–	–	–	–	●	–	–	●	●	–	–	–	–	–	●	–	–	–	–	–	–

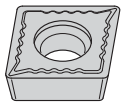
● first choice
○ alternate choice

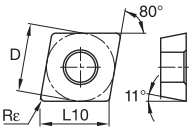




CPMT-MW

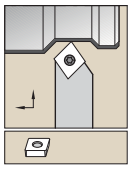
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
CPMT09T304MW	9,53	9,67	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
CPMT09T308MW	9,53	9,67	0,8	–	–	–	–	●	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

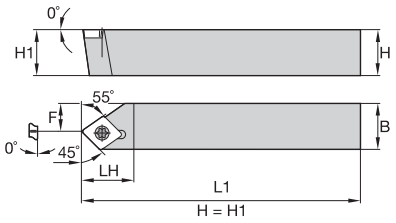




CPMT-UF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
CPMT060204UF	6,35	6,45	0,4	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
CPMT09T304UF	9,53	9,67	0,4	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–



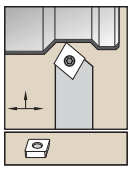


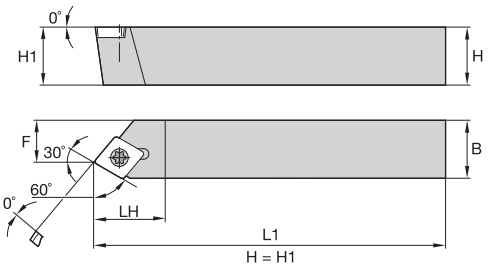


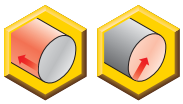
SCDP 45°



order number	catalogue number	H	B	F	L1	LH	gage insert	insert screw	Torx
right hand									
1244893	SCDPR1212H06	12	12	7,0	100	14,0	CP..060203	MS1153	T7



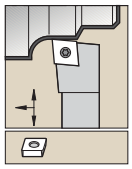


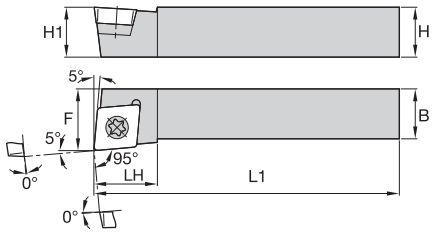


SCEP 60°



order number	catalogue number	H	B	F	L1	LH	gage insert	insert screw	Torx
right hand									
1244896	SCEPR1010H06	10	10	6,5	100	12,0	CP..060203R.	MS1153	T7
1250901	SCEPR1212H06	12	12	8,5	100	12,0	CP..060203R.	MS1153	T7



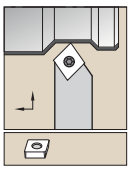


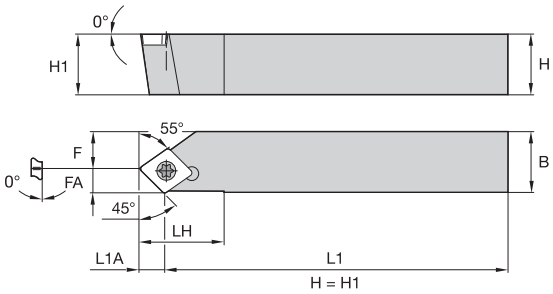


SCLP 95°



order number	catalogue number	H	B	F	L1	LH	gage insert	insert screw	Torx
right hand									
1192469	**SCLPR1212M06**	12	12	13,0	150	11,4	CP..060203	**MS1153**	T7
left hand									
1244913	**SCLPL1212M06**	12	12	13,0	150	11,4	CP..060203	**MS1153**	T7



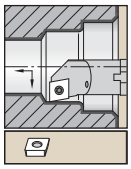




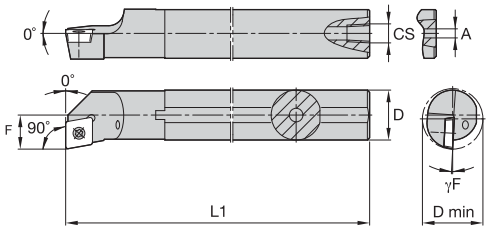
SCSP 45°



order number	catalogue number	H	B	F	L1	LH	FA	L1A	gage insert	insert screw	Torx
right hand											
1244917	**SCSPR1010H06**	10	10	6,0	100	14,0	4,2	4,2	CP..060203	**MS1153**	T7



Steel shank with through coolant.

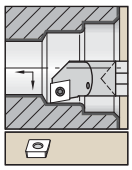




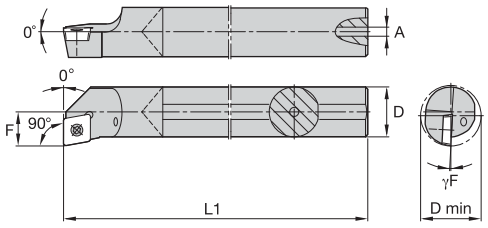
A-SCFP 90°



order number	catalogue number	D	D min	F	L1	A	CS	γF°	gage insert	insert screw	Torx
right hand											
1098157	**A08JSCFPR06**	8	11,0	6,0	110	2,4	–	-8.0	CP..060204	**MS1153**	T7
1098165	**A10KSCFPR06**	10	13,0	7,0	125	3,2	–	-6.0	CP..060204	**MS1153**	T7
1098175	**A12MSCFPR06**	12	16,0	9,0	150	4,0	1/16-27 NPT	-4.0	CP..060204	**MS1153**	T7
1886498	**A16RSCFPR06**	16	20,0	11,0	200	–	1/8-27 NPT	-5.0	CP..060203	**MS1153**	T7
1098221	**A16RSCFPR09**	16	20,0	11,0	200	4,0	1/8-27 NPT	-4.0	CP..09T308	**MS1155**	T15
1098235	**A20SSCFPR09**	20	25,0	13,0	250	4,0	1/8-27 NPT	-2.0	CP..09T308	**MS1155**	T15
left hand											
1098161	**A08JSCFPL06**	8	11,0	6,0	110	2,4	–	-8.0	CP..060204	**MS1153**	T7
1098170	**A10KSCFPL06**	10	13,0	7,0	125	3,2	–	-6.0	CP..060204	**MS1153**	T7
1098180	**A12MSCFPL06**	12	16,0	9,0	150	4,0	1/16-27 NPT	-4.0	CP..060204	**MS1153**	T7
1098227	**A16RSCFPL09**	16	20,0	11,0	200	4,0	1/8-27 NPT	-4.0	CP..09T308	**MS1155**	T15
1098241	**A20SSCFPL09**	20	25,0	13,0	250	4,0	1/8-27 NPT	-2.0	CP..09T308	**MS1155**	T15



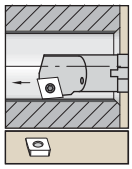
Carbide shank with through coolant.



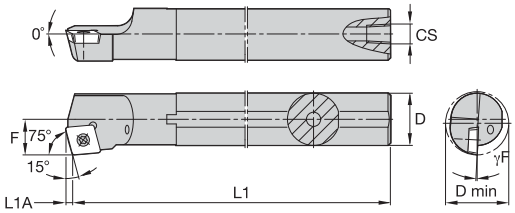
E-SCFP 90°



order number	catalogue number	D	D min	F	L1	A	γF°	gage insert	insert screw	Torx
right hand										
1152852	**E08KSCFPR06A**	8	11,0	6,0	125	2,4	-8.0	CP..060204	**MS1939**	T7
1152854	**E10MSCFPR06A**	10	13,0	7,0	150	3,2	-4.0	CP..060204	**MS1939**	T7
1152888	**E12QSCFPR06**	12	16,0	9,0	180	4,8	-3.0	CP..060204	**MS1153**	T7
left hand										
1152853	**E08KSCFPL06A**	8	11,0	6,0	125	2,4	-8.0	CP..060204	**MS1939**	T7



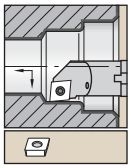
Steel shank with through coolant.



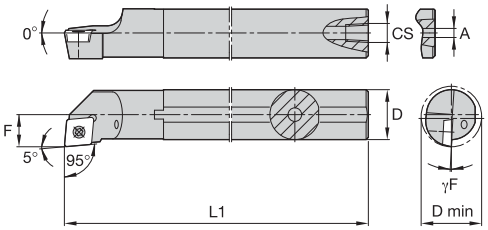
A-SCKP 75°



order number	catalogue number	D	D min	F	L1	L1A	CS	γF°	gage insert	insert screw	Torx
right hand											
1098236	**A20SSCKPR09**	20	25,0	13,0	250	2,3	1/8-27 NPT	-3.0	CP..09T308	**MS1155**	T15



Steel shank with through coolant.

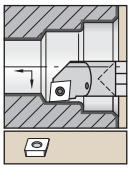




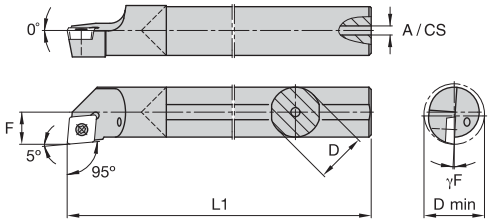
A-SCLP 95°



order number	catalogue number	D	D min	F	L1	A	CS	γF°	gage insert	insert screw	Torx
right hand											
1098156	**A08JSCLPR06**	.315	.433	.236	4.33	.09	–	-6.0	CP..060204	**MS1939**	T7
1098164	**A10KSCLPR06**	.390	.512	.276	4.92	.13	–	-4.0	CP..060204	**MS1939**	T7
1098174	**A12MSCLPR06**	.472	.630	.354	5.91	.16	1/16-27 NPT	-3.0	CP..060204	**MS1153**	T7
1886502	**A16RSCLPR06**	.630	.787	.433	7.87	–	1/8-27 NPT	-5.0	CP..060203	**MS1153**	T7
1098220	**A16RSCLPR09**	.630	.787	.433	7.87	.16	1/8-27 NPT	-4.0	CP..09T308	**MS1155**	T15
1098234	**A20SSCLPR09**	.787	.984	.512	9.84	.16	1/8-27 NPT	-2.0	CP..09T308	**MS1155**	T15
1886504	**A20SSCLPR06**	.787	.984	.512	9.84	–	1/8-27 NPT	-3.0	CP..060203	**MS1153**	T7
left hand											
1098160	**A08JSCLPL06**	.315	.433	.236	4.33	.09	–	-6.0	CP..060204	**MS1939**	T7
1098169	**A10KSCLPL06**	.390	.512	.276	4.92	.13	–	-4.0	CP..060204	**MS1939**	T7
1098179	**A12MSCLPL06**	.472	.630	.354	5.91	.16	1/16-27 NPT	-3.0	CP..060204	**MS1153**	T7
1886501	**A16RSCLPL06**	.630	.787	.433	7.87	–	1/8-27 NPT	-5.0	CP..060203	**MS1153**	T7
1098226	**A16RSCLPL09**	.630	.787	.433	7.87	.16	1/8-27 NPT	-4.0	CP..09T308	**MS1155**	T15
1098240	**A20SSCLPL09**	.787	.984	.512	9.84	.16	1/8-27 NPT	-2.0	CP..09T308	**MS1155**	T15



Carbide shank with through coolant.

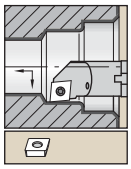




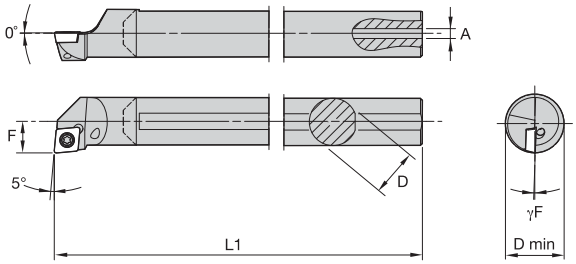
E-SCLP 95°



order number	catalogue number	D	D min	F	L1	A	γF°	gage insert	insert screw	Torx
right hand										
1152856	**E08KSCLPR06A**	8	11,0	6,0	122	2,4	-6.0	CP..060204	**MS1939**	T7
1152858	**E10MSCLPR06A**	10	13,0	7,0	150	3,2	-4.0	CP..060204	**MS1939**	T7
1152889	**E12QSCLPR06**	12	16,0	9,0	180	4,8	-3.0	CP..060204	**MS1153**	T7
1152897	**E16RSCLPR09**	16	20,0	11,0	200	5,5	-4.0	CP..09T308	**MS1155**	T15
1152902	**E20SSCLPR09**	20	25,0	13,0	250	7,1	-2.0	CP..09T308	**MS1155**	T15
left hand										
1152857	**E08KSCLPL06A**	8	11,0	6,0	122	2,4	-6.0	CP..060204	**MS1939**	T7
1152859	**E10MSCLPL06A**	10	13,0	7,0	150	3,2	-4.0	CP..060204	**MS1939**	T7
1152891	**E12QSCLPL06**	12	16,0	9,0	180	4,8	-3.0	CP..060204	**MS1153**	T7
1152899	**E16RSCLPL09**	16	20,0	11,0	200	5,5	-4.0	CP..09T308	**MS1155**	T15
1152905	**E20SSCLPL09**	20	25,0	13,0	250	7,1	-2.0	CP..09T308	**MS1155**	T15



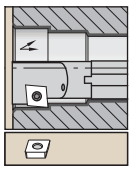
Heavy metal bar with through coolant.



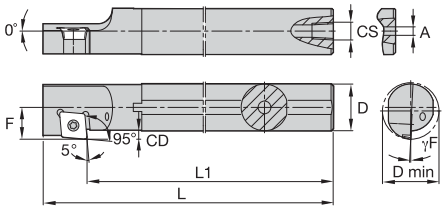
L-SCLP 95°



order number	catalogue number	D	D min	F	L1	A	γF°	gage insert	insert screw	Torx
right hand										
3331115	**L08KSCLPR06**	8	11,0	6,0	123	2,4	-6.0	CP..060204..	**MS1939**	T7
3331107	**L10MSCLPR06**	10	13,0	7,0	149	3,2	-4.0	CP..060204..	**MS1939**	T7
3331110	**L12QSCLPR06**	12	16,0	9,0	181	4,0	-3.0	CP..060204..	**MS1153**	T7
3331108	**L16RSCLPR09**	16	20,0	11,0	203	4,0	-4.0	CP..09T308..	**MS1155**	T15
3331106	**L20SSCLPR09**	20	25,0	13,0	251	4,0	-2.0	CP..09T308..	**MS1155**	T15
left hand										
3331112	**L12QSCLPL06**	12	16,0	9,0	181	4,0	-3.0	CP..060204..	**MS1153**	T7
3331114	**L16RSCLPL09**	16	20,0	11,0	203	4,0	-4.0	CP..09T308..	**MS1155**	T15
3331109	**L20SSCLPL09**	20	25,0	13,0	251	4,0	-2.0	CP..09T308..	**MS1155**	T15



Steel shank with through coolant.

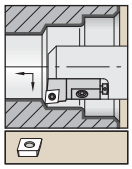


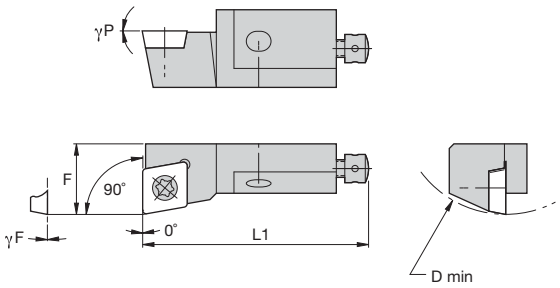


A-SCXP 95°



order number	catalogue number	D	D min	F	L1	L	A	CS	γF°	gage insert	insert screw	Torx
right hand												
1098167	**A10KSCXPR06**	10	13,0	7,0	125	136,0	3,2	–	-4.0	CP..060204	**MS1153**	T7
1098177	**A12MSCXPR06**	12	16,0	9,0	150	161,0	4,0	1/16-27 NPT	-3.0	CP..060204	**MS1153**	T7
1098223	**A16RSCXPR09**	16	20,0	11,0	200	218,0	4,0	1/8-27 NPT	-4.0	CP..09T308	**MS1155**	T15





SCFP 90°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098551	**SCFPR06CA05**	20	8,0	25	0.0	0.0	CP..050204/CP..18151
1082671	**SCFPR08CA06**	25	10,0	32	0.0	0.0	CP..060204/CP..2151
1797235	**SCFPR10CA09**	40	14,0	50	0.0	0.0	CP..09T308/CP..3252
left hand							
1098766	**SCFPL08CA06**	25	10,0	32	0.0	0.0	CP..060204/CP..2151

NOTE: ANSI/ISO compatible 60° countersunk hole inserts.
This tool also accepts CPGM/CPGT/CPGW-21.5_ inserts.

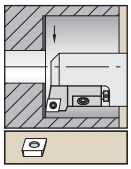
Spare Parts

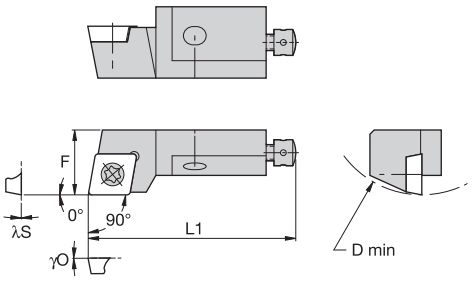






D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
20	**MS1933**	T7	**KUAM34**	1.5 mm	**KUAM35**	**MS2173**	2 mm	**CSWM 035 040**
25	**MS1153**	T7	**KUAM34**	1.5 mm	**KUAM20**	**MS2175**	2.5 mm	**CSWM 040 050**
40	**MS1155**	T15	**KUAM28**	2 mm	**KUAM30**	**191.405**	4 mm	**CSWM 060 050**





SCGP 90°

order number	catalogue number	D min	F	L1	λS°	γO°	gage insert
right hand							
1098554	**SCGPR08CA06**	25	10,0	32	0.0	0.0	CP..060204/CP..2151

NOTE: ANSI/ISO compatible 60° countersunk hole inserts.
This tool also accepts CPGM/CPGT/CPGW-21.5_ inserts.

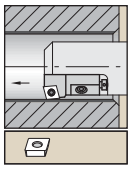
Spare Parts

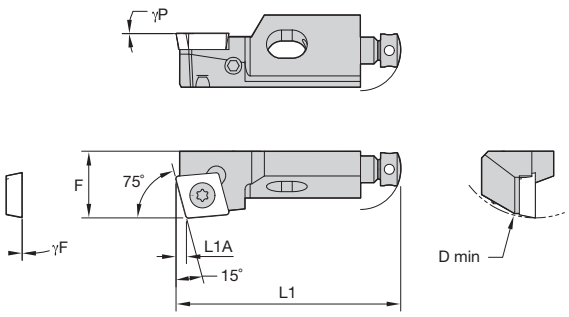






D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
25	**MS1153**	T7	**KUAM34**	1.5 mm	**KUAM20**	**MS2175**	2.5 mm	**CSWM 040 050**





SCKP 75°

order number	catalogue number	D min	F	L1	L1A	γF°	γP°	gage insert
right hand								
1098552	**SCKPR08CA06**	25	10,0	32	1,6	0.0	0.0	CP..060204/CP..2151
left hand								
1098763	**SCKPL08CA06**	25	10,0	32	1,6	0.0	0.0	CP..060204/CP..2151

NOTE: ANSI/ISO compatible 60° countersunk hole inserts.
This tool also accepts CPGM/CPGT/CPGW-21.5_ inserts.

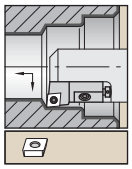
Spare Parts

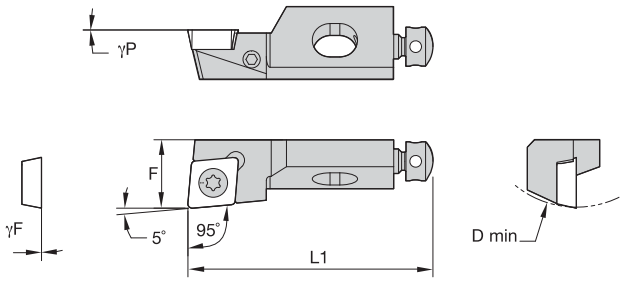






D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
25	**MS1153**	T7	**KUAM34**	1.5 mm	**KUAM20**	**MS2175**	2.5 mm	**CSWM 040 050**





SCLP 95°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098541	**SCLPR06CA05**	20	8,0	25	0.0	0.0	CP..050204/CP..18151
1098542	**SCLPR08CA06**	25	10,0	32	0.0	0.0	CP..060204/CP..2151
1098543	**SCLPR10CA09**	40	14,0	50	0.0	0.0	CP..09T308/CP..3252
left hand							
1098730	**SCLPL08CA06**	25	10,0	32	0.0	0.0	CP..060204/CP..2151
1098731	**SCLPL10CA09**	40	14,0	50	0.0	0.0	CP..09T308/CP..3252

NOTE: ANSI/ISO compatible 60° countersunk hole inserts. This tool also accepts CPGM/CPGT/CPGW-21.5_ inserts.
ANSI/ISO compatible 60° countersunk hole inserts (i.e., CPMT/CPGT/CPGW-32.5_). 90° countersunk hole inserts (i.e., CPGM/CPGB-32.5_) do not fit this tool.

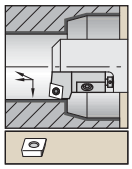
Spare Parts

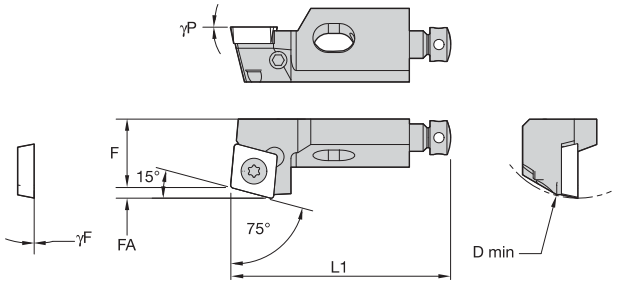






D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
20	**MS1933**	T7	**KUAM34**	1.5 mm	**KUAM35**	**MS2173**	2 mm	**CSWM 035 040**
25	**MS1153**	T7	**KUAM34**	1.5 mm	**KUAM20**	**MS2175**	2.5 mm	**CSWM 040 050**
40	**MS1155**	T15	**KUAM28**	2 mm	**KUAM30**	**191.405**	4 mm	**CSWM 060 050**





SCRP 75°

order number	catalogue number	D min	F	L1	FA	γF°	γP°	gage insert
right hand								
1098555	**SCRPR08CA06**	25	10,0	32	1,5	0.0	0.0	CP..060204/CP..2151

NOTE: ANSI/ISO compatible 60° countersunk hole inserts.
This tool also accepts CPGM/CPGT/CPGW-21.5_ inserts.

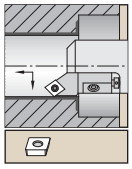
Spare Parts

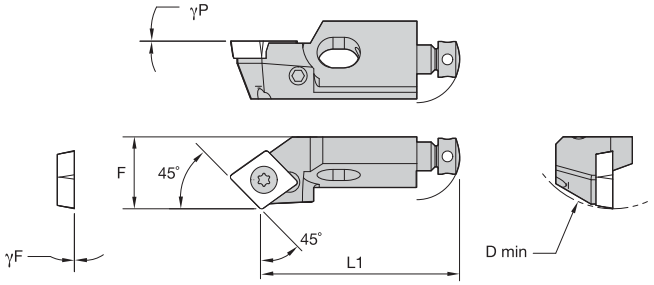






D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
25	**MS1153**	T7	**KUAM34**	1.5 mm	**KUAM20**	**MS2175**	2.5 mm	**CSWM 040 050**





SCSP 45°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098328	**SCSPR06CA05**	20	8,0	21	0.0	0.0	CP..050204/CP..18151
1086536	**SCSPR08CA06**	25	10,0	28	0.0	0.0	CP..060204/CP..2151
left hand							
1098548	**SCSPL06CA05**	20	8,0	21	0.0	0.0	CP..050204/CP..18151
1098549	**SCSPL08CA06**	25	10,0	28	0.0	0.0	CP..060204/CP..2151

NOTE: ANSI/ISO compatible 60° countersunk hole inserts.
This tool also accepts CPGM/CPGT/CPGW-21.5_ inserts.

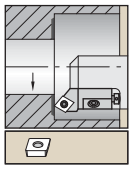
Spare Parts

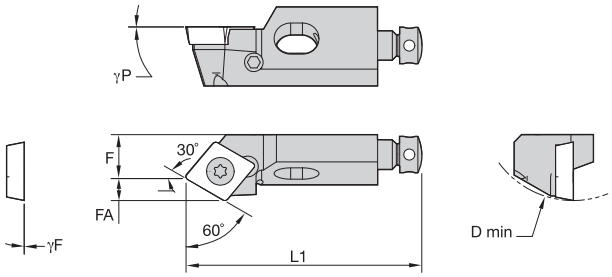






D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
20	**MS1933**	T7	**–**	–	**KUAM35**	**MS2173**	2 mm	**CSWM 035 040**
25	**MS1153**	T7	**KUAM34**	1.5 mm	**KUAM20**	**MS2175**	2.5 mm	**CSWM 040 050**





SCTP 60°

order number	catalogue number	D min	F	L1	FA	γF°	γP°	gage insert
right hand								
1098556	**SCTPR06CA05**	20	5,5	25	2,6	0.0	0.0	CP..050204/CP..18151
1098557	**SCTPR08CA06**	25	6,0	32	3,0	0.0	0.0	CP..060204/CP..2151
left hand								
1098736	**SCTPL08CA06**	25	6,0	32	3,0	0.0	0.0	CP..060204/CP..2151

NOTE: ANSI/ISO compatible 60° countersunk hole inserts.
This tool also accepts CPGM/CPGT/CPGW-21.5_ inserts.

Spare Parts

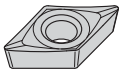


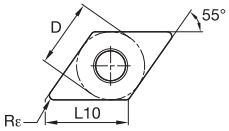




D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
20	**MS1933**	T7	**–**	–	**KUAM35**	**MS2173**	2 mm	**CSWM 035 040**
25	**MS1153**	T7	**KUAM34**	1.5 mm	**KUAM20**	**MS2175**	2.5 mm	**CSWM 040 050**

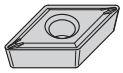
● first choice
○ alternate choice

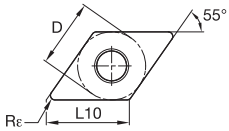




DCGT-HP

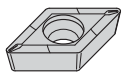
	P	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●		
	M							○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●		
	K	○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●		
	N																			●	●	●		●	●	●	●	●				
	S																			●	●	●	●	●	●	●	●					
	H																															
ISO catalogue number		KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DCGT070202HP	6,35	7,75	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	●	–	–
DCGT070204HP	6,35	7,75	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	●	–	–
DCGT070208HP	6,35	7,75	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–
DCGT11T302HP	9,53	11,63	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	●	–	–
DCGT11T304HP	9,53	11,63	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	●	–	–
DCGT11T308HP	9,53	11,63	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	●	–	–

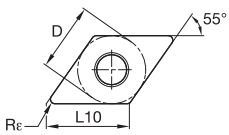




DCGT-LF

ISO catalogue number		KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DCGT0702X0LF	6,35	7,75	0,0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
DCGT070201LF	6,35	7,75	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–	–
DCGT11T3X0LF	9,53	11,63	0,0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
DCGT11T301LF	9,53	11,63	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–	–
DCGT150408LF	12,70	15,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–



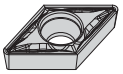


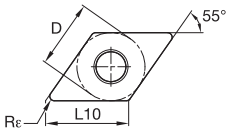
DCMT-11

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DCMT07020211	6,35	7,75	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–
DCMT07020411	6,35	7,75	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–
DCMT11T30411	9,53	11,63	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–
DCMT11T30811	9,53	11,63	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–

● first choice
○ alternate choice

		KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P		●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M								○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K		○	○	○	○	○		●	●	●	●	●	●							●	●	●		●	●	●	●		●	●
N																				●	●	●		●	●	●	●	●		
S																				●	●	●	●	●	●	●	●			
H																														

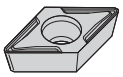


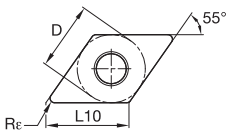


DCMT-FP

ISO catalogue number	D	L10	Rε
DCMT070202FP	6,35	7,75	0,2
DCMT070204FP	6,35	7,75	0,4
DCMT070208FP	6,35	7,75	0,8
DCMT11T302FP	9,53	11,63	0,2
DCMT11T304FP	9,53	11,63	0,4
DCMT11T308FP	9,53	11,63	0,8
DCMT11T312FP	9,53	11,63	1,2
DCMT150404FP	12,70	15,50	0,4
DCMT150408FP	12,70	15,50	0,8

ISO catalogue number	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DCMT070202FP	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	●
DCMT070204FP	–	–	●	–	●	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–	–	●	●	–	–	–	–	–
DCMT070208FP	●	–	–	●	●	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	●	–	–	–	–	–	–
DCMT11T302FP	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	●	●	–	–	–	–	●
DCMT11T304FP	●	●	●	●	●	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–	–	●	●	–	–	–	–	●
DCMT11T308FP	●	●	●	–	●	–	–	–	–	–	–	●	–	–	●	●	●	–	–	–	–	–	●	●	–	–	–	–	●
DCMT11T312FP	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT150404FP	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
DCMT150408FP	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–

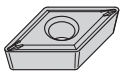


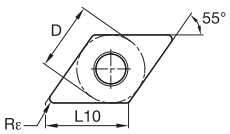


DCMT-FW

ISO catalogue number	D	L10	Rε
DCMT11T304FW	9,53	11,63	0,2
DCMT11T308FW	9,53	11,63	0,8

ISO catalogue number	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DCMT11T304FW	–	–	–	–	●	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–
DCMT11T308FW	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●	–



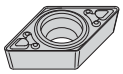


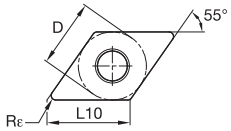
DCMT-LF

ISO catalogue number	D	L10	Rε
DCMT070202LF	6,35	7,75	0,2
DCMT070204LF	6,35	7,75	0,4
DCMT11T302LF	9,53	11,63	0,2
DCMT11T304LF	9,53	11,63	0,4
DCMT11T308LF	9,53	11,63	0,8
DCMT11T312LF	9,53	11,63	1,2
DCMT150404LF	12,70	15,50	0,4
DCMT150408LF	12,70	15,50	0,8

ISO catalogue number	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DCMT070202LF	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●	●	–	–	–
DCMT070204LF	–	●	●	●	●	●	–	–	–	●	–	–	●	●	●	●	●	●	–	●	–	–	–	–	●	●	–	●	–
DCMT11T302LF	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–
DCMT11T304LF	●	●	●	●	●	●	–	–	●	–	●	●	●	●	●	●	●	–	–	●	–	–	–	–	●	●	–	●	–
DCMT11T308LF	–	●	●	●	●	–	–	–	●	●	●	●	●	●	●	●	●	–	–	●	–	–	●	–	●	●	–	●	–
DCMT11T312LF	–	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
DCMT150404LF	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–
DCMT150408LF	–	●	●	●	●	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–

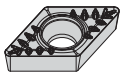
● first choice
○ alternate choice

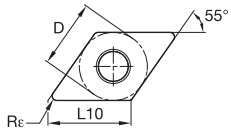




DCMT-MF

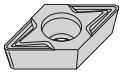
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
DCMT11T304MF	9,53	11,63	0,4	–	●	●	●	●	●	–	–	–	–	●	–	●	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–
DCMT11T308MF	9,53	11,63	0,8	–	●	●	●	●	●	–	–	–	–	●	–	●	●	●	–	●	●	–	–	–	–	–	–	–	–	–	–
DCMT11T312MF	9,53	11,63	1,2	–	●	●	●	–	–	–	–	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

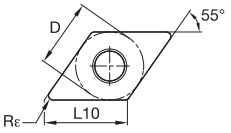




DCMT-MP

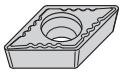
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DCMT11T304MP	9,53	11,63	0,4	–	–	●	–	●	–	–	–	–	–	–	●	●	–	●	●	●	–	–	–	–	–	●	–	–	–	–	–	–
DCMT11T308MP	9,53	11,63	0,8	–	–	●	–	●	–	–	–	–	–	–	●	●	–	●	●	●	–	–	–	–	–	●	–	–	–	–	–	–
DCMT11T312MP	9,53	11,63	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

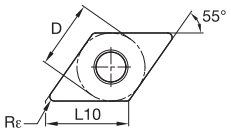




DCMT-MW

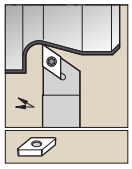
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DCMT11T304MW	9,53	11,63	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
DCMT11T308MW	9,53	11,63	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

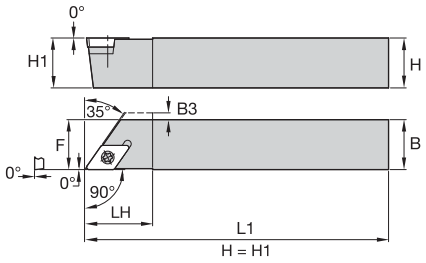


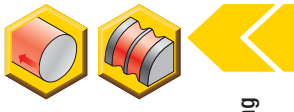


DCMT-UF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DCMT070204UF	6,35	7,75	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
DCMT11T302UF	9,53	11,63	0,2	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
DCMT11T304UF	9,53	11,63	0,4	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
DCMT11T308UF	9,53	11,63	0,8	●	●	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–





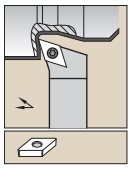


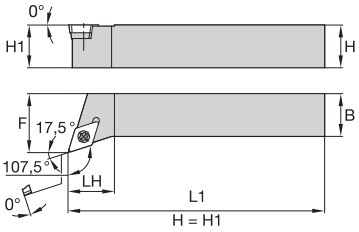
SDAC 90°

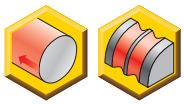




order number	catalogue number	H	B	F	L1	LH	B3	gage insert	shim	shim screw	hex	insert screw	Torx
right hand													
1772159	**SDACR1212M11Q**	12	12	12,0	150	22,0	1,5	DC..11T308	–	–	–	**MS1155**	T15
1097720	**SDACR1616K11Q**	16	16	16,0	125	22,0	–	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
left hand													
1772160	**SDACL1212M11Q**	12	12	12,0	150	22,0	1,5	DC..11T308	–	–	–	**MS1155**	T15





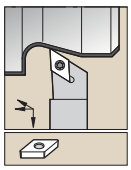


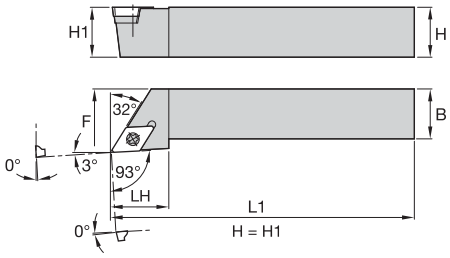
SDHC 107,5°

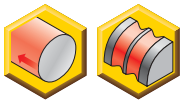




order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	insert screw	Torx
right hand												
1097841	**SDHCR1616H11**	16	16	20,0	100	20,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097989	**SDHCR2020K11**	20	20	25,0	125	20,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1130381	**SDHCR2525M11**	25	25	32,0	150	20,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097843	**SDHCR2525M15**	25	25	32,0	150	25,0	DC..150408	**SKDP453**	**SRS4**	4 mm	**MS1158**	T15
left hand												
1097986	**SDHCL1616H11**	16	16	20,0	100	20,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097930	**SDHCL2020K11**	20	20	25,0	125	20,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1124630	**SDHCL2525M11**	25	25	32,0	150	20,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097988	**SDHCL2525M15**	25	25	32,0	150	25,0	DC..150408	**SKDP453**	**SRS4**	4 mm	**MS1158**	T15





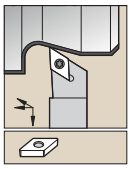


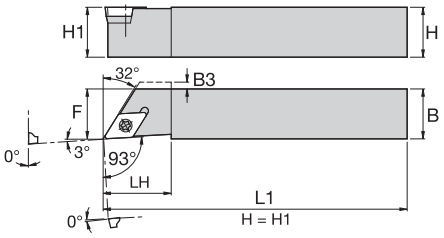
SDJC 93°





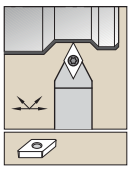
order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	insert screw	Torx
right hand												
1097847	**SDJCR0808L07**	8	8	10,0	140	16,0	DC..070204	–	–	–	**MS1153**	T7
1097848	**SDJCR1010M07**	10	10	12,0	150	16,0	DC..070204	–	–	–	**MS1153**	T7
1097849	**SDJCR1212N07**	12	12	16,0	160	16,0	DC..070204	–	–	–	**MS1153**	T7
1097850	**SDJCR1212N11**	12	12	16,0	160	22,0	DC..11T308	–	–	–	**MS1155**	T15
1244972	**SDJCR1616H07**	16	16	20,0	100	16,0	DC..070204	–	–	–	**MS1153**	T7
1097851	**SDJCR1616H11**	16	16	20,0	100	22,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1244974	**SDJCR2020K07**	20	20	25,0	125	16,0	DC..070204	–	–	–	**MS1153**	T7
1097853	**SDJCR2020K11**	20	20	25,0	125	22,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097852	**SDJCR2020K15**	20	20	25,0	125	32,0	DC..150408	**SKDP453**	**SRS4**	4 mm	**MS1158**	T15
1097854	**SDJCR2525M11**	25	25	32,0	150	22,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097855	**SDJCR2525M15**	25	25	32,0	150	32,0	DC..150408	**SKDP453**	**SRS4**	4 mm	**MS1158**	T15
left hand												
1097997	**SDJCL0808L07**	8	8	10,0	140	16,0	DC..070204	–	–	–	**MS1153**	T7
1097998	**SDJCL1010M07**	10	10	12,0	150	16,0	DC..070204	–	–	–	**MS1153**	T7
1097999	**SDJCL1212N07**	12	12	16,0	160	16,0	DC..070204	–	–	–	**MS1153**	T7
1098000	**SDJCL1212N11**	12	12	16,0	160	22,0	DC..11T308	–	–	–	**MS1155**	T15
1244966	**SDJCL1616H07**	16	16	20,0	100	16,0	DC..070204	–	–	–	**MS1153**	T7
1098001	**SDJCL1616H11**	16	16	20,0	100	22,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1244968	**SDJCL2020K07**	20	20	25,0	125	16,0	DC..070204	–	–	–	**MS1153**	T7
1098003	**SDJCL2020K11**	20	20	25,0	125	22,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1192473	**SDJCL2525M11**	25	25	32,0	150	22,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1098004	**SDJCL2525M15**	25	25	32,0	150	32,0	DC..150408	**SKDP453**	**SRS4**	4 mm	**MS1158**	T15

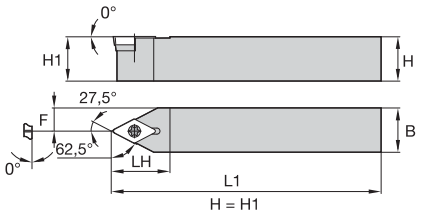




SDJC-F 93°

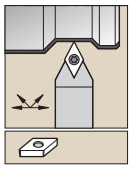
order number	catalogue number	H	B	F	L1	LH	B3	gage insert	shim	shim screw	hex	insert screw	Torx
right hand													
1772157	**SDJCRF0808M07Q**	8	8	8,0	150	16,0	1,5	DC..070204	–	–	–	**MS1153**	T7
1097844	**SDJCRF1010M07Q**	10	10	10,0	150	16,0	–	DC..070204	–	–	–	**MS1153**	T7
1097845	**SDJCRF1212M07Q**	12	12	12,0	150	16,0	–	DC..070204	–	–	–	**MS1153**	T7
1097846	**SDJCRF1616K11Q**	16	16	16,0	125	22,0	–	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
left hand													
1097996	**SDJCLF1616K11Q**	16	16	16,0	125	22,0	–	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15

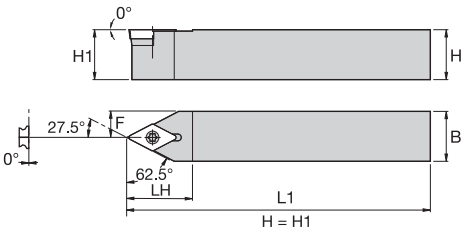


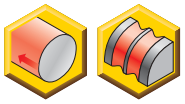


SDNC 62,5°

order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	insert screw	Torx
left hand												
1097856	**SDNCN0808L07**	8	8	4,0	140	16,0	DC..070204	–	–	–	**MS1153**	T7
1097857	**SDNCN1010M07**	10	10	5,0	150	16,0	DC..070204	–	–	–	**MS1153**	T7
1097858	**SDNCN1212N07**	12	12	6,0	160	16,0	DC..070204	–	–	–	**MS1153**	T7
1097859	**SDNCN1616H11**	16	16	8,0	100	22,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097861	**SDNCN2020K11**	20	20	10,0	125	22,0	DC..11T308	**SKDP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097860	**SDNCN2020K15**	20	20	10,0	125	28,0	DC..150408	**SKDP453**	**SRS4**	4 mm	**MS1158**	T15
1097862	**SDNCN2525M15**	25	25	12,5	150	28,0	DC..150408	**SKDP453**	**SRS4**	4 mm	**MS1158**	T15





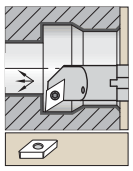


SDPC 62,5°

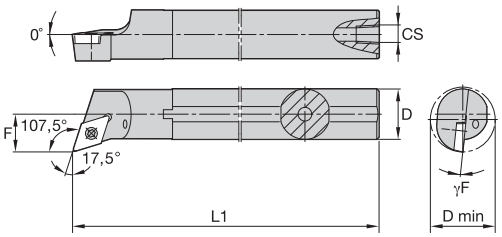


order number	catalogue number	H	B	F	L1	LH	gage insert	insert screw	Torx
1772173	**SDPCN1212M11Q**	12	12	6,0	150	22,0	DC..11T308	**MS1155**	T15

Screw-On Boring Bars



Steel shank with through coolant.

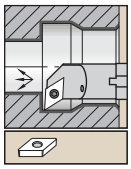




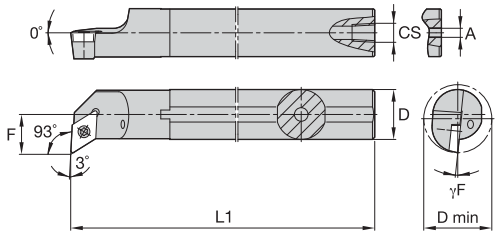
A-SDQC 107,5°



order number	catalogue number	D	D min	F	L1	CS	γF°	gage insert	insert screw	Torx
right hand										
1098188	**A12MSDQCR07**	12	16,0	9,0	150	1/16-27 NPT	-6.0	DC..070204	**MS1153**	T7
1098198	**A16RSDQCR07**	16	20,0	11,0	200	1/8-27 NPT	-5.0	DC..070204	**MS1153**	T7
1098147	**A20SSDQCR11**	20	25,0	13,0	250	1/8-27 NPT	-5.0	DC..11T308	**MS1155**	T15
1098260	**A25TSDQCR11**	25	32,0	17,0	300	1/4-18 NPT	-4.0	DC..11T308	**MS1155**	T15
left hand										
1098193	**A12MSDQCL07**	12	16,0	9,0	150	1/16-27 NPT	-6.0	DC..070204	**MS1153**	T7
1098203	**A16RSDQCL07**	16	20,0	11,0	200	1/8-27 NPT	-5.0	DC..070204	**MS1153**	T7
1098149	**A20SSDQCL11**	20	25,0	13,0	250	1/8-27 NPT	-5.0	DC..11T308	**MS1155**	T15
1098264	**A25TSDQCL11**	25	32,0	17,0	300	1/4-18 NPT	-4.0	DC..11T308	**MS1155**	T15



Steel shank with through coolant.



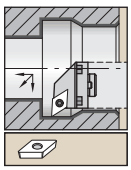


A-SDUC 93°

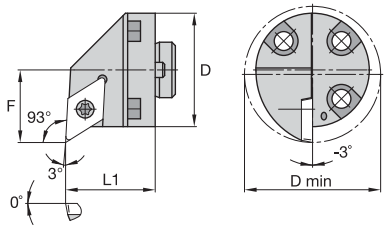


order number	catalogue number	D	D min	F	L1	A	CS	γF°	gage insert	shim	shim screw	hex	insert screw	Torx
right hand														
1886506	**A10KSDUCR07**	10	13,0	7,0	125	3,2	–	-7.0	DC..070204	–	–	–	**MS1153**	T7
1098187	**A12MSDUCR07**	12	16,0	9,0	150	–	1/16-27 NPT	-4.0	DC..070204	–	–	–	**MS1153**	T7
1098197	**A16RSDUCR07**	16	20,0	11,0	200	–	1/8-27 NPT	-4.0	DC..070204	–	–	–	**MS1153**	T7
1886508	**A16RSDUCR11**	16	20,0	11,0	200	–	1/8-27 NPT	-6.0	DC..11T308	–	–	–	**MS1155**	T15
1098146	**A20SSDUCR11**	20	25,0	13,0	250	–	1/8-27 NPT	-5.0	DC..11T308	–	–	–	**MS1155**	T15
1098259	**A25TSDUCR11**	25	32,0	17,0	300	–	1/4-18 NPT	-4.0	DC..11T308	–	–	–	**MS1155**	T15
1098283	**A32TSDUCR15**	32	40,0	22,0	300	–	1/4-18 NPT	-7.0	DC..150408	**SKDP453**	**SRS4**	4 mm	**MS1158**	T15
left hand														
1886505	**A10KSDUCL07**	10	13,0	7,0	125	3,2	–	-7.0	DC..070204	–	–	–	**MS1153**	T7
1098192	**A12MSDUCL07**	12	16,0	9,0	150	–	1/16-27 NPT	-4.0	DC..070204	–	–	–	**MS1153**	T7
1098202	**A16RSDUCL07**	16	20,0	11,0	200	–	1/8-27 NPT	-4.0	DC..070204	–	–	–	**MS1153**	T7
1886507	**A16RSDUCL11**	16	20,0	11,0	200	–	1/8-27 NPT	-6.0	DC..11T308	–	–	–	**MS1155**	T15
1098148	**A20SSDUCL11**	20	25,0	13,0	250	–	1/8-27 NPT	-5.0	DC..11T308	–	–	–	**MS1155**	T15
1098263	**A25TSDUCL11**	25	32,0	17,0	300	–	1/4-18 NPT	-4.0	DC..11T308	–	–	–	**MS1155**	T15
1098284	**A32TSDUCL15**	32	40,0	22,0	300	–	1/4-18 NPT	-7.0	DC..150408	**SKDP453**	**SRS4**	4 mm	**MS1158**	T15

Screw-On Boring Heads



With through coolant.

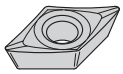


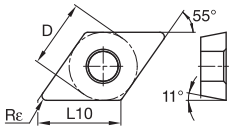
H-SDUC 93°



order number	catalogue number	D	D min	F	L1	gage insert	insert screw	Torx
right hand								
1772255	**H25SDUCR11**	25	32,0	17,0	20	DC..11T308	**MS1155**	T15
1772257	**H32SDUCR11**	32	40,0	22,0	25	DC..11T308	**MS1155**	T15
3612136	**H40SDUCR11**	40	50,0	27,0	41	DC..11T308	**MS1156**	T15
3612138	**H50SDUCR11**	50	63,0	35,0	41	DC..11T308	**MS1156**	T15
left hand								
1772256	**H25SDUCL11**	25	32,0	17,0	20	DC..11T308	**MS1155**	T15
1772258	**H32SDUCL11**	32	40,0	22,0	25	DC..11T308	**MS1155**	T15
3612139	**H50SDUCL11**	50	63,0	35,0	41	DC..11T308	**MS1156**	T15

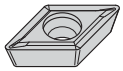
● first choice
○ alternate choice

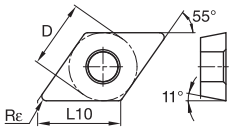




DPGT-HP

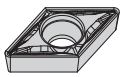
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
				P ●	P ●	P ●	P ●	P ●	P ●	P ●	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ○	P ●	P ●	P ●	P	P ●	P ●	P ●	P ●	P	P ●	P ●
				M	M	M	M	M	M	M ○	M	M	M	M	M	M	M ●	M ●	M ●	M ●	M ●	M ●	M ●	M ●	M ●	M ●	M ●	M ●	M ●	M	M ●	M ●
				K ○	K ○	K ○	K ○	K ○	K	K	K ●	K ●	K ●	K ●	K ●	K ●	K	K	K	K	K	K ●	K ●	K ●	K	K ●	K ●	K ●	K ●	K	K ●	K ●
				N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N ●	N ●	N ●	N	N ●	N ●	N ●	N ●	N	N	N
				S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S	S ●	S ●	S ●	S ●	S ●	S ●	S ●	S	S	S	S
				H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H	H
DPGT070202HP	6,35	7,75	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
DPGT070204HP	6,35	7,75	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	–	–
DPGT070208HP	6,35	7,75	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–
DPGT11T304HP	9,53	11,63	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	–	●	–	–
DPGT11T308HP	9,53	11,63	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–

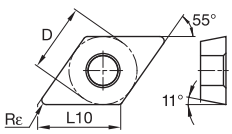




DPGT-LF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DPGT070201LF	6,35	7,75	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
DPGT070202LF	6,35	7,75	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–
DPGT070204LF	6,35	7,75	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–
DPGT11T301LF	9,53	11,63	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
DPGT11T302LF	9,53	11,63	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–
DPGT11T304LF	9,53	11,63	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–
DPGT11T308LF	9,53	11,63	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–

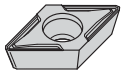


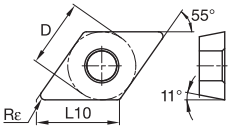


DPMT-FP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DPMT070202FP	6,35	7,75	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
DPMT070204FP	6,35	7,75	0,4	–	–	●	–	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	●	●	–	–	–	–	●
DPMT070208FP	6,35	7,75	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
DPMT11T304FP	9,53	11,63	0,4	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
DPMT11T308FP	9,53	11,63	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●

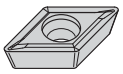
● first choice
○ alternate choice

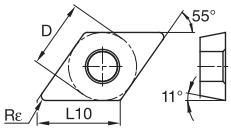




DPMT-FW

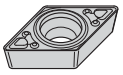
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
				P																												
				M																												
				K																												
				N																												
				S																												
				H																												
DPMT070204FW	6,35	7,75	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DPMT070208FW	6,35	7,75	0,8	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

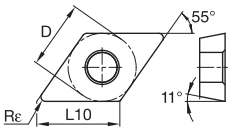




DPMT-LF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DPMT070202LF	6,35	7,75	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–
DPMT070204LF	6,35	7,75	0,4	–	●	●	●	●	–	–	–	●	–	–	–	●	–	–	–	●	–	–	–	–	–	–	–	●	●	–	●	–
DPMT11T302LF	9,53	11,63	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
DPMT11T304LF	9,53	11,63	0,4	–	●	●	●	●	–	–	–	●	–	–	–	●	–	–	–	●	–	–	–	–	–	–	–	●	●	–	●	–
DPMT11T308LF	9,53	11,63	0,8	–	●	●	●	●	–	–	–	–	–	–	–	●	–	–	–	●	–	–	–	–	–	–	–	●	●	–	–	–

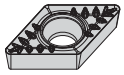


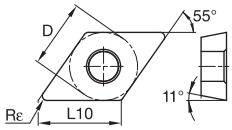


DPMT-MF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DPMT11T308MF	9,53	11,63	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–

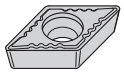
● first choice
○ alternate choice

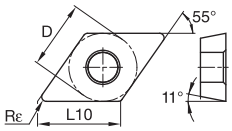




DPMT-MP

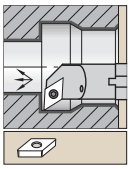
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DPMT11T308MP	9,53	11,63	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–



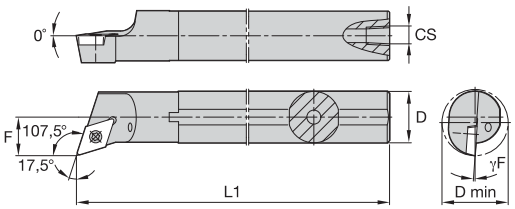


DPMT-UF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
DPMT070204UF	6,35	7,75	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
DPMT11T304UF	9,53	11,63	0,4	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DPMT11T308UF	9,53	11,63	0,8	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



Steel shank with through coolant.

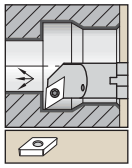




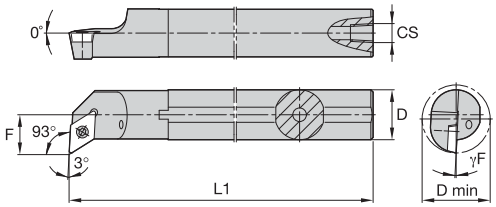
A-SDQP 107,5°



order number	catalogue number	D	D min	F	L1	CS	γF°	gage insert	insert screw	Torx
right hand										
1098186	**A12MSDQPR07**	12	16,0	9,0	150	1/16-27 NPT	-2.0	DP..070204	**MS1153**	T7
1098196	**A16RSDQPR07**	16	20,0	11,0	200	1/8-27 NPT	0.0	DP..070204	**MS1153**	T7
1098247	**A20SSDQPR11**	20	25,0	13,0	250	1/8-27 NPT	-2.0	DP..11T308	**MS1155**	T15
1098258	**A25TSDQPR11**	25	32,0	17,0	300	1/4-18 NPT	0.0	DP..11T308	**MS1155**	T15
left hand										
1098191	**A12MSDQPL07**	12	16,0	9,0	150	1/16-27 NPT	-2.0	DP..070204	**MS1153**	T7
1098201	**A16RSDQPL07**	16	20,0	11,0	200	1/8-27 NPT	0.0	DP..070204	**MS1153**	T7
1098252	**A20SSDQPL11**	20	25,0	13,0	250	1/8-27 NPT	-2.0	DP..11T308	**MS1155**	T15
1098262	**A25TSDQPL11**	25	32,0	17,0	300	1/4-18 NPT	0.0	DP..11T308	**MS1155**	T15



Steel shank with through coolant.

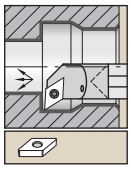




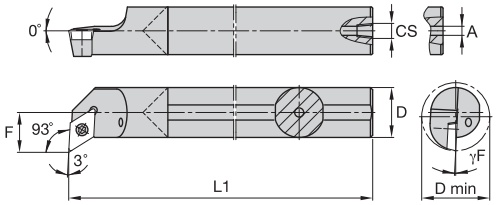
A-SDUP 93°



order number	catalogue number	D	D min	F	L1	CS	γF°	gage insert	insert screw	Torx
right hand										
1098184	**A12MSDUPR07**	12	16,0	9,0	150	1/16-27 NPT	-2.0	DP..070204	**MS1153**	T7
1098194	**A16RSDUPR07**	16	20,0	11,0	200	1/8-27 NPT	0.0	DP..070204	**MS1153**	T7
1098245	**A20SSDUPR11**	20	25,0	13,0	250	1/8-27 NPT	-2.0	DP..11T308	**MS1155**	T15
1098257	**A25TSDUPR11**	25	32,0	17,0	300	1/4-18 NPT	0.0	DP..11T308	**MS1155**	T15
left hand										
1098189	**A12MSDUPL07**	12	16,0	9,0	150	1/16-27 NPT	-2.0	DP..070204	**MS1153**	T7
1098199	**A16RSDUPL07**	16	20,0	11,0	200	1/8-27 NPT	0.0	DP..070204	**MS1153**	T7
1098250	**A20SSDUPL11**	20	25,0	13,0	250	1/8-27 NPT	-2.0	DP..11T308	**MS1155**	T15



Carbide shank with through coolant.

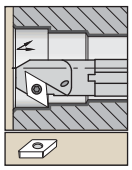




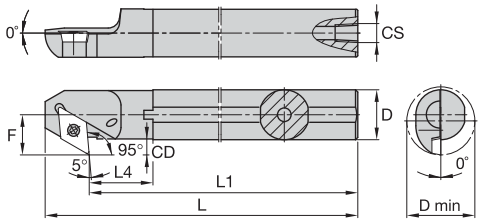
E-SDUP 93°



order number	catalogue number	D	D min	F	L1	A	γF°	gage insert	insert screw	Torx
right hand										
1152892	**E12QSDUPR07**	12	16,0	9,0	180	4,8	-2.0	DP..070204	**MS1153**	T7
1152894	**E16RSDUPR07**	16	20,0	11,0	200	5,5	0.0	DP..070204	**MS1153**	T7
1152906	**E20SSDUPR11**	20	25,0	13,0	250	7,1	-2.0	DP..11T308	**MS1155**	T15
left hand										
1152893	**E12QSDUPL07**	12	16,0	9,0	180	4,8	-2.0	DP..070204	**MS1153**	T7
1152895	**E16RSDUPL07**	16	20,0	11,0	200	5,5	0.0	DP..070204	**MS1153**	T7
1152907	**E20SSDUPL11**	20	25,0	13,0	250	7,1	-2.0	DP..11T308	**MS1155**	T15



Steel shank with through coolant.

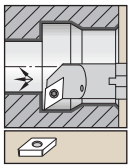




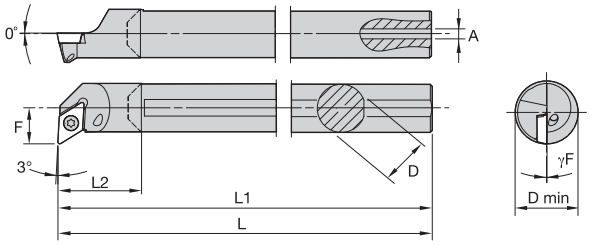
A-SDXP 95°



order number	catalogue number	D	D min	F	L1	L	L4	CD	CS	gage insert	insert screw	Torx
right hand												
1098185	**A12MSDXPR07**	12	16,0	9,0	150	162,0	–	3,09	1/16-27 NPT	DP..070204	**MS1153**	T7
1098195	**A16RSDXPR07**	16	20,0	11,0	200	212,0	–	3,20	1/8-27 NPT	DP..070204	**MS1153**	T7
1098246	**A20SSDXPR11**	20	25,0	13,0	250	270,0	48,44	4,31	1/8-27 NPT	DP..11T308	**MS1155**	T15
left hand												
1098190	**A12MSDXPL07**	12	16,0	9,0	150	162,0	–	3,09	1/16-27 NPT	DP..070204	**MS1153**	T7
1098200	**A16RSDXPL07**	16	20,0	11,0	200	212,0	–	3,20	1/8-27 NPT	DP..070204	**MS1153**	T7
1098251	**A20SSDXPL11**	20	25,0	13,0	250	270,0	48,44	4,31	1/8-27 NPT	DP..11T308	**MS1155**	T15



Heavy metal bar with through coolant.

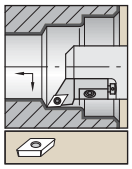


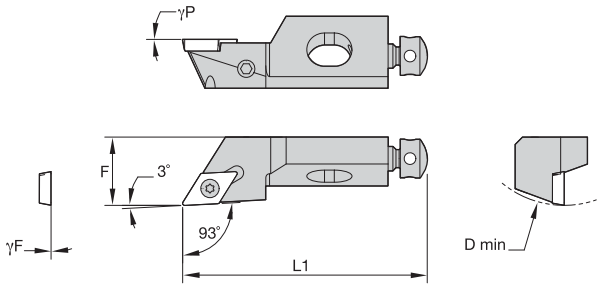


L-SDUP 93°



order number	catalogue number	D	D min	F	L1	L	L2	A	γF°	gage insert	insert screw	Torx
right hand												
3331116	**L12QSDUPR07**	12	16,0	9,0	181	181,2	22,4	4,0	-2.0	DP..070204..	**MS1153**	T7
3331117	**L20SSDUPR11**	20	25,0	13,0	251	251,5	33,6	4,0	-2.0	DP..11T308..	**MS1155**	T15
left hand												
3331121	**L12QSDUPL07**	12	16,0	9,0	181	181,2	22,4	4,0	-2.0	DP..070204..	**MS1153**	T7





SDJP 93°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098757	**SDJPR10CA07**	40	14,0	50	0.0	0.0	DP..070204/DP..2151
left hand							
1098758	**SDJPL10CA07**	40	14,0	50	0.0	0.0	DP..070204/DP..2151

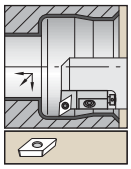
Spare Parts

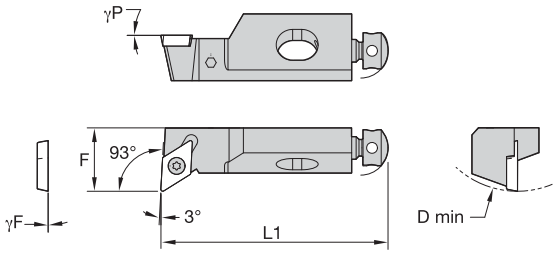






D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
40	**MS1153**	T7	**KUAM28**	2 mm	**KUAM30**	**191.405**	4 mm	**CSWM 060 050**





SDUP 93°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098728	**SDUPR10CA07**	40	14,0	50	0.0	0.0	DP..070204/DP..2151

Spare Parts

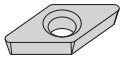


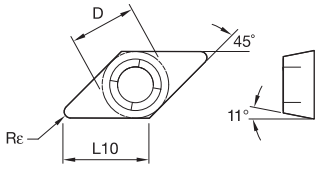




D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
40	**MS1153**	T7	**KUAM28**	2 mm	**KUAM30**	**191.405**	4 mm	**CSWM 060 050**

● first choice
○ alternate choice

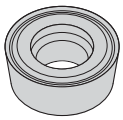


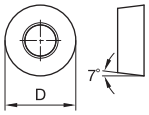


GPCD

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
GPCD050102	3,97	5,61	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–
GPCD050104	3,97	5,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

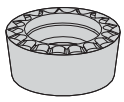
RCGH

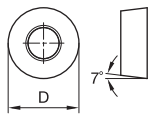




ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
RCGH120400	12,70	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–

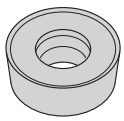
RCGH-MP

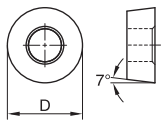




ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
RCGH120400MP	12,70	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–

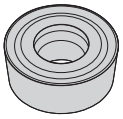
RCGT-HP

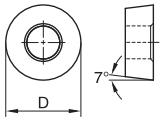




ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
RCGT0803M0HP	8,00	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	●	●	–	●	–	–
RCGT10T3M0HP	10,00	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	●	–	–
RCGT1204M0HP	12,00	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	●	●	–	–	–

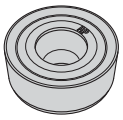
● first choice
○ alternate choice

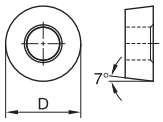




RCGT-MS

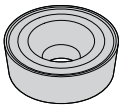
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
RCGT0803M0MS	8,00	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–
RCGT1204M0MS	12,00	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–
RCGT1606M0MS	16,00	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–

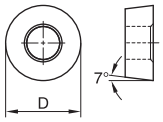




RCGT-RP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
RCGT0602M0RP	6,00	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCGT0803M0RP	8,00	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCGT1204M0RP	12,00	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

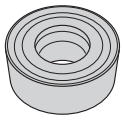


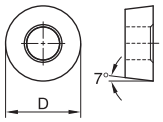


RCMH-K

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
RCMH190600K	19,05	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

● first choice
○ alternate choice

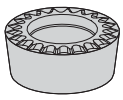


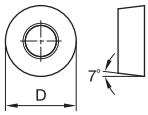


RCMT

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

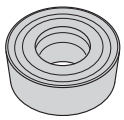
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
RCMT0602M0	6,00	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	–	●	–	●	–	–	–	–
RCMT060200	6,35	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–
RCMT0803M0	8,00	–	–	–	–	–	–	●	–	–	–	–	–	–	●	–	–	–	–	●	–	–	●	–	–	–	–	●	–	–	–	–
RCMT09T300	9,53	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	●	–	–	–	–
RCMT10T3M0	10,00	–	–	–	–	–	–	●	●	–	–	–	–	–	●	–	–	–	–	●	–	–	–	–	–	●	–	●	–	–	–	–
RCMT1204M0	12,00	–	–	–	–	–	–	–	●	–	–	–	●	–	●	●	–	–	–	●	–	–	●	–	–	●	–	●	–	–	–	–
RCMT120400	12,70	–	–	–	●	–	–	–	–	–	–	–	–	–	–	●	–	–	–	●	–	–	–	–	–	–	–	●	–	–	–	–
RCMT1605M0	16,00	–	–	–	–	–	–	●	–	–	–	–	–	–	–	●	–	–	–	●	–	–	●	–	–	●	–	●	–	–	–	–
RCMT2006M0	20,00	–	–	–	–	–	–	●	–	–	–	–	–	–	●	–	–	–	–	●	–	–	●	–	–	●	–	●	–	–	–	–

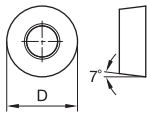




RCMT-MP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
RCMT0803M0MP	8,00	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–
RCMT10T3M0MP	10,00	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–
RCMT1204M0MP	12,00	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–
RCMT120400MP	12,70	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–
RCMT1606M0MP	16,00	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–

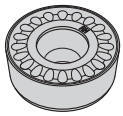


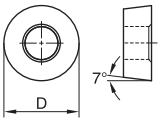


RCMT-M0

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
RCMT1204M0	12,00	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–

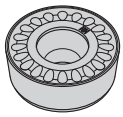
● first choice
○ alternate choice

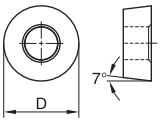




RCMT-RH

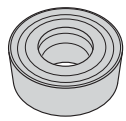
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
RCMT2006M0RH	20,00	—	—	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

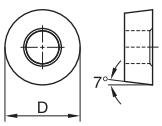




RCMX-RH

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
RCMX2507M0RH	25,00	—	—	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX3209M0RH	32,00	—	—	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

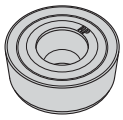


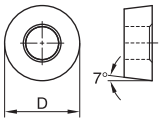


RCMT-RM

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
RCMT2006M0RM	20,00	—	—	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

● first choice
○ alternate choice

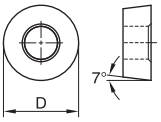




RCMT-RP

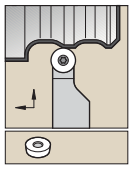
				KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
				P		●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
				M									○						●	●	●	●	●	●	●	●	●	●	●	●		●	●
				K		○	○	○	○	○	○			●	●	●	●	●						●	●	●		●	●	●	●		●	●
				N																			●	●	●		●	●	●	●	●		
				S																			●	●	●	●	●	●	●	●			
				H																													
ISO catalogue number	D	L10	Rε																														
RCMT1204M0RP	12,00	—	—	–	●	●	●	●	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMT1606M0RP	16,00	—	—	–	–	–	●	●	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMT2006M0RP	20,00	—	—	–	–	–	–	●	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

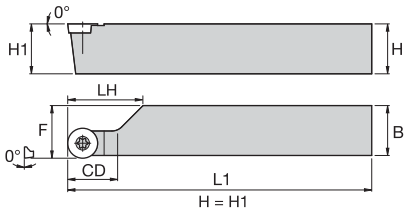




RCMX-RP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
RCMX1003M0RP	10,00	—	—	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX2507M0RP	25,00	—	—	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



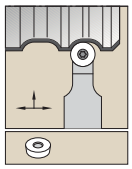


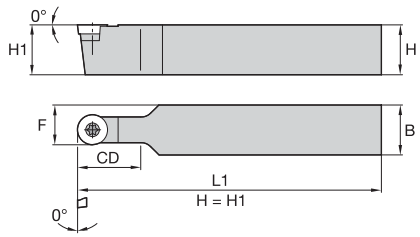


SRAC



order number	catalogue number	H	B	F	L1	LH	CD	gage insert	insert screw	Torx
right hand										
1097887	SRACR1212N08	12	12	13,0	160	31,0	12,0	RC..0803M0	MS1154	T9
1097888	SRACR1616Q08	16	16	17,0	180	35,0	16,0	RC..0803M0	MS1154	T9







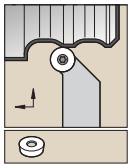
SRDC

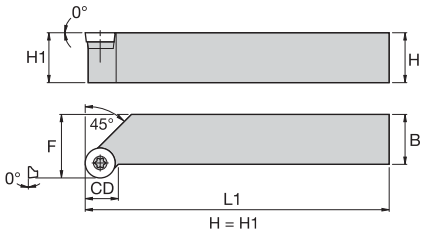






order number	catalogue number	H	B	F	L1	CD	gage insert	shim	shim screw	hex	insert screw	Torx
1097892	SRDCN1212N06	12	12	9,0	160	12,0	RC..0602M0	–	–	–	MS1153	T7
1097891	SRDCN1212N08	12	12	10,0	160	12,0	RC..0803M0	–	–	–	MS1154	T9
1097899	SRDCN1616H06	16	16	11,0	100	16,0	RC..0602M0	–	–	–	MS1153	T7
1097897	SRDCN1616H08	16	16	12,0	100	16,0	RC..0803M0	–	–	–	MS1154	T9
1097898	SRDCN1616H10	16	16	13,0	100	16,0	RC..10T3M0	SKRN100300	SRS3	3.5 mm	MS1156	T15
1097893	SRDCN1616Q08	16	16	12,0	180	16,0	RC..0803M0	–	–	–	MS1154	T9
1097900	SRDCN2020K08	20	20	14,0	125	20,0	RC..0803M0	–	–	–	MS1154	T9
1097901	SRDCN2020K10	20	20	15,0	125	20,0	RC..10T3M0	SKRN100300	SRS3	3.5 mm	MS1156	T15
1097894	SRDCN2020K12	20	20	16,0	125	20,0	RC..1204M0	SKRN1203M0	SRS3	3.5 mm	MS1156	T15
1097903	SRDCN2525M08	25	25	16,5	150	25,0	RC..0803M0	–	–	–	MS1154	T9
1097902	SRDCN2525M10	25	25	17,5	150	25,0	RC..10T3M0	SKRN100300	SRS3	3.5 mm	MS1156	T15
1097895	SRDCN2525M12	25	25	18,5	150	25,0	RC..1204M0	SKRN1203M0	SRS3	3.5 mm	MS1156	T15
1097896	SRDCN2525M16	25	25	20,5	150	25,0	RC..1605M0	SKRN160400	SRS5	4 mm	MS1160	T15





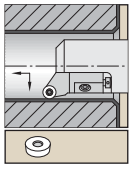


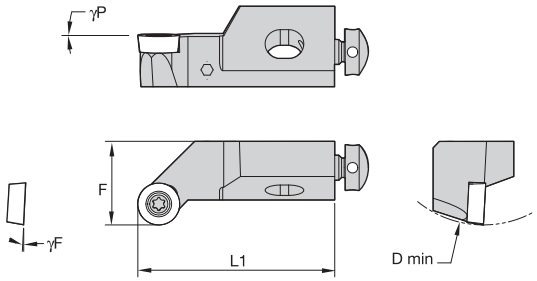
SRGC





order number	catalogue number	H	B	F	L1	CD	gage insert	shim	shim screw	hex	insert screw	Torx
right hand												
1097792	**SRGCR1616H06**	16	16	20,0	100	7,0	RC..0602M0	–	–	–	**MS1153**	T7
1097791	**SRGCR1616H10**	16	16	20,0	100	7,9	RC..10T3M0	**SKRN100300**	**SRS3**	3.5 mm	**MS1156**	T15
1097793	**SRGCR2020K08**	20	20	25,0	125	9,0	RC..0803M0	–	–	–	**MS1154**	T9
1097794	**SRGCR2020K10**	20	20	25,0	125	9,3	RC..10T3M0	**SKRN100300**	**SRS3**	3.5 mm	**MS1156**	T15
1097796	**SRGCR2525M08**	25	25	32,0	150	11,8	RC..0803M0	–	–	–	**MS1154**	T9
1097795	**SRGCR2525M10**	25	25	32,0	150	12,1	RC..10T3M0	**SKRN100300**	**SRS3**	3.5 mm	**MS1156**	T15
1097788	**SRGCR2525M12**	25	25	32,0	150	12,7	RC..1204M0	**SKRN1203M0**	**SRS3**	3.5 mm	**MS1156**	T15
left hand												
1097937	**SRGCL1616H06**	16	16	20,0	100	7,0	RC..0602M0	–	–	–	**MS1153**	T7
1097936	**SRGCL1616H10**	16	16	20,0	100	7,9	RC..10T3M0	**SKRN100300**	**SRS3**	3.5 mm	**MS1156**	T15
1097938	**SRGCL2020K08**	20	20	25,0	125	9,0	RC..0803M0	–	–	–	**MS1154**	T9
1097941	**SRGCL2525M08**	25	25	32,0	150	11,8	RC..0803M0	–	–	–	**MS1154**	T9
1097940	**SRGCL2525M10**	25	25	32,0	150	12,1	RC..10T3M0	**SKRN100300**	**SRS3**	3.5 mm	**MS1156**	T15
1097933	**SRGCL2525M12**	25	25	32,0	150	12,7	RC..1204M0	**SKRN1203M0**	**SRS3**	3.5 mm	**MS1156**	T15





SRGC

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098711	**SRGCR08CA06**	25	10,0	32	-4.0	0.0	RC..0602M0/RC..215
1098713	**SRGCR12CA10**	50	20,0	55	-3.0	0.0	RC..10T3M0/RC..10T3M0

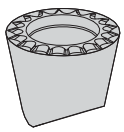
Spare Parts

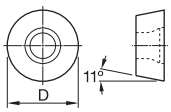


D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	hex	washer
25	**MS1153**	T7	**KUAM34**	1.5 mm	**KUAM20**	**MS2175**	**–**	2.5 mm	**CSWM 040 050**
50	**MS1155**	T15	**KUAM23**	2.5 mm	**KUAM31**	**–**	**191.406**	4 mm	**CSWM 060 050**

ISO Carbide Inserts

● first choice
○ alternate choice





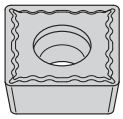
RPGT-MP

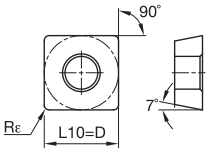
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
RPGT060400MP	6,35	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–

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

NOTE: For V-Bottom style holders, please see page B370.

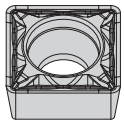
● first choice
○ alternate choice

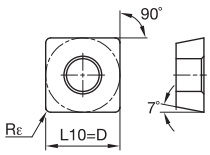




SCMT-11

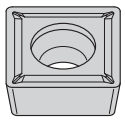
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
SCMT09T30411	9,53	9,53	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–
SCMT09T30811	9,53	9,53	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–
SCMT12040411	12,70	12,70	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–
SCMT12040811	12,70	12,70	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–

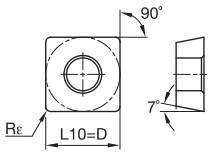




SCMT-FP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
SCMT09T304FP	9,53	9,53	0,4	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	●	–	–	–	–	–
SCMT09T308FP	9,53	9,53	0,8	–	–	●	●	●	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	●	●	–	–	–	–	●
SCMT120404FP	12,70	12,70	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
SCMT120408FP	12,70	12,70	0,8	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–
SCMT120412FP	12,70	12,70	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

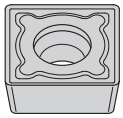


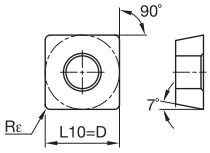


SCMT-LF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
SCMT09T304LF	9,53	9,53	0,4	–	●	●	●	●	●	–	–	●	●	–	●	●	–	–	–	●	–	–	–	–	–	–	–	●	●	–	●	–
SCMT09T308LF	9,53	9,53	0,8	–	●	●	●	●	●	–	●	●	●	●	●	●	–	–	–	●	–	–	–	–	–	–	–	–	●	●	–	–	–
SCMT120404LF	12,70	12,70	0,4	–	–	●	–	●	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–
SCMT120408LF	12,70	12,70	0,8	–	●	–	●	●	●	–	–	●	●	●	●	●	–	●	●	●	–	–	–	–	–	–	–	–	●	●	–	–	–
SCMT120412LF	12,70	12,70	1,2	–	●	–	●	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

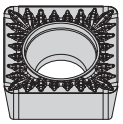
● first choice
○ alternate choice

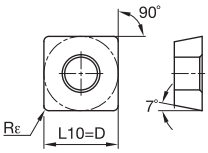




SCMT-MF

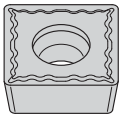
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
				P ●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
				M						○							●	●	●	●	●	●	●	●	●	●	●	●	●			●	●
				K ○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
				N																		●	●	●		●	●	●	●	●		
				S																		●	●	●	●	●	●	●	●			
				H																												
SCMT09T312MF	9,53	9,52	1,2	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SCMT09T308MF	9,53	9,53	0,8	–	●	●	●	●	–	–	–	–	●	●	●	●	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–
SCMT120408MF	12,70	12,70	0,8	–	–	●	●	●	●	–	–	–	●	●	●	●	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–
SCMT120412MF	12,70	12,70	1,2	–	–	●	●	●	–	–	–	–	●	●	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

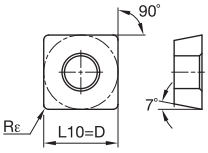




SCMT-MP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
SCMT09T304MP	9,53	9,53	0,4	–	–	–	–	●	–	–	–	–	–	–	–	●	–	●	–	●	–	–	–	–	–	●	–	–	–	–	–	–
SCMT09T308MP	9,53	9,53	0,8	–	–	●	●	●	–	–	–	–	–	–	●	–	–	●	●	●	–	–	–	–	–	●	–	–	–	–	–	–
SCMT120404MP	12,70	12,70	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–
SCMT120408MP	12,70	12,70	0,8	–	–	●	–	●	–	–	–	–	–	–	●	●	–	–	●	●	–	–	–	–	–	●	–	–	–	–	–	–
SCMT120412MP	12,70	12,70	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–

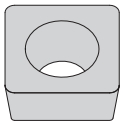


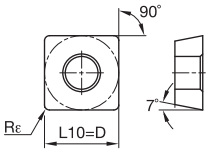


SCMT-UF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
SCMT09T308UF	9,53	9,53	0,8	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

● first choice
○ alternate choice





SCMW

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
SCMW09T304	9,53	9,53	0,4	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SCMW09T308	9,53	9,53	0,8	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SCMW120408	12,70	12,70	0,8	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SCMW120412	12,70	12,70	1,2	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

	P	M	K	N	S	H
KCP05	●		○			
KCP10B	●		○			
KCP10	●		○			
KCP25B	●		○			
KCP25	●		○			
KCP30	●					
KCP40	●	○				
KCK05B	○		●			
KCK05	○		●			
KCK15B	○		●			
KCK15	○		●			
KCK20B	○		●			
KCK20	○		●			
KCM15B	○	●				
KCM15	○	●				
KCM25B	○	●				
KCM25	○	●				
KCM35	○	●				
KU10	●	●	●	●	●	
K313	●	●	●	●	●	
K68	●	●	●	●	●	
KCS10		●			●	
KCU10	●	●	●	●	●	
KCU25	●	●	●	●	●	
KC5010	●	●	●	●	●	
KC5025	●	●	●			
KC5410				●		
KT315	●	●	●			
KTP10	●	●	●			

Mobile Apps

The Kennametal mobile app provides easy access to product information and calculators on both iPhone® and Android™ devices. We've highlighted a few of the key features...

There's an app for that.

SPEEDS & FEEDS

View speeds and feeds information for metalworking products.

PRODUCT AVAILABILITY

Check global availability of products. View available quantities by providing your Konnect login credentials.

CALCULATORS

Utilise our machining calculators for milling and drilling applications.

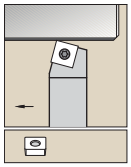


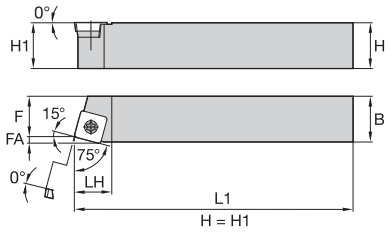
By just scanning the bar code on the insert packet, you can find the most productive cutting conditions for tool life, process time, and chip control.

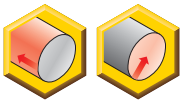
NOTE: The app is currently only available in the English-language version. We have plans to translate the app in different languages with future releases.

Google play

Available on the App Store



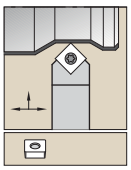


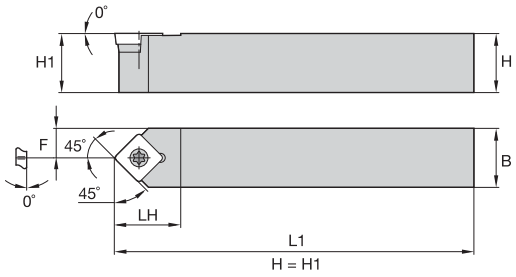


SSBC 75°



order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim screw	hex	insert screw	Torx
right hand													
1097863	**SSBCR1212N09**	12	12	11,0	160	16,0	2,2	SC..09T308	**–**	**–**	–	**MS1155**	T15
1097867	**SSBCR2525M12**	25	25	22,0	150	21,0	3,1	SC..120408	**SKSP453**	**SRS4**	4 mm	**MS1158**	T15
left hand													
1098009	**SSBCL1616H09**	16	16	13,0	100	16,0	2,2	SC..09T308	**SKSP343**	**SRS3**	3.5 mm	**MS1156**	T15



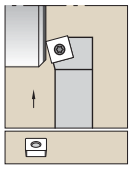


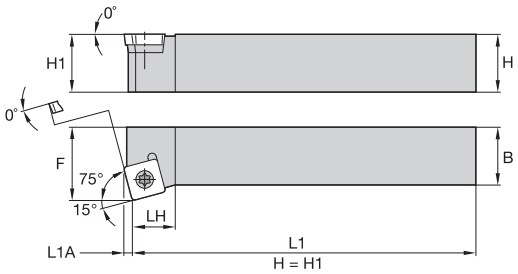


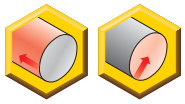
SSDC 45°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	insert screw	Torx
1098005	**SSDCN1212N09**	12	12	6,0	160	18,0	SC..09T308	**–**	**–**	–	**MS1155**	T15
1098006	**SSDCN1616H09**	16	16	8,0	100	18,0	SC..09T308	**SKSP343**	**SRS3**	3.5 mm	**MS1156**	T15
1098007	**SSDCN2020K09**	20	20	10,0	125	18,0	SC..09T308	**SKSP343**	**SRS3**	3.5 mm	**MS1156**	T15



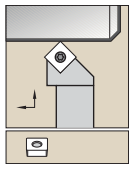


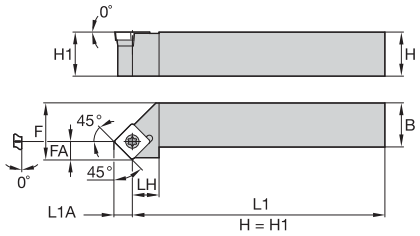


SSKC 75°



order number	catalogue number	H	B	F	L1	LH	L1A	gage insert	shim	shim screw	hex	insert screw	Torx
right hand													
1097882	**SSKCR1616H09**	16	16	20,0	100	16,0	2,2	SC..09T308	**SKSP343**	**SRS3**	3.5 mm	**MS1156**	T15
left hand													
1098027	**SSKCL2020K12**	20	20	25,0	125	22,0	3,1	SC..120408	**SKSP453**	**SRS4**	4 mm	**MS1158**	T15



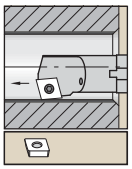




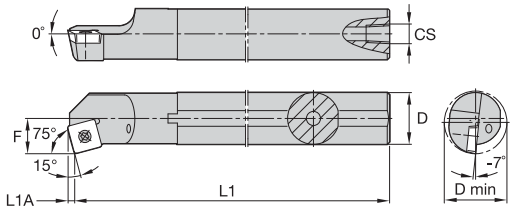
SSSC 45°



order number	catalogue number	H	B	F	L1	LH	FA	L1A	gage insert	shim	shim screw	hex	insert screw	Torx
right hand														
1097808	**SSSCR1212N09**	12	12	16,0	160	18,0	5,8	6,1	SC..09T308	–	–	–	**MS1155**	T15
1097809	**SSSCR1616H09**	16	16	20,0	100	18,0	6,1	6,1	SC..09T308	**SKSP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097811	**SSSCR1616H12**	16	16	20,0	100	25,0	8,3	8,3	SC..120408	**SKSP453**	**SRS4**	4 mm	**MS1158**	T15
1097810	**SSSCR2020K12**	20	20	25,0	125	25,0	8,1	8,3	SC..120408	**SKSP453**	**SRS4**	4 mm	**MS1158**	T15
1244982	**SSSCR2525M12**	25	25	32,0	150	25,0	8,1	8,3	SC..120408	**SKSP453**	**SRS4**	4 mm	**MS1158**	T15
left hand														
1097953	**SSSCL1212N09**	12	12	16,0	160	18,0	5,8	6,1	SC..09T308	–	–	–	**MS1155**	T15
1097954	**SSSCL1616H09**	16	16	20,0	100	18,0	5,8	6,1	SC..09T308	**SKSP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097956	**SSSCL1616H12**	16	16	20,0	100	25,0	8,1	8,3	SC..120408	**SKSP453**	**SRS4**	4 mm	**MS1158**	T15
1097955	**SSSCL2020K12**	20	20	25,0	125	25,0	8,1	8,3	SC..120408	**SKSP453**	**SRS4**	4 mm	**MS1158**	T15
1514473	**SSSCL2525M12**	25	25	32,0	150	25,0	8,1	8,3	SC..120408	**SKSP453**	**SRS4**	4 mm	**MS1158**	T15



Steel shank with through coolant.

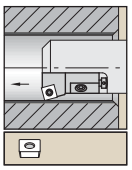


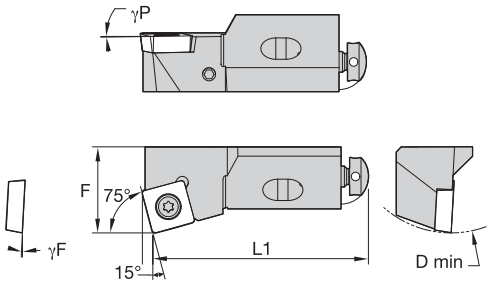
A-SSKC 75°



order number	catalogue number	D	D min	F	L1	L1A	CS	gage insert	insert screw	Torx
right hand										
1886510	**A16RSSKCR09**	16	20,0	11,0	200	2,2	1/8-27 NPT	SC..09T308	**MS1155**	T15

Screw-On Cartridges





SSKC 75°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098719	**SSKCR12CA12**	50	20,0	55	-3.0	0.0	SC..120408/SC..432
1098720	**SSKCR16CA12**	60	25,0	63	-3.0	0.0	SC..120408/SC..432
left hand							
1098721	**SSKCL12CA12**	50	20,0	55	-3.0	0.0	SC..120408/SC..432

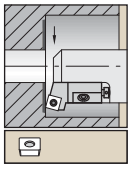
Spare Parts

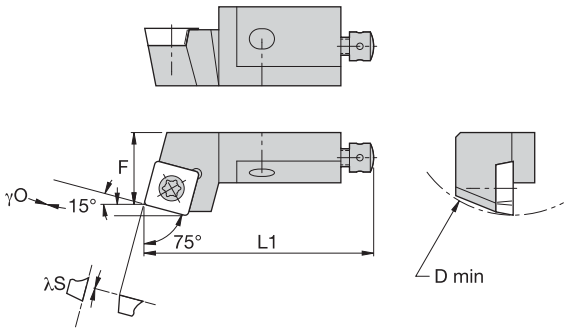






D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	**MS1157**	T15	**KUAM23**	2.5 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**
60	**MS1157**	T15	**KUAM25**	2.5 mm	**KUAM32**	**191.407**	5 mm	**CSWM 080 050**





SSRC 75°

order number	catalogue number	D min	F	L1	λS°	γO°	gage insert
right hand							
1098723	**SSRCR12CA12**	50	20,0	55	-3.0	0.0	SC..120408/SC..432
left hand							
1098725	**SSRCL12CA12**	50	20,0	55	-3.0	0.0	SC..120408/SC..432

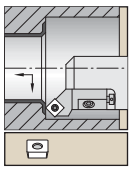
Spare Parts

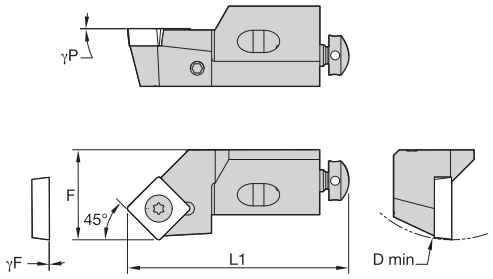






D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	**MS1157**	T15	**KUAM23**	2.5 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**





SSSC 45°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098737	**SSSCR12CA12**	50	20,0	47	-3.0	0.0	SC..120408/SC..432
left hand							
1098739	**SSSCL12CA12**	50	20,0	47	-3.0	0.0	SC..120408/SC..432

Spare Parts

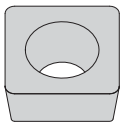


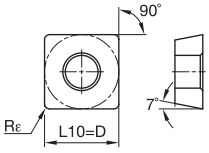




D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	**MS1157**	T15	**KUAM23**	2.5 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**

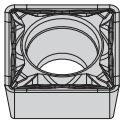
● first choice
○ alternate choice

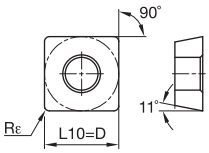




SPGT-LF

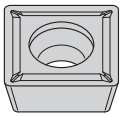
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
SPGT09T304LF	9,53	9,53	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–
SPGT09T308LF	9,53	9,53	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–

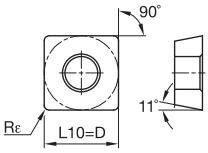




SPMT-FP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
SPMT09T304FP	9,53	9,53	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
SPMT09T308FP	9,53	9,53	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–



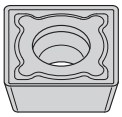


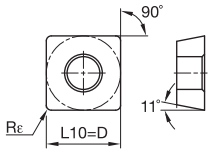
SPMT-LF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
SPMT09T304LF	9,53	9,53	0,4	–	–	●	–	●	–	–	–	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–
SPMT09T308LF	9,53	9,53	0,8	–	●	–	●	●	–	–	–	–	●	●	●	●	–	–	–	–	–	–	–	●	–	–	–	●	●	–	–	–

● first choice
○ alternate choice

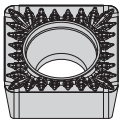
		KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P		●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M								○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K		○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																				●	●	●		●	●	●	●	●		
S																				●	●	●	●	●	●	●	●			
H																														

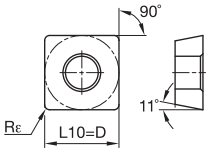




SPMT-MF

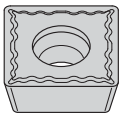
ISO catalogue number	D	L10	Rε
SPMT09T308MF	9,53	9,53	0,8
SPMT120408MF	12,70	12,70	0,8

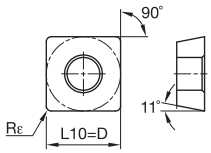




SPMT-MP

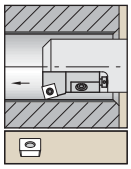
ISO catalogue number	D	L10	Rε
SPMT09T308MP	9,53	9,53	0,8
SPMT120408MP	12,70	12,70	0,8

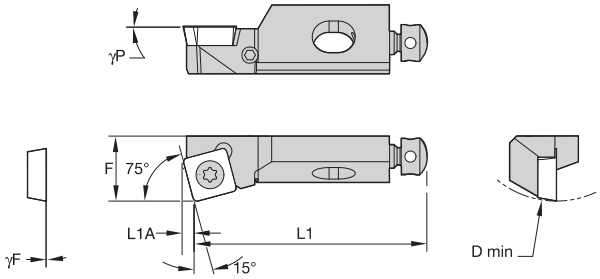




SPMT-UF

ISO catalogue number	D	L10	Rε
SPMT09T304UF	9,53	9,53	0,4





SSKP 75°

order number	catalogue number	D min	F	L1	λS°	γF°	γP°	gage insert
right hand								
1098570	**SSKPR10CA09**	40	14,0	50	0.0	0.0	0.0	SP..09T308/SP..3252

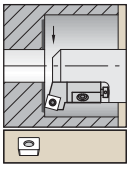
Spare Parts

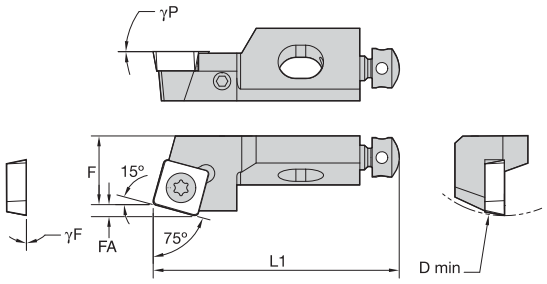






D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
40	**MS1155**	T15	**KUAM28**	2 mm	**KUAM30**	**191.405**	4 mm	**CSWM 060 050**





SSRP 75°

order number	catalogue number	D min	F	FA	L1	γF°	γP°	gage insert
right hand								
1098574	**SSRPR10CA09**	40	14,0	2,2	50	0.0	0.0	SP..09T308/SP..3252

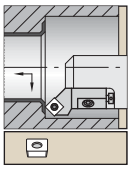
Spare Parts

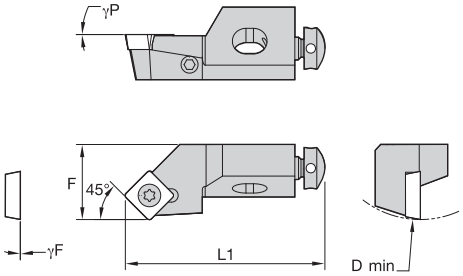






D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
40	**MS1155**	T15	**KUAM28**	2 mm	**KUAM30**	**191.405**	4 mm	**CSWM 060 050**





SSSP 45°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098572	**SSSPR10CA09**	40	14,0	44	0.0	0.0	SP..09T308/SP..3252
left hand							
1098764	**SSSPL10CA09**	40	14,0	44	0.0	0.0	SP..09T308/SP..3252

Spare Parts

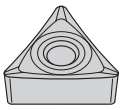


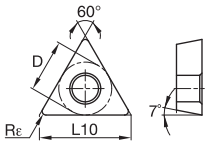




D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
40	**MS1155**	T15	**KUAM28**	2 mm	**KUAM30**	**191.405**	4 mm	**CSWM 060 050**

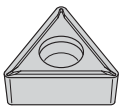
● first choice
○ alternate choice

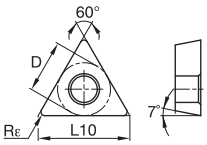




TCGT-HP

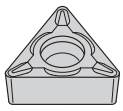
				KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
ISO catalogue number	D	L10	Rε																													
TCGT110202HP	6,35	11,00	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–	–
TCGT110204HP	6,35	11,00	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	●	–	–
TCGT110208HP	6,35	11,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TCGT16T302HP	9,53	16,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–
TCGT16T304HP	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	●	●	●	–	–
TCGT16T308HP	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	●	●	●	–	–

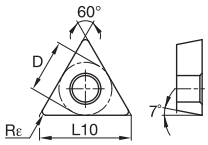




TCGT-LF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TCGT110201LF	6,35	11,00	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	–
TCGT110204LF	6,35	11,00	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–
TCGT16T301LF	9,53	16,50	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TCGT16T302LF	9,53	16,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TCGT16T304LF	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–
TCGT16T308LF	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–

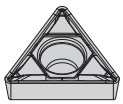


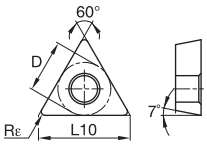


TCMT-11

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TCMT11020411	6,35	11,00	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–
TCMT16T30411	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–
TCMT16T30811	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–

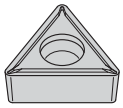
● first choice
○ alternate choice

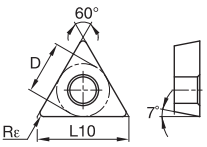




TCMT-FP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
TCMT090204FP	5,56	9,63	0,4	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
TCMT090208FP	5,56	9,63	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
TCMT110202FP	6,35	11,00	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	●
TCMT110204FP	6,35	11,00	0,4	–	–	●	–	●	–	–	–	–	–	–	●	–	–	–	–	●	–	–	–	–	–	●	●	–	–	–	–	●
TCMT110304FP	6,35	11,00	0,4	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
TCMT110208FP	6,35	11,00	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	●	●	–	–	–	–	–
TCMT110308FP	6,35	11,00	0,8	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
TCMT110312FP	6,35	11,00	1,2	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TCMT16T304FP	9,53	16,50	0,4	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
TCMT16T308FP	9,53	16,50	0,8	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	●	–	–	–	–	●
TCMT16T312FP	9,53	16,50	1,2	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
TCMT220408FP	12,70	22,00	0,8	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	●	–	–	–	–	–

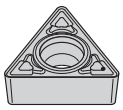


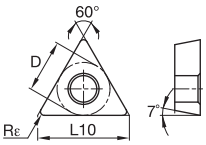


TCMT-LF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TCMT110202LF	6,35	11,00	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–
TCMT110204LF	6,35	11,00	0,4	–	●	●	●	●	●	–	–	●	●	●	●	●	●	●	●	–	●	–	–	–	–	–	–	●	●	–	●	–
TCMT110208LF	6,35	11,00	0,8	–	–	●	●	●	●	–	–	●	●	●	●	●	–	●	●	–	–	–	–	–	–	–	–	●	●	–	●	–
TCMT16T302LF	9,53	16,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–
TCMT16T304LF	9,53	16,50	0,4	–	●	●	●	●	–	–	–	●	–	●	●	●	–	●	●	●	●	–	–	–	–	–	–	●	●	–	●	–
TCMT16T308LF	9,53	16,50	0,8	–	●	●	●	●	●	–	●	–	●	●	●	●	–	–	●	●	●	–	–	–	–	–	–	●	●	–	●	–
TCMT16T312LF	9,53	16,50	1,2	–	●	–	–	●	–	–	–	–	–	●	●	●	–	–	–	●	–	–	–	–	–	–	–	●	–	–	–	–
TCMT220408LF	12,70	22,00	0,8	–	●	–	●	●	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–

● first choice
○ alternate choice

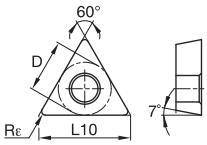




TCMT-MF

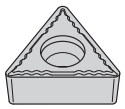
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
TCMT110208MF	6,35	11,00	0,8	–	–	–	●	●	–	–	–	–	–	●	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT16T308MF	9,53	16,50	0,8	–	–	●	●	●	●	–	–	–	●	●	●	●	–	–	●	●	●	–	–	–	–	–	–	–	–	–	–	–
TCMT16T312MF	9,53	16,50	1,2	–	–	●	●	–	–	–	–	–	–	–	●	●	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–

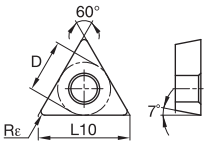




TCMT-MP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TCMT110208MP	6,35	11,00	0,8	–	–	–	–	●	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TCMT16T304MP	9,53	16,50	0,4	–	–	–	–	●	–	–	–	–	–	–	●	–	–	–	●	●	–	–	–	–	–	●	–	–	–	–	–	–
TCMT16T308MP	9,53	16,50	0,8	–	–	●	–	●	–	–	–	–	–	–	●	–	–	●	●	●	–	–	–	–	–	●	–	–	–	–	–	–
TCMT16T312MP	9,53	16,50	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

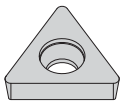


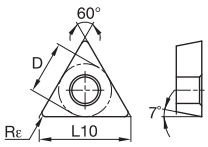


TCMT-UF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TCMT110204UF	6,35	11,00	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TCMT110208UF	6,35	11,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TCMT16T308UF	9,53	16,50	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

● first choice
○ alternate choice





TCMW

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●			●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
TCMW16T304	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMW16T308	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Mobile Apps

The Kennametal mobile app provides easy access to product information and calculators on both iPhone® and Android™ devices. We've highlighted a few of the key features...

There's an app for that.

SPEEDS & FEEDS

View speeds and feeds information for metalworking products.

PRODUCT AVAILABILITY

Check global availability of products. View available quantities by providing your Konnect login credentials.

CALCULATORS

Utilise our machining calculators for milling and drilling applications.

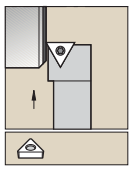


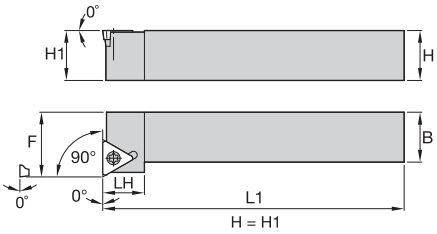
By just scanning the bar code on the insert packet, you can find the most productive cutting conditions for tool life, process time, and chip control.

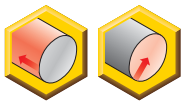
NOTE: The app is currently only available in the English-language version. We have plans to translate the app in different languages with future releases.

Google play

Available on the App Store





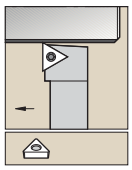


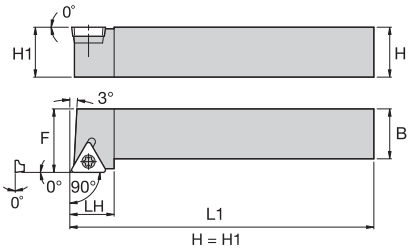
STFC 90°

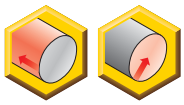




order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	insert screw	Torx
right hand												
1244940	**STFCR1616H11**	16	16	20,0	100	16,0	TC..110204	–	–	–	**MS1153**	T7
1097880	**STFCR1616H16**	16	16	20,0	100	20,0	TC..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097877	**STFCR2020K16**	20	20	25,0	125	20,0	TC..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097878	**STFCR2525M16**	25	25	32,0	150	20,0	TC..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15
left hand												
1098022	**STFCL2020K16**	20	20	25,0	125	20,0	TC..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15
1098023	**STFCL2525M16**	25	25	32,0	150	20,0	TC..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15





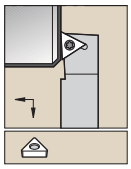


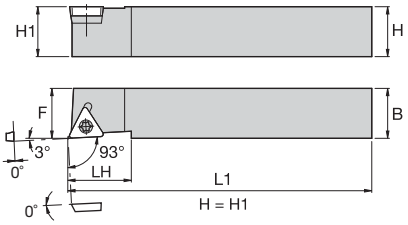
STGC 90°

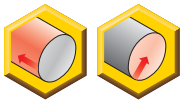




order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	insert screw	Torx
right hand												
1097869	**STGCR1212N11**	12	12	16,0	160	16,0	TC..110204	–	–	–	**MS1153**	T7
1244944	**STGCR1616H11**	16	16	20,0	100	16,0	TC..110204	–	–	–	**MS1153**	T7
1097874	**STGCR1616H16**	16	16	20,0	100	20,0	TC..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097870	**STGCR2020K16**	20	20	25,0	125	20,0	TC..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15
1097871	**STGCR2525M16**	25	25	32,0	150	20,0	TC..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15
left hand												
1098014	**STGCL1212N11**	12	12	16,0	160	16,0	TC..110204	–	–	–	**MS1153**	T7
1244943	**STGCL1616H11**	16	16	20,0	100	16,0	TC..110204	–	–	–	**MS1153**	T7
1098019	**STGCL1616H16**	16	16	20,0	100	20,0	TC..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15
1098015	**STGCL2020K16**	20	20	25,0	125	20,0	TC..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15
1098016	**STGCL2525M16**	25	25	32,0	150	20,0	TC..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15



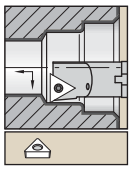




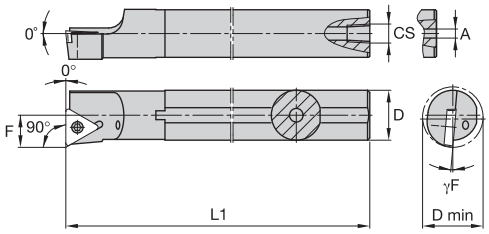
STJC-F 90°



order number	catalogue number	H	B	F	L1	LH	gage insert	insert screw	Torx
right hand									
1772197	**STJCRF1212M11Q**	12	12	12,0	150	16,0	TC..110204	**MS1153**	T7
left hand									
1772198	**STJCLF1212M11Q**	12	12	12,0	150	16,0	TC..110204	**MS1153**	T7



Steel shank with through coolant.



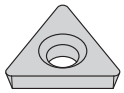


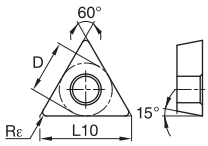
A-STFC 90°



order number	catalogue number	D	D min	F	L1	A	CS	γF°	gage insert	shim	shim screw	hex	insert screw	Torx
right hand														
1098207	**A10KSTFCR11**	10	13,0	7,0	125	3,2	–	-7.0	TC..110204	–	–	–	**MS1153**	T7
1098211	**A12MSTFCR11**	12	16,0	9,0	150	–	1/16-27 NPT	-6.0	TC..110204	–	–	–	**MS1153**	T7
1098286	**A32TSTFCR16**	32	40,0	22,0	300	–	1/4-18 NPT	-2.0	TC..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15
left hand														
1098209	**A10KSTFCL11**	10	13,0	7,0	125	3,2	–	-7.0	TC..110204	–	–	–	**MS1153**	T7
1098213	**A12MSTFCL11**	12	16,0	9,0	150	–	1/16-27 NPT	-6.0	TC..110204	–	–	–	**MS1153**	T7

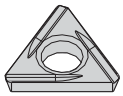
● first choice
○ alternate choice

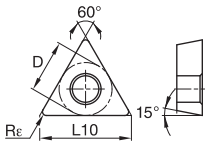




TDHB

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
TDHB07T12S0	4,06	7,04	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–
TDHB07T1202	4,06	7,04	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–	–
TDHB07T1204	4,06	7,04	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	●	–
TDHB07T1208	4,06	7,04	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–

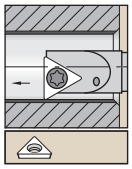




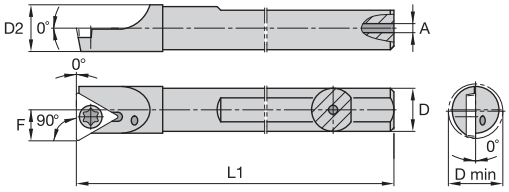
TDHH

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TDHH07T1202L	4,06	7,04	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–
TDHH07T1202R	4,06	7,04	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TDHH07T1204L	4,06	7,04	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–
TDHH07T1204R	4,06	7,04	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

NOTE: Right-hand insert uses left-hand bars.
Left-hand insert uses right-hand bars.



Steel shank with through coolant.

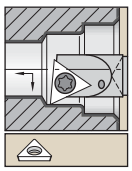




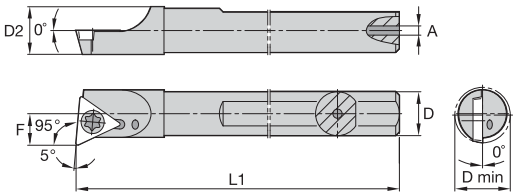
A-STFD 90°



order number	catalogue number	D	D min	D2	F	L1	A	gage insert	insert screw	Torx
right hand										
1288884	**A06HSTFDR07**	6	7,1	6,2	3,7	100	1,0	TD..07S102	**FC11**	T7
1288898	**A08HSTFDR07**	8	9,1	8,2	4,8	102	1,5	TD..07S102	**FC14**	T7
left hand										
1930573	**A12MSTFDL11**	12	13,2	12,2	6,8	152	3,0	TP..110202	**QC26**	T9



Steel shank with through coolant.

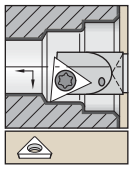




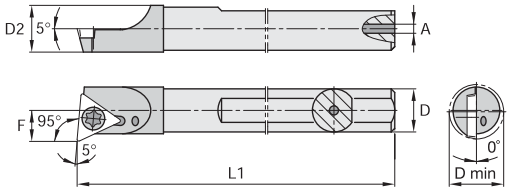
A-STLD 95°



order number	catalogue number	D	D min	D2	F	L1	A	gage insert	insert screw	Torx
right hand										
1288886	**A06HSTLDR07**	6	7,1	6,2	3,7	100	1,0	TD..07S102	**FC11**	T7
1288900	**A08HSTLDR07**	8	9,1	8,2	4,8	102	1,5	TD..07S102	**FC14**	T7



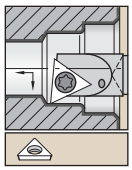
Carbide shank with through coolant.



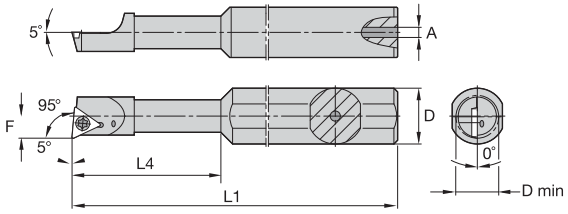
E-STLD 95°



order number	catalogue number	D	D min	F	L1	A	gage insert	insert screw	Torx
right hand									
1270982	**E06MSTLDR07**	6	7,1	3,7	152	1,2	TD..07S102	**FC11**	T7
1270992	**E08MSTLDR07**	8	9,2	4,8	152	2,4	TD..07S102	**FC11**	T7
left hand									
1270981	**E06MSTLDL07**	6	7,1	3,7	152	1,2	TD..130805	**FC11**	T7
1270991	**E08MSTLDL07**	8	9,1	4,8	152	2,4	TD..07S102	**FC14**	T7



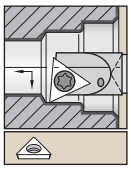
Necked steel shank with through coolant.



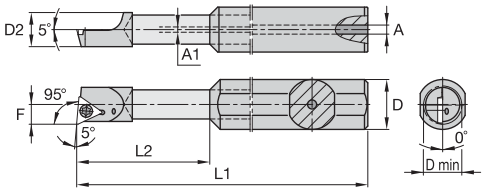
A-STLD 95° • Stepped



order number	catalogue number	D	D min	F	L1	L4	A	gage insert	insert screw	Torx
right hand										
1289155	**A0612XSTLDR0731**	12	7,5	4,0	76	31,75	1,0	TD..07T1202	**FC11**	T7
left hand										
1930492	**A0616HSTLDR0731**	16	7,5	4,0	102	31,75	1,0	TD..07S102	**FC14**	T7



Necked carbide shank with through coolant.



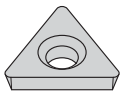


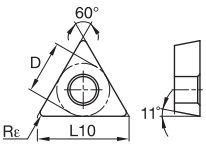
E-STLD 95° • Stepped



order number	catalogue number	D	D min	D2	F	L1	L2	A	A1	gage insert	insert screw	Torx
right hand												
1930512	**E0812XSTLDR0738**	12	9,1	7,9	4,8	76	38,1	3,2	2,0	TD..07S102	**FC14**	T7

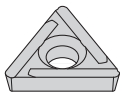
● first choice
○ alternate choice

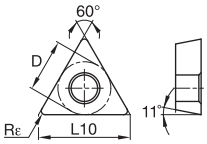




TPCB

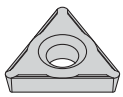
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TPCB110202	6,35	–	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TPCB160302	9,53	16,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TPCB160304	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TD6P	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
TPCB160308	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

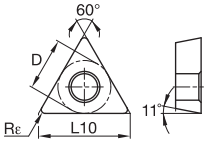




TPCG

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TPCG110202L	6,35	11,00	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TPCG110204L	6,35	11,00	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TPCG110208L	6,35	11,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

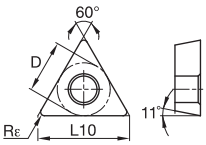




TPCH

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TPCH110202	6,50	11,26	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TPCH110204	6,50	11,26	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

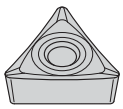


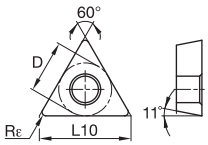


TPGH

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TPGH160304	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
TPGH160308	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–

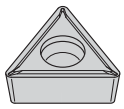
● first choice
○ alternate choice

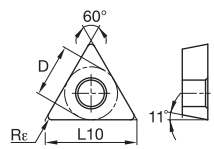




TPGT-HP

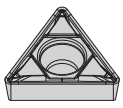
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
TPGT110202HP	6,35	11,00	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–
TPGT110204HP	6,35	11,00	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	–	–
TPGT110208HP	6,35	11,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–
TPGT16T302HP	9,53	16,50	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–
TPGT16T304HP	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–
TPGT16T308HP	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	●	–	–

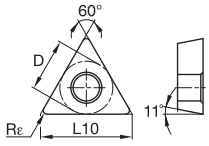




TPGT-LF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TPGT090204LF	5,56	9,62	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–
TPGT090202LF	5,56	9,63	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–
TPGT110201LF	6,35	11,00	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TPGT110202LF	6,35	11,00	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–
TPGT110204LF	6,35	11,00	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–
TPGT110208LF	6,35	11,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–
TPGT16T304LF	9,53	16,50	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–
TPGT16T308LF	9,53	16,50	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	–	–

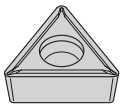


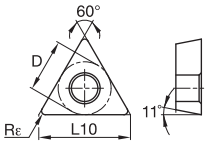


TPMT-FP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TPMT090204FP	5,56	9,63	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TPMT090208FP	5,56	9,63	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
TPMT110202FP	6,35	11,00	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TPMT110204FP	6,35	11,00	0,4	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
TPMT110304FP	6,35	11,00	0,4	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
TPMT110208FP	6,35	11,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TPMT110308FP	6,35	11,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
TPMT16T304FP	9,53	16,50	0,4	–	–	●	–	●	–	–	–	–	–	–	–	●	–	–	–	●	–	–	–	–	–	●	●	–	–	–	–	–
TPMT16T308FP	9,53	16,50	0,8	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–

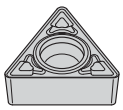
● first choice
○ alternate choice

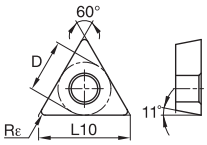




TPMT-LF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TPMT090202LF	5,56	9,63	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TPMT090204LF	5,56	9,63	0,4	–	●	–	●	●	–	–	–	●	–	●	–	–	●	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–
TPMT110202LF	6,35	11,00	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TPMT110204LF	6,35	11,00	0,4	–	●	●	●	●	–	–	–	–	●	–	–	●	–	●	●	–	–	–	●	–	–	–	–	●	●	–	●	–
TPMT110208LF	6,35	11,00	0,8	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	●	●	–	●	–
TPMT16T304LF	9,53	16,50	0,4	–	●	●	●	●	–	–	–	●	–	●	–	–	–	●	●	–	–	–	–	–	–	–	–	●	●	–	●	–
TPMT16T308LF	9,53	16,50	0,8	–	●	–	●	●	–	–	–	●	●	●	●	●	–	–	–	●	–	–	–	–	–	–	–	●	●	–	●	–
TPMT220408LF	12,70	22,00	0,8	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–

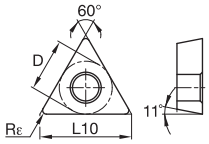




TPMT-MF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TPMT110208MF	6,35	11,00	0,8	–	–	–	●	●	–	–	–	–	–	●	–	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
TPMT16T308MF	9,53	16,50	0,8	–	–	●	–	●	●	–	–	–	–	●	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TPMT16T312MF	9,53	16,50	1,2	–	–	–	–	●	–	–	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



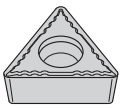


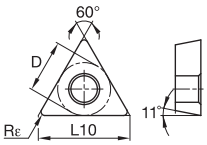
TPMT-MP

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
TPMT110208MP	6,35	11,00	0,8	–	–	–	–	●	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TPMT16T308MP	9,53	16,50	0,8	–	–	–	–	●	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TPMT16T312MP	9,53	16,50	1,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

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

● first choice
○ alternate choice

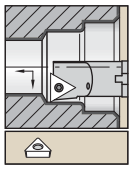




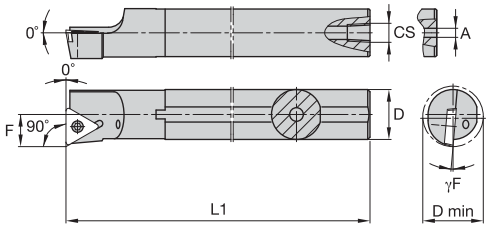
TPMT-UF

	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P	●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M							○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K	○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																			●	●	●		●	●	●	●	●		
S																			●	●	●	●	●	●	●	●			
H																													

ISO catalogue number	D	L10	Rε																										
TPMT110202UF	6,35	11,00	0,2	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TPMT110204UF	6,35	11,00	0,4	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
TPMT16T308UF	9,53	16,50	0,8	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



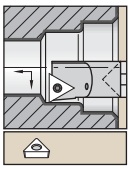
Steel shank with through coolant.



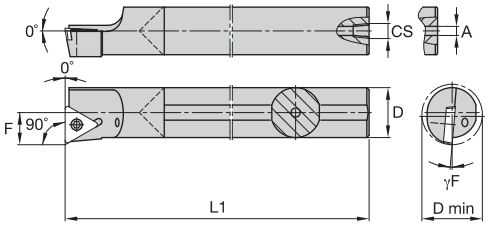
A-STFP 90°



order number	catalogue number	D	D min	F	L1	A	CS	γF°	gage insert	shim	shim screw	hex	insert screw	Torx
right hand														
1098154	**A08JSTFPR09**	8	11,0	6,0	110	2,4	–	-8.0	TP..090204	**–**	**–**	–	**MS1933**	T7
1098204	**A10KSTFPR11**	10	13,0	7,0	125	3,2	–	-4.0	TP..110204	**–**	**–**	–	**MS1153**	T7
1098210	**A12MSTFPR11**	12	16,0	9,0	150	4,0	1/16-27 NPT	-2.0	TP..110204	**–**	**–**	–	**MS1153**	T7
1098214	**A16RSTFPR11**	16	20,0	11,0	200	4,0	1/8-27 NPT	0.0	TP..110204	**–**	**–**	–	**MS1153**	T7
1098255	**A20SSTFPR16**	20	25,0	13,0	250	4,0	1/8-27 NPT	-2.0	TP..16T308	**–**	**–**	–	**MS1155**	T15
1098273	**A25TSTFPR16**	25	32,0	17,0	300	6,4	1/4-18 NPT	0.0	TP..16T308	**–**	**–**	–	**MS1155**	T15
1098285	**A32TSTFPR16**	32	40,0	22,0	300	–	1/4-18 NPT	-2.0	TP..16T308	**SKTP343**	**SRS3**	3.5 mm	**MS1156**	T15
left hand														
1098155	**A08JSTFPL09**	8	11,0	6,0	110	2,4	–	-8.0	TP..090204	**–**	**–**	–	**MS1933**	T7
1098208	**A10KSTFPL11**	10	13,0	7,0	125	3,2	–	-4.0	TP..110204	**–**	**–**	–	**MS1153**	T7
1098212	**A12MSTFPL11**	12	16,0	9,0	150	4,0	1/16-27 NPT	-2.0	TP..110204	**–**	**–**	–	**MS1153**	T7
1098215	**A16RSTFPL11**	16	20,0	11,0	200	4,0	1/8-27 NPT	0.0	TP..110204	**–**	**–**	–	**MS1153**	T7
1098256	**A20SSTFPL16**	20	25,0	13,0	250	4,0	1/8-27 NPT	-2.0	TP..16T308	**–**	**–**	–	**MS1155**	T15
1098276	**A25TSTFPL16**	25	32,0	17,0	300	6,4	1/4-18 NPT	0.0	TP..16T308	**–**	**–**	–	**MS1155**	T15



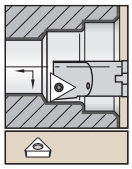
Carbide shank with through coolant.



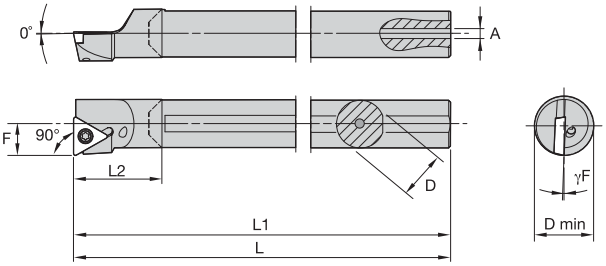
E-STFP 90°



order number	catalogue number	D	D min	F	L1	A	γF°	gage insert	insert screw	Torx
right hand										
1152860	**E08KSTFPR09A**	8	11,0	6,0	125	2,4	-6.0	TP..090204	**MS1933**	T7
1152862	**E10MSTFPR11A**	10	13,0	7,0	150	3,2	-4.0	TP..110204	**MS1153**	T7
1104311	**E12QSTFPR11**	12	16,0	9,0	180	4,8	-2.0	TP..110204	**MS1153**	T7
1152874	**E16RSTFPR11**	16	20,0	11,0	200	5,5	0.0	TP..110204	**MS1153**	T7
1152908	**E20SSTFPR16**	20	25,0	13,0	250	7,1	-2.0	TP..16T308	**MS1155**	T15
left hand										
1152863	**E10MSTFPL11A**	10	13,0	7,0	150	3,2	-4.0	TP..110204	**MS1153**	T7
1152873	**E12QSTFPL11**	12	16,0	9,0	180	4,8	-2.0	TP..110204	**MS1153**	T7
1152875	**E16RSTFPL11**	16	20,0	11,0	200	5,5	0.0	TP..110204	**MS1153**	T7
1152909	**E20SSTFPL16**	20	25,0	13,0	250	7,1	-2.0	TP..16T308	**MS1155**	T15



Heavy-metal bar with through coolant.

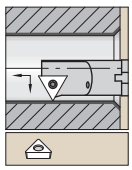




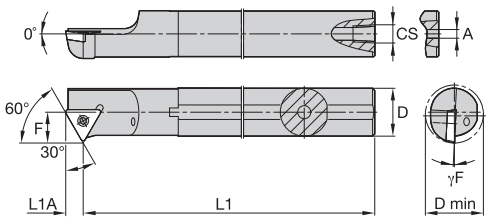
L-STFP 90°



order number	catalogue number	D	D min	F	L1	L2	A	γF°	gage insert	insert screw	Torx
right hand											
3331128	**L08KSTFPR09**	8	11,0	6,0	125	19,1	2,4	-6.0	TP..090204..	**MS1933**	T7
3331123	**L12QSTFPR11**	12	16,0	9,0	183	24,4	4,0	-2.0	TP..110204..	**MS1153**	T7
left hand											
3331131	**L08KSTFPL09**	8	11,0	6,0	125	19,1	2,4	-6.0	TP..090204..	**MS1933**	T7



Steel shank with through coolant.

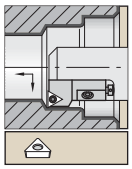


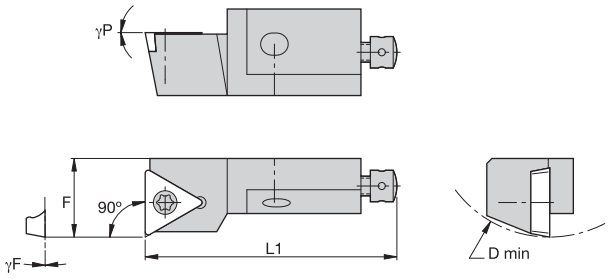


A-STWP 60°



order number	catalogue number	D	D min	F	L1	L1A	A	CS	γF°	gage insert	insert screw	Torx
right hand												
1098205	**A10KSTWPR11**	10	13,0	7,0	125	5,0	3,2	–	-4.0	TP..110204	**MS1153**	T7
1098216	**A12MSTWPR11**	12	16,0	9,0	150	–	4,0	1/16-27 NPT	-2.0	TP..110204	**MS1153**	T7
1098218	**A16RSTWPR11**	16	20,0	11,0	200	–	4,0	1/8-27 NPT	-2.0	TP..110204	**MS1153**	T7
left hand												
1098206	**A10KSTWPL11**	10	13,0	7,0	125	–	3,2	–	-4.0	TP..110204	**MS1153**	T7





STFP 90°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098565	**STFPR08CA09**	25	10,0	32	0.0	0.0	TP..090204/TP..18151
1098563	**STFPR10CA11**	40	14,0	50	0.0	0.0	TP..110204/TP..2151
1098562	**STFPR12CA16**	50	20,0	55	0.0	0.0	TP..16T308/TP..3252
left hand							
1098561	**STFPL08CA09**	25	10,0	32	0.0	0.0	TP..090204/TP..18151
1098559	**STFPL10CA11**	40	14,0	50	0.0	0.0	TP..110204/TP..2151
1098558	**STFPL12CA16**	50	20,0	55	0.0	0.0	TP..16T308/TP..3252

NOTE: ANSI/ISO compatible 60° countersunk hole inserts. This tool also accepts TPGM/TPGT/TPGW-21.5_ inserts.
ANSI/ISO compatible 60° countersunk hole inserts (i.e., TPMT/TPGT/TPGW-32.5_). 90° countersunk hole inserts (i.e., TPGM/TPGB-32.5_) do not fit this tool.

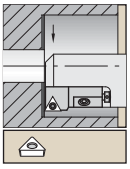
Spare Parts

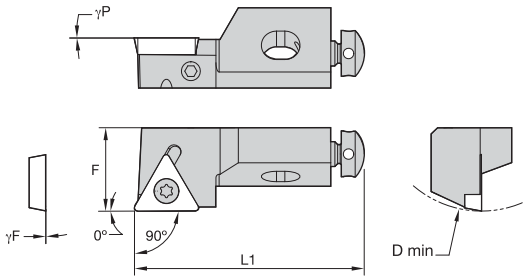







D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	hex	washer
25	**MS1152**	T7	**KUAM34**	1.5 mm	**KUAM20**	**MS2175**	–	2.5 mm	**CSWM 040 050**
40	**MS1153**	T7	**KUAM28**	2 mm	**KUAM30**	**191.405**	–	4 mm	**CSWM 060 050**
50	**MS1155**	T15	**KUAM23**	2.5 mm	**KUAM31**	–	**191.406**	4 mm	**CSWM 060 050**





STGP 90°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098567	**STGPR10CA11**	40	14,0	50	0.0	0.0	TP..110204/TP..2151
1098566	**STGPR12CA16**	50	20,0	55	0.0	0.0	TP..16T308/TP..3252
left hand							
1098762	**STGPL08CA09**	25	10,0	32	0.0	0.0	TP..090204/TP..18151
1098760	**STGPL10CA11**	40	14,0	50	0.0	0.0	TP..110204/TP..2151

NOTE: ANSI/ISO compatible 60° countersunk hole inserts. This tool also accepts TPGM/TPGT/TPGW-21.5_ inserts.
ANSI/ISO compatible 60° countersunk hole inserts (i.e., TPMT/TPGT/TPGW-32.5_). 90° countersunk hole inserts (i.e., TPGM/TPGB-32.5_) do not fit this tool.

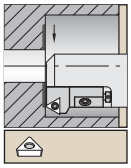
Spare Parts

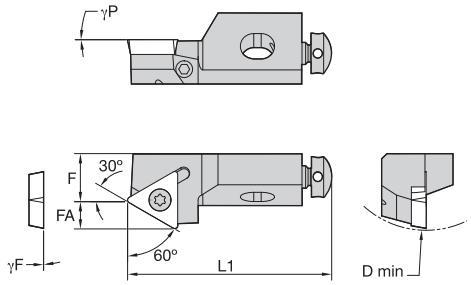







D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	hex	washer
25	**MS1152**	T7	**KUAM34**	1.5 mm	**KUAM20**	**MS2175**	**–**	2.5 mm	**CSWM 040 050**
40	**MS1153**	T7	**KUAM28**	2 mm	**KUAM30**	**191.405**	**–**	4 mm	**CSWM 060 050**
50	**MS1155**	T15	**KUAM23**	2.5 mm	**KUAM31**	**–**	**191.406**	4 mm	**CSWM 060 050**





STTP 60°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098744	**STTPR08CA09**	25	6,0	32	0.0	0.0	TP..090204/TP..18151
1098742	**STTPR10CA11**	40	9,0	50	0.0	0.0	TP..110204/TP..2151
1098741	**STTPR12CA16**	50	13,0	55	0.0	0.0	TP..16T308/TP..3252

NOTE: ANSI/ISO compatible 60° countersunk hole inserts.
This tool also accepts TPGM/TPGT/TPGW-21.5_ inserts.

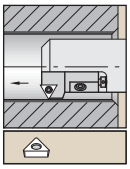
Spare Parts

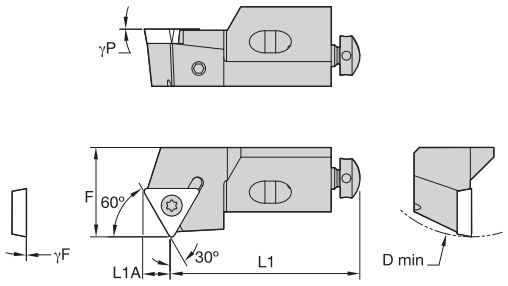







D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	hex	washer
25	**MS1152**	T7	**KUAM34**	1.5 mm	**KUAM20**	**MS2175**	–	2.5 mm	**CSWM 040 050**
40	**MS1153**	T7	**KUAM28**	2 mm	**KUAM30**	**191.405**	–	4 mm	**CSWM 060 050**
50	**MS1155**	T15	**KUAM23**	2.5 mm	**KUAM31**	–	**191.406**	4 mm	**CSWM 060 050**





STWP 60°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
1098750	**STWPR10CA11**	40	14,0	44	0.0	0.0	TP..110204/TP..2151
1098749	**STWPR12CA16**	50	20,0	47	0.0	0.0	TP..16T308/TP..3252

NOTE: ANSI/ISO compatible 60° countersunk hole inserts.
This tool also accepts TPGM/TPGT/TPGW-21.5_ inserts.

Spare Parts

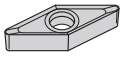


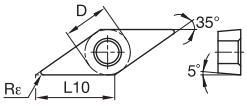





D min	insert screw	Torx	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	hex	washer
40	**MS1153**	T7	**KUAM28**	2 mm	**KUAM30**	**191.405**	**–**	4 mm	**CSWM 060 050**
50	**MS1155**	T15	**KUAM23**	2.5 mm	**KUAM31**	**–**	**191.406**	4 mm	**CSWM 060 050**

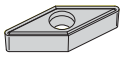
● first choice
○ alternate choice

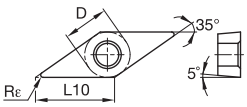




VBGT-HP

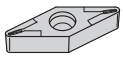
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
VBGT110302HP	6,35	11,07	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–
VBGT110304HP	6,35	11,07	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–
VBGT160404HP	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	●	●	●	●	–	–
VBGT160408HP	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	●	●	●	●	–	–

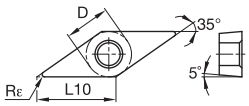




VBGT-LF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
VBGT1103X0LF	6,35	11,07	0,0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
VBGT110301LF	6,35	11,07	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–
VBGT110302LF	6,35	11,07	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	●	●	–	–	–
VBGT110304LF	6,35	11,07	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	●	●	–	–	–
VBGT1604X0LF	9,53	16,61	0,0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
VBGT160401LF	9,53	16,61	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	–	–	–
VBGT160402LF	9,53	16,61	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–	●	●	●	–	–
VBGT160404LF	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	●	●	–	–

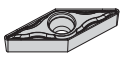


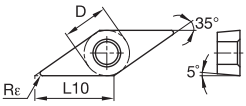


VBMT-11

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
VBMT11030211	6,35	11,07	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–
VBMT11030411	6,35	11,07	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–
VBMT16040411	9,53	16,61	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–
VBMT16040811	9,53	16,61	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–

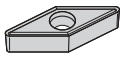
● first choice
○ alternate choice

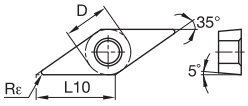




VBMT-FP

				KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
P				●	●	●	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	●	●	●		●	●	●	●		●	●
M										○							●	●	●	●	●	●	●	●	●	●	●	●	●		●	●
K				○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
N																						●	●	●		●	●	●	●	●		
S																						●	●	●	●	●	●	●	●			
H																																
ISO catalogue number	D	L10	Rε																													
VBMT110302FP	6,35	11,07	0,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
VBMT110304FP	6,35	11,07	0,4	–	–	●	–	●	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–	–	●	●	–	–	–	–	●
VBMT110308FP	6,35	11,07	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	●	●	–	–	–	–	–
VBMT160402FP	9,53	16,61	0,2	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	●	–	–	–	–	●
VBMT160404FP	9,53	16,61	0,4	●	●	●	●	●	–	–	–	–	–	–	●	–	–	●	–	●	–	–	–	–	–	●	●	–	–	–	–	●
VBMT160408FP	9,53	16,61	0,8	●	●	●	●	●	–	–	–	–	–	–	●	●	–	●	–	●	–	–	–	–	–	●	●	–	–	–	–	●
VBMT160412FP	9,53	16,61	1,2	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

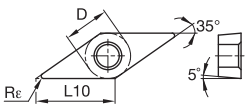




VBMT-LF

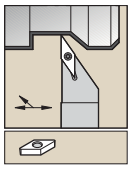
				KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
ISO catalogue number	D	L10	Rε																													
VBMT110302LF	6,35	11,07	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	●	–
VBMT110304LF	6,35	11,07	0,4	●	●	●	●	●	–	–	–	●	–	–	–	–	–	●	●	–	–	–	●	–	–	–	–	●	●	–	●	–
VBMT110308LF	6,35	11,07	0,8	●	–	●	●	●	–	–	–	●	–	–	●	–	–	–	–	●	–	–	–	–	–	–	–	–	●	●	–	–	–
VBMT160402LF	9,53	16,61	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	●	–	●	–
VBMT160404LF	9,53	16,61	0,4	–	●	●	●	●	●	–	–	–	●	●	●	–	●	●	●	●	●	–	●	–	–	–	–	–	●	●	–	●	–
VBMT160408LF	9,53	16,61	0,8	●	●	●	●	●	●	–	–	●	●	●	–	●	●	●	●	●	●	–	●	–	–	–	–	–	●	●	–	●	–
VBMT160412LF	9,53	16,61	1,2	–	–	–	–	●	–	–	–	●	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

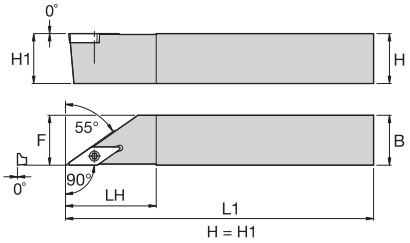


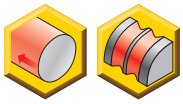


VBMT-MP

				KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
ISO catalogue number	D	L10	Rε																													
VBMT160404MP	9,53	16,61	0,4	–	–	–	●	●	–	–	–	–	–	–	●	–	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–
VBMT160408MP	9,53	16,61	0,8	–	–	–	●	●	–	–	–	–	–	–	●	●	–	–	●	●	–	–	–	–	–	–	–	–	–	–	–	–	–



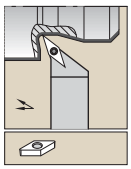


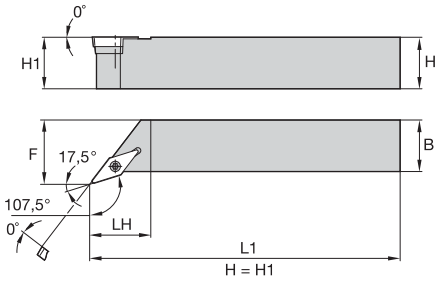


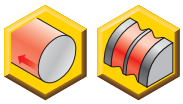
SVAB 90°



order number	catalogue number	H	B	F	L1	LH	gage insert	insert screw	Torx
right hand									
1097722	**SVABR1010M11Q**	10	10	10,0	150	22,0	VB..110304	**MS1153**	T7
1097724	**SVABR1212M11Q**	12	12	12,0	150	22,0	VB..110304	**MS1153**	T7
1097726	**SVABR1616K16Q**	16	16	16,0	125	30,0	VB..160408	**MS1155**	T15
left hand									
1097725	**SVABL1212M11Q**	12	12	12,0	150	22,0	VB..110304	**MS1153**	T7
1097727	**SVABL1616K16Q**	16	16	16,0	125	30,0	VB..160408	**MS1155**	T15







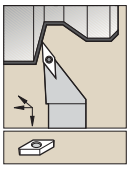
SVHB 107,5°

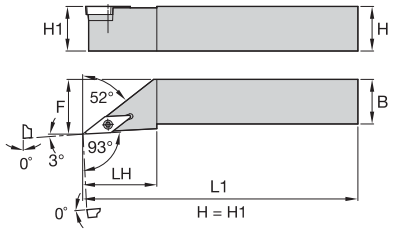






order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	insert screw	Torx
right hand												
1097804	**SVHBR1212N11**	12	12	16,0	160	19,0	VB..110304	–	–	–	**MS1153**	T7
1097805	**SVHBR1616H11**	16	16	20,0	100	19,0	VB..110304	–	–	–	**MS1153**	T7
1244953	**SVHBR2020K11**	20	20	25,0	125	26,0	VB..110304	–	–	–	**MS1153**	T7
1097806	**SVHBR2020K16**	20	20	25,0	125	28,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
1097807	**SVHBR2525M16**	25	25	32,0	150	28,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
left hand												
1097949	**SVHBL1212N11**	12	12	16,0	160	19,0	VB..110304	–	–	–	**MS1153**	T7
1097950	**SVHBL1616H11**	16	16	20,0	100	19,0	VB..110304	–	–	–	**MS1153**	T7
1244949	**SVHBL2020K11**	20	20	25,0	125	26,0	VB..110304	–	–	–	**MS1153**	T7
1097951	**SVHBL2020K16**	20	20	25,0	125	28,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
1097952	**SVHBL2525M16**	25	25	32,0	150	28,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15



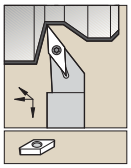


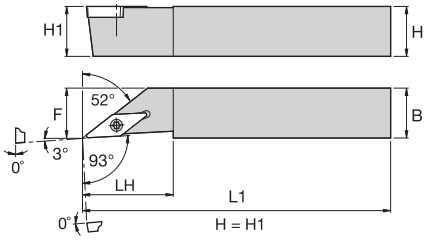
SVJB 93°





order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	insert screw	Torx
right hand												
1097800	**SVJBR1212N11**	12	12	16,0	160	22,0	VB..110304	–	–	–	**MS1153**	T7
1097801	**SVJBR1616H11**	16	16	20,0	100	22,0	VB..110304	–	–	–	**MS1153**	T7
1244959	**SVJBR1616H16**	16	16	20,0	100	35,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
1252235	**SVJBR2020K11**	20	20	25,0	125	26,0	VB..110304	–	–	–	**MS1153**	T7
1097802	**SVJBR2020K16**	20	20	25,0	125	35,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
1097803	**SVJBR2525M16**	25	25	32,0	150	35,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
1244992	**SVJBR3225P16**	32	25	32,0	170	35,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
left hand												
1097945	**SVJBL1212N11**	12	12	16,0	160	22,0	VB..110304	–	–	–	**MS1153**	T7
1097946	**SVJBL1616H11**	16	16	20,0	100	22,0	VB..110304	–	–	–	**MS1153**	T7
1244957	**SVJBL1616H16**	16	16	20,0	100	35,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
1252234	**SVJBL2020K11**	20	20	25,0	125	26,0	VB..110304	–	–	–	**MS1153**	T7
1097947	**SVJBL2020K16**	20	20	25,0	125	35,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
1097948	**SVJBL2525M16**	25	25	32,0	150	35,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
1192560	**SVJBL3225P16**	32	25	32,0	170	35,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15

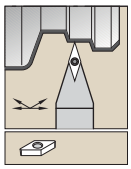


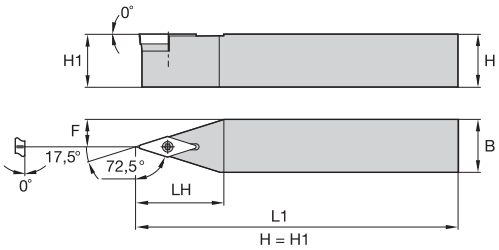


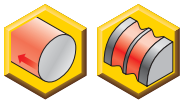
SVJB-F 93°



order number	catalogue number	H	B	F	L1	LH	gage insert	insert screw	Torx
right hand									
1097797	**SVJBRF1010M11Q**	10	10	10,0	150	23,0	VB..110304	**MS1153**	T7
1097798	**SVJBRF1212M11Q**	12	12	12,0	150	23,0	VB..110304	**MS1153**	T7
1097799	**SVJBRF1616K16Q**	16	16	16,0	125	31,0	VB..160408	**MS1155**	T15
left hand									
1097942	**SVJBLF1010M11Q**	10	10	10,0	150	23,0	VB..110304	**MS1153**	T7
1097943	**SVJBLF1212M11Q**	12	12	12,0	150	23,0	VB..110304	**MS1153**	T7
1097944	**SVJBLF1616K16Q**	16	16	16,0	125	31,0	VB..160408	**MS1155**	T15





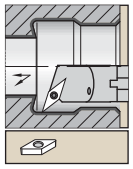


SVVB 72,5°

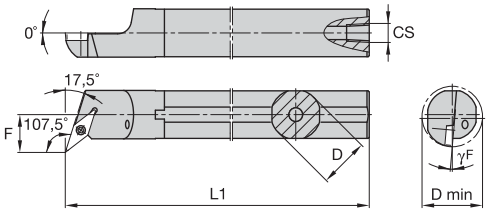


order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	insert screw	Torx
1097990	**SVVBN1212N11**	12	12	6,0	160	26,0	VB..110304	–	–	–	**MS1153**	T7
1097991	**SVVBN1616H11**	16	16	8,0	100	26,0	VB..110304	–	–	–	**MS1153**	T7
1244961	**SVVBN1616H16**	16	16	8,0	100	33,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
1244962	**SVVBN2020K11**	20	20	10,0	125	26,0	VB..110304	–	–	–	**MS1153**	T7
1097992	**SVVBN2020K16**	20	20	10,0	125	33,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
1097993	**SVVBN2525M16**	25	25	12,5	150	33,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15
1192561	**SVVBN3225P16**	32	25	12,5	170	33,0	VB..160408	**SKVN343**	**SRS3**	3.5 mm	**MS1156**	T15

Screw-On Boring Bars



Steel shank with through coolant.

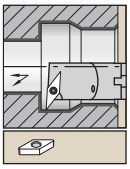




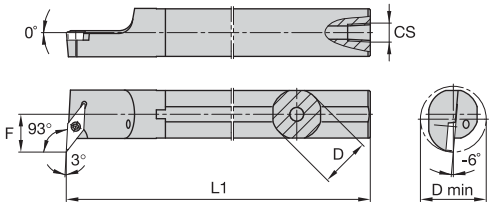
A-SVQB 107,5°



order number	catalogue number	D	D min	F	L1	CS	γF°	gage insert	insert screw	Torx
right hand										
1098232	**A16RSVQBR11**	16	20,0	11,0	200	1/8-27 NPT	-7.0	VB..110304	**MS1153**	T7
1098248	**A20SSVQBR11**	20	25,0	13,0	250	1/8-27 NPT	-6.0	VB..110304	**MS1153**	T7
1098274	**A25TSVQBR16**	25	32,0	17,0	300	1/4-18 NPT	-6.0	VB..160408	**MS1155**	T15
left hand										
1098233	**A16RSVQBL11**	16	20,0	11,0	200	1/8-27 NPT	-7.0	VB..110304	**MS1153**	T7
1098253	**A20SSVQBL11**	20	25,0	13,0	250	1/8-27 NPT	-6.0	VB..110304	**MS1153**	T7
1098277	**A25TSVQBL16**	25	32,0	17,0	300	1/4-18 NPT	-6.0	VB..160408	**MS1155**	T15



Steel shank with through coolant.



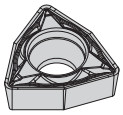


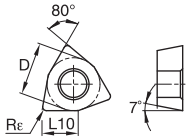
A-SVUB 93°



order number	catalogue number	D	D min	F	L1	CS	gage insert	insert screw	Torx
right hand									
1098249	**A20SSVUBR11**	20	25,0	13,0	250	1/8-27 NPT	VB..110304	**MS1153**	T7
1098275	**A25TSVUBR16**	25	32,0	17,0	300	1/4-18 NPT	VB..160408	**MS1155**	T15
left hand									
1098254	**A20SSVUBL11**	20	25,0	13,0	250	1/8-27 NPT	VB..110304	**MS1153**	T7
1098278	**A25TSVUBL16**	25	32,0	17,0	300	1/4-18 NPT	VB..160408	**MS1155**	T15

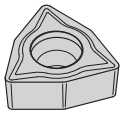
● first choice
○ alternate choice

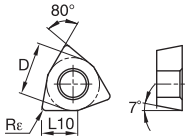




WCMT-FP

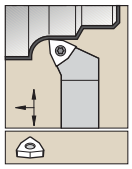
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
				P																												
				M																												
				K																												
				N																												
				S																												
				H																												
WCMT040204FP	6,35	4,34	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	–
WCMT06T308FP	9,53	6,52	0,8	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

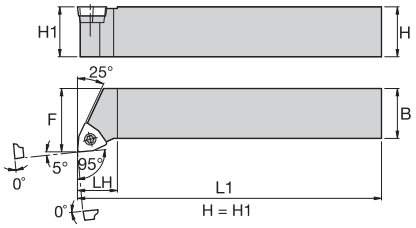




WCMT-LF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
				P																												
				M																												
				K																												
				N																												
				S																												
				H																												
WCMT040204LF	6,35	4,34	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
WCMT06T308LF	9,53	6,52	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–





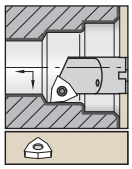


SWLC 95°

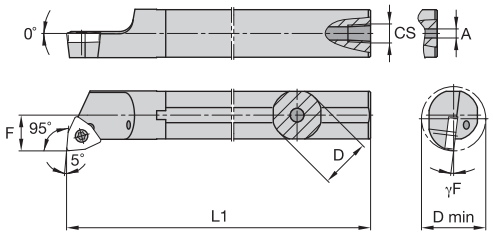


order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	insert screw	Torx
right hand												
1097732	**SWLCR2020K06**	20	20	25,0	125	16,0	WC..06T308	**SKWP343**	**SRS3**	3.5 mm	**MS1156**	T15

Screw-On Boring Bars



Steel shank with through coolant.



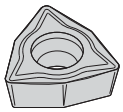


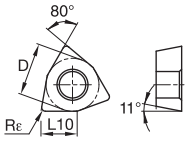
A-SWLC 95°



order number	catalogue number	D	D min	F	L1	A	CS	γF°	gage insert	insert screw	Torx
right hand											
1328642	**A06MSWLCR2**	10	12,2	6,4	152	3,2	–	-8.0	WC..2151	**MS1939**	T7
1328644	**A08RSWLCR2**	13	15,2	7,9	203	4,0	1/16-27 NPT	-6.0	WC..2151	**MS1153**	T7
1098062	**A10KSWLCR04**	10	13,0	7,0	125	3,0	–	-7.0	WC..040204	**MS1153**	T7
1328646	**A10SSWLCR3**	16	19,6	10,3	254	4,0	1/8-27 NPT	-7.0	WC..3252	**MS1155**	T15
1098063	**A12MSWLCR04**	12	16,0	9,0	150	–	1/16-27 NPT	-6.0	WC..040204	**MS1153**	T7
1098064	**A16RSWLCR06**	16	20,0	11,0	200	4,0	1/8-27 NPT	-7.0	WC..06T308	**MS1155**	T15
1098065	**A20SSWLCR06**	20	25,0	13,0	250	4,0	1/8-27 NPT	-5.0	WC..06T308	**MS1155**	T15
left hand											
1098069	**A16RSWLCL06**	16	20,0	11,0	200	4,0	1/8-27 NPT	-7.0	WC..06T308	**MS1155**	T15

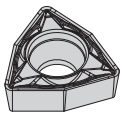
● first choice
○ alternate choice

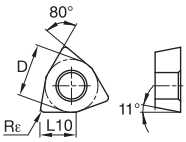




WPGT-UF

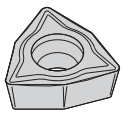
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
				P																												
				M																												
				K	○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
				N																		●	●	●		●	●	●	●	●		
				S																		●	●	●	●	●	●	●	●			
				H																												
WPGTS30101UF	4,76	3,26	0,1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–
WPGTS30102UF	4,76	3,26	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–
WPGT040202UF	6,35	4,34	0,2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

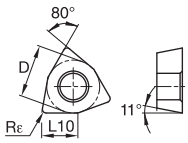




WPMT-FP

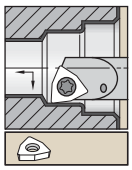
ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
				P																												
				M																												
				K	○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
				N																		●	●	●		●	●	●	●	●		
				S																		●	●	●	●	●	●	●	●			
				H																												
WPMTS3T104FP	4,76	3,25	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
WPMT040204FP	6,35	4,34	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–
WPMT06T304FP	9,53	6,52	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
WPMT06T308FP	9,53	6,52	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–



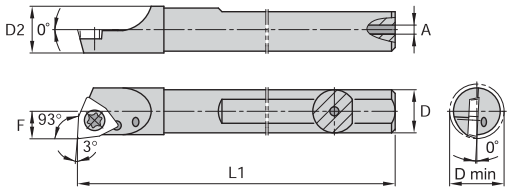


WPMT-LF

ISO catalogue number	D	L10	Rε	KCP05	KCP10B	KCP10	KCP25B	KCP25	KCP30	KCP40	KCK05B	KCK05	KCK15B	KCK15	KCK20B	KCK20	KCM15B	KCM15	KCM25B	KCM25	KCM35	KU10	K313	K68	KCS10	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KTP10
				P																												
				M																												
				K	○	○	○	○	○			●	●	●	●	●	●						●	●	●		●	●	●	●		●	●
				N																		●	●	●		●	●	●	●	●		
				S																		●	●	●	●	●	●	●	●			
				H																												
WPMTS3T104LF	4,76	3,25	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–
WPMT040204LF	6,35	4,34	0,4	–	–	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–
WPMT06T304LF	9,53	6,52	0,4	–	–	–	–	●	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
WPMT06T308LF	9,53	6,52	0,8	–	–	–	●	–	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–



Steel shank with through coolant.

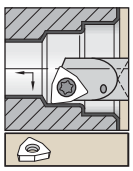




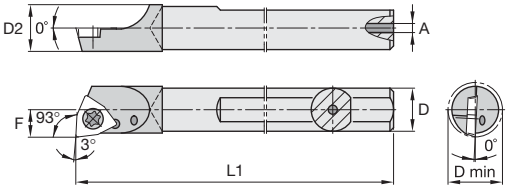
A-SWUP 93°



order number	catalogue number	D	D min	D2	F	L1	A	gage insert	insert screw	Torx
right hand										
1930544	**A06HSWUPRS3**	6	6,8	6,2	3,4	102	1,0	WP..S30104	**CT11**	T6
1930546	**A08HSWUPRS3**	8	8,8	8,2	4,4	102	2,4	WP..S30104	**CT11**	T6
1930556	**A12MSWUPR04**	12	12,9	12,2	6,6	152	4,0	WP..040204	**QTM20**	T7



Carbide shank with through coolant.





E-SWUP 93°



order number	catalogue number	D	D min	D2	F	L1	A	gage insert	insert screw	Torx
right hand										
1930550	**E06MSWUPRS3**	6	6,8	6,2	3,4	152	1,2	WP..S30104	**CT11**	T6
1930552	**E08MSWUPRS3**	8	8,8	–	4,4	152	2,4	WP..S30104	**CT11**	T6
1930558	**E10SSWUPR04**	10	11,0	–	5,6	254	3,2	WP..040204	**QTM20**	T7
1930560	**E12SSWUPR04**	12	12,9	–	6,6	254	4,7	WP..040204	**QTM20**	T7
left hand										
1930549	**E06MSWUPLS3**	6	6,8	6,2	3,4	152	1,2	WP..S30104	**CT11**	T6

Turning with Advanced Material Inserts

Ceramic, PcBN, and PCD Inserts

Turning inserts made from advanced materials, such as ceramics, PcBN (polycrystalline cubic boron nitride), and PCD (polycrystalline diamond), can be applied in hard-part turning and machining of cast irons, hardened materials, high-temp alloys, and non-ferrous materials.

Ceramic, PcBN, and PCD inserts offer:
- Improved performance.
- Greater wear resistance.



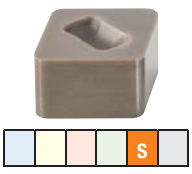
Ceramic Inserts

- Silicon-nitride based ceramic for cast iron machining.
- Mixed ceramic for hard machining and finishing of cast iron.
- Whisker ceramic for high-temp alloys and hard machining.

KYK25



KYS30™

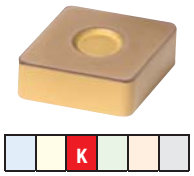


PcBN

Solid Inserts

- Inserts are made only from PcBN.
- No material joint.
- Best heat-absorption capacity.
- Can work at highest temperatures.

KBK45



Tipped Inserts

- Require a carrier and a PcBN tip.
- The tips are brazed to a carrier.
- The substrate has to have a pocket that will accommodate and support the tip.

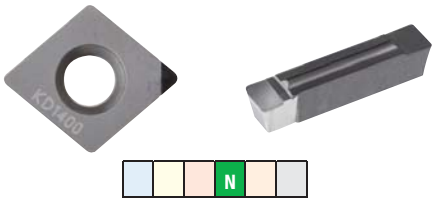
KBH20™



PCD

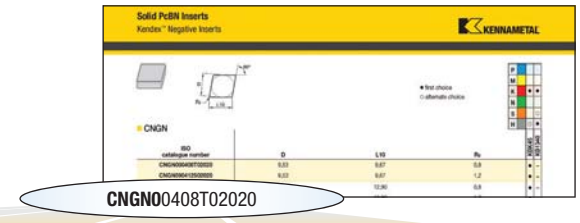
- Targeted machining of non-ferrous materials.
- Significant advantage in hardness over carbide tools.
- Increased productivity through higher speeds and longer tool life.
- Best used in processing materials that are un-machinable with conventional tooling.

KD1400



How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



C — Insert Shape

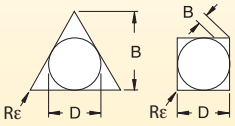
H	Hexagon 120°	
O	Octagon 135°	
P	Pentagon 108°	
R	Round —	
S	Square 90°	
T	Triangular 60°	
C D E M V	Rhomboid 80° 55° 75° 86° 35°	
W	Trigon 80° with enlarged corner angles	
L	Rectangular 90°	
A B N/K	Parallelogram 85° 82° 55°	

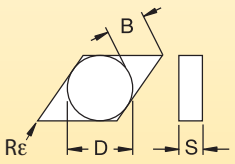
N — Insert Clearance Angle

A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	For other clearance angles requiring descriptions.

G — Tolerance Class

Tolerances apply prior to edge prep and coating





D = Theoretical diameter of the insert inscribed circle
S = Thickness
B = See figures below

N — Insert Features

N	
R	
F	
A	
M	
G	
W	
T	
Q	
U	
B	
H	
C	
J	
X V	Special Design

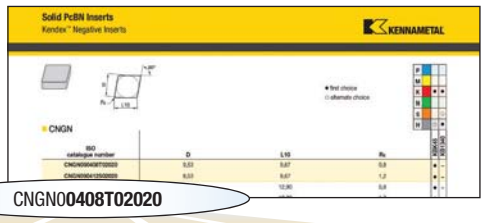
O — Size

"D"	Code for metric cutting edge length "L10"						
mm	C	D	R	S	T	V	W
3,97	S4	04	03	03	06	—	—
4,76	04	05	04	04	08	08	S3
5,56	05	06	05	05	09	09	03
6,00	—	—	06	—	—	—	—
6,35	06	07	06	06	11	11	04
7,94	08	09	07	07	13	13	05
8,00	—	—	08	—	—	—	—
9,52	09	11	09	09	16	16	06
10,00	—	—	10	—	—	—	—
11,11	11	13	11	11	19	19	07
12,00	—	—	12	—	—	—	—
12,70	12	15	12	12	22	22	08
14,29	14	17	14	14	24	24	09
15,88	16	19	15	15	27	27	10
16,00	—	—	16	—	—	—	—
17,46	17	21	17	17	30	30	11
19,05	19	23	19	19	33	33	13
20,00	—	—	20	—	—	—	—
22,22	22	27	22	22	38	38	15
25,00	—	—	25	—	—	—	—
25,40	25	31	25	25	44	44	17
31,75	32	38	31	31	54	54	21
32,00	—	—	32	—	—	—	—

tolerance class*	tolerance on "D"	tolerance on "B"	tolerance on "S"
C	±0,025	±0,013	±0,025
H	±0,013	±0,013	±0,025
E	±0,025	±0,025	±0,025
G	±0,025	±0,025	±0,013
M	See tables on next page		±0,013
U	See tables on next page		±0,013

*Tolerances apply prior to edge prep and coating.

By referencing this easy-to-use guide, you can identify the correct product to meet your needs.



04	08		T	020	20		
Thickness "S"	Corner Radius "Rε"	Hand of Insert *(optional)*	Cutting Edge *(optional)*	T-Land Width *(optional)*	T-Land Angle *(optional)*	Tip Style *(optional)*	Chipbreaker *(optional)*

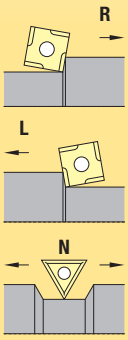
symbol	thickness
mm	mm
—	0,79
T0	1,00
01	11,59
T1	1,98
02	2,38
03	3,18
T3	3,97
04	4,76
05	5,56
06	6,35
07	7,94
09	9,52
11	11,11
12	12,70

symbol	corner radius
mm	mm
X0	0,4
01	0,1
02	0,2
04	0,4
08	0,8
12	1,2
16	1,6
20	2,0
24	2,4
28	2,8
32	3,2
00	round insert
M0	

R = Right hand

L = Left hand

N = Neutral



F* Sharp

E Rounded

T* Chamfered

S* Chamfered and Rounded

K Double-Chamfered

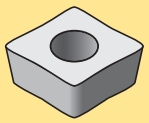
P Double-Chamfered and Rounded

*Also available in wiper style.

symbol	size
ISO	mm
010	0,01
020	0,02

symbol	size
10	10°
15	15°
20	20°
25	25°
30	30°

symbol	usage
C	full tip
M	mini tip
MT	multi-tip
ST	single tip



FW = Finishing Wiper

MW = Medium Wiper

"D"	± Tolerance on "D"			
	Class M Tolerance			Class U Tolerance
	Shapes S, T, C, R, & W	Shape D	Shape V	Shapes S, T, & C
mm	mm	mm	mm	mm
3,97	0,05	–	–	–
4,76	0,05	–	–	0,08
5,56	0,05	0,05	0,05	0,08
6,35	0,05	0,05	0,05	0,08
7,94	0,05	0,05	0,05	0,08
9,52	0,05	0,05	0,05	0,08
11,11	0,08	0,08	0,08	0,13
12,70	0,08	0,08	0,08	0,13
14,29	0,08	0,08	0,08	0,13
15,88	0,10	0,10	0,10	0,18
17,46	0,10	0,10	0,10	0,18
19,05	0,10	0,10	0,10	0,18
22,22	0,13	–	–	0,25
25,40	0,13	–	–	0,25
31,75	0,15	–	–	0,25

"D"	± Tolerance on "B"			
	Class M Tolerance			Class U Tolerance
	Shapes S, T, C, R, & W	Shape D	Shape V	Shapes S, T, & C
mm	mm	mm	mm	mm
3,97	0,08	–	–	–
4,76	0,08	–	–	0,13
5,56	0,08	0,11	–	0,13
6,35	0,08	0,11	–	0,13
7,94	0,08	0,11	–	0,13
9,52	0,08	0,11	0,18	0,13
11,11	0,13	0,15	–	–
12,70	0,13	0,15	0,25	0,20
14,29	0,13	0,15	–	–
15,88	0,15	0,18	–	0,27
17,46	0,15	0,18	–	0,27
19,05	0,15	0,18	–	0,27
22,22	0,15	–	–	0,38
25,40	0,18	–	–	0,38
31,75	0,20	–	–	0,38

Advanced Materials for Cast Iron Machining

Primary Application

The Kennametal advanced materials, utilising Beyond™ technology, offer greater wear resistance and toughness, depending on the job.

KYK ceramic inserts are the first choice for high-speed, continuous, and lightly interrupted turning applications in cast iron materials. Benefits include improved fracture toughness, better wear resistance, and an extended application range. Combining grades KYK10™ and CVD-coated KYK25™ with our other ceramic grades for cast iron, Kennametal provides a complete high-performance ceramic portfolio that can reduce machining cycle times and lower manufacturing costs.

The Kennametal SiAlON grades, such as KYK10 grade, can be applied at high cutting speeds up to the PcBN range and at varying cast iron material machinability. Combining SiAlON material science, CVD coating technology, and PcBN grades for cast iron machining, Kennametal provides a complete high-performance portfolio that can reduce cycle time and lower machining costs.

Features and Benefits

Solid PcBN Inserts

KBK45™ Grade

- Designed for elevated abrasion-resistance.
- Go-to grade for cost-per-part manufacturing.
- For roughing and finishing.
- Gold colour for improved usage monitoring.

KB1340™ Grade

- Designed for elevated abrasion-resistance.
- High-temperature resistance.
- For roughing and finishing.

Tipped PcBN Inserts

KB5630™ Grade

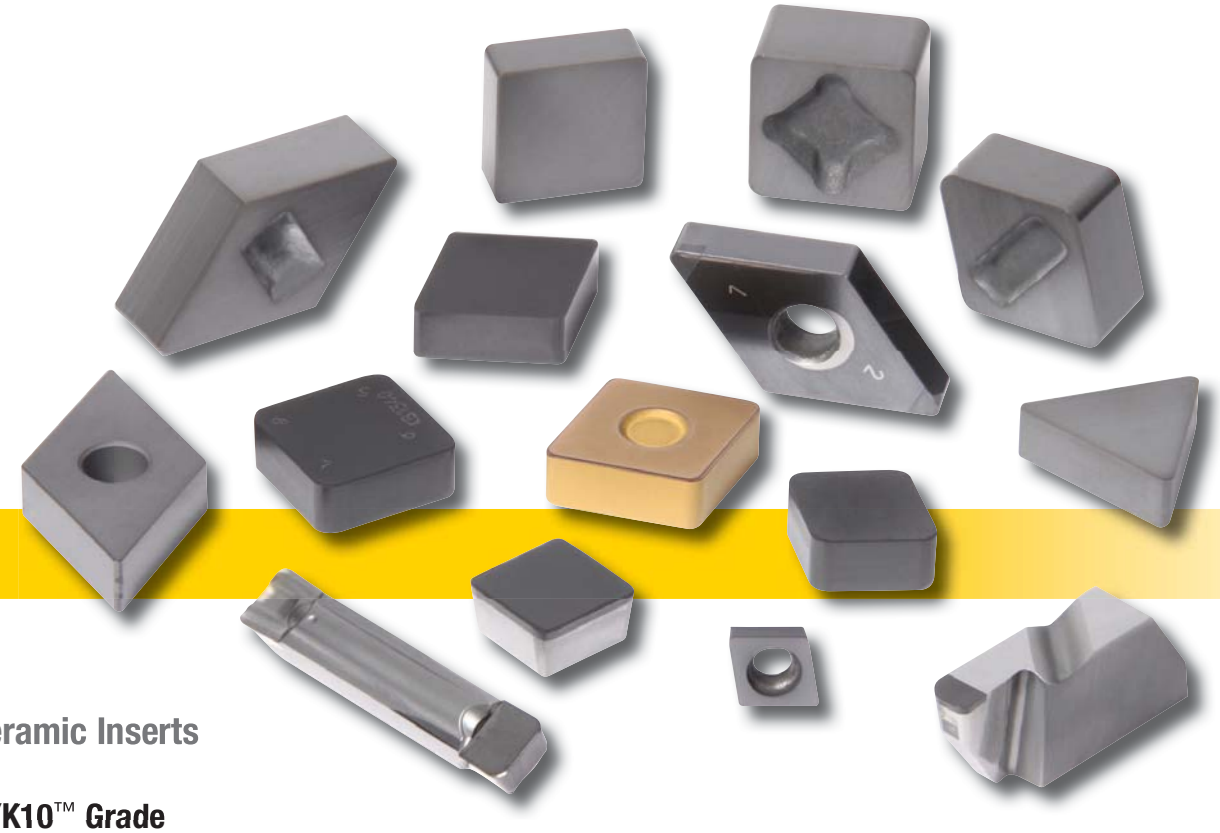
- Laminated material for fine finishing.
- Excellent edge stability.
- PVD coating for reliable tool life, even at varying material machinability.

KB1345™ Grade

- Abrasion-resistant high CBN content tipped grade.
- Very fine PcBN structure suitable for fine finishing applications.

KBK45™ grade provides the best cost-per-part in cast irons.

KB5630™ grade has greater abrasion resistance for chilled and hardened irons.



Ceramic Inserts

KYK10™ Grade

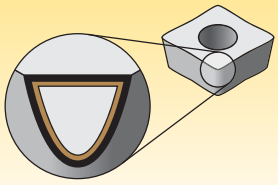
- Improved wear resistance and toughness with up to 20% longer tool life than current KY1310™ grade.
- Best suited for continuous turning of cast iron materials and in lightly interrupted cuts.

KYK25™ Grade

- 12-micron thick coating provides excellent wear resistance, and pre-coat treatment allows for very consistent tool life and performance in cast iron applications.
- Up to 30% longer tool life vs. competitors' CVD-coated ceramic grades.

KY3500™ Grade

- Excellent for roughing to finishing operations in wet or dry cuts with speeds up to 1000 m/min.
- Performs well in difficult interrupted cuts in ductile or malleable cast iron (<70 KSI tensile strength) at speeds of 250–450 m/min.



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

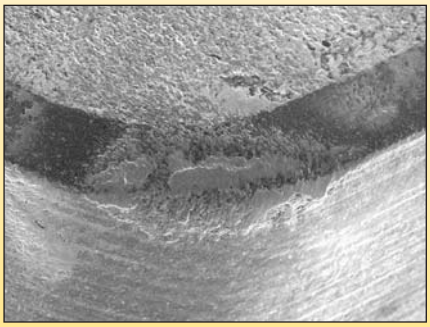
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

wear resistance ← → toughness

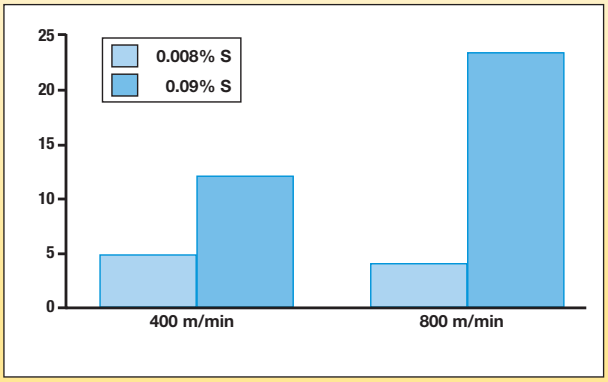
	Coating	Grade Description	05	10	15	20	25	30	35	40	45
Solid PcBN Grades	KBK45 —	**Composition:** A PVD TiN coated high CBN content, solid PcBN insert having multiple cutting edges. **Application:** Applied in roughing to finishing of grey and hard cast irons. Also used for finishing chilled cast iron and fully pearlitic cast iron. The solid PcBN insert offers better security and shock resistance compared to tipped PcBN inserts, while also enabling deeper depth-of-cut capabilities. beyond			K	K	K	K	K	K	
	KB1340 —	**Composition:** A high CBN content, solid PcBN insert having multiple cutting edges. **Application:** Applied in roughing to finishing of fully pearlitic grey cast iron, chilled irons, high-chrome alloyed steels, and heavy cuts in hardened steels (>45 HRC). The solid PcBN insert offers better security and shock resistance compared to tipped PcBN inserts, while also enabling deeper depth-of-cut capabilities.		K	K	K	K	K			
Tipped PcBN Grades	KB1345 —	**Composition:** A high CBN content, PcBN tip brazed onto a carbide insert. **Application:** Applied in roughing to finishing of fully pearlitic grey cast iron, chilled irons, high-chrome alloyed steels, sintered powdered metals, and heavy cuts in hardened steels (>45 HRC). Also used for finishing chilled cast iron and fully pearlitic cast iron. The tipped PcBN insert is available in a wide range of insert styles including positive rake geometries that are ideally suited for boring applications.				K	K	K	K	K	K
	KB5630 —	**Composition:** A high content PcBN with a PVD AlTiN coating for added wear resistance. **Application:** Designed for roughing to finishing of hardened steels (>45 HRC), abrasive workpiece materials such as sintered valve seat materials, powder metallurgy steels, and hard high-alloy cast irons. The PVD coating provides resistance to crater wear and increased resistance to chipping. A wide range of styles are available, including Screw-On geometries that are ideal for boring applications.			K	K	K	K	K		
Ceramic Grades	KYK10 —	**Composition:** An advanced SiAlON ceramic grade. **Application:** Provides maximum wear resistance. Used for high-speed continuous turning of grey cast iron, including through scale. To be used for varying cast iron machinability. beyond			K	K	K	K	K	K	K
	KYK25 —	**Composition:** Pure silicon nitride ceramic with an alumina CVD coating. **Application:** Excellent combination of toughness and edge wear resistance. Used for general purpose machining of grey, ductile, or nodular cast irons. To be used for varying cast iron machinability. beyond			K	K	K	K	K	K	K
	KY3500 —	**Composition:** Pure silicon nitride grade. **Application:** Maximum toughness. Used at high feed rates for rough machining of grey cast iron, including machining through interruptions.			K	K	K	K	K	K	K

Machinability of Cast Iron

- Unaged casting is difficult to machine and leads to shorter tool life.
- Low sulphur content leads to shorter tool life.
- High titanium content decreases the tool life significantly.
- Increased ferrite content leads to high chemical wear and a substantially shorter tool life.
- Compacted graphite cast iron shows high chemical wear.



Proper application of KB1340™ — formation of protective layer; tool life should exceed 70 km sliding distance.

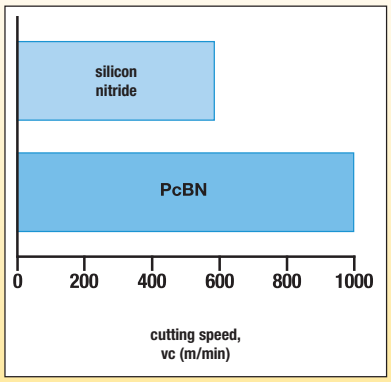


Comparison of the life of PcBN cutting tools in machining two different grey cast irons, primarily differing in sulphur content.

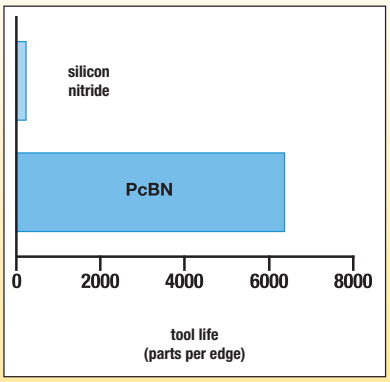
Grey Cast Iron Brake Disk Machining • Ceramic vs. PcBN



(a)



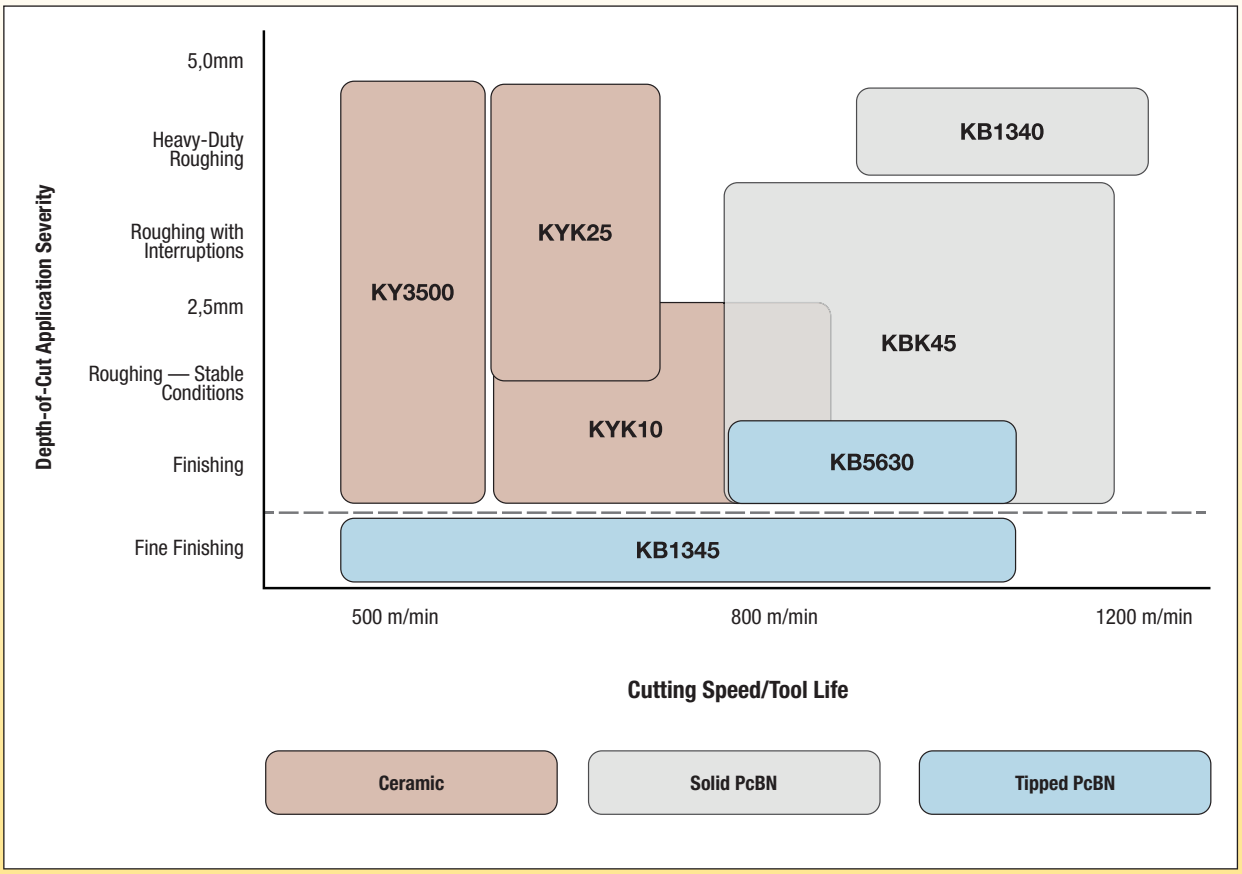
(b)



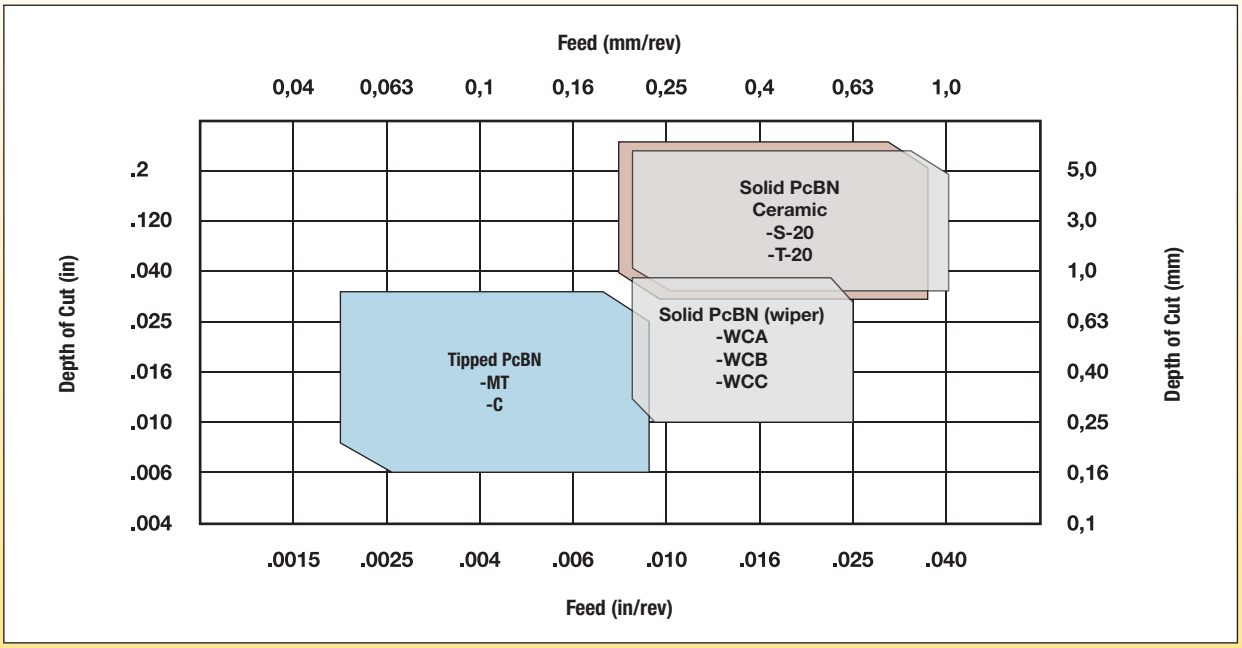
(c)

PcBN increases productivity when machining grey iron brake disks (a) in terms of cutting speed (b) and tool life (c) compared to silicon nitride ceramic.

Select the Cutting Material



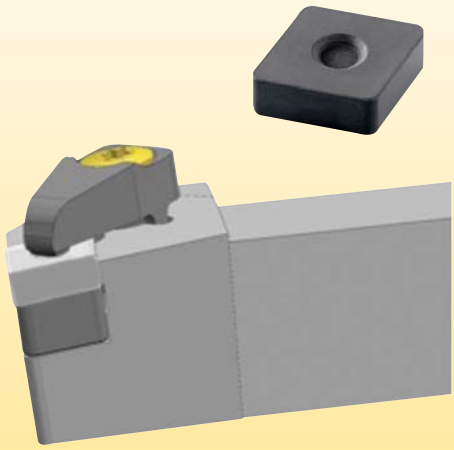
Depth of Cut



Dimple Clamps for Added Stability

Typical Application

Continuous cost pressures force manufacturers of grey cast iron brake disks to look for cost-cutting solutions. CBN inserts deliver high productivity and long tool life. Kennametal has developed the solid, high-content grade KB1340™, which provides superior performance when machining grey cast iron components, such as brake disks or fly wheels. To ensure secure seating in the toolholder, the inserts are available with dimple-design clamping. The clamps fit Ceramtec holders, which makes the conversion to Kennametal tooling easier.



Higher Productivity and Profitability

- Ensures tight and rigid clamping.
- Dimpled insert with special clamping provides increased stability in the pocket.
- Ideal for use in heavy-duty machining applications.
- Cladded clamps for improved resistance against chip wash are available upon request.
- The shallow dimple design enables the use of less expensive 4,76mm (3/16") inserts.
- Round dimple design works with custom tooling where clamping direction must be offset due to space limitations.

Clamp Selection Chart

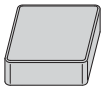
inserts		clamp	
ANSI Catalogue Number	ISO Catalogue number	Catalogue Number	Order Number
CNGX433S0415	CNGX120412S01015	551.718–100° Corner	3968904
CNGX433S0415FW	CNGX120412S01015FW	551.718–100° Corner	3968904
CNGX434S0820	CNGX120416S02020	551.718–100° Corner	3968904
CNGF432	CNGF120408	551.718–100° Corner	3968904
DNGX434S0820	DNGX150416S02020	551.720	4094234
SNGX434S0820	SNGX120416S02020	551.718	3968904
SNGX534S0820	SNGX150416S02020	551.718	3968904
VNGX333S0820	VNGX160412S02020	551.721	4094236
TNGX333EFW	TNGX160412EFW	551.733	4094235

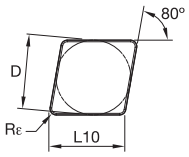
Wipers for Cast Iron Machining

WCA
Wiper for cast iron machining for a feed rate up to f = 0,25 mm/rev.

WCB
Wiper for cast iron machining for a feed rate up to f = 0,45 mm/rev.

WCC
Wiper for cast iron machining for a feed rate up to f = 0,65 mm/rev.



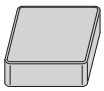


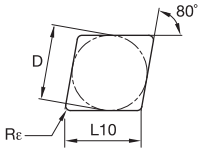
● first choice
○ alternate choice

P		
M		
K	●	●
N		
S		○
H	○	●

CNGN

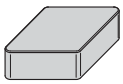
ISO catalogue number	D	L10	Rε	KBK45	KB1340
CNGN090408T02020	9,53	9,67	0,8	●	–
CNGN090412S02020	9,53	9,67	1,2	●	–
CNGN120408T02020	12,70	12,90	0,8	●	–
CNGN120412S02020	12,70	12,90	1,2	●	–
CNGN120416S02020	12,70	12,90	1,6	●	–

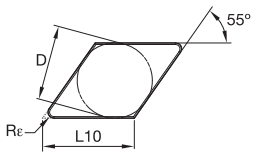




CNMN

ISO catalogue number	D	L10	Rε	KBK45	KB1340
CNMN120408S02020	12,70	12,90	0,8	–	●
CNMN120412S02020	12,70	12,90	1,2	–	●

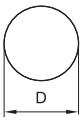




DNGN

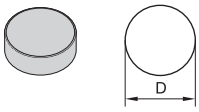
ISO catalogue number	D	L10	Rε	KBK45	KB1340
DNGN120408S02020	10,00	12,21	0,8	●	–
DNGN120412S02020	10,00	12,21	1,2	●	–





RNGN

ISO catalogue number	D	L10	Rε	KBK45	KB1340
RNGN090400S02020	9,53	–	–	●	–
RNGN120400S02020	12,70	–	–	●	–



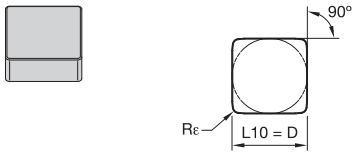
● first choice
○ alternate choice

P		
M		
K	●	●
N		
S		○
H	○	●

RNMN

ISO catalogue number	D	L10	Rε	KBK45	KB1340
RNMN090300S02020	9,53	–	–	–	●
RNMN120300S02020	12,70	–	–	–	●
RNMN120400S02020	12,70	–	–	–	●

Kendex Positive Inserts

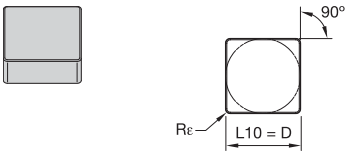


P		
M		
K	●	●
N		
S		○
H	○	●

SNGN

ISO catalogue number	D	L10	Rε	KBK45	KB1340
SNGN120408T02020	12,70	12,70	0,8	●	–
SNGN120412S02020	12,70	12,70	1,2	●	–
SNGN120416S02020	12,70	12,70	1,6	●	–

Kendex Positive Wiper Inserts

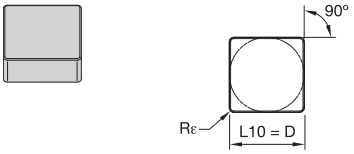


● first choice
○ alternate choice

P		
M		
K	●	●
N		
S		○
H	○	●

SNGN-WCB

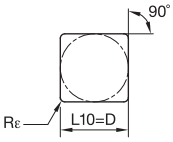
ISO catalogue number	D	L10	Rε	KBK45	KB1340
SNGN090408S01015WCB	9,53	9,52	0,8	●	–



SNGN-WCC

ISO catalogue number	D	L10	Rε	KBK45	KB1340
SNGN090408S01015WCC	9,53	9,53	0,8	●	–





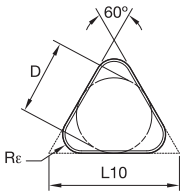
● first choice
○ alternate choice

P		
M		
K	●	●
N		
S		○
H	○	●

SNMN

ISO catalogue number	D	L10	Rε	KBK45	KB1340
SNMN090308S02020	9,53	9,53	0,8	–	●
SNMN090316S02020	9,53	9,53	1,6	–	●
SNMN120316S02020	12,70	12,70	1,6	–	●
SNMN120416T02020	12,70	12,70	1,6	–	●

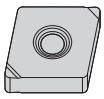


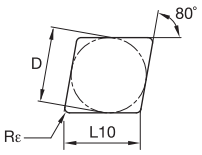


TNGN

ISO catalogue number	D	L10	Rε	KBK45	KB1340
TNGN110416S02020	6,35	11,00	1,6	●	–
TNGN160416S02020	9,53	16,50	1,6	●	–

Kendex™ Negative Dimple Inserts





● first choice
○ alternate choice

P		
M		
K	●	●
N		
S		○
H	○	●

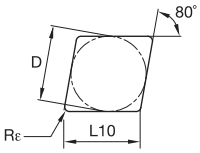
CNGF

ISO catalogue number	D	L10	Rε	KBK45	KB1340
CNGF120408	12,70	12,90	0,8	–	●

● first choice
○ alternate choice

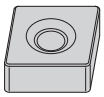
P		
M		
K	●	●
N		
S		○
H	○	●

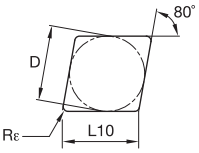




CNGX

ISO catalogue number	D	L10	Rε	KBK45	KB1340
CNGX120408T02020	12,70	12,90	0,8	●	–
CNGX120412S01015	12,70	12,90	1,2	–	●
CNGX120412S02020	12,70	12,90	1,2	●	–
CNGX120416S02020	12,70	12,90	1,6	●	●

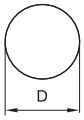




CNGX-FW

ISO catalogue number	D	L10	Rε	KBK45	KB1340
CNGX120412S01015FW	12,70	12,90	1,2	–	●

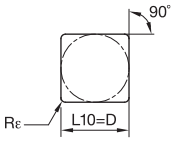




RNGX

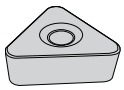
ISO catalogue number	D	L10	Rε	KBK45	KB1340
RNGX120400S02020	12,70	–	–	●	–

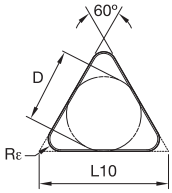




SNGX

ISO catalogue number	D	L10	Rε	KBK45	KB1340
SNGX120408T02020	12,70	12,70	0,8	●	–
SNGX120412S02020	12,70	12,70	1,2	●	–
SNGX120416S02020	12,70	12,70	1,6	●	●





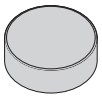
● first choice
○ alternate choice

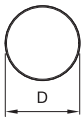
P		
M		
K	●	●
N		
S		○
H	○	●

TNGX

ISO catalogue number	D	L10	Rε	KBK45	KB1340
TNGX160416S02020	9,53	16,50	1,6	●	–

Kendex™ Positive Inserts





● first choice
○ alternate choice

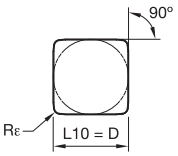
P		
M		
K	●	●
N		
S		○
H	○	●

RCGN

ISO catalogue number	D	L10	Rε	KBK45	KB1340
RCGN090400T01015	9,53	–	–	●	–

Kendex™ Negative Wiper Inserts





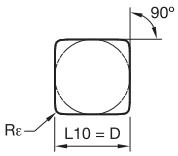
● first choice
○ alternate choice

P		
M		
K	●	●
N		
S		○
H	○	●

SCGN-WCB

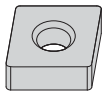
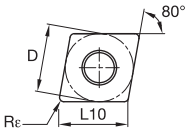
ISO catalogue number	D	L10	Rε	KBK45	KB1340
SCGN090408S01015WCB	9,53	9,52	0,8	●	–





SCGN-WCC

ISO catalogue number	D	L10	Rε	KBK45	KB1340
SCGN090408S01015WCC	9,53	9,52	0,8	●	–

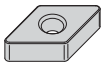
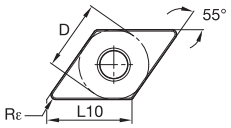
● first choice
○ alternate choice

P		
M		
K	●	●
N		
S		○
H	○	●

CNMA

ISO catalogue number	D	L10	Rε	KBK45	KB1340
CNMA120408S02020	12,70	12,90	0,8	–	●
CNMA120412S02020	12,70	12,90	1,2	–	●

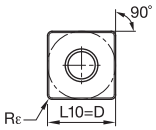
NOTE: For toolholders and boring bars, see pages B58–B73.

DNMA

ISO catalogue number	D	L10	Rε	KBK45	KB1340
DNMA110408S02020	9,53	11,63	0,8	–	●
DNMA110412S02020	9,53	11,63	1,2	–	●

NOTE: For toolholders and boring bars, see pages B85–B93.

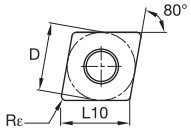



SNMA

ISO catalogue number	D	L10	Rε	KBK45	KB1340
SNMA120412S02020	12,70	12,70	1,2	–	●

NOTE: For toolholders and boring bars, see pages B105–B121.

Advanced Material Inserts • Hard Turning Materials

● first choice
○ alternate choice

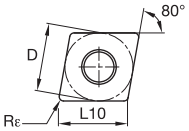
P		
M		
K	●	●
N		
S	○	●
H	●	●

CNGA-FWMT

ISO catalogue number	D	L10	Rε	KB1345	KB5630
CNGA120404S01025FWMT	12,70	12,90	0,4	–	●
CNGA120408S01025FWMT	12,70	12,90	0,8	–	●

NOTE: For toolholders and boring bars, see pages B58–B73.





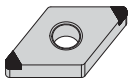
● first choice
○ alternate choice

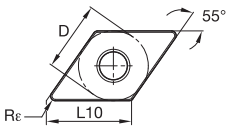
P			
M			
K	●	●	
N			
S	○	●	
H	●	●	

CNGA-MT

ISO catalogue number	D	L10	Rε	KB1345	KB5630
CNGA120404S01025MT	12,70	12,90	0,4	–	●
CNGA120408S01020MT	12,70	12,90	0,8	●	–
CNGA120408S01025MT	12,70	12,90	0,8	–	●
CNGA120408S02020MT	12,70	12,90	0,8	●	–
CNGA120412S01020MT	12,70	12,90	1,2	–	●
CNGA120412S01025MT	12,70	12,90	1,2	–	●

NOTE: For toolholders and boring bars, see pages B58–B73.





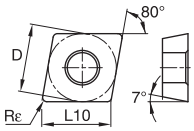
DNGA-MT

ISO catalogue number	D	L10	Rε	KB1345	KB5630
DNGA150404S01025MT	12,70	15,50	0,4	–	●
DNGA150408S01020MT	12,70	15,50	0,8	●	–
DNGA150408S01025MT	12,70	15,50	0,8	–	●

NOTE: For toolholders and boring bars, see pages B85–B93.

Advanced Material Inserts • Hard Turning Materials





● first choice
○ alternate choice

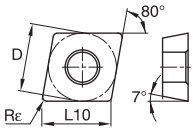
P			
M			
K	●	●	
N			
S	○	●	
H	●	●	

CCGW-C

ISO catalogue number	D	L10	Rε	KB1345	KB5630
CCGW060202S01015C	6,35	6,45	0,2	–	●
CCGW060204S01015C	6,35	6,45	0,4	–	●
CCGW09T308EC	9,53	9,67	0,8	●	–

NOTE: For toolholders and boring bars, see pages B179–B183.





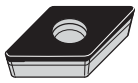
● first choice
○ alternate choice

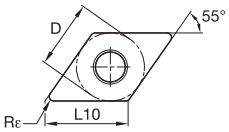
P		
M		
K	●	●
N		
S	○	●
H	●	●

CCGW-MT

ISO catalogue number	D	L10	Rε	KB1345	KB5630
CCGW09T304S01015MT	9,53	9,67	0,4	–	●
CCGW09T308S01015MT	9,53	9,67	0,8	–	●

NOTE: For toolholders and boring bars, see pages B179–B183.

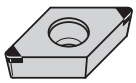


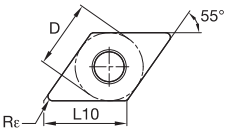


DCGW-C

ISO catalogue number	D	L10	Rε	KB1345	KB5630
DCGW070202S01015C	6,35	7,75	0,2	–	●
DCGW070204S01015C	6,35	7,75	0,4	–	●

NOTE: For toolholders and boring bars, see pages B209–B213.





● first choice
○ alternate choice

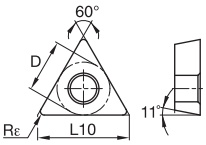
P		
M		
K	●	●
N		
S	○	●
H	●	●

DCGW-MT

ISO catalogue number	D	L10	Rε	KB1345	KB5630
DCGW11T304S01015MT	9,53	11,63	0,4	●	●
DCGW11T308S01015MT	9,53	11,63	0,8	●	●

NOTE: For toolholders and boring bars, see pages B209–B213.

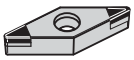


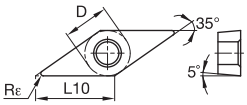


TPGW-C

ISO catalogue number	D	L10	Rε	KB1345	KB5630
TPGW110204EC	6,35	11,00	0,4	●	–
TPGW110208S01015C	6,35	11,00	0,8	–	●

NOTE: For toolholders and boring bars, see pages B257–B263.





● first choice
○ alternate choice

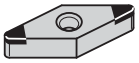
P			
M			
K		●	●
N			
S		○	●
H		●	●

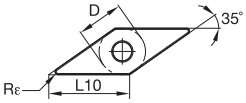
VBGW-MT

ISO catalogue number	D	L10	Rε	KB1345	KB5630
VBGW160404S01015MT	9,53	16,61	0,4	–	●
VBGW160408S01015MT	9,53	16,61	0,8	–	●

NOTE: For toolholders and boring bars, see pages B266–B269.

Kenloc™ Inserts





● first choice
○ alternate choice

P			
M			
K		●	●
N			
S		○	●
H		●	●

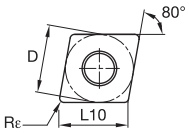
VNGA-MT

ISO catalogue number	D	L10	Rε	KB1345	KB5630
VNGA160404S01025MT	9,53	16,61	0,4	–	●
VNGA160408S01025MT	9,53	16,61	0,8	–	●

NOTE: For toolholders and boring bars, see pages B149–B153.

ISO Ceramic Inserts • Kenloc™ Inserts





● first choice
○ alternate choice

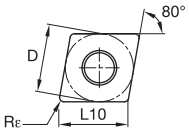
P			
M			
K		●	●
N			
S			
H			

CNGA

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
CNGA120408T02020	12,70	12,90	0,8	●	●	●
CNGA120412T02020	12,70	12,90	1,2	●	●	●
CNGA120416T02020	12,70	12,90	1,6	●	●	●
CNGA160612T02020	15,88	16,12	1,2	●	–	●
CNGA160616T02020	15,88	16,12	1,6	–	–	●
CNGA190612T02020	19,05	19,34	1,2	–	–	●
CNGA190616T02020	19,05	19,34	1,6	●	–	●

NOTE: For toolholders and boring bars, see pages B58–B73.





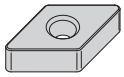
● first choice
○ alternate choice

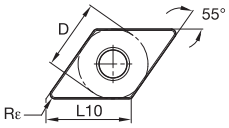
P			
M			
K	●	●	●
N			
S			
H			

CNGA-FW

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
CNGA120408T01020FW	12,70	12,90	0,8	●	–	●
CNGA120412T01020FW	12,70	12,90	1,2	●	●	●
CNGA120412T02020FW	12,70	12,90	1,2	–	●	–
CNGA120416T01020FW	12,70	12,90	1,6	–	–	●

NOTE: For toolholders and boring bars, see pages B58–B73.



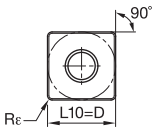


DNGA

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
DNGA150408T02020	12,70	15,50	0,8	–	–	●
DNGA150412T02020	12,70	15,50	1,2	–	–	●
DNGA150416T02020	12,70	15,50	1,6	●	●	●
DNGA150608T02020	12,70	15,50	0,8	–	–	●
DNGA150612T02020	12,70	15,50	1,2	–	–	●

NOTE: For toolholders and boring bars, see pages B85–B93.

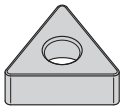


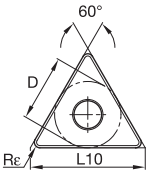


SNGA

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
SNGA120408T02020	12,70	12,70	0,8	●	●	●
SNGA120412T02020	12,70	12,70	1,2	●	–	●
SNGA120416T02020	12,70	12,70	1,6	–	–	●
SNGA150612T02020	15,88	15,88	1,2	–	–	●
SNGA150612T02020	15,88	15,88	1,2	●	–	–
SNGA150616T02020	15,88	15,88	1,6	–	–	●
SNGA190612T02020	19,05	19,05	1,2	–	–	●

NOTE: For toolholders and boring bars, see pages B105–B121.





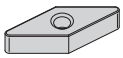
● first choice
○ alternate choice

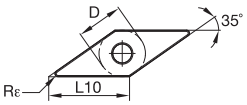
P				
M				
K	●	●	●	
N				
S				
H				

TNGA

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
TNGA160408T02020	9,53	16,50	0,8	–	●	●
TNGA160412T02020	9,53	16,50	1,2	–	–	●
TNGA160416T02020	9,53	16,50	1,6	–	–	●

NOTE: For toolholders and boring bars, see pages B132–B142.

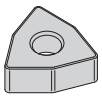


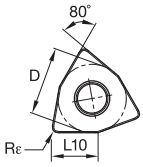


VNGA

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
VNGA160408T02020	9,53	16,61	0,8	–	–	●
VNGA220408T02020	12,70	22,14	0,8	●	–	–

NOTE: For toolholders and boring bars, see pages B149–B153.

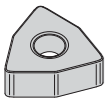


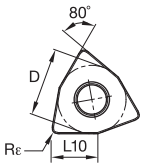


WNGA

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
WNGA080408T02020	12,70	8,69	0,8	●	–	●
WNGA080412T02020	12,70	8,69	1,2	●	–	●
WNGA080416T02020	12,70	8,69	1,6	–	–	●

NOTE: For toolholders and boring bars, see pages B161–B165.



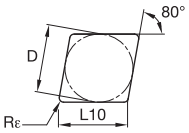


WNGA-FW

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
WNGA080408T01020FW	12,70	8,69	0,8	–	–	●

NOTE: For toolholders and boring bars, see pages B161–B165.



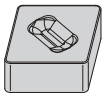


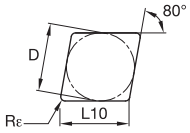
● first choice
○ alternate choice

P			
M			
K	●	●	●
N			
S			
H			

CNGN

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
CNGN120408T02020	12,70	12,90	0,8	–	–	●
CNGN120412T02020	12,70	12,90	1,2	–	–	●
CNGN120416T02020	12,70	12,90	1,6	–	–	●
CNGN120712T02020	12,70	12,90	1,2	–	–	●
CNGN120716T02020	12,70	12,90	1,6	–	●	–

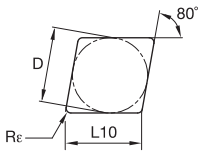




CNGX-FW

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
CNGX120708T01020FW	12,70	12,90	0,8	–	–	●
CNGX120712T01020FW	12,70	12,90	1,2	–	–	●
CNGX120716T01020FW	12,70	12,90	1,6	–	–	●



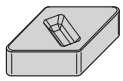


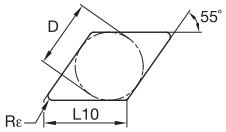
CNMX

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
CNMX120708T02020	12,70	12,90	0,8	–	–	●
CNMX120712T02020	12,70	12,90	1,2	–	–	●
CNMX120716T02020	12,70	12,90	1,6	–	–	●

● first choice
○ alternate choice

P			
M			
K	●	●	●
N			
S			
H			

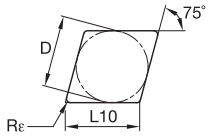




DNGX

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
DNGX120708T02020	10,00	12,21	0,8	–	–	●
DNGX120712T02020	10,00	12,21	1,2	●	–	●
DNGX120716T02020	10,00	12,21	1,6	–	–	●
DNGX150708T02020	12,70	15,50	0,8	–	–	●
DNGX150712T02020	12,70	15,50	1,2	●	–	●
DNGX150716T02020	12,70	15,50	1,6	–	–	●

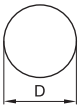




ENGX

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
ENGX130716T02020	12,70	13,15	1,6	–	–	●

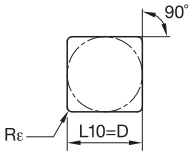




RNGN

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
RNGN120400T02020	12,70	–	–	–	●	●
RNGN120700T02020	12,70	–	–	–	–	●
RNGN190700T02020	19,05	–	–	–	–	●





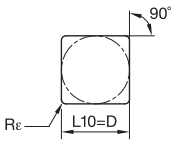
● first choice
○ alternate choice

P				
M				
K	●	●	●	
N				
S				
H				

SNGN

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
SNGN090308T02020	9,53	9,53	0,8	–	–	●
SNGN120408T02020	12,70	12,70	0,8	●	–	●
SNGN120412T02020	12,70	12,70	1,2	●	–	●
SNGN120416T02020	12,70	12,70	1,6	–	–	●
SNGN120432T02020	12,70	12,70	3,2	–	–	●
SNGN120712T02020	12,70	12,70	1,2	●	–	–
SNGN120716T02020	12,70	12,70	1,6	–	–	●
SNGN190416T02020	19,05	19,05	1,6	–	–	●

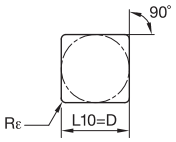




SNGX

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
SNGX120712T02020	12,70	12,70	1,2	●	●	●
SNGX120716T02020	12,70	12,70	1,6	●	●	●
SNGX150716T02020	15,88	15,88	1,6	–	–	●
SNGX150724T02020	15,88	15,88	2,4	–	–	●



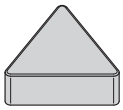


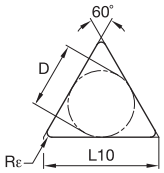
● first choice
○ alternate choice

P				
M				
K	●	●	●	
N				
S				
H				

SNMX

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
SNMX120712T02020	12,70	12,70	1,2	–	–	●
SNMX120716T02020	12,70	12,70	1,6	–	–	●
SNMX150716T02020	15,88	15,88	1,6	–	–	●

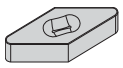


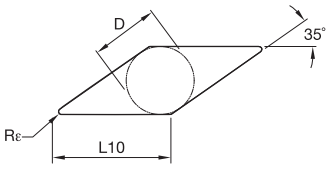


TNGN

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
TNGN160408T02020	9,53	16,50	0,8	–	–	●
TNGN220416T02020	12,70	22,00	1,6	–	–	●

Kendex™ Negative Dimple Inserts





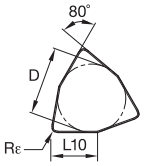
● first choice
○ alternate choice

P				
M				
K	●	●	●	
N				
S				
H				

VNGX

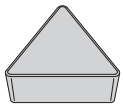
ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
VNGX160712T02020	9,52	16,61	1,2	–	–	●
VNGX160716T02020	9,53	16,61	1,6	–	–	●

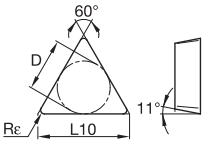




WNGX

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
WNGX080712T02020	12,70	8,69	1,2	–	●	●



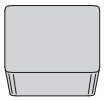


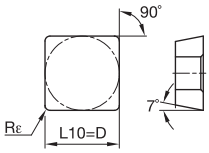
● first choice
○ alternate choice

P				
M				
K	●	●	●	
N				
S				
H				

TPGN

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
TPGN160308T02020	9,53	16,50	0,8	–	–	●
TPGN160312T02020	9,53	16,50	1,2	–	●	●
TPGN220408T02020	12,70	22,00	0,8	–	–	●
TPGN220412T02020	12,70	22,00	1,2	–	–	●



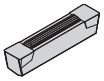


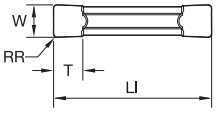
SCGN-FW

ISO catalogue number	D	L10	Rε	KYK25	KYK10	KY3500
SCGN090408EFW	9,53	9,53	0,8	–	–	●

Clamp Selection Chart

order number	catalogue number	clamp	
3960807	CNGX120412S01015	551.718–100° Corner	551.716–80° Corner
3960808	CNGX120412S01015FW	551.718–100° Corner	551.716–80° Corner
3960806	CNGX120416S02020	551.718–100° Corner	551.716–80° Corner
3960811	DNGX150416S02020	551.720	551.720
3960812	SNGX120416S02020	551.718	551.718
3960823	SNGX150416S02020	551.718	551.718
3876843	CNGF120408	551.718–100° Corner	551.716–80° Corner
3960825	TNGX160412EFW	551.733	551.733





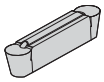
● first choice
○ alternate choice

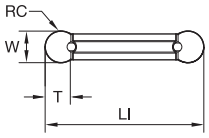
P		
M		
K		●
N		
S		
H		

A4G-P-T

ISO catalogue number	seat size	W	RR	LI	T	KY3500
A4G0300M03P04T01025	3	3,00	0,4	20	3,4	●
A4G125I03P1T0425	3	3,18	0,4	20	3,4	●
A4G0400M04P04T01025	4	4,00	0,4	20	3,4	●
A4G0500M05P08T01025	5	5,00	0,8	25	4,2	●
A4G0600M06P08T01025	6	6,00	0,8	30	4,8	●
A4G250I06P2T0425	6	6,35	0,8	30	4,9	●
A4G0800M08P08T01025	8	8,00	0,8	30	6,4	●

NOTE: For A4 holder, boring bars, and blades, see pages C104–C135.





A4R-P-T

ISO catalogue number	seat size	W	RC	LI	T	KY3500
A4R0300M03P00T01025	3	3,00	1,5	20	2,4	●
A4R0500M05P00T01025	5	5,00	2,5	25	4,1	●
A4R0600M06P00T01025	6	6,00	3,0	30	4,3	●
A4R250I06P00T0425	6	6,35	3,2	30	4,8	●
A4R0800M08P00T01025	8	8,00	4,0	30	6,4	●

NOTE: For A4 holder, boring bars, and blades, see pages C104–C135.

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Hard Turning

High- and Low-Content PcBN Inserts

The current global metalcutting climate has put increased focus on high productivity and cost reductions coming from cutting tools. These requirements lead to the rapid growth and implementation of cutting tools using superhard materials. As the name implies, these materials have a significant advantage in hardness over conventional tool materials. For the end user this translates into increased productivity (higher cutting speeds, longer tool life, etc.), lower tooling cost per part, and the ability to process materials that were previously not machinable with conventional tooling.

Kennametal is at the forefront of developing and implementing superhard materials in our standard and special tooling solutions across all our product lines. Our approach to superhard tooling starts with customer needs and constraints. We then develop the best superhard solutions for the customer's specific needs.



PcBN is thermally stable up to approximately 1200º C and has high resistance to chemical attack. As a result, extreme temperatures like those that occur when machining hard ferrous metals do not cause difficulties and can be used to promote self-induced hot cutting. This adds technical and productivity benefits, especially when compared with grinding. In most cases, performance is significantly better than that attained with conventional tool materials, such as tungsten carbides and ceramics.

There are limitations for PcBN, however, in the machining of austenitic steels and ferritic cast irons, which can cause increased PcBN edge wear.

PcBN Inserts

KBH10™ Grade

High Volume

- A new patented low PcBN content grade for continuous turning operations.
- Excellent performance in the machining of hardened steels with lower carbide inclusion content.
- Available as tipped and solid PcBN inserts.

KBH20™ Grade

Higher Productivity and Profitability



- Newly developed substrate allows application in a wide variety of demanding applications.
- Nano-composite coating enhances speed capabilities and tool life. Improved edge preparation technology for longer tool life, reliable performance, better surface finish, and tighter workpiece tolerances.
- Large standard portfolio.
- CB1 chipbreaker in positive and negative geometry, solving chipbreaking and chip control issues.

KB5630™ Grade



- Best applied in severe cutting conditions and heavy interruptions.
- Excellent abrasion resistance.
- PVD coating provides a thermal barrier to reduce crater wear and extend tool life.
- Excellent performance in machining of hardened steels and powder metals.
- Available as tipped and full face PcBN inserts.

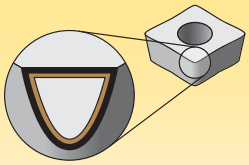
Ceramic Inserts

KY1615 Grade

Low Volume and Higher Process Variations



- Mixed (black) ceramic.
- Excellent wear resistance combined with good toughness properties.
- Excellent performance in the finishing and semi-finishing of hardened steels and iron-based materials.



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

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

wear resistance ← → toughness

PcBN — Polycrystalline Cubic Boron Nitride Grades

KBH20

Coating: —

Composition: A low content PcBN grade with a PVD TiN/AlTiN coating for added wear resistance.
Application: KBH20™ is the ideal PcBN hard turning grade for continuous to lightly interrupted cutting applications. The structure, as well as the different edge preparations, enable repeatable workpiece tolerances, excellent surface finishes, and surface integrity. Typical applications are case-hardened steel components such as gears, shafts, and other drive-train components.

	05	10	15	20	25	30	35	40	45
P									
M									
K									
N									
S									
H			■	■	■				

KBH10

Coating: —

Composition: A low content PcBN grade with a patented binder structure.
Application: Designed for the precision machining of hardened steels (>45 HRC). It can be effectively applied on bearing steels, hot and cold work tool steels, high speed steels, die steels, case hardened steels, carburised and nitrided irons, and some hard coatings. Available in a multi-tip format with a wide range of edge preps, insert styles, and wiper geometries.

	05	10	15	20	25	30	35	40	45
P									
M									
K									
N									
S									
H	■	■	■						

KB5630

Coating: —

Composition: A high content PcBN with a PVD AlTiN coating for added wear resistance.
Application: Designed for roughing to finishing of hardened steels (>45 HRC), abrasive workpiece materials such as sintered valve seat materials, powder metallurgy steels, and hard high-alloy cast irons. The PVD coating provides resistance to crater wear and increased resistance to chipping. A wide range of styles are available, including Screw-On geometries that are ideal for boring applications.

	05	10	15	20	25	30	35	40	45
P									
M									
K	■	■	■						
N									
S		■	■						
H					■	■	■		

Ceramic Grades

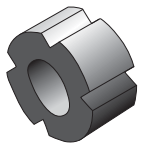
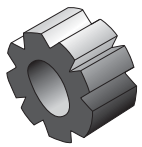
KY1615

Coating: —

Composition: An advanced lumina/TiC black ceramic grade.
Application: Great combination of toughness and wear resistance; used for machining alloy steels, tool steels, and stainless steels to 60 HRC (653 HB). It is also applied in finish turning and boring of cast irons.

	05	10	15	20	25	30	35	40	45
P									
M									
K									
N									
S									
H	■	■							

Tool Testing Information

	Grade	Sharp	Light Cut Edge Metric Inch	Standard Cut Edge Metric Inch	Strong Cut Edge Metric Inch
	KBH10*	E	10 15 04 15	12 25 05 25	custom
	KBH20*	custom	10 15 04 15	12 25 05 25	17 35 07 35
	KB5630***	custom	custom	10 25 04 25	17 35 07 35

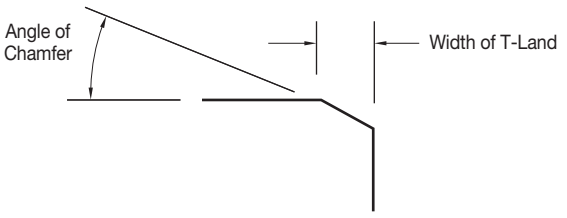
- X Crater Wear
- ✔ Chipping
- ✔ Breakages
- ✔ Stability

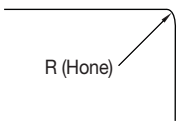
- ✔ Crater Wear
- X Chipping
- ✔ Breakages
- X Stability

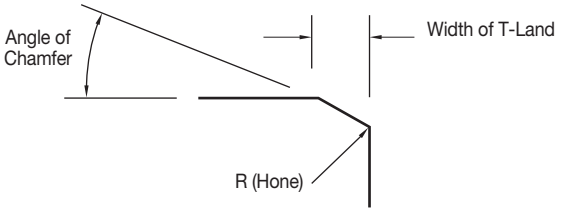
NOTE: KBH20™ Inserts with 1225 (0525 in inch) are the inserts of choice for initial testing.
For fine tuning, stay in the same grade but use either sharper edges in light cuts or heavier edges if need to overcome interruptions and variations.
If KBH20 is failing, change grade to either a more wear–resistant or fracture–resistant grade.
* Lowest toughness
** Medium toughness
*** Highest toughness

E = Hone
T = T-land with angle
S = T-land with angle and hone

Example: S01015 is a 100 µm T-land at 15 degrees with honing.







Step 1 • Select the insert geometry

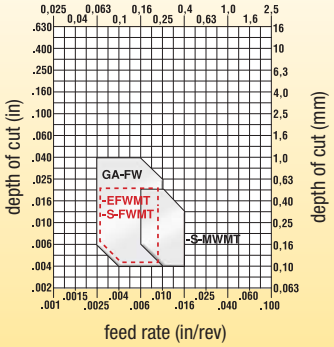
Negative Wiper Inserts



-S..MWMT (multitipped) Medium Wiper

..MS (multitipped) Finishing Wiper

-S..FWMT (multitipped) Finishing Wiper

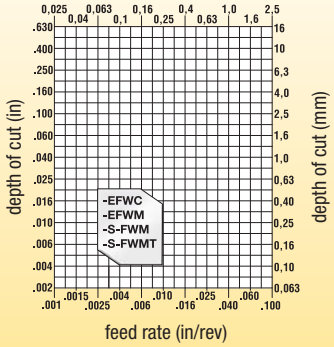


Positive Wiper Inserts



-EFWC (full face) -EFWM (single tipped) Finishing Wiper

-S..FWM (single tipped) -S..FWMT (multitipped) Fine Finishing Wiper

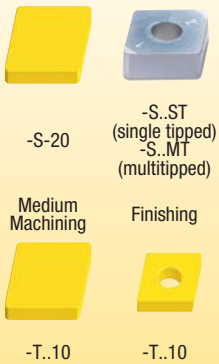


Step 2 • Select the grade

cutting condition	Negative Insert Geometry -S..FWMT	Negative Insert Geometry -EFWMT	Positive Insert Geometry -S..FWMT	Positive Insert Geometry -S..FWM -S..FWMT	Positive Insert Geometry -EFWM -EFWC
heavily interrupted cut	KB5630	KB5630	–	–	–
lightly interrupted cut	KB5630/KBH20	KBH20	KBH20	KBH20	KBH20
varying depth of cut, casting, or forging skin	KBH20	KB1610/KBH10	KBH20	KBH20	KBH20
smooth cut, pre-turned surface	KBH10	KBH10	KBH10	KBH10	KBH10

Step 1 • Select the insert geometry

Negative Wiper Inserts

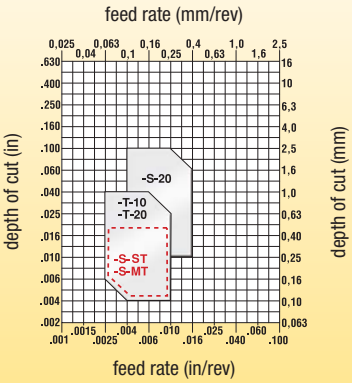


-S-20 Medium Machining

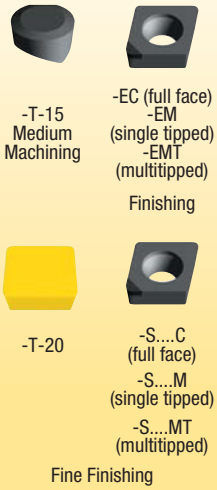
-S..ST (single tipped) -S..MT (multitipped) Finishing

-T..10 -T.20 Fine Finishing

-T..10 -T.20



Positive Wiper Inserts

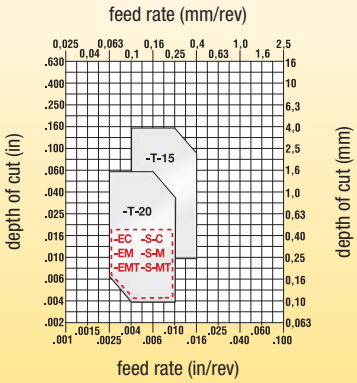


-T-15 Medium Machining

-EC (full face) -EM (single tipped) -EMT (multitipped) Finishing

-T-20

-S....C (full face) -S....M (single tipped) -S....MT (multitipped) Fine Finishing



Step 2 • Select the grade

cutting condition	Negative Insert Geometry -T.10 -T.20	Positive Insert Geometry -T-15
heavily interrupted cut	–	–
lightly interrupted cut	–	KY1615
varying depth of cut, casting, or forging skin	KY1615	KY1615
smooth cut, pre-turned surface	KY1615	KY1615

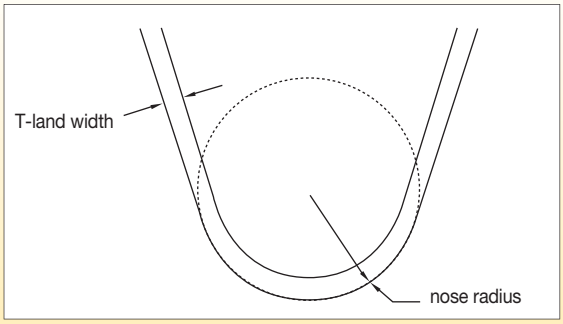
Step 1 • Select the cutting speed

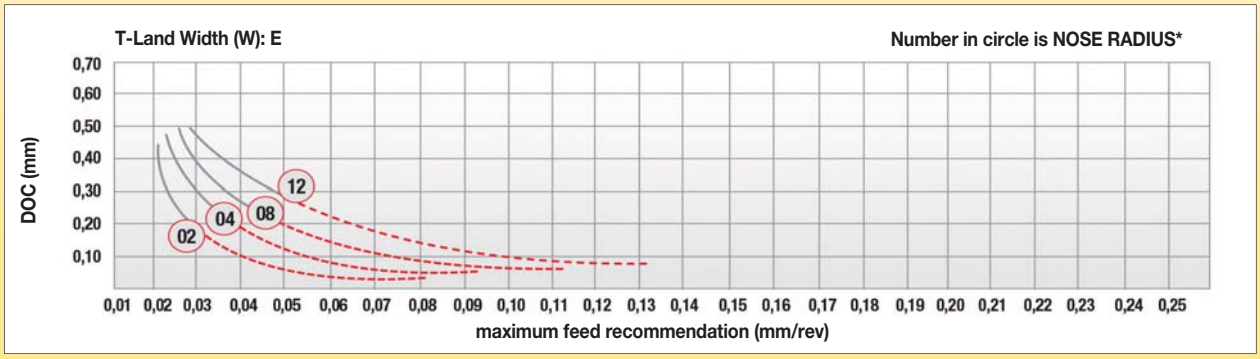
material group	grade	speed — m/min (SFM) 15 (50)	45 (150)	75 (250)	110 (350)	140 (450)	170 (550)	200 (650)	230 (750)	260 (850)	Starting Conditions m/min	SFM
H1	KBH20					◁▷					155	510
	KBH10					◁▷					150	490
	KB5630				◁▷						105	345
	KY1615				◁▷						100	325

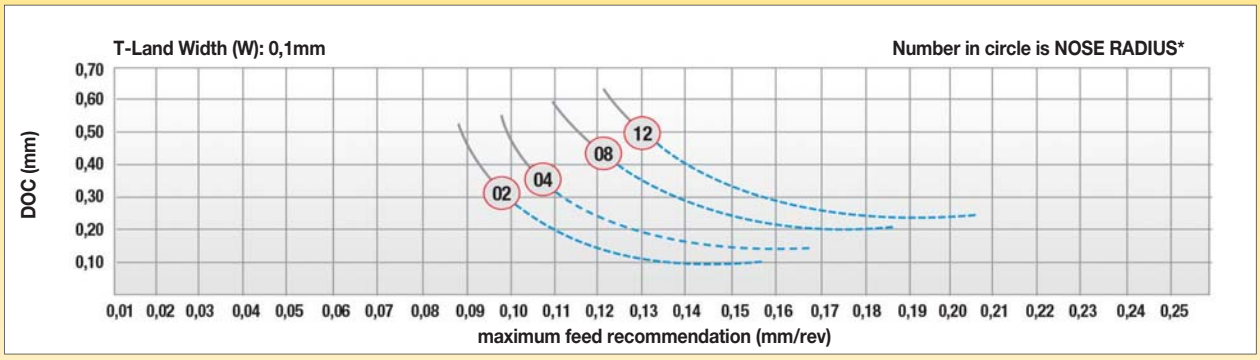
T-Land Width

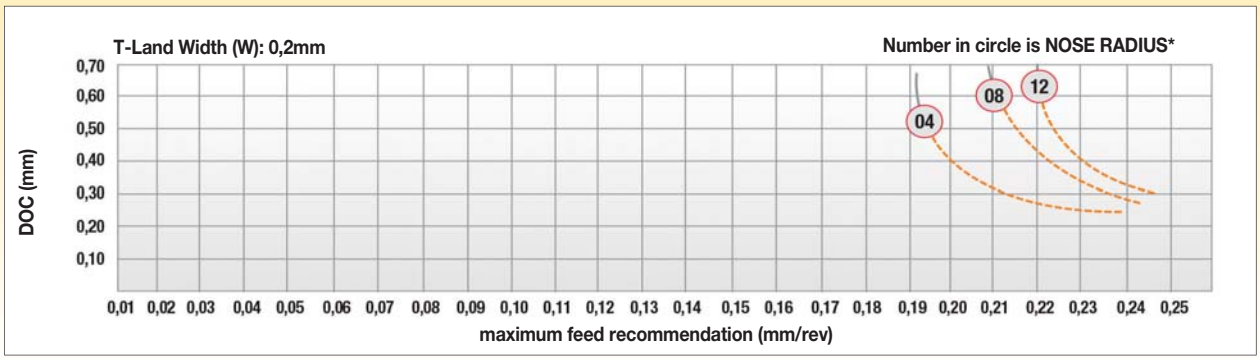
Example 1: If the feed, depth of cut, and the tool nose radius are fixed, use these values to see what T-land width should be used.

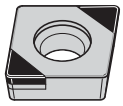
Example 2: If you want to use a specific T-land width or hone only edge, use the chart below to see what maximum feeds and depths of cut are recommended for different nose radii.

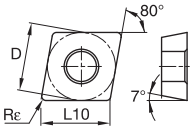












● first choice
○ alternate choice

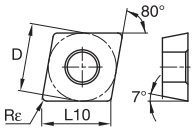
P			●	
M				
K			●	
N				
S			●	
H	●	●	●	●

CCGM

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
CCGM09T304S01325MTCB1	9,53	9,67	0,4	–	●	–	–
CCGM09T308S01325MTCB1	9,53	9,67	0,8	–	●	–	–

NOTE: For toolholders and boring bars, see pages B179–B183.

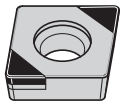


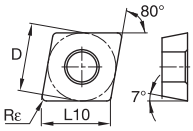


CCGW-C

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
CCGW060202S01015C	6,35	6,45	0,2	–	–	●	–
CCGW060204S01015C	6,35	6,45	0,4	–	–	●	–

NOTE: For toolholders and boring bars, see pages B179–B183.

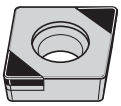


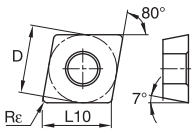


CCGW-FWMT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
CCGW09T304S01015FWMT	9,53	9,67	0,4	–	●	–	–
CCGW09T308S01015FWMT	9,53	9,67	0,8	●	●	–	–

NOTE: For toolholders and boring bars, see pages B179–B183.

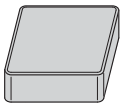


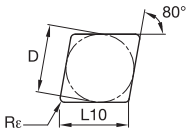


CCGW-MT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
CCGW060202S01015MT	6,35	6,45	0,2	●	–	–	–
CCGW060202S01225MT	6,35	6,45	0,2	–	●	–	–
CCGW060204S01015MT	6,35	6,45	0,4	●	–	–	–
CCGW060204S01225MT	6,35	6,45	0,4	–	●	–	–
CCGW09T302S01015MT	9,53	9,67	0,2	●	–	–	–
CCGW09T302S01225MT	9,53	9,67	0,2	–	●	–	–
CCGW09T304S01015MT	9,53	9,67	0,4	●	●	●	–
CCGW09T304S01225MT	9,53	9,67	0,4	●	●	–	–
CCGW09T308S01015MT	9,53	9,67	0,8	●	●	●	–
CCGW09T308S01225MT	9,53	9,67	0,8	●	●	–	–
CCGW120408S01015MT	12,70	12,90	0,8	–	●	–	–

NOTE: For toolholders and boring bars, see pages B179–B183.



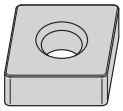


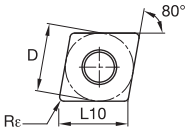
● first choice
○ alternate choice

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

CNGN

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
CNGN120404T02020	12,70	12,90	0,4	–	–	–	●
CNGN120408T02020	12,70	12,90	0,8	–	–	–	●
CNGN120708T02020	12,70	12,90	0,8	–	–	–	●
CNGN120412T02020	12,70	12,90	1,2	–	–	–	●
CNGN120712T02020	12,70	12,90	1,2	–	–	–	●
CNGN120716T02020	12,70	12,90	1,6	–	–	–	●
CNGN160716T02020	15,88	16,12	1,6	–	–	–	●
CNGN160716T05015	15,88	16,12	1,6	–	–	–	●

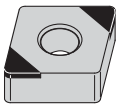


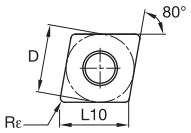


CNGA

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
CNGA120404T02020	12,70	12,90	0,4	–	–	–	●
CNGA120408T00520	12,70	12,90	0,8	–	–	–	●
CNGA120408T02020	12,70	12,90	0,8	–	–	–	●
CNGA120412T02020	12,70	12,90	1,2	–	–	–	●
CNGA120416T02020	12,70	12,90	1,6	–	–	–	●
CNGA160612T02020	15,88	16,12	1,2	–	–	–	●
CNGA190612T02020	19,05	19,34	1,2	–	–	–	●
CNGA190616T02020	19,05	19,34	1,6	–	–	–	●

NOTE: For toolholders and boring bars, see pages B58–B73.





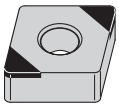
● first choice
○ alternate choice

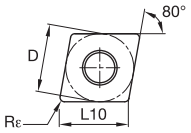
P			●	
M				
K			●	
N				
S			●	
H	●	●	●	●

CNGA-FWMT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
CNGA120404S01015FWMT	12,70	12,90	0,4	●	●	–	–
CNGA120404S01025FWMT	12,70	12,90	0,4	–	–	●	–
CNGA120408S01015FWMT	12,70	12,90	0,8	●	●	–	–
CNGA120408S01025FWMT	12,70	12,90	0,8	–	–	●	–
CNGA120408S01225FWMT	12,70	12,90	0,8	●	–	–	–
CNGA120412S01015FWMT	12,70	12,90	1,2	–	●	–	–
CNGA120412S01225FWMT	12,70	12,90	1,2	●	–	–	–

NOTE: For toolholders and boring bars, see pages B58–B73.

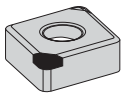


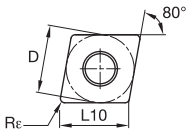


CNGA-MT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
CNGA120404S01015MT	12,70	12,90	0,4	●	●	–	–
CNGA120404S01025MT	12,70	12,90	0,4	–	–	●	–
CNGA120404S01225MT	12,70	12,90	0,4	–	●	–	–
CNGA120404S01735MT	12,70	12,90	0,4	–	●	–	–
CNGA120408S01015MT	12,70	12,90	0,8	●	●	–	–
CNGA120408S01025MT	12,70	12,90	0,8	–	–	●	–
CNGA120408S01225MT	12,70	12,90	0,8	●	●	–	–
CNGA120408S01735MT	12,70	12,90	0,8	●	●	–	–
CNGA120412S01015MT	12,70	12,90	1,2	●	●	–	–
CNGA120412S01020MT	12,70	12,90	1,2	–	–	●	–
CNGA120412S01025MT	12,70	12,90	1,2	–	–	●	–
CNGA120412S01225MT	12,70	12,90	1,2	●	●	–	–
CNGA120412S01735MT	12,70	12,90	1,2	●	●	–	–

NOTE: For toolholders and boring bars, see pages B58–B73.

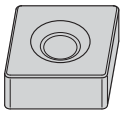


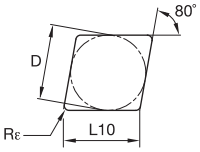


CNGM-CB1

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
CNGM120404S01325MTCB1	12,70	12,90	0,4	–	●	–	–
CNGM120408S01325MTCB1	12,70	12,90	0,8	–	●	–	–
CNGM120412S01325MTCB1	12,70	12,90	1,2	–	●	–	–

NOTE: For toolholders and boring bars, see pages B58–B73.





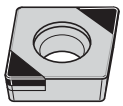
● first choice
○ alternate choice

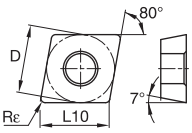
P				●	
M					
K				●	
N					
S				●	
H		●	●	●	●

CNGX

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
CNGX120708T02020	12,70	12,90	0,8	–	–	–	●
CNGX120712T02020	12,70	12,90	1,2	–	–	–	●

NOTE: For toolholders and boring bars, see pages B58–B73.

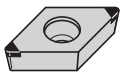


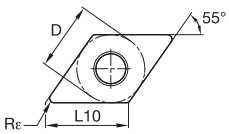


CPGW-MT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
CPGW09T304S01015MT	9,53	9,67	0,4	–	–	●	–
CPGW09T308S01015MT	9,53	9,67	0,8	–	–	●	–

NOTE: For toolholders and boring bars, see pages B192–B205.

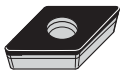


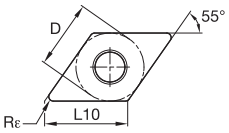


DCGM

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
DCGM11T304S01325MTCB1	9,53	11,63	0,4	–	●	–	–

NOTE: For toolholders and boring bars, see pages B209–B213.





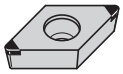
● first choice
○ alternate choice

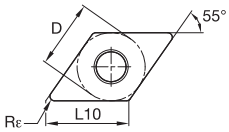
P			●	
M				
K			●	
N				
S			●	
H	●	●	●	●

DCGW-C

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
DCGW070202S01015C	6,35	7,75	0,2	–	–	●	–
DCGW070204S01015C	6,35	7,75	0,4	–	–	●	–

NOTE: For toolholders and boring bars, see pages B209–B213.

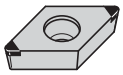


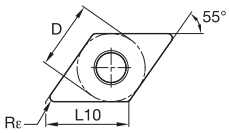


DCGW-FWMT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
DCGW11T308S01015FWMT	9,53	11,63	0,4	●	●	–	–
DCGW11T308S01225FWMT	9,53	11,63	0,4	●	–	–	–

NOTE: For toolholders and boring bars, see pages B209–B213.

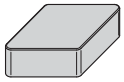


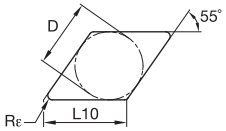


DCGW-MT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
DCGW070202S01225MT	6,35	7,75	0,2	–	●	–	–
DCGW070204S01015MT	6,35	7,75	0,4	–	●	–	–
DCGW070204S01225MT	6,35	7,75	0,4	–	●	–	–
DCGW70202S01015MT	6,35	7,75	0,4	●	–	–	–
DCGW70204S01015MT	6,35	7,75	0,4	●	–	–	–
DCGW70204S01225MT	6,35	7,75	0,4	●	–	–	–
DCGW11T302S01015MT	9,53	11,63	0,2	●	–	–	–
DCGW11T302S01225MT	9,53	11,63	0,2	–	●	–	–
DCGW11T304S01225MT	9,53	11,63	0,4	●	●	–	–
DCGW11T304S01015MT	9,53	11,63	0,4	●	●	●	–
DCGW11T308S01015MT	9,53	11,63	0,8	●	●	●	–
DCGW11T308S01225MT	9,53	11,63	0,8	●	●	–	–

NOTE: For toolholders and boring bars, see pages B209–B213.



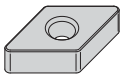


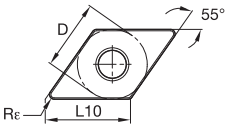
● first choice
○ alternate choice

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

DNGN/DNG

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
DNGN150704T02020	12,70	15,50	0,4	–	–	–	●
DNGN150708T02020	12,70	15,50	0,8	–	–	–	●
DNGN150712T02020	12,70	15,50	1,2	–	–	–	●
DNGN150716T02020	12,70	15,50	1,6	–	–	–	●

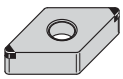


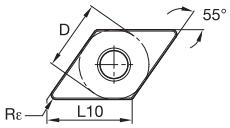


DNGA

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
DNGA150404T02020	12,70	15,50	0,4	–	–	–	●
DNGA150604T02020	12,70	15,50	0,4	–	–	–	●
DNGA150408T02020	12,70	15,50	0,8	–	–	–	●
DNGA150608T02020	12,70	15,50	0,8	–	–	–	●
DNGA150412T02020	12,70	15,50	1,2	–	–	–	●
DNGA150612T02020	12,70	15,50	1,2	–	–	–	●
DNGA150416T02020	12,70	15,50	1,6	–	–	–	●

NOTE: For toolholders and boring bars, see pages B85–B93.

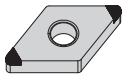


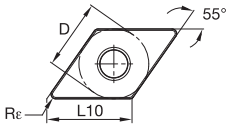


DNGA-FWMT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
DNGA150408S01015FWMT	12,70	15,50	0,4	●	●	–	–
DNGA150408S01225FWMT	12,70	15,50	0,4	●	–	–	–
DNGA150412S01015FWMT	12,70	15,50	0,8	–	●	–	–
DNGA150412S01225FWMT	12,70	15,50	0,8	●	–	–	–

NOTE: For toolholders and boring bars, see pages B85–B93.





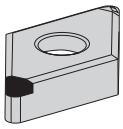
● first choice
○ alternate choice

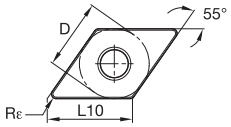
P				●	
M					
K				●	
N					
S				●	
H		●	●	●	●

DNGA-MT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
DNGA150404S01015MT	12,70	15,50	0,4	●	●	–	–
DNGA150404S01025MT	12,70	15,50	0,4	–	–	●	–
DNGA150404S01225MT	12,70	15,50	0,4	–	●	–	–
DNGA150404S01735MT	12,70	15,50	0,4	–	●	–	–
DNGA150604S01015MT	12,70	15,50	0,4	●	●	–	–
DNGA150604S01225MT	12,70	15,50	0,4	–	●	–	–
DNGA150604S01735MT	12,70	15,50	0,4	–	●	–	–
DNGA150408S01735MT	12,70	15,50	0,8	●	●	–	–
DNGA150408S01015MT	12,70	15,50	0,8	●	●	–	–
DNGA150408S01025MT	12,70	15,50	0,8	–	–	●	–
DNGA150408S01225MT	12,70	15,50	0,8	●	●	–	–
DNGA150608S01015MT	12,70	15,50	0,8	●	●	–	–
DNGA150608S01225MT	12,70	15,50	0,8	●	●	–	–
DNGA150608S01735MT	12,70	15,50	0,8	–	●	–	–
DNGA150412S01015MT	12,70	15,50	1,2	●	●	–	–
DNGA150412S01225MT	12,70	15,50	1,2	●	●	–	–
DNGA150412S01735MT	12,70	15,50	1,2	●	●	–	–
DNGA150612S01015MT	12,70	15,50	1,2	●	●	–	–
DNGA150612S01225MT	12,70	15,50	1,2	●	●	–	–
DNGA150612S01735MT	12,70	15,50	1,2	–	●	–	–

NOTE: For toolholders and boring bars, see pages B85–B93.





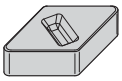
DNGM-CB1

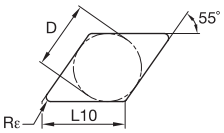
ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
DNGM150408S01325MTCB1	12,70	15,50	0,8	–	●	–	–
DNGM150412S01325MTCB1	12,70	15,50	1,2	–	●	–	–
DNGM150608S01325MTCB1	12,70	15,50	0,8	–	●	–	–
DNGM150612S01325MTCB1	12,70	15,50	1,2	–	●	–	–

NOTE: For toolholders and boring bars, see pages B85–B93.

● first choice
○ alternate choice

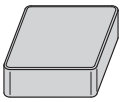
P				●	
M					
K				●	
N					
S				●	
H		●	●	●	●

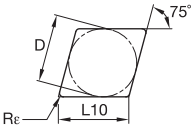




DNGX

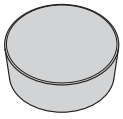
ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
DNGX150708T02020	12,70	15,50	0,8	–	–	–	●

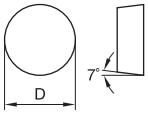




ENGN

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
ENGN130704T02020	12,70	13,15	0,4	–	–	–	●
ENGN130708T02020	12,70	13,15	0,8	–	–	–	●
ENGN130712T02020	12,70	13,15	1,2	–	–	–	●
ENGN130716T02020	12,70	13,15	1,6	–	–	–	●



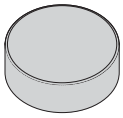
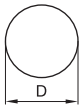


RCGX

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
RCGX090700T01020	9,53	–	–	–	–	–	●
RCGX090700T02020	9,53	–	–	–	–	–	●
RCGX090700T10015	9,53	–	–	–	–	–	●
RCGX090700T20015	9,53	–	–	–	–	–	●
RCGX120700T02020	12,70	–	–	–	–	–	●
RCGX120700T10015	12,70	–	–	–	–	–	●
RCGX120700T20015	12,70	–	–	–	–	–	●
RCGX151000T20015	15,88	–	–	–	–	–	●
RCGX191000T20015	19,05	–	–	–	–	–	●
RCGX251200T20015	25,40	–	–	–	–	–	●

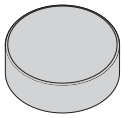
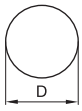
● first choice
○ alternate choice

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

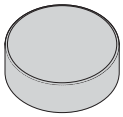
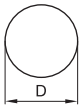
RCGW-T

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
RCGW1204M0T01020	12,00	–	–	–	–	–	●

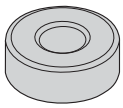
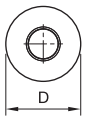
RCGX

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
RCGX0907-001	9,53	–	–	–	–	–	●

RNGN

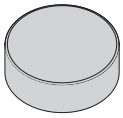
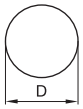
ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
RNGN090300T02020	9,53	–	–	–	–	–	●
RNGN090400T02020	9,53	–	–	–	–	–	●
RNGN120300T02020	12,70	–	–	–	–	–	●
RNGN120400T02020	12,70	–	–	–	–	–	●
RNGN120700T02020	12,70	–	–	–	–	–	●
RNGN120700T10015	12,70	–	–	–	–	–	●
RNGN120700T20015	12,70	–	–	–	–	–	●
RNGN190700T02020	19,05	–	–	–	–	–	●

RNGA

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
RNGA090300T02020	9,53	–	–	–	–	–	●
RNGA120400T02020	12,70	–	–	–	–	–	●

NOTE: For toolholders and boring bars, see page B95.

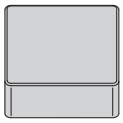
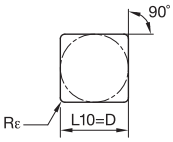



● first choice
○ alternate choice

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

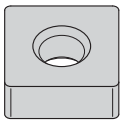
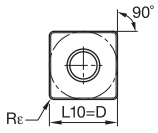
RNGN-C

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
RNGN090300S02015C	9,53	—	—	–	–	●	–

SNGN

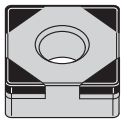
ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
SNGN090308T02020	9,53	9,53	0,8	–	–	–	●
SNGN120704T02020	12,70	12,70	0,4	–	–	–	●
SNGN120408T00520	12,70	12,70	0,8	–	–	–	●
SNGN120408T02020	12,70	12,70	0,8	–	–	–	●
SNGN120708T02020	12,70	12,70	0,8	–	–	–	●
SNGN120412T02020	12,70	12,70	1,2	–	–	–	●
SNGN120712T02020	12,70	12,70	1,2	–	–	–	●
SNGN120416T02020	12,70	12,70	1,6	–	–	–	●
SNGN120716T02020	12,70	12,70	1,6	–	–	–	●
SNGN120720T02020	12,70	12,70	2,0	–	–	–	●
SNGN120720T10015	12,70	12,70	2,0	–	–	–	●
SNGN120720T20015	12,70	12,70	2,0	–	–	–	●
SNGN150716T02020	15,88	15,88	1,6	–	–	–	●

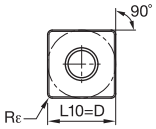



SNGA

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
SNGA120408T02020	12,70	12,70	0,8	–	–	–	●
SNGA120412T02020	12,70	12,70	1,2	–	–	–	●

NOTE: For toolholders and boring bars, see pages B105–B121.





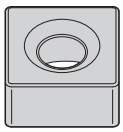
● first choice
○ alternate choice

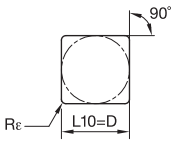
P			●	
M				
K			●	
N				
S			●	
H	●	●	●	●

SNGA-MT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
SNGA120408S01015MT	12,70	12,70	0,8	●	–	–	–
SNGA120408S01225MT	12,70	12,70	0,8	●	●	–	–
SNGA120412S01225MT	12,70	12,70	1,2	●	●	–	–

NOTE: For toolholders and boring bars, see pages B105–B121.

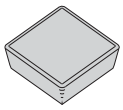


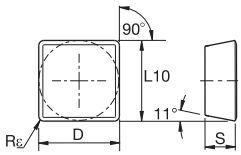


SNGX

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
SNGX120712T02020	12,70	12,70	1,2	–	–	–	●

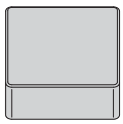
NOTE: For toolholders and boring bars, see pages B105–B121.

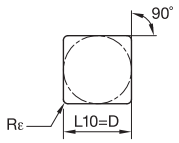




SPG-T

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
SPGN090308T01020	9,53	9,53	0,8	–	–	–	●
SPGN120308T01020	12,70	12,70	0,8	–	–	–	●

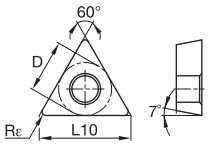




SPU-T

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
SPUN120308T00520	12,70	12,70	0,8	–	–	–	●





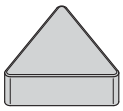
● first choice
○ alternate choice

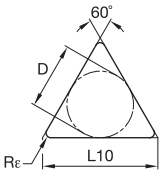
P			●	
M				
K			●	
N				
S			●	
H	●	●	●	●

TCGW-MT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
TCGW090202S01015MT	5,56	9,62	0,2	–	●	–	–
TCGW090204S01015 MT	5,56	9,62	0,4	–	●	–	–
TCGW110202S01015MT	6,35	11,00	0,2	●	●	–	–
TCGW110204S01015MT	6,35	11,00	0,4	●	●	–	–
TCGW110204S01225MT	6,35	11,00	0,4	●	–	–	–
TCGW110208S01015MT	6,35	11,00	0,8	●	●	–	–
TCGW110208S01225MT	6,35	11,00	0,8	●	–	–	–

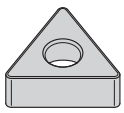
NOTE: For toolholders and boring bars, see pages B247–B248.

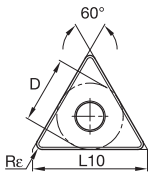




TNGN

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
TNGN110308T02020	6,35	11,00	0,8	–	–	–	●
TNGN160404T02020	9,53	16,50	0,4	–	–	–	●
TNGN160408T02020	9,53	16,50	0,8	–	–	–	●
TNGN160708T02020	9,53	16,50	0,8	–	–	–	●
TNGN160412T02020	9,53	16,50	1,2	–	–	–	●
TNGN160712T02020	9,53	16,50	1,2	–	–	–	●
TNGN160416T02020	9,53	16,50	1,6	–	–	–	●
TNGN220408T02020	12,70	22,00	0,8	–	–	–	●

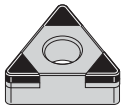


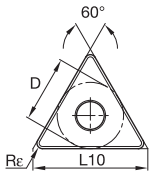


TNGA

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
TNGA160408T02020	9,53	16,50	0,8	–	–	–	●
TNGA160412T02020	9,53	16,50	1,2	–	–	–	●
TNGA220408T02020	12,70	22,00	0,8	–	–	–	●
TNGA220412T02020	12,70	22,00	1,2	–	–	–	●

NOTE: For toolholders and boring bars, see pages B132–B142.





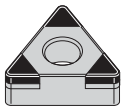
● first choice
○ alternate choice

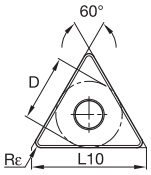
P			●	
M				
K			●	
N				
S			●	
H	●	●	●	●

TNGA-MT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
TNGA160404S01015MT	9,53	16,50	0,4	●	●	–	–
TNGA160404S01225MT	9,53	16,50	0,4	–	●	–	–
TNGA160404S01735MT	9,53	16,50	0,4	–	●	–	–
TNGA160408S01015MT	9,53	16,50	0,8	●	●	–	–
TNGA160408S01225MT	9,53	16,50	0,8	●	●	–	–
TNGA160408S01735MT	9,53	16,50	0,8	●	●	–	–
TNGA160412S01015MT	9,53	16,50	1,2	●	●	–	–
TNGA160412S01225MT	9,53	16,50	1,2	●	●	–	–
TNGA160412S01735MT	9,53	16,50	1,2	●	●	–	–

NOTE: For toolholders and boring bars, see pages B132–B142.

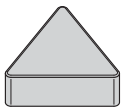


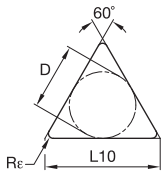


TNGM • Medium Machining

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
TNGM160408S01325MTCB1	9,53	16,50	0,8	–	●	–	–

NOTE: For toolholders and boring bars, see pages B132–B142.

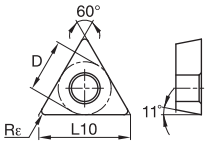




TPGN

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
TPGN110304T01020	6,35	11,00	0,4	–	–	–	●
TPGN110308T01020	6,35	11,00	0,8	–	–	–	●
TPGN110312T01020	6,35	11,00	1,2	–	–	–	●
TPGN160304T00520	9,53	16,50	0,4	–	–	–	●
TPGN160304T01020	9,53	16,50	0,4	–	–	–	●
TPGN160308T00520	9,53	16,50	0,8	–	–	–	●
TPGN160308T01020	9,53	16,50	0,8	–	–	–	●
TPGN160312T01020	9,53	16,50	1,2	–	–	–	●





● first choice
○ alternate choice

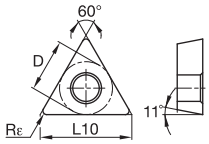
P			●	
M				
K			●	
N				
S			●	
H	●	●	●	●

TPGW-C

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
TPGW110208S01015C	6,35	11,00	0,8	–	–	●	–

NOTE: For toolholders and boring bars, see pages B257–B263.

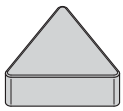


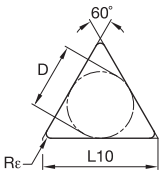


TPGW-MT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
TPGW110308S01225MT	6,35	10,96	0,8	●	–	–	–
TPGW110202S01015MT	6,35	11,00	0,2	–	●	–	–
TPGW110304S01015MT	6,35	11,00	0,4	●	–	–	–
TPGW110304S01225MT	6,35	11,00	0,4	●	–	–	–
TPGW110204S01015MT	6,35	11,00	0,4	–	●	–	–
TPGW110208S01015MT	6,35	11,00	0,8	–	●	–	–
TPGW160404S01015MT	9,53	16,50	0,4	●	–	–	–
TPGW160404S01225MT	9,53	16,50	0,4	●	–	–	–
TPGW16T304S01015MT	9,53	16,50	0,4	–	●	–	–
TPGW160408S01015MT	9,53	16,50	0,8	●	–	–	–
TPGW160408S01225MT	9,53	16,50	0,8	●	–	–	–
TPGW16T308S01015MT	9,53	16,50	0,8	–	●	–	–
TPGW16T308S01225MT	9,53	16,50	0,8	–	●	–	–

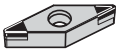
NOTE: For toolholders and boring bars, see pages B257–B263.

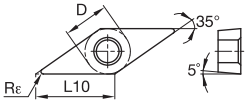




TPU-T

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
TPUN110304T00520	6,35	11,00	0,4	–	–	–	●
TPUN110308T00520	6,35	11,00	0,8	–	–	–	●
TPUN160304T00520	9,53	16,50	0,4	–	–	–	●
TPUN160308T00520	9,53	16,50	0,8	–	–	–	●
TPUN160312T00520	9,53	16,50	1,2	–	–	–	●





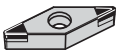
● first choice
○ alternate choice

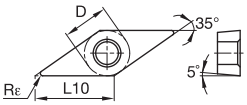
P			●	
M				
K			●	
N				
S			●	
H	●	●	●	●

VBGW-MT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
VBGW110304S01015MT	6,35	11,07	0,4	●	●	–	–
VBGW110304S01225MT	6,35	11,07	0,4	–	●	–	–
VBGW110308S01015MT	6,35	11,07	0,8	●	–	–	–
VBGW110308S01225MT	6,35	11,07	0,8	–	●	–	–
VBGW160404S01015MT	9,53	16,61	0,4	●	–	●	–
VBGW160408S01015MT	9,53	16,61	0,8	●	●	●	–
VBGW160412S01015MT	9,53	16,61	1,2	–	●	–	–

NOTE: For toolholders and boring bars, see pages B266–B269.

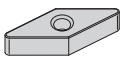


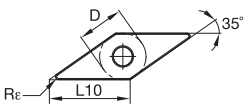


VCGW • Light Machining

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
VCGW160404S01015MT	9,53	16,61	0,4	–	●	–	–
VCGW160404S01225MT	9,53	16,61	0,4	–	●	–	–
VCGW160408S01015MT	9,53	16,61	0,8	–	●	–	–
VCGW160408S01225MT	9,53	16,61	0,8	–	●	–	–

NOTE: For toolholders and boring bars, see pages B266–B269.

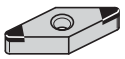


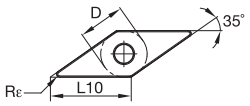


VNGA

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
VNGA160404T02020	9,53	16,61	0,4	–	–	–	●
VNGA160408T02020	9,53	16,61	0,8	–	–	–	●
VNGA160412T02020	9,53	16,61	1,2	–	–	–	●
VNGA220408T02020	12,70	22,14	0,8	–	–	–	●

NOTE: For toolholders and boring bars, see pages B149–B153.





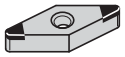
● first choice
○ alternate choice

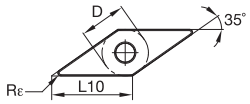
P				●
M				
K				●
N				
S				●
H	●	●	●	●

VNGA-MT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
VNGA160404S01015MT	9,53	16,61	0,4	●	●	–	–
VNGA160404S01025MT	9,53	16,61	0,4	–	–	●	–
VNGA160404S01225MT	9,53	16,61	0,4	●	●	–	–
VNGA160404S01735MT	9,53	16,61	0,4	–	●	–	–
VNGA160408S01015MT	9,53	16,61	0,8	●	●	–	–
VNGA160408S01025MT	9,53	16,61	0,8	–	–	●	–
VNGA160408S01225MT	9,53	16,61	0,8	●	●	–	–
VNGA160408S01735MT	9,53	16,61	0,8	–	●	–	–
VNGA160412S01225MT	9,53	16,61	1,2	–	●	–	–

NOTE: For toolholders and boring bars, see pages B149–B153.

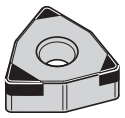


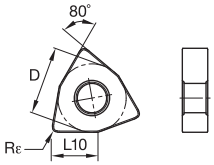


VNGM

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
VNGM160408S01325MTCB1	9,53	16,61	0,8	–	●	–	–
VNGM160412S01325MTCB1	9,53	16,61	1,2	–	●	–	–

NOTE: For toolholders and boring bars, see pages B149–B153.

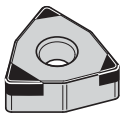


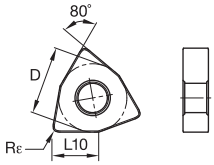


WNGA

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
WNGA080408S01015FWMT	12,70	8,69	0,8	–	●	–	–

NOTE: For toolholders and boring bars, see pages B161–B165.





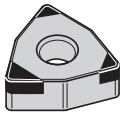
● first choice
○ alternate choice

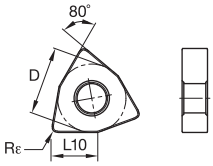
P			●	
M				
K			●	
N				
S			●	
H	●	●	●	●

WNGA-FWMT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
WNGA080408S01015FWHBMT	12,70	8,69	0,8	–	●	–	–

NOTE: For toolholders and boring bars, see pages B161–B165.





WNGA-MT

ISO catalogue number	D	L10	Rε	KBH10	KBH20	KB5630	KY1615
WNGA080404S01015MT	12,70	8,69	0,4	–	●	–	–
WNGA080408S01015MT	12,70	8,69	0,8	–	●	–	–
WNGA080408S01225MT	12,70	8,69	0,8	–	●	–	–
WNGA080408S01735MT	12,70	8,69	0,8	–	●	–	–
WNGA80408S01015MT	12,70	8,69	0,8	●	–	–	–
WNGA80408S01225MT	12,70	8,69	0,8	●	–	–	–

NOTE: For toolholders and boring bars, see pages B161–B165.

A4™ Tooling and Beyond™ Inserts



Choose A4 tooling for turning, facing, grooving, face grooving, and cut-off applications across a broad range of workpiece materials. The unique clamping system and versatile insert geometry delivers a very high metal removal rate.

FEATURES AND BENEFITS

A4 Grooving and Turning System

- One tool for turning, facing, grooving, face-grooving, and cut-off in O.D. and I.D. applications means exceptionally fast cycle times, no turret indexes!
- Extra-long clamping area, ground 120° bottom prism seating surface, and an exclusive top guide rail combine to deliver unsurpassed grooving and side-turning stability!
- Precise insert positioning is ensured for accurate cuts!
- Rigid clamping securely locks insert in place through the toughest cuts.
- Versatile design enables one system to handle O.D. and I.D. grooving, face grooving, back turning, undercutting, and even threading operations.
- Chip control inserts provide excellent chip evacuation in grooving, and offer better chip control in multidirectional turning.

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

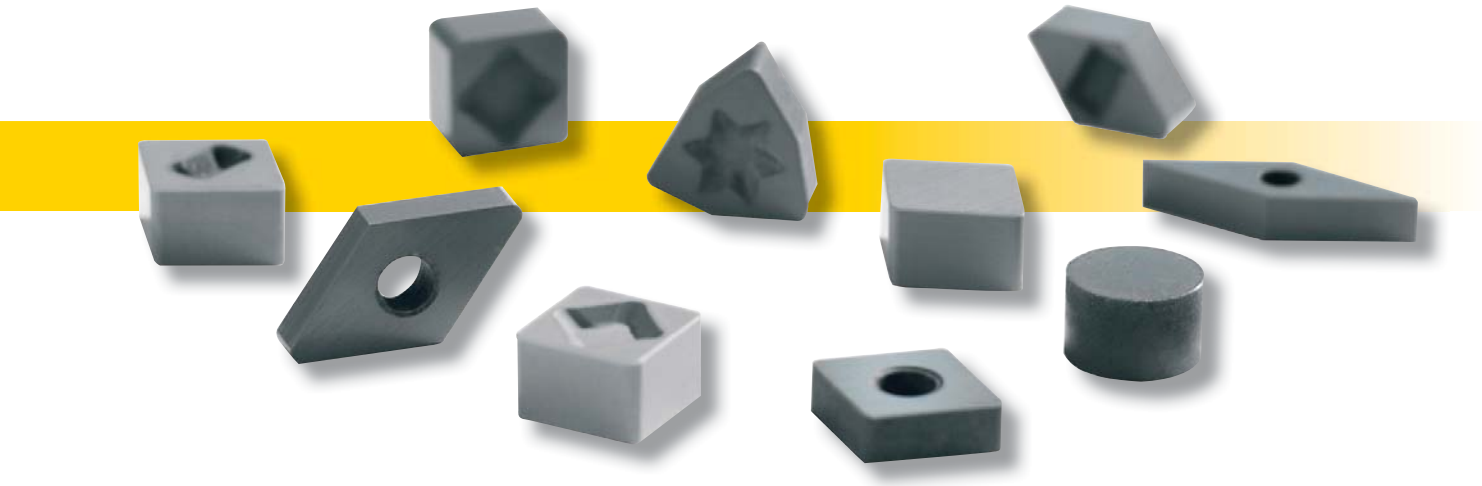
KENNAMETAL®

kennametal.com

Machining High-Temp Alloys with **Ceramics** and **PcBN**

Kennametal advanced materials, utilising Beyond™ technology, offer greater wear resistance and toughness, depending on the job.

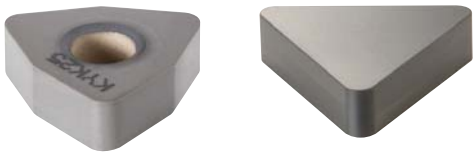
KYS ceramic inserts are the first choice for high-speed applications in high-temp alloys. The multilayer coating offers enhanced chemical wear resistance versus uncoated grades. A superior SiAlON ceramic substrate provides excellent depth of cut notching resistance versus whisker-reinforced ceramics.



Ceramic Inserts

KYS25™ Grade

- Excellent surface finish, lower cutting forces, and higher speeds.
- Advanced CVD coating provides excellent chemical and depth-of-cut notch resistance.



KYS30™ Grade

- Long, consistent tool life.
- Excellent toughness and depth-of-cut notch resistance.
- Performs in a wide variety of machining conditions, including interrupted cuts and applications involving scale.

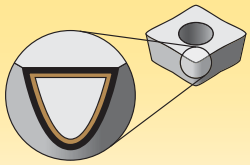


Tipped PcBN Inserts

KB1630 Grade

- Long, consistent tool life.
- Excellent toughness and depth-of-cut notch resistance.
- Performs in a wide variety of machining conditions, including interrupted cuts and applications involving scale.





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

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

wear resistance ⟷ toughness

	Coating	Grade Description		05	10	15	20	25	30	35	40	45
Ceramic Grades	KYS25	**Composition:** SiAlON ceramic with a multilayered alumina-TiCN CVD coating. **Application:** Complements the KYS30™ grade when machining high-temp and nickel-based alloys and cast materials with high Brinell hardness. This advanced CVD coating provides excellent chemical and depth-of-cut notch resistance compared to whisker ceramics.	S			■	■	■				
			H						■	■		
	KYS30	**Composition:** Latest and most advanced SiAlON material developed. **Application:** Combines excellent wear properties, fracture toughness, and thermal shock resistance for general-purpose to finish machining of high-temp alloys. Provides superior depth-of-cut notch resistance compared to whisker ceramics.	S				■	■	■			
PcBN – Polycrystalline Cubic Boron Nitride Grades	KB1630	**Composition:** An uncoated high content PcBN grade. PcBN tips are brazed onto a carbide insert. **Application:** Designed for roughing to finishing in interrupted cuts on hardened steels (>45 HRC). It can also be applied on grey cast iron, chilled irons, high chrome alloyed steels, high temp alloys and sintered powder metals. The tipped PcBN inserts are available in a wide range of insert styles, including Top Notch™ and Screw-On geometries.	K	■	■	■						
			S		■	■						
			H					■	■	■		

NOVO KNOWS SEARCH

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

ADVISE

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

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

SELECT

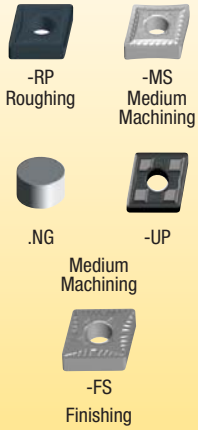
A method of selecting cutting tools from a tree structure via a hierarchy or parametric search:

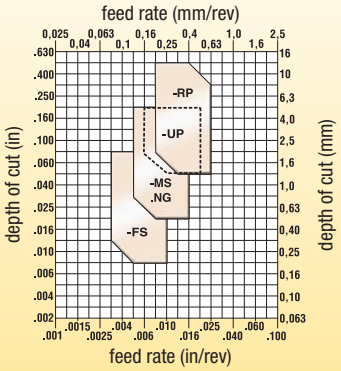
- If you know which product you are looking for, a quick search can be performed by just the catalogue number or product description.
- Smart filters significantly reduce the amount of potential tooling solutions.
- After the tool is selected, NOVO also provides cutting and adaptive item options that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

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

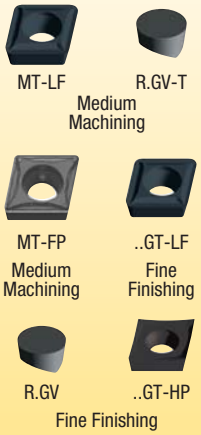
Step 1 • Select the insert geometry

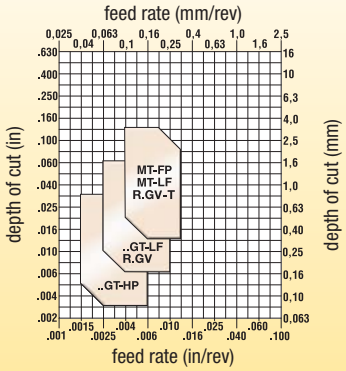
Negative Inserts





Positive Inserts





Step 2 • Select the grade

cutting condition	Negative Insert Geometry .NG
heavily interrupted cut	–
lightly interrupted cut	KYS30/KY1540
varying depth of cut, casting, or forging skin	KYS30/KY1540/KYS25/KY4300
smooth cut, pre-turned surface	KYS25/KY4300

cutting condition	Positive Insert Geometry R.GV-T
heavily interrupted cut	–
lightly interrupted cut	KYS30/KY1540
varying depth of cut, casting, or forging skin	KYS30/KY1540/KYS25/KY4300
smooth cut, pre-turned surface	KYS25/KY4300

Step 3 • Select the cutting speed

Iron-Based, Heat-Resistant Alloys (135–320 HB) (≤34 HRC) — speed — m/min (SFM) — Starting Conditions ◁▷

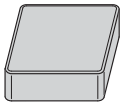
material group	grade	15 (50)	45 (150)	75 (250)	105 (350)	140 (450)	170 (550)	200 (650)	230 (750)	260 (850)	290 (950)	310 (1050)	350 (1150)	380 (1250)	m/min	SFM
S1	KB1630									◁▷					260	850
	KYS25/KY4300								◁▷						200	650
	KYS30/KY1540							◁▷							170	550

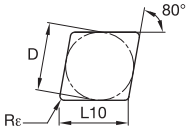
Cobalt-Based, Heat-Resistant Alloys (150–425 HB) (≤45 HRC) — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	15 (50)	45 (150)	75 (250)	105 (350)	140 (450)	170 (550)	200 (650)	230 (750)	260 (850)	290 (950)	310 (1050)	350 (1150)	380 (1250)	m/min	SFM
S2	KB1630									◁▷					260	850
	KYS25/KY4300								◁▷						220	720
	KYS30/KY1540							◁▷							185	600

Nickel-Based, Heat-Resistant Alloys (140–475 HB) (≤48 HRC) — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	15 (50)	45 (150)	75 (250)	105 (350)	140 (450)	170 (550)	200 (650)	230 (750)	260 (850)	290 (950)	310 (1050)	350 (1150)	380 (1250)	m/min	SFM
S3	KB1630									◁▷					260	850
	KYS25/KY4300									◁▷					250	820
	KYS30/KY1540							◁▷							215	700



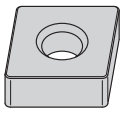


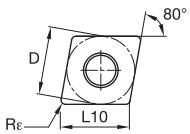
● first choice
○ alternate choice

P			
M			
K			
N			
S	●	●	○
H	○		●

CNGN

ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
CNGN120416T01020	12,70	12,90	1,6	●	–	–
CNGN120712T01020	12,70	12,90	1,2	●	●	–
CNGN120716T01020	12,70	12,90	1,6	–	●	–

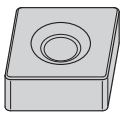


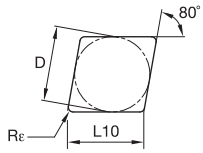


CNGA

ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
CNGA120408E	12,70	12,90	0,8	●	●	–
CNGA120408T01020	12,70	12,90	0,8	●	●	–
CNGA120412T01020	12,70	12,90	1,2	●	●	–

NOTE: For toolholders and boring bars, see pages B58–B73.

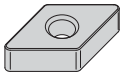


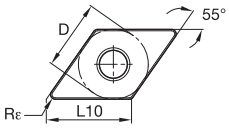


CNGX

ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
CNGX120708T01020	12,70	12,90	0,8	●	●	–
CNGX120712T01020	12,70	12,90	1,2	●	●	–
CNGX120716E	12,70	12,90	1,6	–	●	–

NOTE: For toolholders and boring bars, see pages B58–B73.





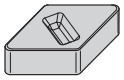
● first choice
○ alternate choice

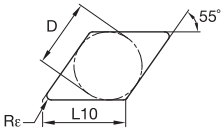
P			
M			
K			
N			
S	●	●	○
H	○		●

DNGA

ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
DNGA150408T01020	12,70	15,50	0,8	–	●	–
DNGA150412T01020	12,70	15,50	1,2	–	●	–

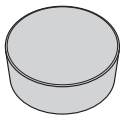
NOTE: For toolholders and boring bars, see pages B85–B93.

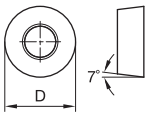




DNGX

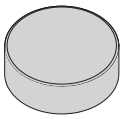
ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
DNGX150708T01020	12,70	15,50	0,8	●	–	–
DNGX150712T01020	12,70	15,50	1,2	●	●	–
DNGX150716T01020	12,70	15,50	1,6	–	●	–

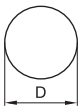




RCGX

ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
RCGX060400E	6,35	–	–	●	●	–
RCGX090700E	9,53	–	–	●	●	–
RCGX090700T00525	9,53	–	–	–	●	–
RCGX090700T01020	9,53	–	–	●	●	–
RCGX120700E	12,70	–	–	●	●	–
RCGX120700T01020	12,70	–	–	●	●	–
RCGX120700T01025	12,70	–	–	●	●	–



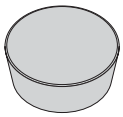


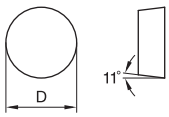
● first choice
○ alternate choice

P			
M			
K			
N			
S	●	●	○
H	○		●

RNGN

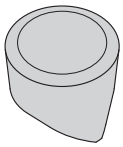
ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
RNGN120400T01020	12,70	–	–	–	●	–
RNGN120700T00525	12,70	–	–	–	●	–
RNGN120700T01020	12,70	–	–	–	●	–
RNGN120700T01025	12,70	–	–	●	●	–
RNGN190700T01020	19,05	–	–	–	●	–

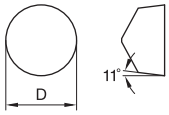




RPGN

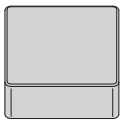
ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
RPGN060200E	6,35	–	–	–	●	–
RPGN090300E	9,53	–	–	–	●	–
RPGN090300T01020	9,53	–	–	–	●	–
RPGN120400E	12,70	–	–	–	●	–
RPGN120400T01020	12,70	–	–	–	●	–

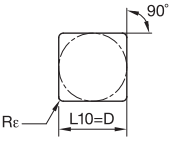




RPGX

ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
RPGX090700E	9,53	–	–	●	●	–
RPGX090700T01020	9,53	–	–	–	●	–
RPGX120700E	12,70	–	–	●	●	–
RPGX120700T01020	12,70	–	–	–	●	–



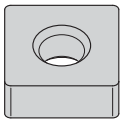


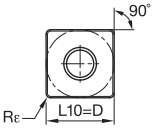
● first choice
○ alternate choice

P			
M			
K			
N			
S	●	●	○
H	○		●

SNGN

ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
SNGN120408T01020	12,70	12,70	0,8	–	●	–
SNGN120412T01020	12,70	12,70	1,2	–	●	–
SNGN120416T01020	12,70	12,70	1,6	●	●	–
SNGN120716T01020	12,70	12,70	1,6	–	●	–
SNGN190616E	19,05	19,05	1,6	●	–	–
SNGN190616T01020	19,05	19,05	1,6	–	●	–
SNGN190724E	19,05	19,05	2,4	–	●	–

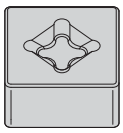


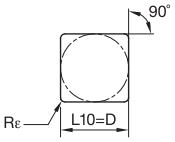


SNGA

ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
SNGA120412T01020	12,70	12,70	1,2	●	●	–

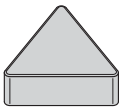
NOTE: For toolholders and boring bars, see pages B105–B121.

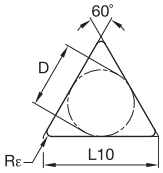




SNGX

ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
SNGX120712T01020	12,70	12,70	1,2	–	●	–
SNGX120716T01020	12,70	12,70	1,6	–	●	–



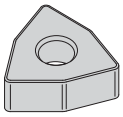


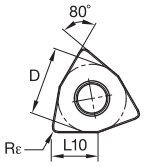
● first choice
○ alternate choice

P			
M			
K			
N			
S	●	●	○
H	○		●

TNGN

ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
TNGN220412T01020	12,70	22,00	1,2	●	–	–
TNGN220416T01020	12,70	22,00	1,6	●	–	–

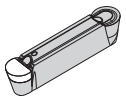


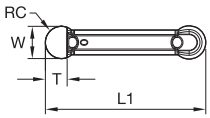


WNGA

ISO catalogue number	D	L10	Rε	KYS25	KYS30	KB1630
WNGA080408T01020	12,70	8,69	0,8	–	●	–
WNGA080416T01020	12,70	8,69	1,6	–	●	–

NOTE: For toolholders and boring bars, see pages B161–B165.





● first choice
○ alternate choice

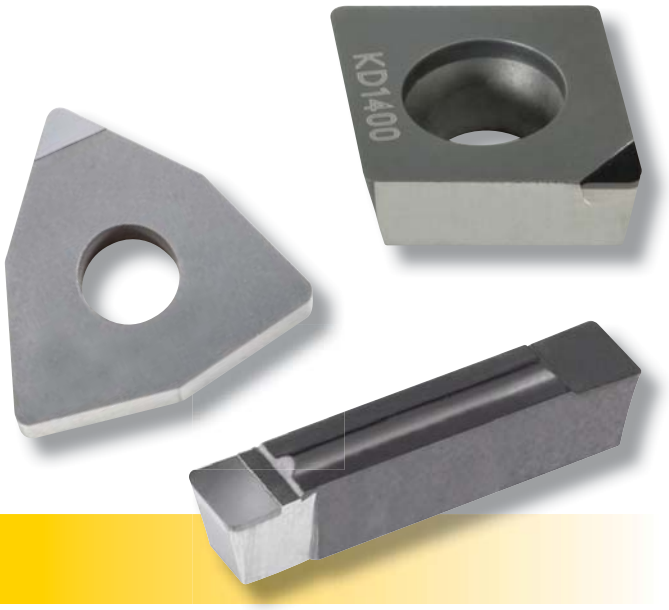
		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	

Flat Top Full Radius Precision Ground • PcBN

catalogue number	seat size	W	RC	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4R0300M03P00EST	3	3,00	1,5	20	2,2	–	–	–	–	–	–	–	–	–	–	●	–	–
A4R0400M04P00EST	4	4,00	2,0	20	2,9	–	–	–	–	–	–	–	–	–	–	●	–	–
A4R0500M05P00EST	5	5,00	2,5	25	3,7	–	–	–	–	–	–	–	–	–	–	●	–	–
A4R0600M06P00EST	6	6,00	3,0	30	4,4	–	–	–	–	–	–	–	–	–	–	●	–	–

NOTE: For A4 holder, boring bars, and blades, see pages C104–C135.

Polycrystalline Diamond Inserts



Polycrystalline Diamond (PCD) Inserts

- Use for machining high-temperature alloys and in targeted machining of non-ferrous materials.
- Significant hardness advantage compared to carbide inserts.
- Increased productivity through higher speeds and longer tool life.
- Best used in processing materials that cannot be machined with conventional tooling.

KD1400™ Grade

- Ideal for general-purpose turning of non-ferrous materials.
- Use on low to medium silicon-content aluminium alloys, non-metallics, copper, and brass- and zinc-based alloys.
- Excellent mechanical shock resistance.
- Use in a wide range of continuous to interrupted cuts where superior surface finished is needed.



KD1405™ Grade

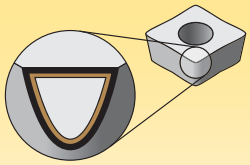
- The most abrasion-resistant tool material for non-ferrous and non-metallic materials from Kennametal.
- Use when abrasion resistance is needed in the application.
- CVD diamond grade.



KD1425™ Grade

- Engineered for extreme abrasion resistance.
- Good edge strength in demanding applications.
- Ideal choice for high-silicon aluminium alloys, bi-metallic materials, carbon-fibre reinforced plastics, and other abrasive non-metallic materials.



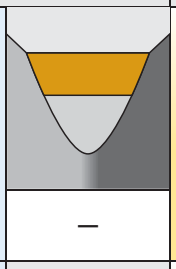
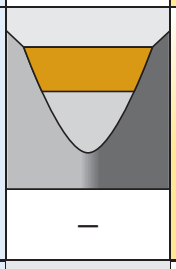
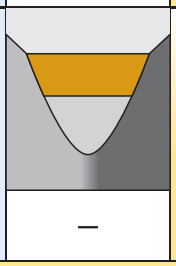


Coatings provide high-speed capability and are engineered for finishing to light roughing.

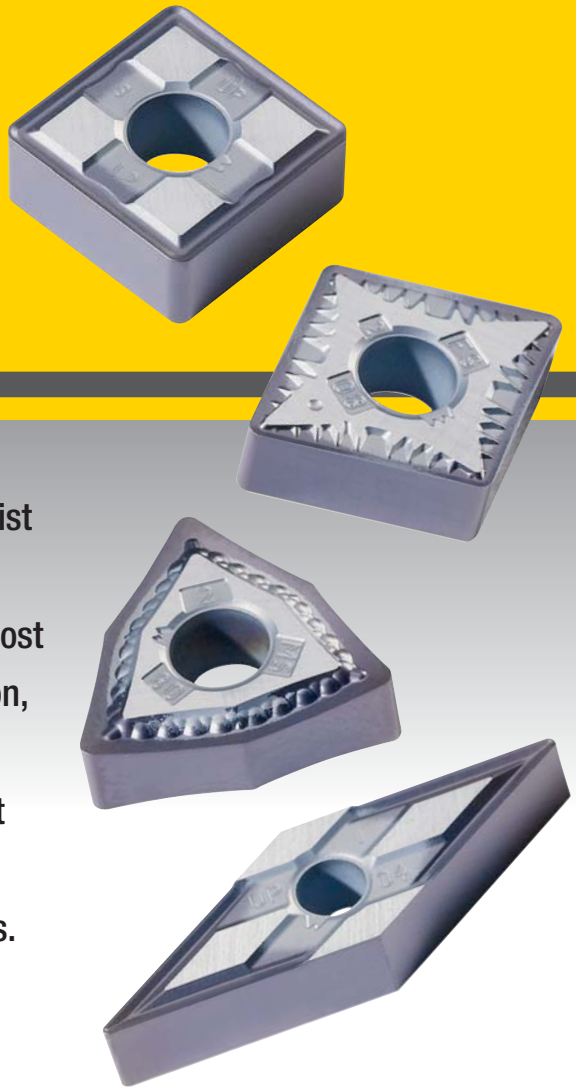
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

wear resistance ← → toughness

PCD — Polycrystalline Diamond Grades

Coating	Grade Description		05	10	15	20	25	30	35	40	45
KD1400 	**Composition:** An ultra-fine-grain, polycrystalline diamond (PCD) tip brazed onto a carbide substrate. **Application:** Designed for general-purpose turning of primarily non-ferrous materials. It can be applied over a wide range of continuous to interrupted cuts where superior surface finish is needed. Use on low to medium silicon-content aluminium alloys, non-metallics, copper, and brass- and zincbased alloys. The ultra-fine-grain diamond particle size enables superior surface finishes while ensuring the best mechanical shock resistance of any PCD cutting tool.	N	■	■	■						
		S	■								
KD1405 	**Composition:** A pure CVD-deposited diamond-sheet tool brazed directly to a carbide substrate. **Application:** KD1405™ is the best Kennametal abrasion-resistant tool material for non-ferrous and non-metallic materials. Best applied when abrasion resistance is the desired benefit.	N	■	■							
		S	■								
KD1425 	**Composition:** A multimodal PCD grade with a range of grain sizes brazed onto a carbide substrate. **Application:** Engineered for extreme abrasion resistance, combined with good edge strength for demanding applications. An ideal choice for high-silicon aluminium alloys, bi-metallic (AL/GCI) materials, MMC, carbon-fibre reinforced plastics, and other abrasive non-metallic materials.	N		■	■	■					

Beyond™ PVD Grades



Beyond™ advanced PVD coatings are well suited to resist high temperatures associated with machining tough alloys. These coatings offer increased tool life and a boost in productivity to the general engineering, transportation, aerospace, energy, and earthworks markets. Use the strength of Beyond PVD coatings and the broad product offering to perform turning, grooving, and cut-off operations in a wide array of materials and applications. Beyond PVD coatings help to maintain consistent chip control and minimise insert edge wear.

beyond™

KCU10™ Grade

- PVD-coated grade with excellent wear resistance. Finishing to medium applications.
- Use in all materials, especially stainless steels and high-temp alloys.

KCU25™ Grade

- PVD-coated grade with superior edge toughness and excellent wear resistance. Medium to roughing applications.
- Use in all materials.

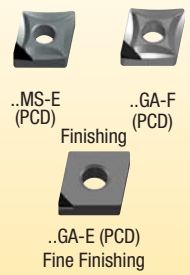
Experience the advantages at your Authorised Kennametal Distributor or at **kennametal.com.**

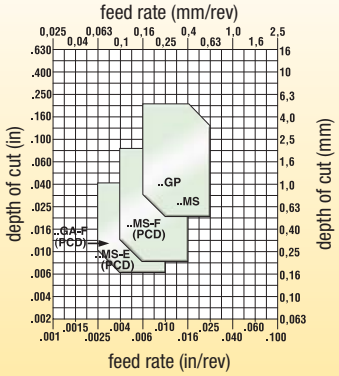
KENNAMETAL®

kennametal.com

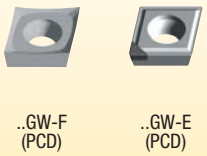
Step 1 • Select the insert geometry

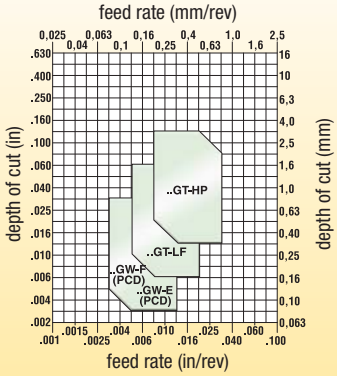
Negative Inserts





Positive Inserts





Step 2 • Select the grade

cutting condition		Negative Insert Geometry ..GA-E (PCD)	..MS-E (PCD)	..GA-F (PCD)	Positive Insert Geometry ..GW-E (PCD)	..GW-F (PCD)
heavily interrupted cut		–	–	KD1400	–	KD1400
lightly interrupted cut		KD1405	KD1405	KD1400	KD1405	KD1400
varying depth of cut, casting, or forging skin		KD1405	KD1405	KD1425	KD1405	KD1425
smooth cut, pre-turned surface		KD1405	KD1405	KD1425	KD1405	KD1425

Step 3 • Selecting the cutting speed

Low-Silicon Aluminium Alloys (hypoeutectic <12.2% Si) and Magnesium Alloys — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	1250 (4000)	1500 (4800)	1750 (5600)	2000 (6400)	2250 (7200)	2500 (8000)	m/min	SFM
N1	KD1400			◁▷								765	2500

High-Silicon Aluminium Alloys (hypereutectic >12.2% Si) and Magnesium Alloys — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	m/min	SFM
N3	KD1405		◁▷			550	1800
	KD1425		◁▷			765	2500

Additional cutting speed recommendations for miscellaneous workpiece materials

Copper-, Brass-, Zinc-Based on a Machinability Index Range of 70–100 — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	m/min	SFM
N4	KD1400/KD1405		◁▷			520	1700
	KD1425		◁▷			500	1600

Nylon, Plastics, Rubbers, Phenolics, Resins, Fibreglass, and Glass — speed — m/min (SFM) — Starting Conditions ◁▷

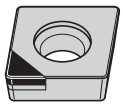
material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	m/min	SFM
N5	KD1400/KD1405		◁▷			400	1300
	KD1425	◁▷				365	1200

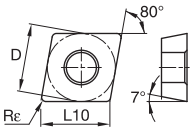
Carbon and Graphite Composites: Brush Alloys, Kevlar, and Graphite (280–400 HB) (30–43 HRC) — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	m/min	SFM
N6	KD1400/KD1405			◁▷		760	2500

MMCs (Aluminium-Based Metal Matrix Composites) — speed — m/min (SFM) — Starting Conditions ◁▷

material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	m/min	SFM
N7	KD1405		◁▷			460	1500
	KD1400		◁▷			365	1200





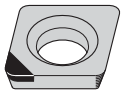
● first choice
○ alternate choice

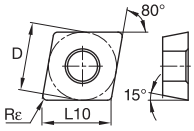
P			
M			
K			
N	●	○	●
S		●	●
H			

CCGW-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
CCGW060204FST	6,35	6,45	0,4	●	–	●
CCGW09T304FST	9,53	9,67	0,4	●	–	●
CCGW09T308FST	9,53	9,67	0,8	●	–	●

NOTE: For toolholders and boring bars, see pages B179–B183.

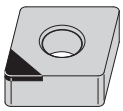


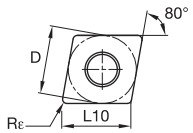


CDHB-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
CDHBS4T002FST	3,97	4,03	0,2	●	–	●
CDHBS4T0X0FST	3,97	4,03	0,1	●	–	–

NOTE: For toolholders and boring bars, see pages B185–B187.

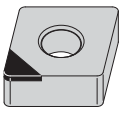


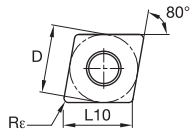


CNGA

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
CNGA120404E	12,70	12,90	0,4	–	●	–
CNGA120408E	12,70	12,90	0,8	–	●	–

NOTE: For toolholders and boring bars, see pages B58–B73.

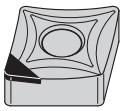


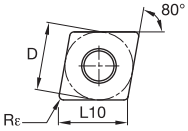


CNGA-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
CNGA120404FST	12,70	12,90	0,4	●	–	●
CNGA120408FST	12,70	12,90	0,8	●	–	●

NOTE: For toolholders and boring bars, see pages B58–B73.





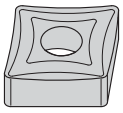
● first choice
○ alternate choice

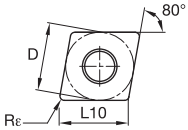
P			
M			
K			
N	●	○	●
S		●	●
H			

CNMS-E

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
CNMS120408E	12,70	12,90	0,8	–	●	–

NOTE: For toolholders and boring bars, see pages B58–B73.

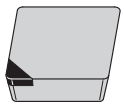


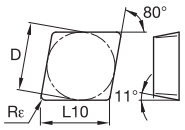


CNMS-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
CNMS120404FST	12,70	12,90	0,4	●	–	–
CNMS120408FST	12,70	12,90	0,8	●	–	●

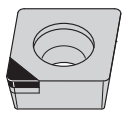
NOTE: For toolholders and boring bars, see pages B58–B73.

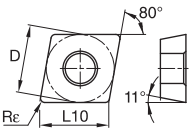




CPGN

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
CPGN120304F	12,70	12,90	0,4	–	–	●
CPGN120308F	12,70	12,90	0,8	–	–	●





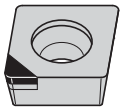
CPGW-E-F

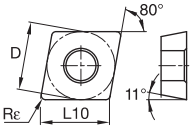
ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
CPGW060204E	6,35	6,45	0,4	–	●	–
CPGW09T304E	9,53	9,67	0,4	–	●	–

NOTE: For toolholders and boring bars, see pages B192–B205.

● first choice
○ alternate choice

P			
M			
K			
N	●	○	●
S		●	●
H			



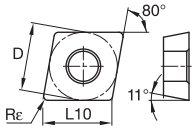


CPGW-FWST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
CPGW060204FWST	6,35	6,45	0,4	●	–	●
CPGW09T308FWST	9,53	9,67	0,8	●	–	●
CPGW120408FWST	12,70	12,90	0,8	●	–	●

NOTE: For toolholders and boring bars, see pages B192–B205.

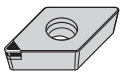


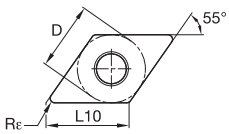


CPGW-ST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
CPGW060202FST	6,35	6,45	0,2	●	–	●
CPGW060204FST	6,35	6,45	0,4	●	–	●
CPGW060208FST	6,35	6,45	0,8	●	–	●
CPGW09T304FST	9,53	9,67	0,4	●	–	●
CPGW09T308FST	9,53	9,67	0,8	●	–	●

NOTE: For toolholders and boring bars, see pages B192–B205.

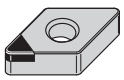


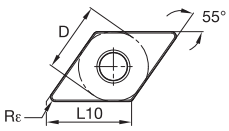


DCGW-ST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
DCGW070204FST	6,35	7,75	0,4	●	–	●
DCGW11T304FST	9,53	11,63	0,4	●	–	●

NOTE: For toolholders and boring bars, see pages B209–B213.

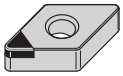


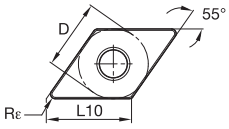


DNGA

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
DNGA150404E	12,70	15,50	0,4	–	●	–

NOTE: For toolholders and boring bars, see pages B85–B93.





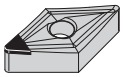
● first choice
○ alternate choice

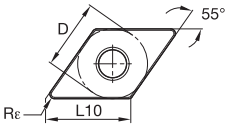
P			
M			
K			
N	●	○	●
S		●	●
H			

DNGA-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
DNGA150404FST	12,70	15,50	0,4	●	–	●
DNGA150408FST	12,70	15,50	0,8	●	–	●

NOTE: For toolholders and boring bars, see pages B192–B205.

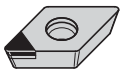


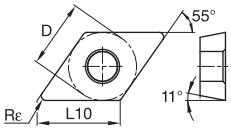


DNMS-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
DNMS150404FST	12,70	15,50	0,4	●	–	–
DNMS150408FST	12,70	15,50	0,8	●	–	●

NOTE: For toolholders and boring bars, see pages B192–B205.





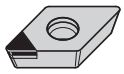
DPGW-E

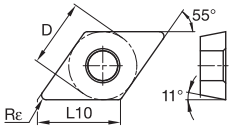
ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
DPGW11T304E	9,53	11,63	0,4	–	●	–

NOTE: For toolholders and boring bars, see pages B217–B221.

● first choice
○ alternate choice

P			
M			
K			
N	●	○	●
S		●	●
H			

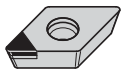


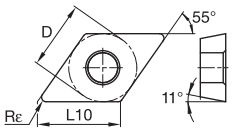


DPGW-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
DPGW070202FST	6,35	7,75	0,2	●	–	●
DPGW070204FST	6,35	7,75	0,4	●	–	●
DPGW11T304FST	9,53	11,63	0,4	●	–	●

NOTE: For toolholders and boring bars, see pages B217–B221.

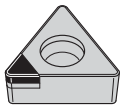


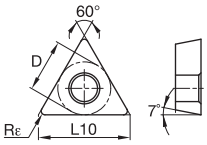


DPGW-FWST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
DPGW11T304FWST	9,53	11,63	0,2	–	–	●

NOTE: For toolholders and boring bars, see pages B217–B221.

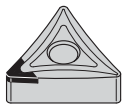


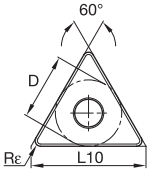


TCGW-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
TCGW110204FST	6,35	11,00	0,4	●	–	●
TCGW16T304FST	9,53	16,50	0,4	●	–	–

NOTE: For toolholders and boring bars, see pages B247–B248.





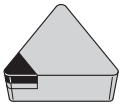
TNMS-FST

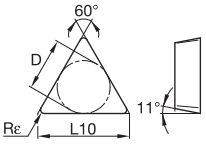
ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
TNMS160404FST	9,53	16,50	0,4	●	–	●
TNMS160408FST	9,53	16,50	0,8	●	–	●

NOTE: For toolholders and boring bars, see pages B132–B142.

● first choice
○ alternate choice

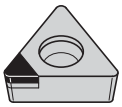
P			
M			
K			
N	●	○	●
S		●	●
H			

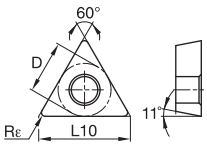




TPGN

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
TPGN110304F	6,35	11,00	0,4	–	–	●
TPGN160304F	9,53	16,50	0,4	–	–	●
TPGN160308F	9,53	16,50	0,8	–	–	●
TPGN220408F	12,70	22,00	0,8	–	–	●

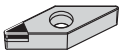


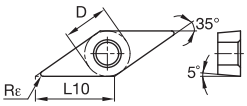


TPGW-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
TPGW110204FST	6,35	11,00	0,4	●	–	●
TPGW110208FST	6,35	11,00	0,8	●	–	–
TPGW16T304FST	9,53	16,50	0,4	–	–	●
TPGW16T308FST	9,53	16,50	0,8	●	–	●

NOTE: For toolholders and boring bars, see pages B257–B263.





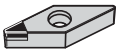
VBGW-E

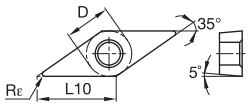
ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
VBGW160408E	9,53	16,61	0,8	–	●	–

NOTE: For toolholders and boring bars, see pages B266–B269.

● first choice
○ alternate choice

P			
M			
K			
N	●	○	●
S		●	●
H			

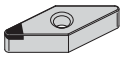


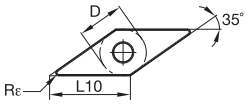


VBGW-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
VBGW110304FST	6,35	11,07	0,4	●	–	●
VBGW160404FST	9,53	16,61	0,4	●	–	●

NOTE: For toolholders and boring bars, see pages B266–B269.

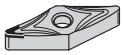


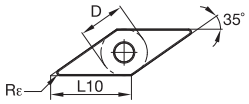


VNGA-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
VNGA160404FST	9,53	16,61	0,4	●	–	–
VNGA160408FST	9,53	16,61	0,8	●	–	●

NOTE: For toolholders and boring bars, see pages B149–B153.

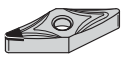


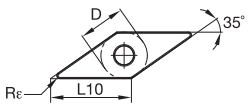


VNMS-E

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
VNMS160404E	9,53	16,61	0,4	–	●	–
VNMS160408E	9,53	16,61	0,8	–	●	–

NOTE: For toolholders and boring bars, see pages B149–B153.

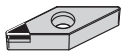


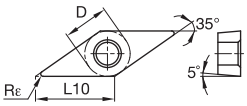


VNMS-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
VNMS160404FST	9,53	16,61	0,4	●	–	●
VNMS160408FST	9,53	16,61	0,8	●	–	●

NOTE: For toolholders and boring bars, see pages B149–B153.



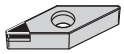


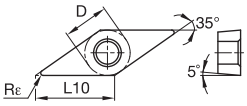
● first choice
○ alternate choice

P			
M			
K			
N	●	○	●
S		●	●
H			

VPGN

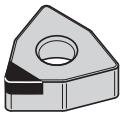
ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
VCGN160404	9,53	16,61	0,4	–	–	●
VCGN160408	9,53	16,61	0,8	–	–	●

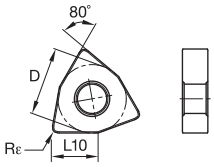




VPGR

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
VCGR160404	9,53	16,61	0,4	–	–	●
VCGR160408	9,52	16,61	0,8	–	–	●
VCGR160412	9,53	16,61	1,2	–	–	●

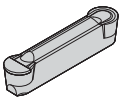


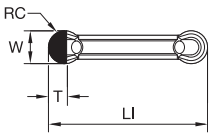


WNGA-FST

ISO catalogue number	D	L10	Rε	KD1400	KD1405	KD1425
WNGA080408FST	12,70	8,69	0,8	–	–	●

NOTE: For toolholders and boring bars, see pages B161–B165.





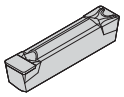
● first choice
○ alternate choice

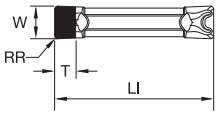
		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	

Flat Top Full Radius Precision Ground • PCD

catalogue number	seat size	W	RC	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4R0500M05P00E	5	5,00	2,5	25	3,0	–	–	–	–	–	–	–	–	–	–	–	–	●

NOTE: For A4 holder, boring bars, and blades, see pages C104–C135.

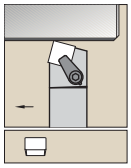


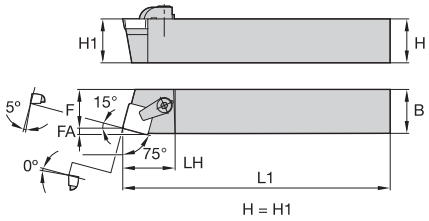


Flat Top Precision Ground • PCD

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0300M03P04E	3	3,00	0,4	20	3,0	–	–	–	–	–	–	–	–	–	–	–	–	●
A4G0400M04P04E	4	4,00	0,4	20	3,0	–	–	–	–	–	–	–	–	–	–	–	–	●
A4G0500M05P08E	5	5,00	0,8	25	3,0	–	–	–	–	–	–	–	–	–	–	–	–	●

NOTE: For A4 holder, boring bars, and blades, see pages C104–C135.

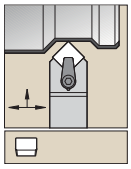


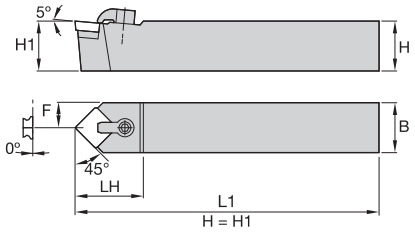


CSBP 75°



order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand														
1097750	**CSBPR2020K12**	20	20	17,0	125	30,0	3,1	SP..120308	**SM840**	**MS111**	2 mm	**CKM10**	**STCM8**	4 mm

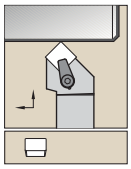


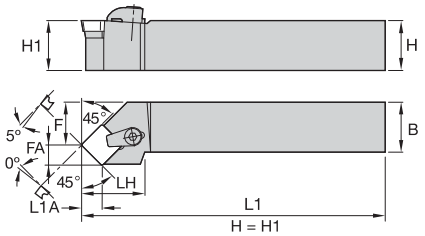


CSDP 45°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
1097754	**CSDPN2020K12**	20	20	10,0	125	32,0	SP..120308	**SM840**	**MS111**	2 mm	**CKM10**	**STCM8**	4 mm
1097755	**CSDPN2525M12**	25	25	12,5	150	32,0	SP..120308	**SM840**	**MS111**	2 mm	**CKM9**	**STCM4**	4 mm

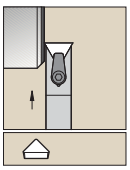


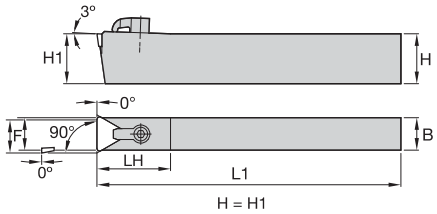


CSSP 45°



order number	catalogue number	H	B	F	L1	LH	FA	L1A	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand															
1244605	**CSSPR2020K12**	20	20	25,0	125	32,0	8,7	8,3	SP..120308	**SM840**	**MS111**	2 mm	**CKM10**	**STCM8**	4 mm
1244606	**CSSPR2525M12**	25	25	32,0	150	32,0	8,7	8,3	SP..120308	**SM840**	**MS111**	2 mm	**CKM9**	**STCM4**	4 mm
left hand															
1244604	**CSSPL2525M12**	25	25	32,0	150	32,0	8,7	8,3	SP..120308	**SM840**	**MS111**	2 mm	**CKM9**	**STCM4**	4 mm

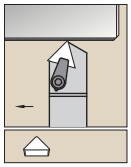


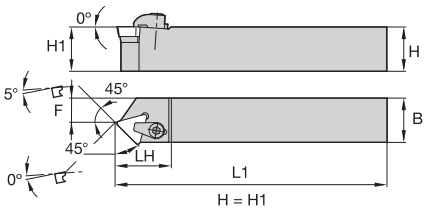


CTCP 90°



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
1097775	**CTCPN2510M11**	25	10	10,0	150	26,0	TP..110304	**SM819**	**MS960**	–	**CKM7**	**STCM5**	2.5 mm
1097776	**CTCPN2514M16**	25	14	14,4	150	28,0	TP..160308	**SM841**	**MS111**	2 mm	**CKM13**	**STCM4**	4 mm
1097781	**CTCPN2518M22**	25	18	19,2	150	41,0	TP..220408	**SM837**	**MS125**	2.5 mm	**CKM13**	**STCM4**	4 mm
1097778	**CTCPN2520M22**	25	20	20,2	150	41,0	TP..220408	**SM837**	**MS125**	2.5 mm	**CKM13**	**STCM4**	4 mm



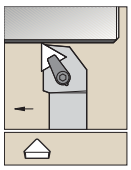


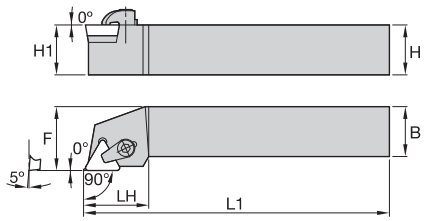
CTDP 45°






order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	clamp	clamp screw	hex
right hand												
1244613	**CTDPR1212F11**	12	12	6,0	80	22,0	TP..110304	**SM819**	**MS960**	**CKM19**	**STCM9**	2.5 mm



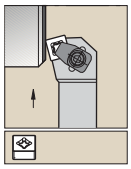


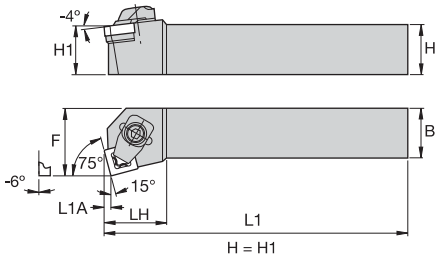
CTGP 90°






order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand													
1097762	**CTGPR1212F11**	12	12	16,0	80	20,0	TP..110304	**SM819**	**MS960**	–	**CKM19**	**STCM9**	2.5 mm
1097763	**CTGPR1616H11**	16	16	20,0	100	20,0	TP..110304	**SM819**	**MS960**	–	**CKM19**	**STCM9**	2.5 mm
1244595	**CTGPR2020K11**	20	20	25,0	125	20,0	TP..110304	**SM819**	**MS960**	–	**CKM19**	**STCM9**	2.5 mm
1097764	**CTGPR2020K16**	20	20	25,0	125	26,0	TP..160308	**SM841**	**MS111**	2 mm	**CKM10**	**STCM8**	4 mm
1097765	**CTGPR2525M16**	25	25	32,0	150	26,0	TP..160308	**SM841**	**MS111**	2 mm	**CKM9**	**STCM4**	4 mm
left hand													
1097916	**CTGPL1212F11**	12	12	16,0	80	20,0	TP..110304	**SM819**	**MS960**	–	**CKM19**	**STCM9**	2.5 mm
1097918	**CTGPL2020K16**	20	20	25,0	125	26,0	TP..160308	**SM841**	**MS111**	2 mm	**CKM10**	**STCM8**	4 mm
1097919	**CTGPL2525M16**	25	25	32,0	150	26,0	TP..160308	**SM841**	**MS111**	2 mm	**CKM9**	**STCM4**	4 mm





CCKN 75° • MX

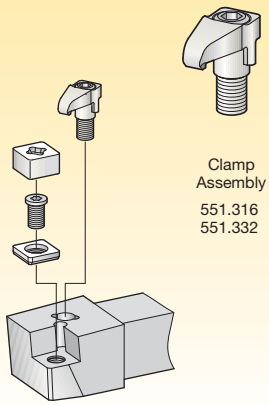




order number	catalogue number	H	B	F	L1	LH	L1A	gage insert	shim	shim screw	hex	clamp assembly	hex
right hand													
2891706	**CCKNR2525M12MX7**	25	25	32,0	150	32,0	3,1	CNGX120708	**552.221**	**554.252**	2.5 mm	**551.013**	4 mm
left hand													
2891727	**CCKNL2525M12MX7**	25	25	32,0	150	32,0	3,1	CNGX120708	**552.221**	**554.252**	2.5 mm	**551.013**	4 mm

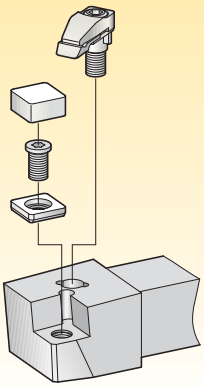
Spare Parts • -MX, -MN, -MF, and -MA Clamping Version

Clamping Mode MX

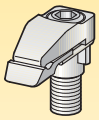


Clamp Assembly
551.316
551.332

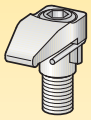
Clamping Mode MN



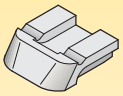
Individual Clamping Elements



Clamp Assembly
551.251
551.255

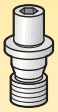


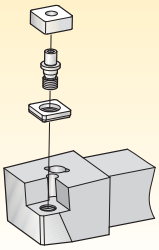
Clamping Element
551.333
551.317



Pressure Plate
557.111
557.111

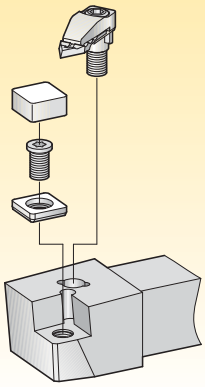
Clamping Mode MA



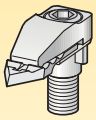


Lock Pin
554.016
554.017
554.018

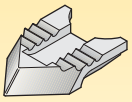
Clamping Mode MF



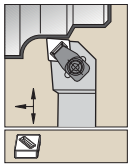
Individual Clamping Elements

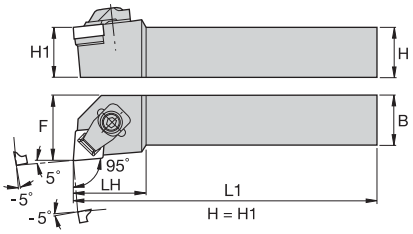


Clamp Assembly
551.252
551.253
551.254
551.256
551.257
551.258
551.260
551.261



Chipbreaker
557.125
557.126
557.127
557.120
557.121
557.122
557.123
557.124





CCLN 95° • MX





order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	clamp assembly	hex
right hand												
1260025	**CCLNR2525M12-MX7**	25	25	32,0	150	32,0	CN.X120708	**552.221**	**554.252**	2.5 mm	**551.316**	4 mm
1260028	**CCLNR3225P12-MX7**	32	25	32,0	170	32,0	CN.X120708	**552.221**	**554.252**	2.5 mm	**551.316**	4 mm
left hand												
1260017	**CCLNL2525M12-MX7**	25	25	32,0	150	30,0	CN.X120708	**552.221**	**554.252**	2.5 mm	**551.316**	4 mm
1260020	**CCLNL3225P12-MX7**	32	25	32,0	170	32,0	CN.X120708	**552.221**	**554.252**	2.5 mm	**551.316**	4 mm

CCLN 95° • MN

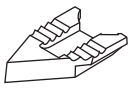





order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand													
1260023	**CCLNR2525M12-MN4**	25	25	32,0	150	32,0	CN.N120408	**552.220**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1260024	**CCLNR2525M12-MN7**	25	25	32,0	150	32,0	CN.N120708	**552.221**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1504937	**CCLNR3225P12-MN4**	32	25	32,0	170	32,0	CN.N120408	**552.220**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1260027	**CCLNR3225P12-MN7**	32	25	32,0	170	32,0	CN.N120708	**552.221**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
left hand													
1260015	**CCLNL2525M12-MN4**	25	25	32,0	150	32,0	CN.N120408	**552.220**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1260016	**CCLNL2525M12-MN7**	25	25	32,0	150	32,0	CN.N120708	**552.221**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1504931	**CCLNL3225P12-MN7**	32	25	32,0	170	32,0	CN.N120708	**552.221**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm

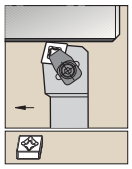
CCLN 95° • MF

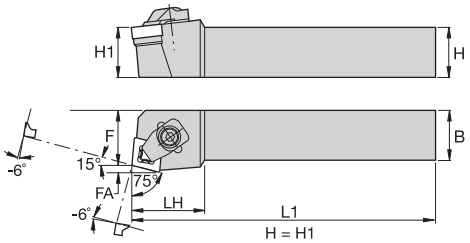





order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	chipbreaker	clamp assembly	hex
right hand													
1260022	**CCLNR2525M12-MF4**	25	25	32,0	150	32,0	CN.N120408	**552.220**	**554.252**	2.5 mm	**557.125**	**551.317**	4 mm
1503826	**CCLNR2525M12-MF7**	25	25	32,0	150	32,0	CN.N120708	**552.221**	**554.252**	2.5 mm	**557.125**	**551.317**	4 mm
left hand													
1260014	**CCLNL2525M12-MF4**	25	25	32,0	150	32,0	CN.N120408	**552.220**	**554.252**	2.5 mm	**557.125**	**551.317**	4 mm
1504935	**CCLNL2525M12-MF7**	25	25	32,0	150	32,0	CN.N120708	**552.221**	**554.252**	2.5 mm	**557.125**	**551.317**	4 mm

NOTE: MX — clamping version is shown.
Basic holder may be ordered separately:
V.CLN R/L 2525M12
V.CLN R/L 3225P12
V.CLN R/L 3225P16



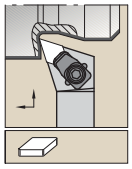


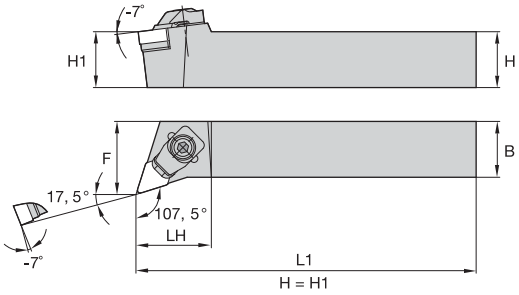
CCRN 75° • MN



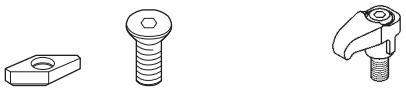
order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand														
1504885	**CCRNR3225P12-MN7**	32	25	27,0	170	35,0	3,1	CN.N120708	**552.221**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
left hand														
1503827	**CCRNL2525M12-MN7**	25	25	27,0	150	35,0	3,1	CN.N120708	**552.221**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm

NOTE: MX — clamping version is shown.
Basic holder may be ordered separately:
V.CRN R/L 2525M12
V.CRN R/L 3225P12
V.CRN R/L 3225P16



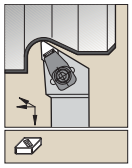


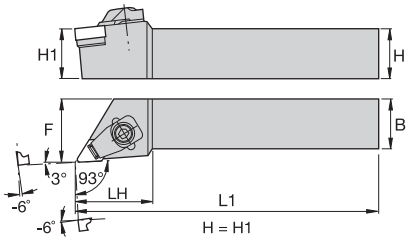
CDHN 107,5° • MX



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	clamp assembly	hex
right hand												
1505504	**CDHNR2525M12-MX7**	25	25	32,0	150	30,0	DN.X120708	**552.225**	**554.254**	2.5 mm	**551.316**	4 mm

NOTE: MN — clamping version is shown.
Basic holder may be ordered separately:
V.DHN R/L 2525M12
V.DHN R/L 2525M15
V.DHN R/L 3225P15





CDJN 93° • MX





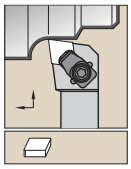
order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	clamp assembly	hex
right hand												
1260177	**CDJNR2525M15-MX7**	25	25	32,0	150	38,0	DN.X150708	**552.228**	**554.252**	2.5 mm	**551.332**	4 mm
left hand												
1260172	**CDJNL2525M12-MX7**	25	25	32,0	150	38,0	DN.X120708	**552.225**	**554.254**	2.5 mm	**551.316**	4 mm
1504968	**CDJNL2525M15MX7**	25	25	32,0	150	38,0	DN.X150708	**552.228**	**554.252**	2.5 mm	**551.332**	4 mm

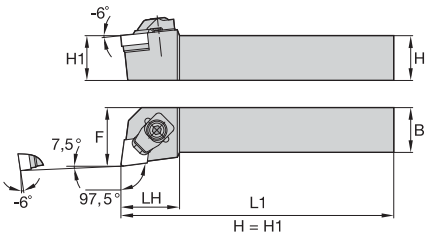
CDJN 93° • MN






order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand													
1260176	**CDJNR2525M15MN7**	25	25	32,0	150	38,0	DN.N150708	**552.228**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1327362	**CDJNR3225P15MN7**	32	25	32,0	170	38,0	DN.N150708	**552.228**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
left hand													
1504969	**CDJNL2525M15MN7**	25	25	32,0	150	38,0	DN.N150708	**552.228**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1327363	**CDJNL3225P15MN7**	32	25	32,0	170	38,0	DN.N150708	**552.228**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm





CELN 97,5° • MX





order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	clamp assembly	hex
right hand												
1505803	**CELNR2525M13-MX7**	25	25	32,0	150	32,0	EN.X130708	**552.240**	**554.252**	2.5 mm	**551.316**	4 mm

CELN 97,5° • MN

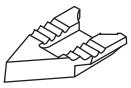





order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand													
1501222	**CELNR2525M13MN7**	25	25	32,0	150	32,0	EN.N130708	**552.240**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
left hand													
1501221	**CELNL2525M13MN7**	25	25	32,0	150	32,0	EN.N130708	**552.240**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm

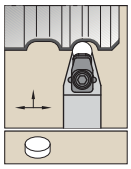
CELN 97,5° • MF

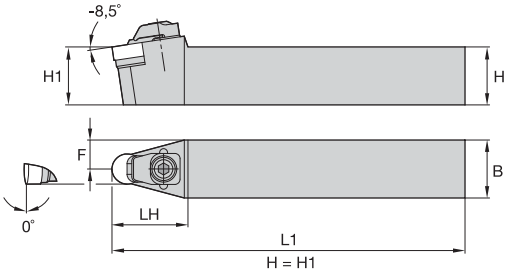





order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	chipbreaker	clamp assembly	hex
right hand													
1331458	**CELNR2525M13MF7**	25	25	32,0	150	32,0	EN.N130708	**552.240**	**554.252**	2.5 mm	**557.125**	**551.317**	4 mm

NOTE: MN — clamping version is shown.
Basic holder may be ordered separately:
V.ELN R/L 2525M13
V.ELN R/L 3225P13



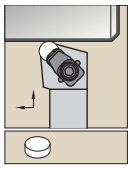


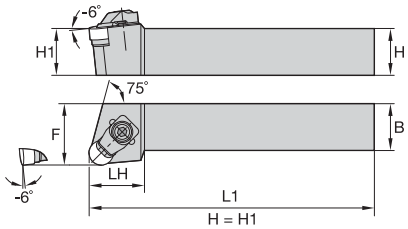
CRDN • MN



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
1510281	**CRDNN2525M12MN4**	25	25	12,5	150	30,0	RN.N120400	**552.229**	**554.252**	2.5 mm	**557.111**	**551.333**	4 mm
1313053	**CRDNN2525M12MN7**	25	25	12,5	150	30,0	RN.N120700	**552.230**	**554.252**	2.5 mm	**557.111**	**551.333**	4 mm
1502204	**CRDNN3225P12MN4**	32	25	12,5	170	30,0	RN.N120400	**552.229**	**554.252**	2.5 mm	**557.111**	**551.333**	4 mm
1320407	**CRDNN3225P12MN7**	32	25	12,5	170	30,0	RN.N120700	**552.230**	**554.252**	2.5 mm	**557.111**	**551.333**	4 mm

NOTE: MN — clamping version is shown.
Basic holder may be ordered separately:
V.RDN N 2525M12
V.RDN N 3225M12



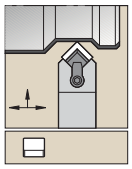


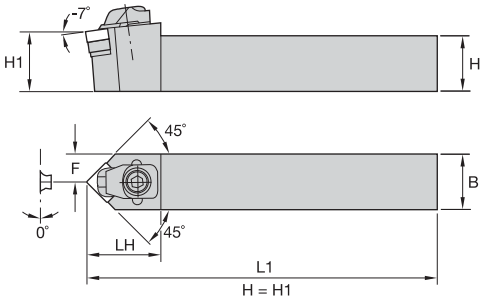
CRSN • MN



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand													
1510285	**CRSNR2525M12-MN4**	25	25	32,0	150	26,0	RN.N120400	**552.229**	**554.252**	2.5 mm	**557.111**	**551.333**	4 mm
1324116	**CRSNR2525M12MN7**	25	25	32,0	150	26,0	RN.N120700	**552.230**	**554.252**	2.5 mm	**557.111**	**551.333**	4 mm
1510286	**CRSNR3225P12MN4**	32	25	32,0	170	26,0	RN.N120400	**552.229**	**554.252**	2.5 mm	**557.111**	**551.333**	4 mm
1261273	**CRSNR3225P12MN7**	32	25	32,0	170	26,0	RN.N120700	**552.230**	**554.252**	2.5 mm	**557.111**	**551.333**	4 mm
left hand													
1510282	**CRSNL2525M12-MN4**	25	25	32,0	150	26,0	RN.N120400	**552.229**	**554.252**	2.5 mm	**557.111**	**551.333**	4 mm
1510283	**CRSNL2525M12MN7**	25	25	32,0	150	26,0	RN.N120700	**552.230**	**554.252**	2.5 mm	**557.111**	**551.333**	4 mm
1510284	**CRSNL3225P12MN4**	32	25	32,0	170	26,0	RN.N120400	**552.229**	**554.252**	2.5 mm	**557.111**	**551.333**	4 mm
1331597	**CRSNL3225P12MN7**	32	25	32,0	170	26,0	RN.N120700	**552.230**	**554.252**	2.5 mm	**557.111**	**551.333**	4 mm

NOTE: MN — clamping version is shown.
Basic holder may be ordered separately:
V.RSN R/L 2525M12
V.RSN R/L 3225P12

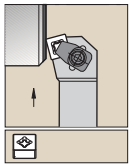


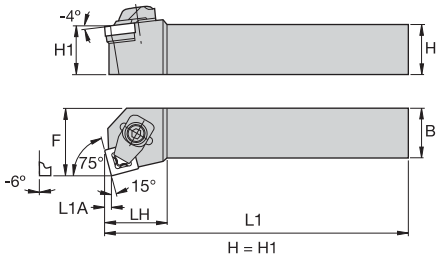


CSDN • MX



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	clamp assembly	hex
2891696	**CSDNN2525M12MX7**	25	25	12,5	151	36,0	SNGX120708	**552.232**	**554.252**	2.5 mm	**551.316**	4 mm



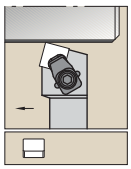


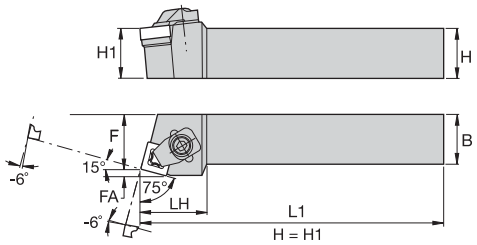
CSKN 75° • MN



order number	catalogue number	H	B	F	L1	LH	L1A	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand														
1261315	**CSKNR2525M12-MN7**	25	25	32,0	150	27,0	3,0	SN.N120708	**552.232**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
left hand														
1261299	**CSKNL2525M12-MN4**	25	25	32,0	150	27,0	3,0	SN.N120408	**552.231**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1261300	**CSKNL2525M12-MN7**	25	25	32,0	150	27,0	3,0	SN.N120708	**552.232**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm

NOTE: MX — clamping version is shown.
Basic holder may be ordered separately:
V.SKN R/L 2525M12



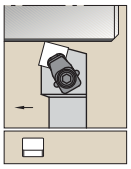


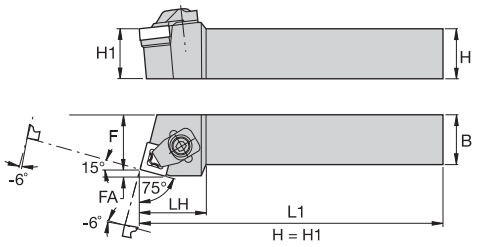
CSRN 75° • MX



order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim screw	hex	clamp assembly	hex
left hand													
1510300	**CSRNL3225P15-MX7**	32	25	27,0	170	34,0	4,1	SN.X150708	**552.234**	**554.253**	3 mm	**551.316**	4 mm

NOTE: MX — clamping version is shown.
Basic holder may be ordered separately:
V.SRN R/L 2525M12
V.SRN R/L 3225P12
V.SRN R/L 3225P15

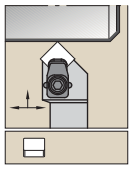


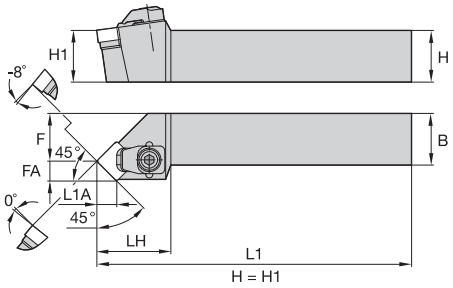


CSRN 75° • MN



order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand														
1510303	**CSRNR2525M12-MN4**	25	25	27,0	150	32,0	3,1	SN.N120408	**552.231**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1261336	**CSRNR2525M12-MN7**	25	25	27,0	150	32,0	3,1	SN.N120708	**552.232**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
left hand														
1510291	**CSRNL2525M12-MN4**	25	25	27,0	150	32,0	3,1	SN.N120408	**552.231**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1510292	**CSRNL2525M12-MN7**	25	25	27,0	150	32,0	3,1	SN.N120708	**552.232**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1261334	**CSRNL3225P12-MN7**	32	25	27,0	170	32,0	3,1	SN.N120708	**552.232**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm





CSSN 45° • MX

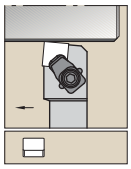


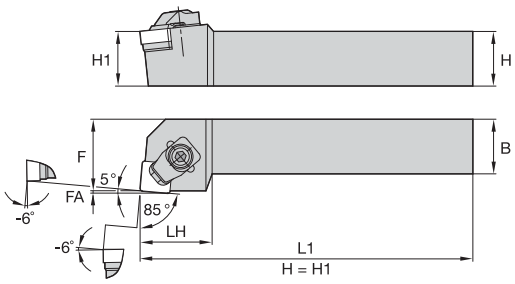
order number	catalogue number	H	B	F	L1	LH	FA	L1A	gage insert	shim	shim screw	hex	clamp assembly	hex
right hand														
1261367	**CSSNR2525M12-MX7**	25	25	32,0	150	35,0	8,3	8,3	SN.X120708	**552.232**	**554.252**	2.5 mm	**551.316**	4 mm
1261378	**CSSNR3225P15-MX7**	32	25	32,0	159	37,0	10,6	10,6	SN.X150708	**552.234**	**554.253**	3 mm	**551.316**	4 mm
left hand														
1261350	**CSSNL2525M12-MX7**	25	25	23,7	150	35,0	8,6	8,3	SN.X120708	**552.232**	**554.252**	2.5 mm	**551.316**	4 mm

CSSN 45° • MN

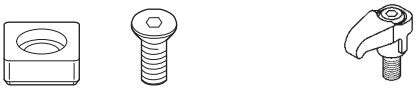


order number	catalogue number	H	B	F	L1	LH	FA	L1A	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand															
1261366	**CSSNR2525M12-MN7**	25	25	32,0	142	35,0	8,3	8,3	SN.N120708	**552.232**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1261370	**CSSNR3225P12-MN4**	32	25	32,0	162	35,0	8,3	8,3	SN.N120408	**552.231**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1261371	**CSSNR3225P12-MN7**	32	25	32,0	162	35,0	8,3	8,3	SN.N120708	**552.232**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
left hand															
1261349	**CSSNL2525M12-MN7**	25	25	32,0	142	35,0	8,3	8,3	SN.N120708	**552.232**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1261353	**CSSNL3225P12-MN4**	32	25	32,0	162	35,0	8,3	8,3	SN.N120408	**552.231**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1261354	**CSSNL3225P12-MN7**	32	25	32,0	162	35,0	8,3	8,3	SN.N120708	**552.232**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm





CSXN 85° • MX

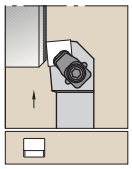


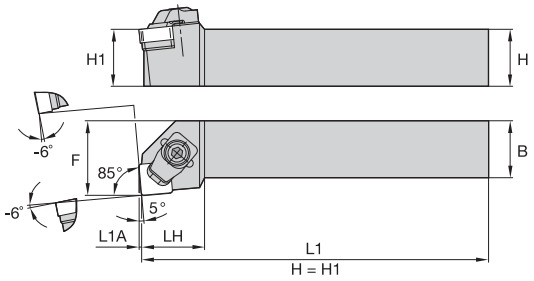
order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim screw	hex	clamp assembly	hex
right hand													
1510334	**CSXNR3225P12-MX7**	32	25	32,0	170	30,0	1,1	SN.X120708	**552.232**	**554.252**	2.5 mm	**551.316**	4 mm

CSXN 85° • MN



order number	catalogue number	H	B	F	L1	LH	FA	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand														
1510327	**CSXNR2525M12-MN4**	25	25	32,0	150	30,0	1,1	SN.N120408	**552.231**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
left hand														
1510313	**CSXNL2525M12-MN4**	25	25	32,0	150	30,0	1,1	SN.N120408	**552.231**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm





CSYN 85° • MX



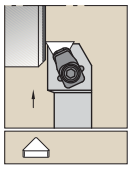
order number	catalogue number	H	B	F	L1	LH	L1A	gage insert	shim	shim screw	hex	clamp assembly	hex
left hand													
1261414	**CSYNL3225P12-MX7**	32	25	32,0	170	27,0	1,0	SN.X120708	**552.232**	**554.252**	2.5 mm	**551.316**	4 mm

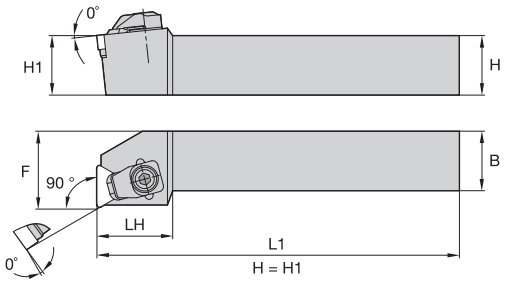
CSYN 85° • MN



order number	catalogue number	H	B	F	L1	LH	L1A	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand														
1261423	**CSYNR2525M12-MN7**	25	25	32,0	150	27,0	1,1	SN.N120708	**552.232**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
left hand														
1261408	**CSYNL2525M12-MN7**	25	25	32,0	150	27,0	1,1	SN.N120708	**552.232**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm

NOTE: MN — clamping version is shown.
Basic holder may be ordered separately:
V.SYN R/L 2525M12
V.SYN R/L 3225P12



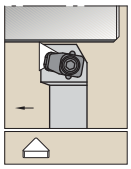


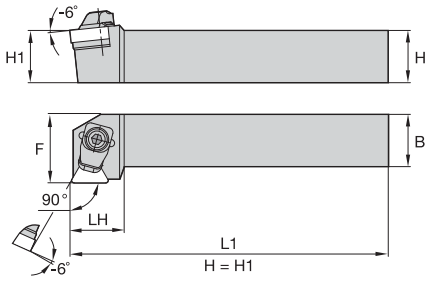
CTFN 90° • MN



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand													
1510344	**CTFNR2525M16-MN4**	25	25	32,0	150	29,0	TN.N160408	**552.235-H**	**554.254**	2.5 mm	**557.111**	**551.333**	4 mm
left hand													
1510341	**CTFNL2525M16-MN4**	25	25	32,0	150	29,0	TN.N160408	**552.235-H**	**554.254**	2.5 mm	**557.111**	**551.333**	4 mm

NOTE: MN — clamping version is shown.
Basic holder may be ordered separately:
V.TFN R/L 2525M16



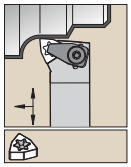


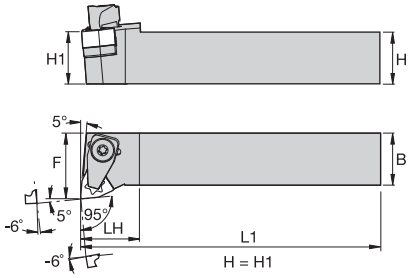
CTGN 90° • MN



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand													
1261482	**CTGNR2525M16-MN4**	25	25	32,0	150	20,0	TN.N160408	**552.235-H**	**554.254**	2.5 mm	**557.111**	**551.333**	4 mm
1261483	**CTGNR2525M16-MN7**	25	25	32,0	150	20,0	TN.N160708	**552.236**	**554.254**	2.5 mm	**557.111**	**551.333**	4 mm
left hand													
1261478	**CTGNL2525M16-MN4**	25	25	32,0	150	20,0	TN.N160408	**552.235-H**	**554.254**	2.5 mm	**557.111**	**551.333**	4 mm
1261479	**CTGNL2525M16-MN7**	25	25	32,0	150	20,0	TN.N160708	**552.236**	**554.254**	2.5 mm	**557.111**	**551.333**	4 mm

NOTE: MN — clamping version is shown.
Basic holder may be ordered separately:
V.TGN R/L 2525M16



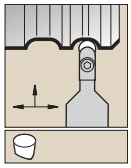


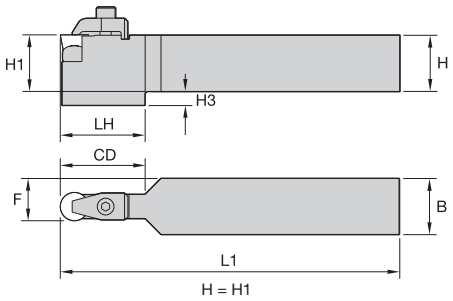
CWLN 95° • MX



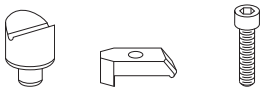


order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	hex	clamp assembly	hex
right hand												
1873227	**CWLNR3225P08-MX7**	32	25	32,0	170	32,0	WN.X080708	**552.210**	**554.252**	2.5 mm	**551.316**	4 mm
left hand												
1873224	**CWLNL2525M08-MX7**	25	25	32,0	150	32,0	WN.X080708	**552.210**	**554.252**	2.5 mm	**551.316**	4 mm



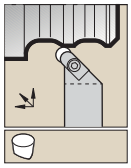


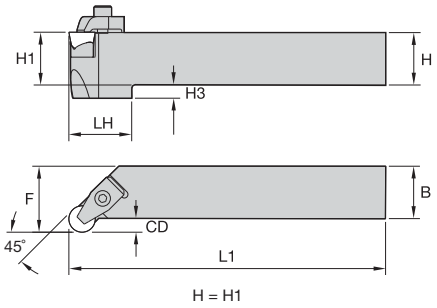
CRDP



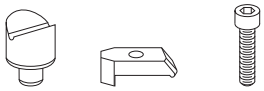
order number	catalogue number	H	B	F	L1	LH	H3	CD	gage insert	nest	clamp	clamp screw	hex
3642247	**CRDPN2525M06V**	25	25	12,5	151	—	—	19,0	RPGX060400E	**NST1**	**CM214**	**MS1321**	2.5 mm
3642249	**CRDPN3232P09V**	32	32	16,0	171	—	—	29,0	RPGX090700E	**NST2**	**CM219**	**CS412**	3.5 mm
3642248	**CRDPN2525M09V**	25	25	12,5	151	—	—	29,0	RPGX090700E	**NST2**	**CM219**	**CS412**	3.5 mm
3642251	**CRDPN3232P12V**	32	32	16,0	171	—	—	38,0	RPGX120700E	**NST3**	**CM216**	**CS412**	3.5 mm
3642252	**CRDPN3232P15V**	32	32	16,0	171	38,1	6,4	38,0	RPGX151000	**NST4**	**CM217**	**MS1294**	6 mm

NOTE: CRDP toolholders are able to use RPGX and RCGX insert styles.



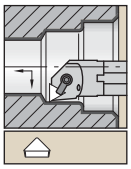


CRGP

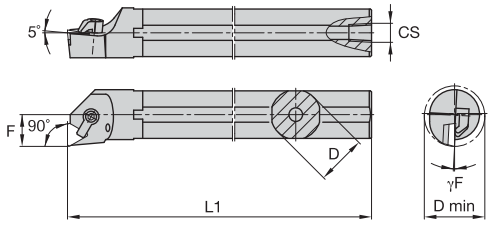


order number	catalogue number	H	B	F	L1	CD	gage insert	nest	clamp	clamp screw	hex
right hand											
3642276	**CRGPR2525M06V**	25	25	32,0	151	7,0	RPGX060400E	**NST1**	**CM214**	**MS1321**	2.5 mm
3642280	**CRGPR3232P09V**	32	32	40,0	171	8,0	RPGX090700E	**NST2**	**CM219**	**CS412**	3.5 mm
left hand											
3642277	**CRGPL2525M06V**	25	25	32,0	151	7,0	RPGX060400E	**NST1**	**CM214**	**MS1321**	2.5 mm
3642281	**CRGPL3232P09V**	32	32	40,0	171	8,0	RPGX090700E	**NST2**	**CM219**	**CS412**	3.5 mm

NOTE: CRGP toolholders are able to use RPGX and RCGX insert styles.



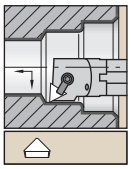
Steel shank with through coolant.



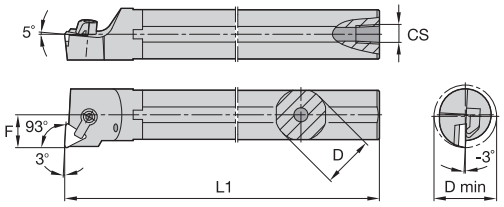
A-CTFP 90°



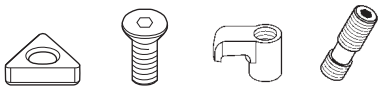
order number	catalogue number	D	D min	F	L1	CS	γF°	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand														
1886492	**A16RCTFPR11**	16	20,0	11,0	200	1/8-27 NPT	-4.0	TP..110304	**–**	**–**	–	**CKM19**	**STCM9**	2.5 mm
1098051	**A20QCTFPR11**	20	25,0	13,0	180	1/8-27 NPT	0.0	TP..110304	**SM815**	**MS961**	–	**CKM19**	**STCM9**	2.5 mm
1098053	**A25RCTFPR16**	25	32,0	17,0	200	1/4-18 NPT	-3.0	TP..160308	**SM841**	**MS110**	2 mm	**CKM10**	**STCM8**	4 mm
1098055	**A32SCTFPR16**	32	40,0	22,0	250	1/4-18 NPT	-3.0	TP..160308	**SM841**	**MS110**	2 mm	**CKM10**	**STCM8**	4 mm
1886494	**A40VCTFPR16**	40	48,0	27,0	400	1/4-18 NPT	-3.0	TP..160308	**SM841**	**MS110**	2 mm	**CKM10**	**STCM8**	4 mm
left hand														
1098054	**A25RCTFPL16**	25	32,0	17,0	200	1/4-18 NPT	-3.0	TP..160308	**SM841**	**MS110**	2 mm	**CKM10**	**STCM8**	4 mm
1098056	**A32SCTFPL16**	32	40,0	22,0	250	1/4-18 NPT	-3.0	TP..160308	**SM841**	**MS110**	2 mm	**CKM10**	**STCM8**	4 mm



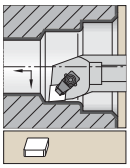
Steel shank with through coolant.



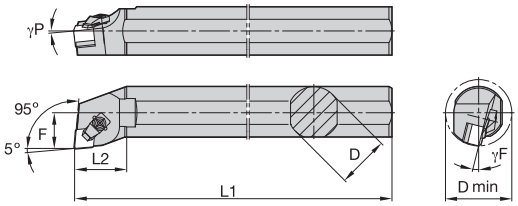
A-CTUP 93°



order number	catalogue number	D	D min	F	L1	CS	gage insert	shim	shim screw	clamp	clamp screw	hex
right hand												
1098057	**A16MCTUPR11**	16	20,0	11,0	150	1/8-27 NPT	TP..110304	**SM815**	**MS961**	**CKM19**	**STCM9**	2.5 mm
left hand												
1098058	**A16MCTUPL11**	16	20,0	11,0	150	1/8-27 NPT	TP..110304	**SM815**	**MS961**	**CKM19**	**STCM9**	2.5 mm



Steel shank without through coolant.



S-CCLN 95° • MX



order number	catalogue number	D	D min	F	L1	L2	γF°	γP°	gage insert	shim	shim screw	hex	clamp assembly	hex
right hand														
2890773	**S32SCCLNR12MX7**	32	40,0	22,0	251	43	-14.0	-5.0	CN.X120708	**–**	**–**	–	**551.316**	4 mm
1289077	**S40T-CCLNR12-MX7**	40	55,0	27,0	300	40	-14.0	-6.0	CN.X120708	**552.221**	**554.252**	2.5 mm	**551.316**	4 mm
left hand														
1510401	**S40T-CCLNL12-MX7**	40	55,0	27,0	300	40	-14.0	-6.0	CN.X120708	**552.221**	**554.252**	2.5 mm	**551.316**	4 mm

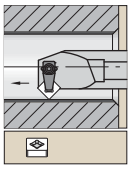
NOTE: MN – clamping version is shown.
Basic holder may be ordered separately:
S40T-V.CLN R/L 12

S-CCLN 95° • MN

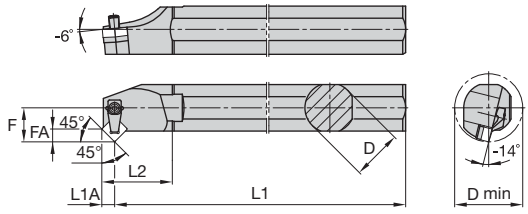


order number	catalogue number	D	D min	F	L1	L2	γF°	γP°	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand															
1289075	**S40T-CCLNR12-MN4**	40	55,0	27,0	300	40	-14.0	-6.0	CN.N120408	**552.220**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
1289076	**S40T-CCLNR12-MN7**	40	55,0	27,0	300	40	-14.0	-6.0	CN.N120708	**552.221**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm
left hand															
1289072	**S40T-CCLNL12-MN7**	40	55,0	27,0	300	40	-14.0	-6.0	CN.N120708	**552.221**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm

NOTE: MN – clamping version is shown.
Basic holder may be ordered separately:
S40T-V.SSN R/L 12



Steel shank without through coolant.

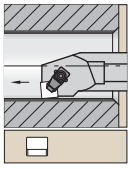


S-CSSN 45° • MX

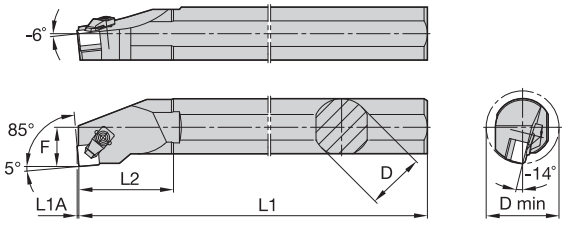


order number	catalogue number	D	D min	F	L1	L2	L1A	FA	gage insert	shim	shim screw	hex	clamp assembly	hex
right hand														
1873498	**S40T-CSSNR12-MX7**	40	55,0	27,0	300	67,0	8,3	8,3	SN.X120708	**552.232**	**554.252**	2.5 mm	**551.316**	4 mm
left hand														
1873499	**S40T-CSSNL12-MX7**	40	55,0	27,0	300	67,0	8,3	8,3	SN.X120708	**552.232**	**554.252**	2.5 mm	**551.316**	4 mm

NOTE: MX – clamping version is shown.
Basic holder may be ordered separately:
S40T-V.SSN R/L 12



Steel shank without through coolant.



S-CSYN 85° • MN

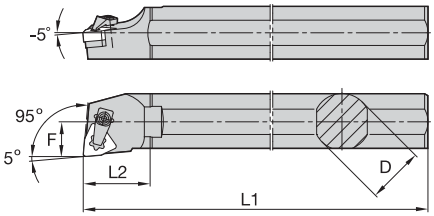


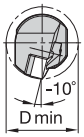
order number	catalogue number	D	D min	F	L1	L2	L1A	gage insert	shim	shim screw	hex	thrust plate	clamp assembly	hex
right hand														
1245016	**S40T-CSYNR12-MN7**	40	55,0	27,0	300	67,0	1,0	SN.N120708	**552.232**	**554.252**	2.5 mm	**557.111**	**551.317**	4 mm

NOTE: MN – clamping version is shown.
Basic holder may be ordered separately:
S40T-V.SYN R/L 08



Steel shank without through coolant.





S-CWLN 95° • MX



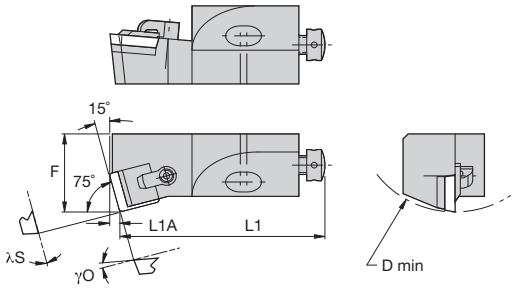




order number	catalogue number	D	D min	F	L1	L2	γF°	gage insert	shim	shim screw	hex	clamp assembly	hex
left hand													
1873496	**S40T-CWLNL08-MX7**	40	80,0	27,0	300	55,0	-10.0 deg	WN.X080708	**552.210**	**554.252**	2.5 mm	**551.316**	4 mm

NOTE: Basic holder may be ordered separately:
S40T-V. WLN R/L 12





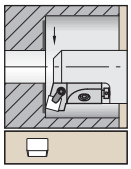
CSKP 75°

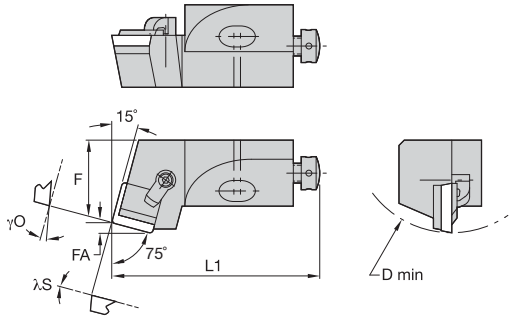
order number	catalogue number	D min	F	L1	L1A	λS°	γO°	gage insert
right hand								
1261328	**CSKPR12CA12**	50	20,0	55	3,1	0.0	5.0	SP..120308/SP..422

Spare Parts



D min	shim	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
50	–	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	**191.406**	4 mm	**CSWM 060 050**





CSRP 75°

order number	catalogue number	D min	F	L1	FA	λS°	γO°	gage insert
right hand								
3331132	**CSRPR10CA09**	40	14,0	50	2,2	0.0	0.0	SP..090308/SP..322

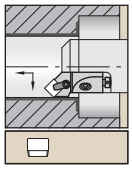
Spare Parts

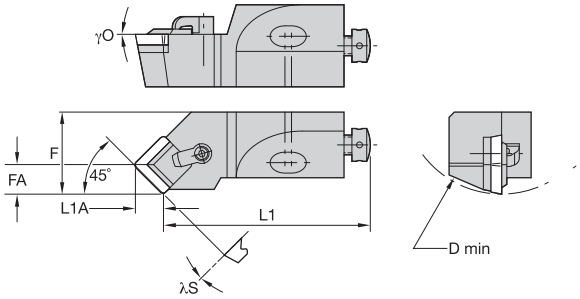







D min	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
40	**CKM34**	**STCM38**	2 mm	**KUAM28**	2 mm	**KUAM30**	**191.405**	4 mm	**CSWM 060 050**





CSSP 45°

order number	catalogue number	D min	F	L1	FA	L1A	λS°	γO°	gage insert
right hand									
1261379	**CSSPR10CA09**	40	14,0	44	6,5	6,1	0.0	0.0	SP..090308/SP..322
left hand									
3331143	**CSSPL10CA09**	40	14,0	44	6,5	6,1	0.0	0.0	SP..090308/SP..322

NOTE: Select spare parts based off of D min and insert size selected.

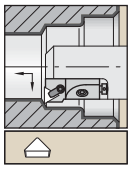
Spare Parts

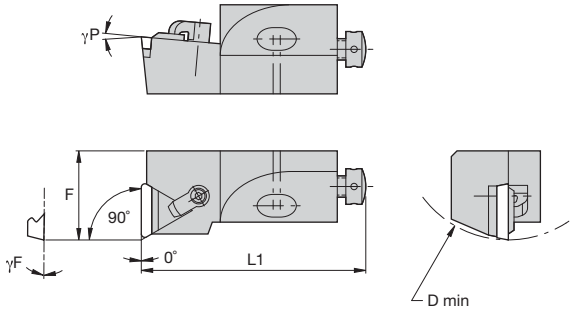







D min	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	hex	washer
40	**CKM34**	**STCM38**	2 mm	**KUAM28**	2 mm	**KUAM30**	**191.405**	4 mm	**CSWM 060 050**

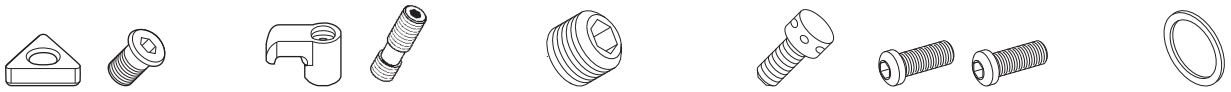




CTFP 90°

order number	catalogue number	D min	F	L1	γF°	γP°	gage insert
right hand							
2116588	**CTFPR10CA11**	40	14,0	50	0.0	5.0	TP..110304/TP..221
1746442	**CTFPR12CA16**	50	20,0	55	0.0	5.0	TP..160308/TP..322
2582207	**CTFPR20CA22**	70	25,0	70	0.0	5.0	TP..220408/TP..432
left hand							
2114034	**CTFPL10CA11**	40	14,0	50	0.0	5.0	TP..110304/TP..221

Spare Parts



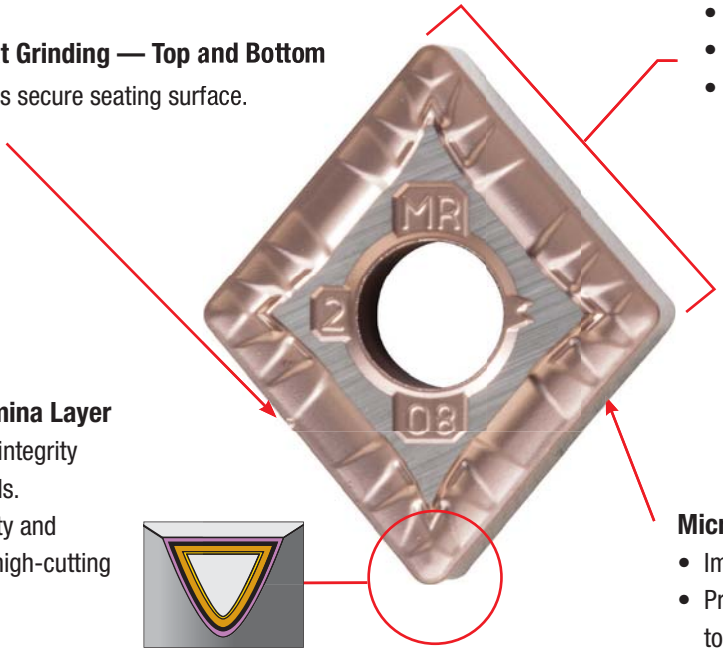
D min	shim	shim screw	hex	clamp	clamp screw	hex	radial adjusting screw	hex	axial adjusting screw	mounting screw	mounting screw	hex	washer
40	**–**	**–**	–	**CKM34**	**STCM38**	2 mm	**KUAM28**	2 mm	**KUAM30**	**191.405**	**–**	4 mm	**CSWM 060 050**
50	**–**	**–**	–	**CKM34**	**STCM38**	2 mm	**KUAM22**	2 mm	**KUAM31**	**–**	**191.406**	4 mm	**CSWM 060 050**
70	**SM837**	**MS125**	2.5 mm	**CKM35**	**STCM8**	4 mm	**KUAM25**	2.5 mm	**KUAM32**	**–**	**191.407**	5 mm	**CSWM 080 050**

Beyond™ Drive™ Inserts

- Designed for increased productivity.
- Post-coat treatment reduces stress, improves coating adhesion.
- Excellent toughness and wear resistance.
- Better insert wear detection.

Post-Coat Treatment
- Improves edge toughness.
- Long predictable tool life.
- Reduces depth-of-cut notching.
- Wide range of applications.

Post-Coat Grinding — Top and Bottom
- Provides secure seating surface.



Fine-Grained Alumina Layer
- Provides coating integrity at elevated speeds.
- Higher productivity and dependability at high-cutting temperatures.

TiN/MT-TiCN/TiCN/Al_2O_3/TiOCN

Micro-Polished Edges
- Improves edge toughness.
- Provides smooth outer surface to reduce forces, friction, and workpiece sticking.

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

KENNAMETAL®

kennametal.com

Tunable Boring Bars

With Front End KM™ Quick-Change Adaptor

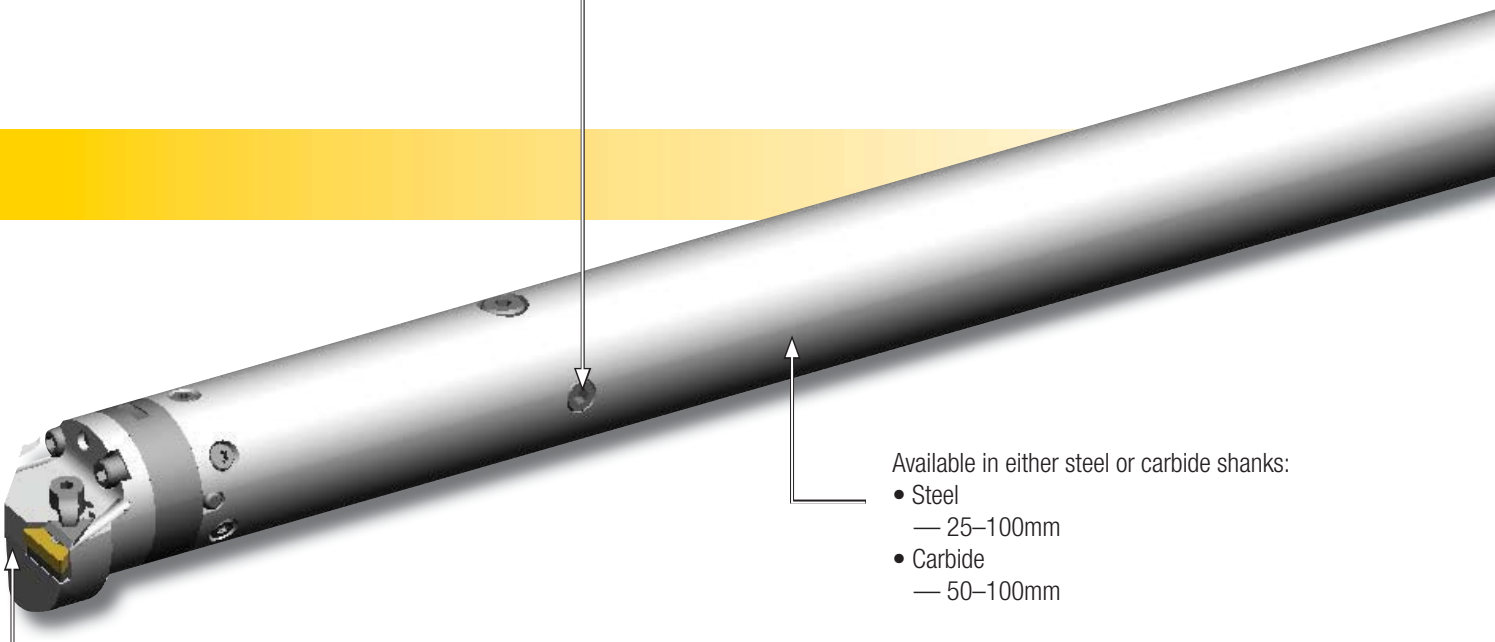
Kennametal offers a portfolio of tunable boring bars to increase productivity and solve chatter and other issues in long-boring operations.

Features, Functions, and Benefits

Features	Functions	Benefits
Robust internal clamping package	• Eliminates chatter and vibration. • Higher metal removal rate. • Larger depths of cut.	• High surface quality. • Low scrap rate. • Increased productivity. • Reduced noise exposure.
Tunable clamping mechanism	Bar can be tuned on the machine with just the turn of a screw.	Optimised damping characteristics for all kinds of machining conditions.
KM Quick-Change front end adaptor	• Ridged clamping system. • Wide selection of KM Quick-Change cutting units.	Flexible system reduces tooling inventory and setup times.

Kennametal has made several key improvements to our current tunable boring bar portfolio:

- Enhanced standardised tuning process at the manufacturing plant ensures bars are accurately tuned at the maximum overhang.
- Nitriding of steel tunable boring bars to eliminate the effects of chip wash.
- Elimination of flats on tunable boring bars enhances stability and promotes proper toolholding.
- Addition of a small flat on the connection collar enables the use of a centre-height tool.
- Enhanced assembly process.



Appearance of the Tunable Boring Bars

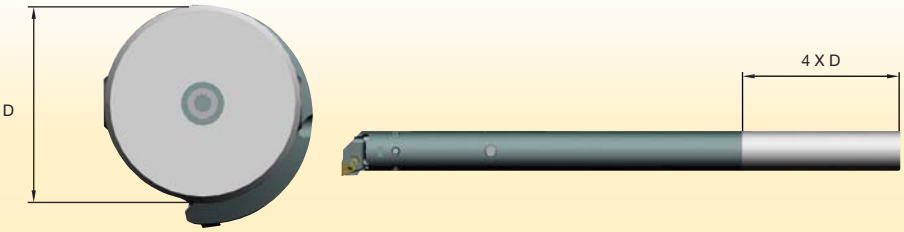
- **NEW** All tunable boring bars are tuned at the manufacturing plant and delivered to the customer with the tune specified at the maximum overhang of the bar.
- **NEW** All steel tunable bars undergo a nitriding process to help prevent chip wash damage to the bar and extend the bar's tool life.
- The nitride process of the black oxide steel tunable boring bars gives the shanks a bluish tint. These bars are through-coolant capable and use bolt-on heads or KM™ Quick-Change cutting adaptors. There is a set screw to tune the bar.
- Tunable boring bars with carbide shanks will appear grey in colour. They are through-coolant capable and use KM Quick-Change cutting adaptors. There is a set screw to tune the bar.

Application Recommendations

- Choose a boring bar as big as possible, but make sure there is adequate space for the chip evacuation.
- Balance the machining settings to avoid uncontrollable vibrations.
- Keep the L/D ratio as small as possible.
- Bar comes pre-tuned, but can be adjusted by hand.

1 Holding the Bar

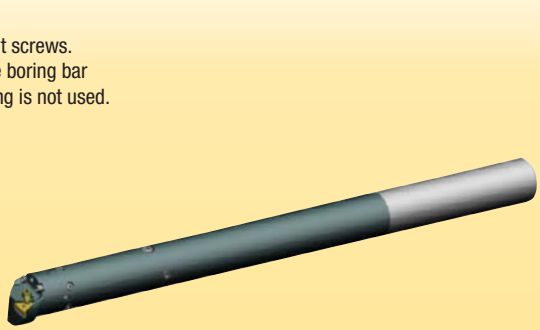
- Hold the bar correctly. Kennametal recommends holding the bar at 4 x D.

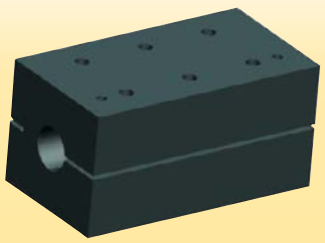


2 Kennametal recommends holding the boring bar in a split-style holder, with a split-style reducer if needed, with an ISO H7 diametral tolerance.

3 NEW: All flats have been removed from steel tunable boring bars.

- Do not clamp the bars with set screws.
- Kennametal cannot guarantee boring bar performance if proper clamping is not used.



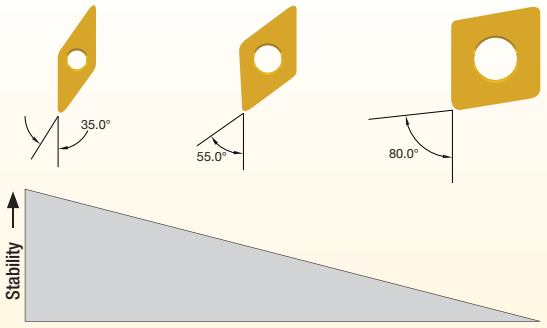


4 Tunable boring bars are designed and pre-tuned at the maximum overhang.

- Steel bars: pre-tuned to 10 x D; use as low as 6 x D.
- Carbide composite bars: pre-tuned to 15 x D; use as low as 12 x D.
- Re-tuning may be necessary if the boring bar is not used at its pre-tuned overhang.
- Never clamp or use the boring bar below its minimum overhang.

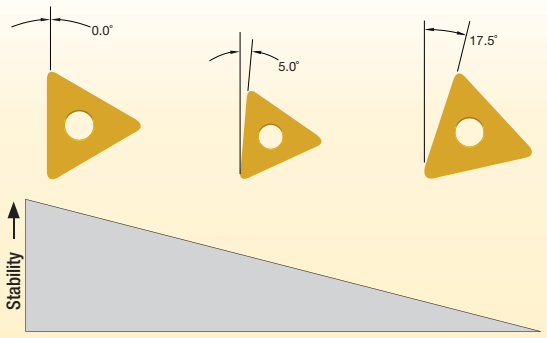
5 Insert Angle

- Smaller point angles produce consistent chip sizes and increase bore clearance for better chip evacuation.
- Larger point angles may cause rubbing due to larger cutting edge, which can result in vibration.



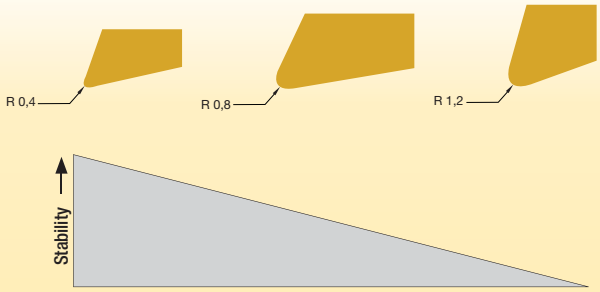
6 Lead Angle

- Choose a lead angle as close to 90º as possible for increased stability.



7 Nose Radius

- Choose a small nose radius for better stability.
- Depth of cut should be larger than the nose radius.



8 Insert Geometries

- Use positive, free-flowing insert geometries and sharp edge preps to reduce cutting forces.
- Use PVD inserts as a first choice because thinner coating keeps edge prep smaller.

9 Centre Cutting Height

- Cutting height tolerances are +/-.005".
- Kennametal recommends using our new centre height alignment tool kit. The kit includes a magnet, a seat, and an angle finder that can be mounted onto a small flat located on the connection collar of the tunable boring bar.

10 Chip Evacuation

- Chip packing and re-cutting can cause unwanted vibration while boring.
- Use coolant to flush out chips and to keep the damping element cool.
- Use insert geometries and cutting parameters that produce small chips.
- The boring bar can be used upside down to improve chip evacuation.

Tuning Recommendations

- Loosen the two locking screws on the bar.
- Turn the adjusting screw clockwise until the screw stops turning freely and the mass is in the locked-down position.
- You are now ready to tune the bar.
- Turn the adjusting screw in the anti-clockwise direction in quarter turn increments to adjust.
- After the adjustment has been completed, tighten the locking screws.

Kennametal Tunable Boring Bar Centre Height Alignment Procedure

The following procedure will walk the user through setting up a tunable boring bar on centre without the use of flats on the shank.

Equipment

- Digital angle finder
- Angle finder seat
- Boring bar to be used



Figure 1: Angle finder seat (left) and digital angle finder (right)

Assembly

- Clean any dirt, chips, debris, etc. from the mounting surfaces of the digital angle finder and the corresponding surfaces of the angle finder seat.
- Assemble the digital angle finder onto the angle finder seat, making sure it is flush against the back of the angle finder seat.

Calibration

- Clean an area on the X-axis of the lathe to create a reference surface for calibration.
- Clean any dirt, chips, debris, etc. from the magnet on the bottom of the angle finder seat.
- Place the angle finder assembly onto the X-axis of the lathe.
  - Keep the angle finder assembly parallel to the axis.
  - It is helpful to butt the assembly up against the turret housing to keep it parallel to the X-axis.
- Turn the digital angle finder on by pressing the on/off button.
- Zero the digital angle finder by pressing the zero button.

NOTE: The angle finder is now calibrated to the X-axis of the lathe and will measure angles corresponding to this axis.



Figure 2: X-axis calibration

Boring Bar Alignment

- With the boring bar already placed in the holder and set to the correct overhang, clean any dirt, chips, debris, etc. from the small flat on the collar of the boring bar.
- Place the angle finder assembly onto the boring bar by aligning the small magnet on the bottom of the assembly with the small flat on the collar of the boring bar.
  - — Be sure the angle finder assembly is perpendicular to the axis of the boring bar.
  - — Be sure the angle finder assembly is oriented in the same direction it was when it was calibrated to the X-axis of the lathe.



Figure 3: Boring bar collar flat

- Rotate the boring bar until the digital angle finder reads zero degrees.



Figure 4: Aligning the boring bar

- Tighten the boring bar holder to lock the boring bar position.
  - — Be sure the digital angle finder still reads zero after clamping the bar.
- The boring bar should now be on centre.

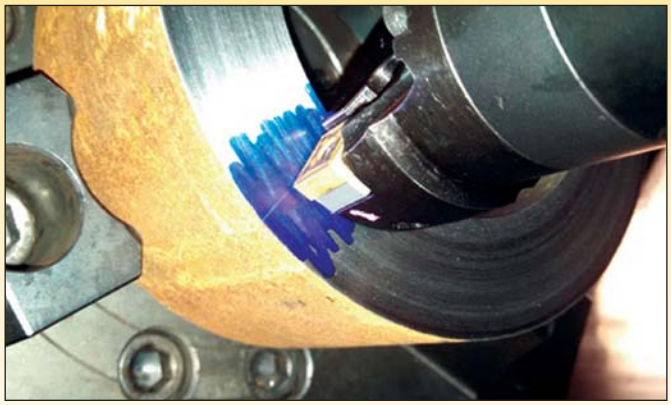
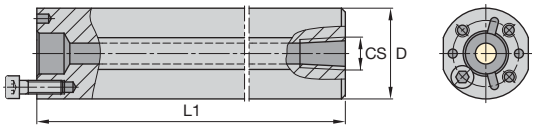


Figure 5: Boring bar centre height

Order the Kennametal Centre Height Alignment Tool Kit

The centre height alignment tool kit is available to order. Use order number 6141867, or catalogue number KIT-BB-AF.

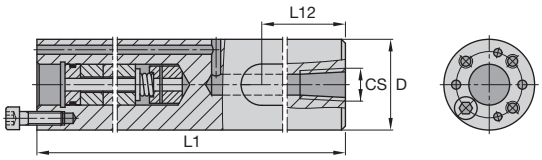


Steel shank with through coolant.
Max 4:1 overhang ratio.



BS

order number	catalogue number	D	L1	CS	screw 3 required	screw	hex
1098078	**BS32S**	32	210	RP3/8	**MS412**	**MS330**	4 mm
1098079	**BS40T**	40	260	RP3/8	**MS412**	**MS330**	4 mm
1098080	**BS50U**	50	310	RP3/8	**MS337**	**MS339**	5 mm

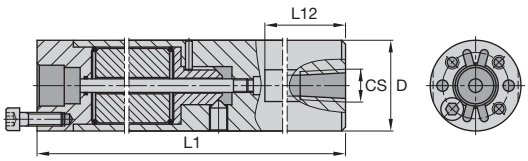


Steel shank DeVibrator with through coolant.
Max 6:1 overhang ratio.



BSD

order number	catalogue number	D	L1	CS	L12	L1 min	screw 3 required	screw	hex
1098150	**BSD32U**	32	310	RP3/8	200	200	**MS330**	**MS412**	4 mm
1098151	**BSD40V**	40	360	RP3/8	248	228	**MS330**	**MS412**	4 mm
1098152	**BSD50W**	50	410	RP3/8	280	276	**MS339**	**MS337**	5 mm

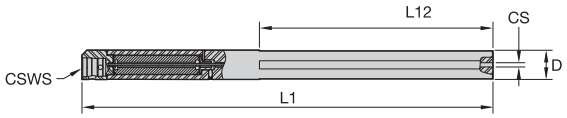


Tunable steel shank with through coolant.



D...TTB

order number	catalogue number	D	L1	CS	L12	L1 min	screw 3 required	screw	hex
1772222	**D25MTTB400**	25	381	RP1/4	203	227	**MS1499**	**MS319**	3 mm
1772223	**D32MTTB447**	32	422	RP3/8	267	332	**MS325**	**MS1130**	4 mm
1772224	**D40MTTB530**	40	492	RP3/8	305	300	**MS326**	**MS330**	4 mm
1772230	**D50MTTB700**	50	670	RP3/8	470	309	**MS337**	**MS337**	5 mm

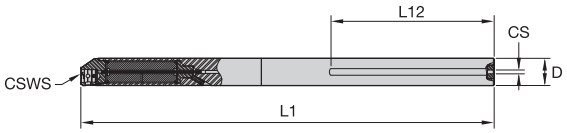


Tunable steel shank with through coolant and front end KM™ clamping unit.



D...TTB-KM • Metric

order number	catalogue number	D	L1	CS	L12	L1 min	CSWS system size
3637636	**D40MTTB560KM40**	40	520	RP 3/8-19	305	330	KM40
3637637	**D50MTTB737KM40**	50	697	RP 3/8-19	470	337	KM40
3637638	**D60MTTB1000KM40**	60	976	RP 3/8-19	686	396	KM40
3642134	**D80MTTB1120KM63**	80	1060	RP 3/8-19	610	560	KM63
3642135	**D100MTTB1330KM63**	100	1384	RP 3/8-19	622	695	KM63



Carbide tunable boring bar with KM™ Quick-Change connection.



G-TTB-KM • Metric

order number	catalogue number	D	L1	CS	L12	CSWS system size
3954298	**G50MTTB1026KM40**	50	986	RP 3/8-19	300	KM40
3954300	**G80MTTB1564KM63**	80	1504	RP 3/8-19	480	KM63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Grooving and Cut-Off

Beyond Evolution • Grooving, Turning, and Cut-Off C2–C77

Application Guidelines C76–C77

A4 Groove and Turn C78–C135

Top Notch • Shallow Grooving C136–C179

Application Guidelines C172–C179

Getting started made **EASY**

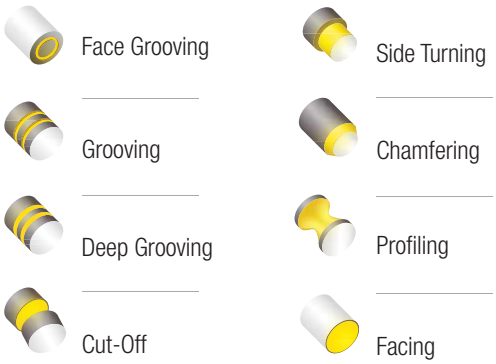
beyond™ EVOLUTION™

Your day made **EASY**

Choosing the right tooling can be complicated and time-consuming. Built on simplicity, we have engineered a new tool that makes every machine operator's life EASY.

Unwilling to sacrifice performance or applications, Kennametal introduces Beyond™ Evolution™.

Beyond™ Evolution™ is the new single-side grooving and cut-off tool that also performs multi-directional turning.

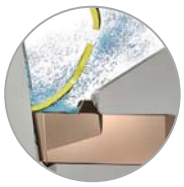


Productivity made **EASY**

Active Coolant Control

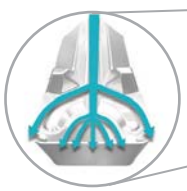
If your coolant delivery is typical to the market, you may be applying more heat to the cutting edge than you think. This reduces tool life and increases cycle time.

With Beyond™ Evolution™, you won't have to change your existing equipment. Whether you are using a high-pressure or low-pressure coolant supply, Beyond™ Evolution™, featuring Active Coolant Control, delivers more tool life and higher Metal Removal Rates (MRR).



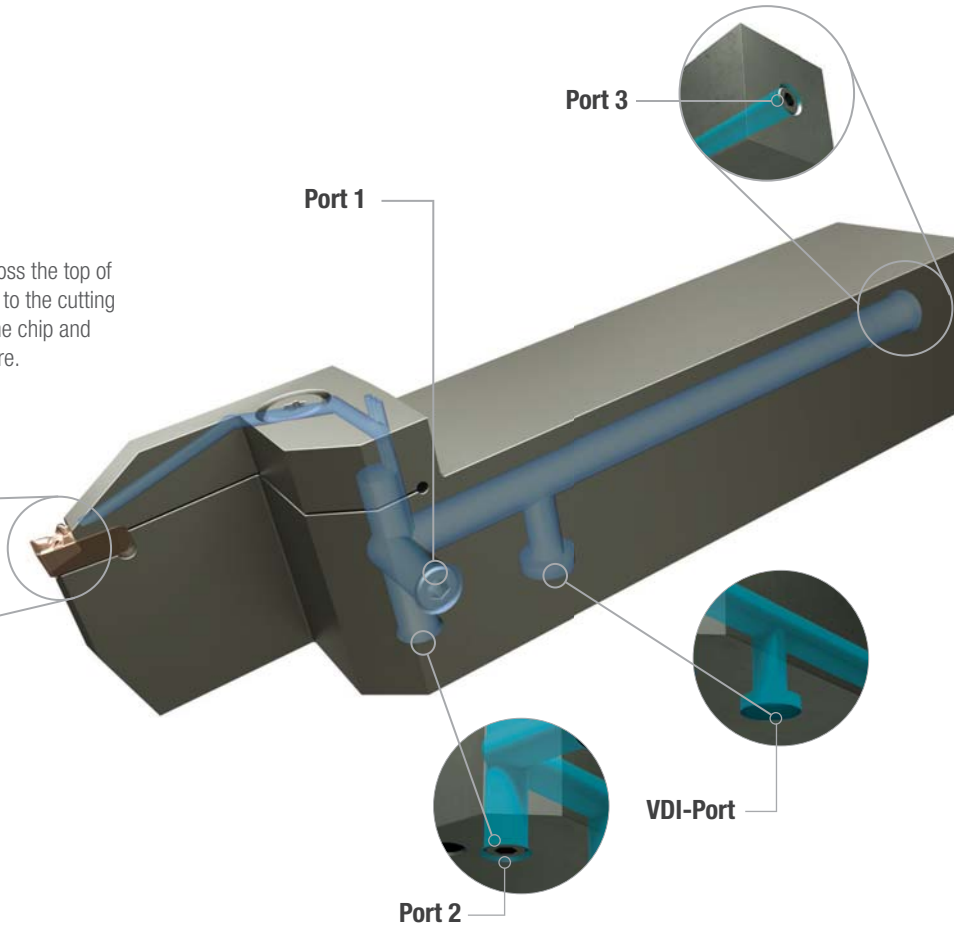
Fan Effect

Directs coolant across the top of the insert precisely to the cutting zone underneath the chip and controls temperature.



Chipbreaking Effect

Improve chip control in all grooving, cut-off, and multi-directional turning applications.



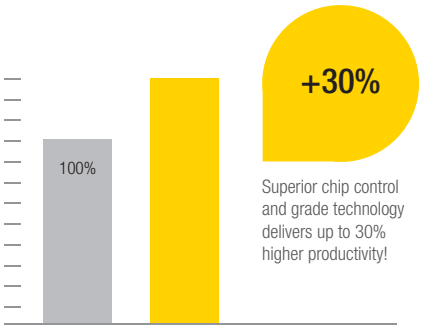
Smooth surface finish made **EASY**

Triple-V Seating

Problem: Traditional single-sided grooving and cut-off systems cannot deliver smooth surface finish due to lack of stability.

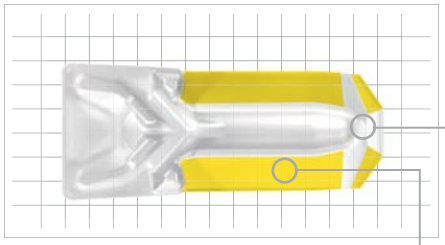
Solution: The Beyond™ Evolution™ proprietary new Triple-V Seating feature provides functional stability and minimises vibration.

Three contact surfaces provide unmatched stability: When combined with GUP and CF chipbreakers, Triple-V Seating provides excellent surface finish.



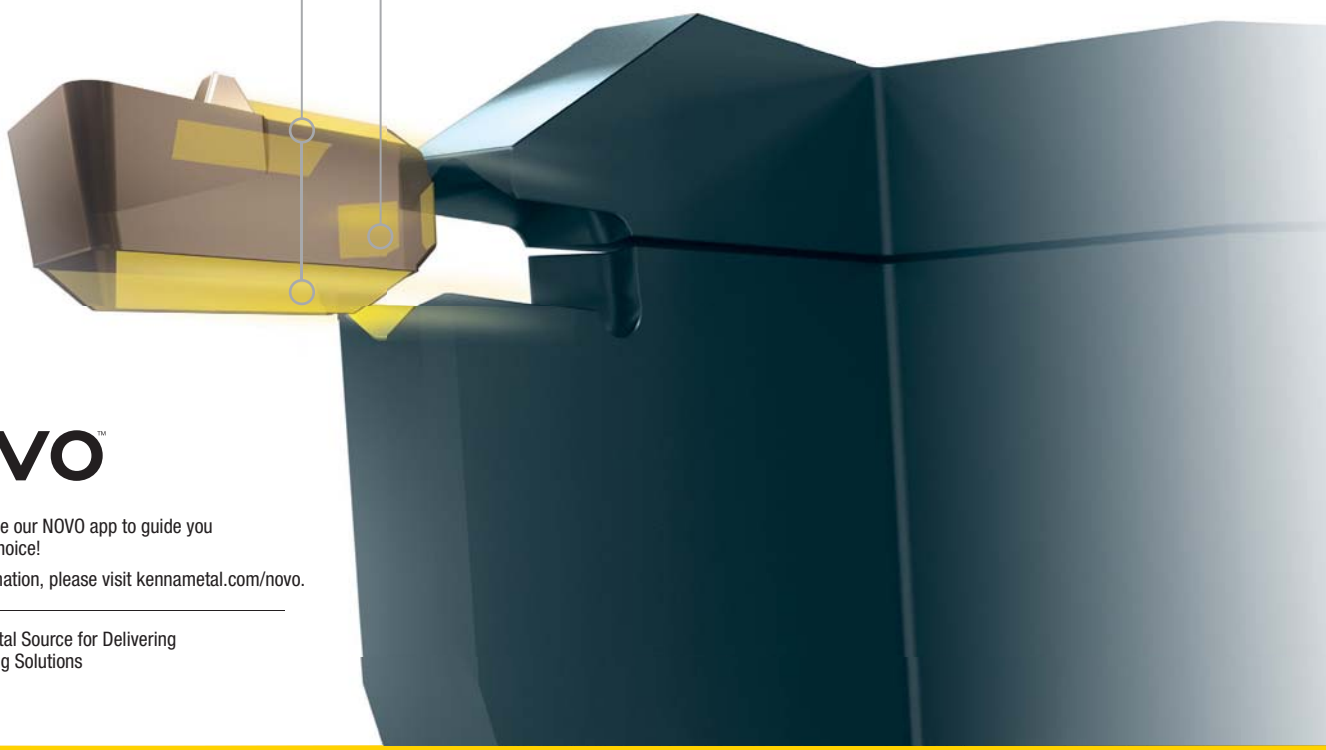
Saving money made **EASY**

Beyond™ Evolution™, featuring Active Coolant Control, Triple-V Seating, and Beyond™ Drive™ grades with Wear Detection Technology, provides longer tool life, maximum stability, and higher Metal Removal Rates (MRR), resulting in up to 30% higher productivity.



V-Back Design
Unsurpassed grooving, cut-off, and multi-directional turning load stability.

Top and Bottom-V
Precise and secure insert positioning for increased rigidity and dimensional accuracy



NOVO™

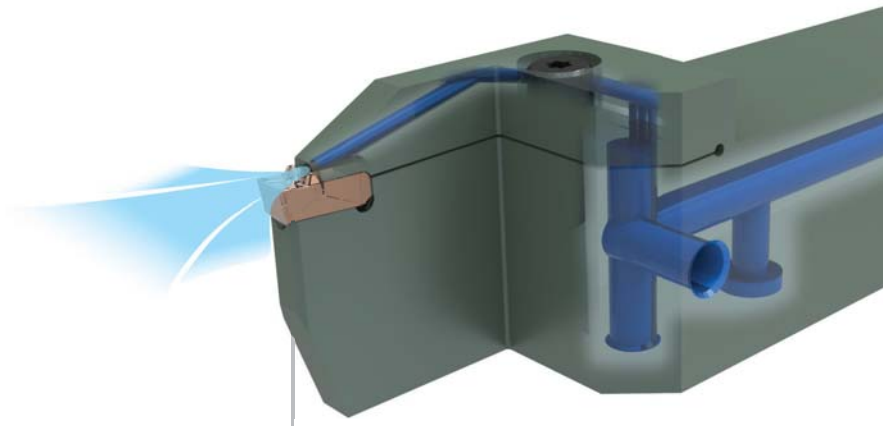
You can also use our NOVO app to guide you to the correct choice!

For more information, please visit kennametal.com/novo.

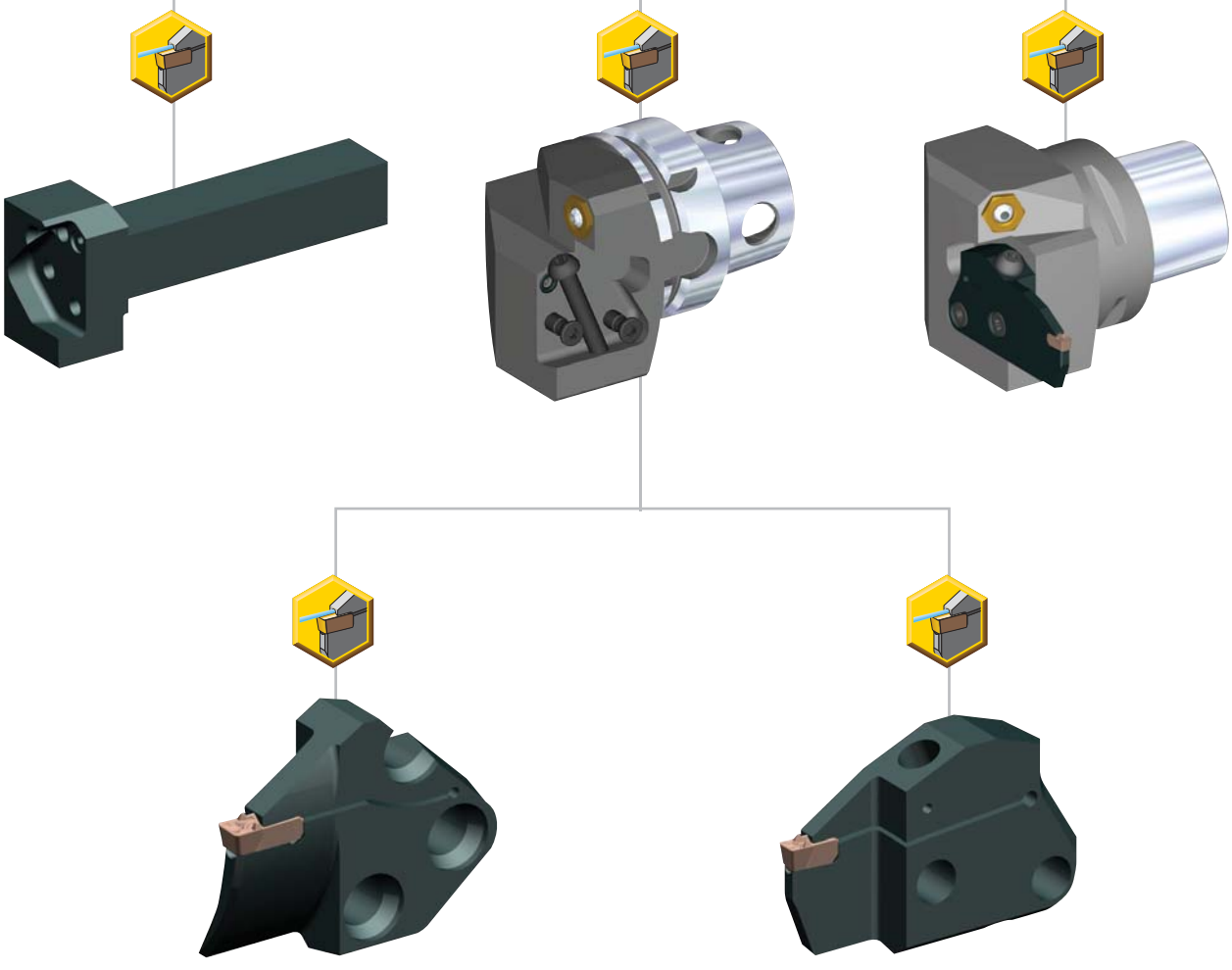
NOVO: The Digital Source for Delivering Smart Machining Solutions

Your day made **EASY** —

Efficient coolant delivery. Available in seat sizes 3 and higher.

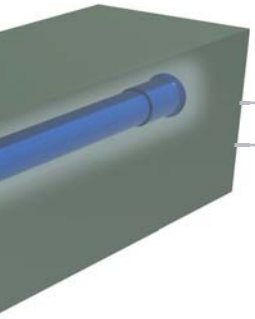


Modular with through coolant



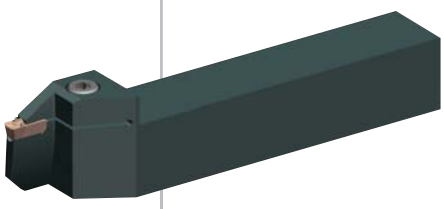
beyond™ EVOLUTION™

high-performance system.



Face grooving
with through coolant

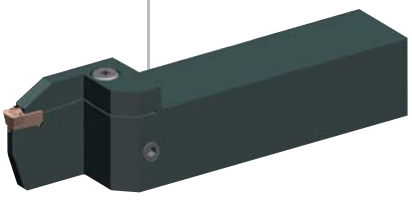
I.D. Boring Bar

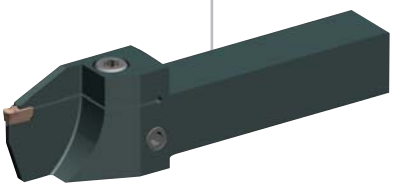




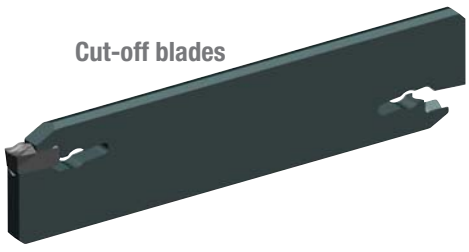


Square shank
with through coolant





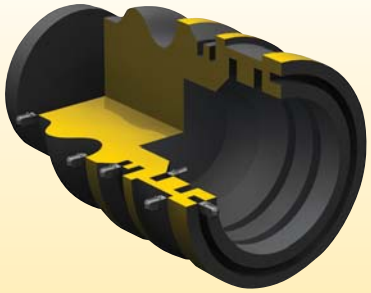
Cut-off blades



Step 1 • Identify your grooving or cut-off application

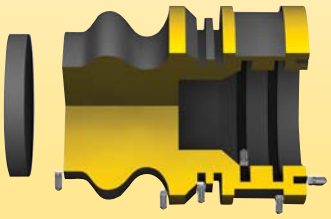
What you need to know:

- Groove depth, width, and profile.
- Material being machined.
- Application to be performed (O.D. and I.D. grooving, turning, face grooving, and cut-off).
- Shank size requirements of the machine.



General Recommendation to Select the Insert Size

for workpiece diameters	insert seat size
<25mm	3
25–50mm	4
>50mm	5–10



Step 2 • Select chipbreaker style and feed rate

Based on the application and seat size, determine the recommended geometry and starting feed rate.

Plunge feed rates

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

● first choice
○ alternate choice

Chip Control	Description	Insert Geometry	Seat Size	Corner Radius mm	Starting Conditions mm	Plunge Feed Rates mm/rev 0,05 0,10 0,15 0,20 0,25 0,30 0,35
-GUP	Positive rake angle for lower cutting forces.		1F	0,2	0,06	●
			2	0,2	0,08	○
			3	0,2	0,09	●
				0,4	0,11	○
			4	0,4	0,12	●
				0,8	0,15	○
			5	0,4	0,15	●
				0,8	0,16	○
			6	0,4	0,16	●
				0,8	0,18	○
				1,2	0,20	●
			8	0,8	0,20	○
				1,2	0,22	●
			10	1,2	0,24	○
-GUN	Stable negative cutting edge allowing for more aggressive applications.		1F	0,2	0,06	●
			2	0,2	0,08	○
			3	0,2	0,09	●
				0,4	0,11	○
			4	0,4	0,12	●
				0,8	0,15	○
			5	0,4	0,15	●
				0,8	0,16	○
			6	0,4	0,16	●
				0,8	0,18	○
				1,2	0,20	●
			8	0,8	0,20	○
				1,2	0,22	●
			10	1,2	0,24	○

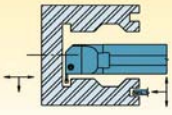
Maximum Feed Rate Values

Data above is for P and K material groups. **Maximum** feed rates should be adjusted by multiplying max feed rate values by following factors for shown material groups.

Material Group	Feed Factor
M	.8
N	1.2
S	.8
H	.5

I.D. and Face Grooving

For I.D. and face grooving applications, reduce feed rate by 20%.



Step 3 • Select the starting speed

Based on material and grade, identify starting speed (vc). First choice is in **bold** type.

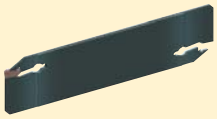
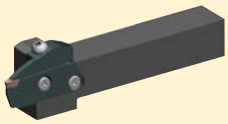
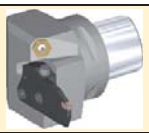
A Based on material group and grade, identify starting speed (vc).
B First choice starting speed is in **bold.**

Recommended Starting Speeds [m/min]

Material Group		K313			KCU10			KCU25			KCM35B			KCP10B			KCP25B		
																A			
P	0–1	–	–	–	140	**280**	350	110	**225**	270	90	**180**	213	185	**400**	450	145	**290**	365
	2	–	–	–	140	**200**	300	110	**160**	260	90	**130**	155	185	**270**	350	145	**200**	305
	3	–	–	–	140	**155**	245	110	**125**	235	90	**100**	155	170	**190**	260	140	**155**	245
	4	–	–	–	75	**110**	170	60	**90**	160	50	**70**	110	90	**145**	200	75	**110**	180
	5	–	–	–	120	**200**	260	100	**160**	210	80	**130**	165	150	**220**	305	120	**200**	270
	6	–	–	–	110	**150**	230	85	**120**	185	70	**100**	145	120	**180**	275	110	**150**	230
M	1	60	**90**	120	140	**210**	280	90	**170**	245	75	**120**	135	–	–	–	–	–	–
	2	45	**75**	110	120	**200**	245	90	**150**	245	75	**110**	135	–	–	B –	–	–	–
	3	35	**65**	100	120	**180**	245	90	**140**	210	75	**90**	135	–	–	–	–	–	–
K	1	30	**75**	120	120	**180**	245	100	**145**	225	–	–	–	170	**245**	440	140	**200**	360
	2	25	**70**	110	90	**150**	240	70	**120**	170	–	–	–	120	**195**	340	100	**160**	280
	3	20	**60**	90	60	**110**	150	50	**85**	120	–	–	–	120	**170**	270	100	**140**	220
	1–2	150	**370**	610	150	**550**	975	120	**440**	780	–	–	–	–	–	–	–	–	–

Step 4 • Select toolholder based on application

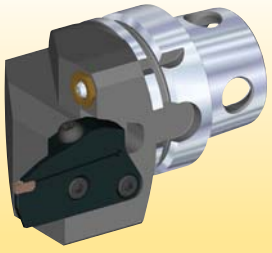
Choose the high-performance holder based on your specific grooving or cut-off application, with the corresponding seat size.

Style		Application
	**Boring Bar**	• For use in I.D. grooving applications.
	**Cut-Off Blade**	• Allows user to vary the depth of cut.
	**Toolholder — Integral**	• Offers the most stability over other styles.
	**Toolholder — Modular**	• Interchangeable blades for versatility.
	**KM™ — Modular** **KM4X™ — Modular**	• Best-in-class KM™ Quick-Change platform.
	**PSC — Modular**	• The modular system in the PSC Quick-Change platform.

Step 5 • Select the insert and holder from catalogue page

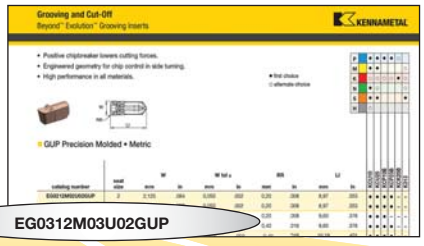
Congratulations!

You have successfully maximised your productivity by selecting the best insert geometry, grade, and cutting specifications for your application!



How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



E	G	0312	M	03	U	02	GUP
Family Name	Insert Type	Groove Width	Unit	Seat Size	Tolerance	Corner Radius	Chipbreaker/ Edge Condition
Beyond™ Evolution™	**G** = Square **R** = Full Radius	**Metric** = 1/100mm **Inch** = 1/1000"	**M** = Metric **I** = Inch		**U** = Precision Moulded **P** = Precision Ground		**GUP** = Groove-Turn Universal Positive **GUN** = Groove-Turn Universal Negative **FB** = Flat Top Blank **PB** = Positive Chip Control Blank

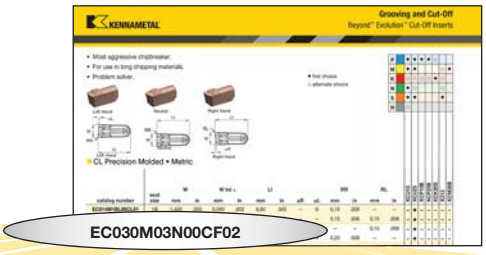
seat size	groove width	
	mm	inch
1B	1,40	.055
1F	1,60–1,99	.063–.078
02	2,00–2,99	.079–.117
03	3,00–3,99	.118–.156
04	4,00–4,99	.157–.196
05	5,00–5,99	.197–.235
06	6,00–7,99	.236–.314
08	8,00–8,99	.315–.353
10	9,00–10,12	.354–.398

*.312" = seat size 08

mm	
00	full radius
01	0,1
02	0,2
04	0,4
08	0,8
12	1,2

inch	
00	full radius
05	.008
1	.016
2	.032
3	.047

By referencing this easy-to-use guide, you can identify the correct product to meet your needs.

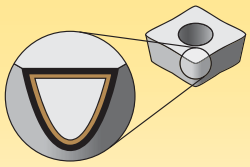


E	C	030	M	03	N	00	CF	02
Family Name	Insert Type	Cutting Edge Width	Unit	Seat Size	Hand of Insert	Approach Angle	Chipbreaker	Corner Radius
Beyond™ Evolution™	**C** = Cut-Off		**M** = Metric **I** = Inch		**N** = Neutral **L** = Left hand **R** = Right hand	**00** = Neutral **06** = 6°	**CL** = Cut-Off Low Feed **CF** = Cut-Off Fine **CM** = Cut-Off Medium **CR** = Cut-Off Rough	

Cutting Edge Width	mm	inch
014	1,4	.055
020	2,0	.079
030	3,0	.118
040	4,0	.157
050	5,0	.197
060	6,0	.236
070	7,0	.279
080	8,0	.315

Seat Size	mm	inch
1B	1,4	.055
1F	2,0	.079
02	3,0	.118
03	4,0	.157
04	5,0	.197
05	6,0	.236
06	7,0	.279
08	8,0	.315

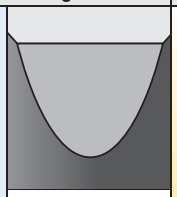
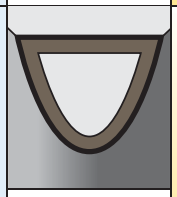
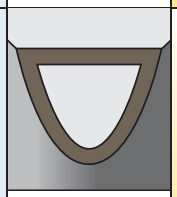
Corner Radius	mm	inch
01	0,1	.004
02	0,2	.008
04	0,4	.016

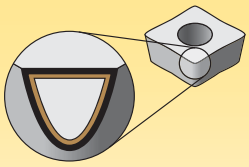


Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

Grades

Coating	Grade Description	wear resistance ← → toughness: 05	10	15	20	25	30	35	40	45
K313  —	**Composition:** A hard, low binder content, unalloyed WC/Co fine-grain grade. **Application:** Exceptional edge wear resistance combined with very high strength for machining titanium, cast irons, austenitic stainless steels, non-ferrous metals, non-metals, and most high-temp alloys. Superior thermal deformation and depth-of-cut notch resistance. The grain structure is well controlled for minimal pits and flaws, which contributes to long, reliable service.	M: 10, 15, 20 · K: 05, 10, 15, 20 · N: 10, 15, 20 · S: 10, 15, 20								beyond
KCU10  —	**Composition:** An advanced multilayer PVD coating over a very deformation-resistant unalloyed carbide substrate. The new and improved coating improves edge stability with wide range speed and feed capabilities. **Application:** The KCU10™ grade is ideal for finishing to general machining of most workpiece materials at a wide range of speed and feed capabilities. Excellent for machining most steels, stainless steels, cast irons, non-ferrous materials, and super alloys with improved edge toughness and higher cutting speed/feed capability.	P: 10, 15, 20 · M: 10, 15, 20 · K: 10, 15, 20 · N: 10, 15, 20 · S: 10, 15, 20 · H: 10								beyond
KCU25  —	**Composition:** An advanced PVD grade with hard AlTiN coating and fine-grain unalloyed substrate. The new and improved coating improves edge stability with wide range speed and feed capabilities. **Application:** The KCU25™ grade is ideal for general machining of most steels, stainless steels, high-temp alloys, titanium, irons, and non-ferrous materials in a wide range of speeds and feeds with improved edge toughness for interrupted cuts and high feed rates.	P: 20, 25, 30 · M: 20, 25, 30 · K: 20, 25, 30 · N: 20, 25, 30 · S: 20, 25, 30								beyond DRIVE™



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

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

CVD-Coated Carbide Grades

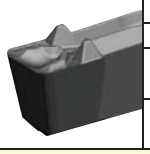
wear resistance ⟷ toughness

Coating	Grade Description	05	10	15	20	25	30	35	40	45
KCP10B	**Composition:** A specially engineered wear-resistant carbide grade with a newly designed multilayer MTCVD-TiCN-Al_2O_3-TiOCN coating with superior interlayer adhesion. **Application:** An excellent finishing to medium machining grade for a variety of workpiece materials, including most steels, ferritic, martensitic, and PH stainless steels, and cast irons. The cobalt-enriched substrate offers a balanced combination of deformation resistance and edge toughness, while the thick coating layers offer outstanding abrasion resistance and crater wear resistance for high-speed machining. Smooth coating provides resistance to edge build-up and microchipping and produces excellent surface finishes.	P									
		K								
		beyond DRIVE™								
KCP25B	**Composition:** A tough cobalt-enriched carbide grade with a newly designed multilayer MTCVD-TiCN-Al_2O_3-TiOCN coating with superior interlayer adhesion. **Application:** Best general-purpose turning grade for most steels and ferritic and martensitic stainless steels. The substrate design ensures adequate deformation resistance with excellent insert edge strength. Coating layers offer good wear resistance over a wide range of machining conditions and the post-coat treatment minimises microchipping and improves coating adhesion to substrate leading to long tool life and improved workpiece finishes.	P									
		K								
		beyond DRIVE™								
KCK20B	**Composition:** A multilayered coating with thick MTCVD TiCN-Al_2O_3-TiOCN layers applied over a carbide substrate specifically engineered for cast irons. **Application:** Delivers consistent performance in high-speed machining of grey and ductile irons. The substrate design permits the insert to stay in the cut for a long time at high speeds with minimum deformation. The thick CVD coating and post-coat treatment provide superior wear resistance ensuring long and consistent tool life. Can be applied both in straight and lightly interrupted cuts.	P									
		K								
		beyond DRIVE™								
KCM35B	**Composition:** A multilayer TiN-MT-TiCN-Al_2O_3-TiOCN CVD coating over a super-tough substrate. **Application:** KCM35B is an excellent general purpose to roughing grade for machining stainless steels and roughing steels in turning and cut-off applications. The substrate provides improved toughness while the coating layers offer improved abrasion resistance and dependability at high cutting temperatures, along with wear identification. The polished surface improves edge toughness and provides a smooth outer surface to reduce forces and resist workpiece build-up on the cutting edge even at low cutting speeds. The grade is available in multiple sizes and geometries appropriate for increased feeds and large depths of cut.	P									
		M								
		S								
		beyond DRIVE™								

Select the geometry

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

● first choice
○ alternate choice

Chip Control	Description	Insert Geometry	Seat Size	Corner Radius in (mm)	Starting Conditions in (mm)	Plunge Feed Rates inch/rev (mm/rev) .0020 (0,05)	.0040 (0,10)	.0060 (0,15)	.0080 (0,20)	.0100 (0,25)	.0120 (0,30)
-GUP	Positive rake angle for lower cutting forces.		1F	.008 (0,2)	.0024 (0,06)						
			2	.008 (0,2)	.0031 (0,08)						
			3	.008 (0,2)	.0035 (0,09)						
				.016 (0,4)	.0043 (0,11)						
			4	.016 (0,4)	.0047 (0,12)						
				.031 (0,8)	.0059 (0,15)						

Pictorial View of Insert

Corner Radius

Recommended Starting Feed Rate

Plunge Feed Rates

Seat Size

Recommended Feed Rate Range

Primary Workpiece Material Group

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

● first choice
○ alternate choice

Chip Control Geometry Designation

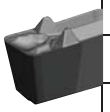
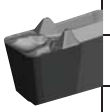
Maximum Feed Rate Values

	Material Group	Feed Factor
Data above is for P and K material groups. **Maximum** feed rates should be adjusted by multiplying max feed rate values by following factors for shown material groups.	M	.8
	N	1.2
	S	.8
	H	.5

Plunge feed rates

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

● first choice
○ alternate choice

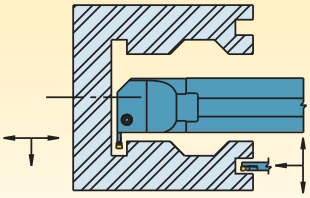
Chip Control	Description	Insert Geometry	Seat Size	Corner Radius mm	Starting Conditions mm	Plunge Feed Rates mm/rev 0,05 0,10 0,15 0,20 0,25 0,30 0,35
-GUP	Positive rake angle for lower cutting forces.		1F	0,2	0,06	
			2	0,2	0,08	
			3	0,2	0,09	
				0,4	0,11	
			4	0,4	0,12	
				0,8	0,15	
			5	0,4	0,15	
				0,8	0,16	
			6	0,4	0,16	
				0,8	0,18	
				1,2	0,20	
			8	0,8	0,20	
				1,2	0,22	
			10	1,2	0,24	
-GUN	Stable negative cutting edge allowing for more aggressive applications.		1F	0,2	0,06	
			2	0,2	0,08	
			3	0,2	0,09	
				0,4	0,11	
			4	0,4	0,12	
				0,8	0,15	
			5	0,4	0,15	
				0,8	0,16	
			6	0,4	0,16	
				0,8	0,18	
				1,2	0,20	
			8	0,8	0,20	
				1,2	0,22	
			10	1,2	0,24	

Maximum Feed Rate Values

	Material Group	Feed Factor
Data above is for P and K material groups. **Maximum** feed rates should be adjusted by multiplying max feed rate values by following factors for shown material groups.	M	.8
	N	1.2
	S	.8
	H	.5

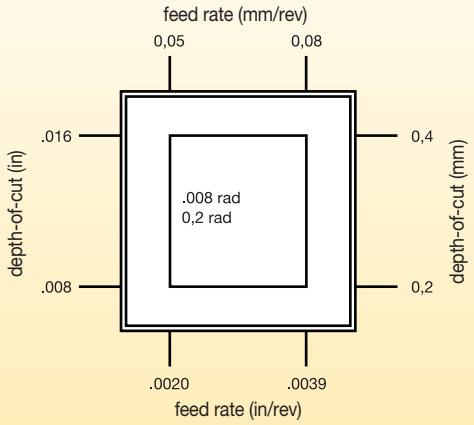
I.D. and Face Grooving

For I.D. and face grooving applications, reduce feed rate by 20%.

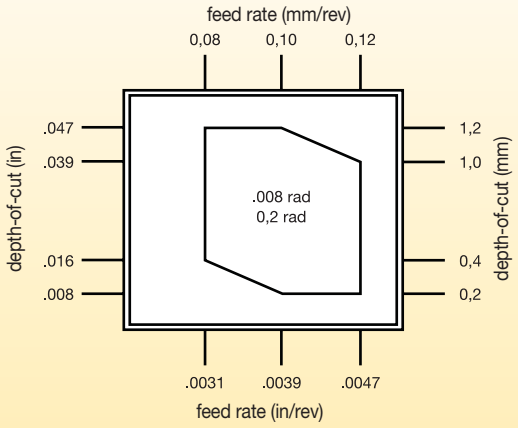


Turn and profile feed rates

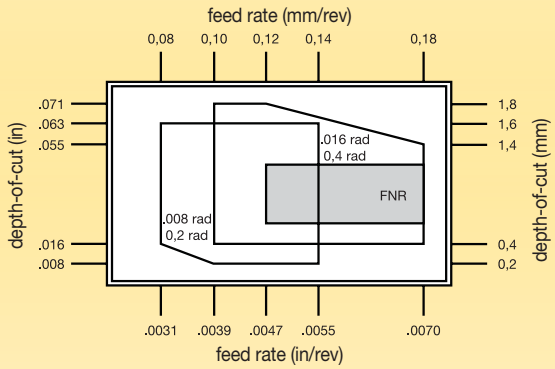
Seat Size 1F



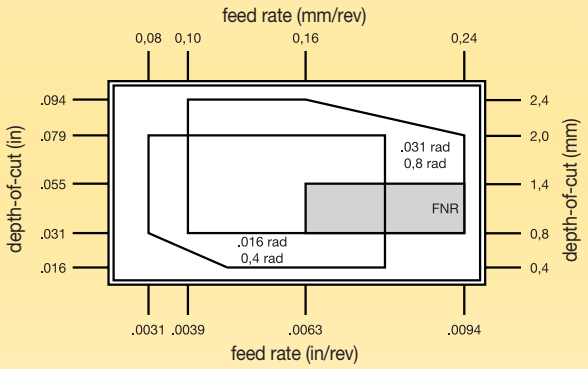
Seat Size 2



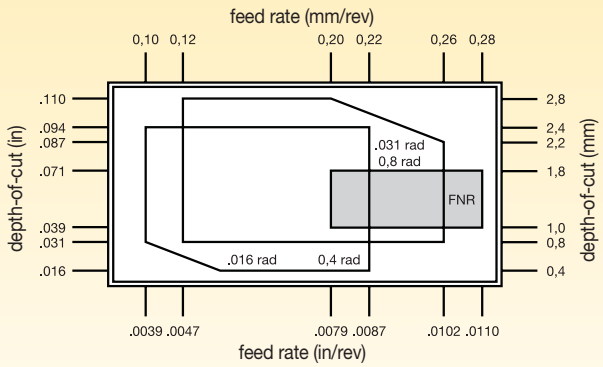
Seat Size 3



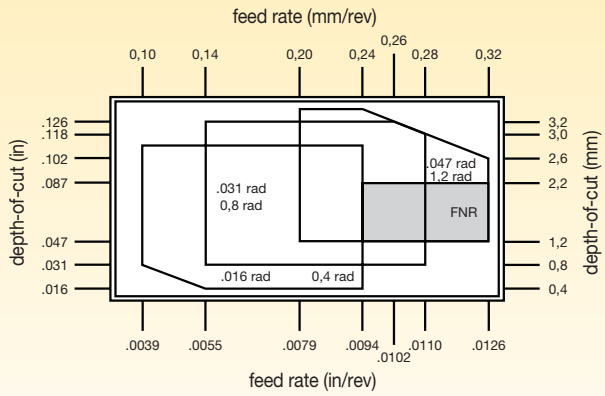
Seat Size 4



Seat Size 5



Seat Size 6

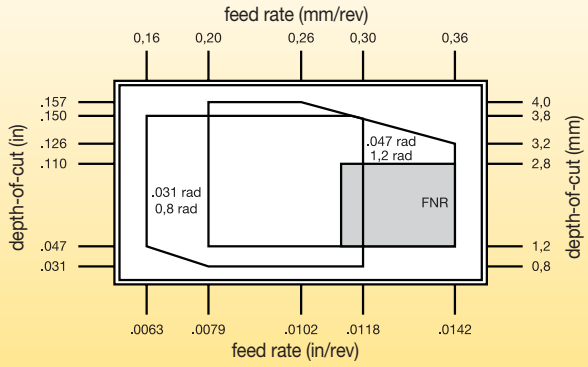


* **FNR** = Full Nose Radius

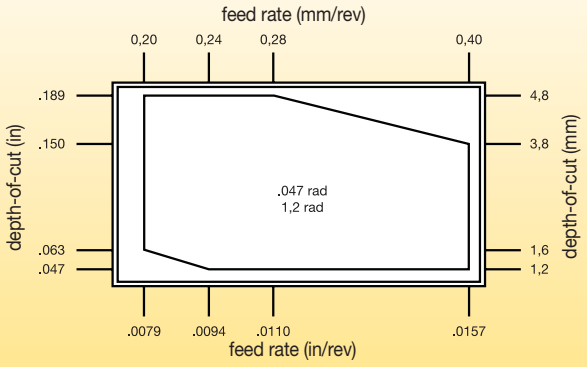
(continued)

(Turn and profile feed rates — continued)

Seat Size 8



Seat Size 10

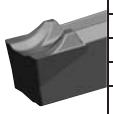
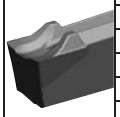
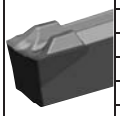
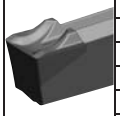


Cut-Off Feed Rates

Plunge feed rates

● first choice
○ alternate choice

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

Geometry	Description	Insert Geometry	Seat Size	Starting Conditions mm	Cut-Off Feed Rates mm/rev
-CL	Aggressive geometry for hard to break chips.		1B	0,06	
			2	0,07	
			3	0,08	
			4	0,09	
-CF	Positive geometry for reduced cutting forces.		1B	0,06	
			2	0,07	
			3	0,09	
			4	0,11	
			5	0,13	
-CM	Stable cutting edge for aggressive feed rates. Primarily in cast iron.		1B	0,06	
			2	0,07	
			3	0,09	
			4	0,11	
			5	0,14	
			6	0,16	
			8	0,14	
-CR	Most stable cutting edge for steel.		2	0,10	
			3	0,14	
			4	0,16	
			5	0,19	
			6	0,21	
			8	0,23	

NOTE: For cut-off inserts with a lead angle, maximum feed rate should be reduced by up to 40%.

Maximum Feed Rate Values

Data above is for P and K material groups. **Maximum** feed rates should be adjusted by multiplying max feed rate values by following factors for shown material groups.

Material Group	Feed Factor
M	.8
N	1.2
S	.8
H	.5

Recommended Starting Speeds [m/min]

Material Group		K313			KCU10			KCU25			KCM35B			KCP10B			KCP25B			KCK20B		
P	0–1	–	–	–	140	**280**	350	110	**225**	270	90	**180**	213	185	**400**	450	145	**290**	365	200	**440**	490
	2	–	–	–	140	**200**	300	110	**160**	260	90	**130**	155	185	**270**	350	145	**200**	305	200	**300**	380
	3	–	–	–	140	**155**	245	110	**125**	235	90	**100**	155	170	**190**	260	140	**155**	245	600	**200**	280
	4	–	–	–	75	**110**	170	60	**90**	160	50	**70**	110	90	**145**	200	75	**110**	180	100	**160**	220
	5	–	–	–	120	**200**	260	100	**160**	210	80	**130**	165	150	**220**	305	120	**200**	270	165	**240**	330
	6	–	–	–	110	**150**	230	85	**120**	185	70	**100**	145	120	**180**	275	110	**150**	230	130	**190**	300
M	1	60	**90**	120	140	**210**	280	90	**170**	245	75	**120**	135	–	–	–	–	–	–	–	–	–
	2	45	**75**	110	120	**200**	245	90	**150**	245	75	**110**	135	–	–	–	–	–	–	–	–	–
	3	35	**65**	100	120	**180**	245	90	**140**	210	75	**90**	135	–	–	–	–	–	–	–	–	–
K	1	30	**75**	120	120	**180**	245	100	**145**	225	–	–	–	170	**245**	440	140	**200**	360	210	**305**	550
	2	25	**70**	110	90	**150**	240	70	**120**	170	–	–	–	120	**195**	340	100	**160**	280	150	**245**	430
	3	20	**60**	90	60	**110**	150	50	**85**	120	–	–	–	120	**170**	270	100	**140**	220	150	**210**	335
N	1–2	150	**370**	610	150	**550**	975	120	**440**	780	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	120	**275**	430	120	**365**	700	100	**290**	490	–	–	–	–	–	–	–	–	–	–	–	–
	5	45	**90**	150	90	**170**	245	70	**135**	195	–	–	–	–	–	–	–	–	–	–	–	–
	6	40	**75**	150	120	**210**	305	100	**170**	245	–	–	–	–	–	–	–	–	–	–	–	–
S	1	8	**30**	75	15	**55**	135	8	**40**	60	8	**35**	60	–	–	–	–	–	–	–	–	–
	2	8	**35**	75	15	**60**	135	8	**30**	75	8	**30**	60	–	–	–	–	–	–	–	–	–
	3	8	**40**	75	15	**70**	150	15	**40**	75	15	**35**	60	–	–	–	–	–	–	–	–	–
	4	8	**45**	75	15	**70**	170	8	**50**	110	15	**45**	90	–	–	–	–	–	–	–	–	–
H	1	–	–	–	30	**45**	60	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	15	**30**	45	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Mobile Apps

The Kennametal mobile app provides easy access to product information and calculators on both iPhone® and Android™ devices. We've highlighted a few of the key features...

There's an app for that.

SPEEDS & FEEDS

View speeds and feeds information for metalworking products.

PRODUCT AVAILABILITY

Check global availability of products. View available quantities by providing your Konnect login credentials.

CALCULATORS

Utilise our machining calculators for milling and drilling applications.



By just scanning the bar code on the insert packet, you can find the most productive cutting conditions for tool life, process time, and chip control.

NOTE: The app is currently only available in the English-language version. We have plans to translate the app in different languages with future releases.

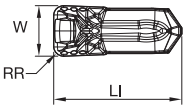
Google play | Available on the App Store

- Positive chipbreaker lowers cutting forces.
- Engineered geometry for chip control in side turning.
- High performance in all materials.

● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
P		●	●	●	●	○		
M		●	●				●	○
K		○	○	○	○	●		○
N		●	○					●
S		●	●					●
H		○						





GUP Precision Moulded • Metric

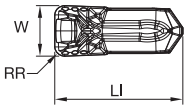
catalogue number	seat size	W	W tol ±	RR	LI	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
EG0212M02U02GUP	2	2,125	0,050	0,20	8,97	●	●	●	●	–	–	–
EG0251M02U02GUP	2	2,511	0,050	0,20	8,97	●	●	●	●	–	–	–
EG0312M03U02GUP	3	3,125	0,075	0,20	9,60	●	●	●	–	–	–	–
EG0312M03U04GUP	3	3,125	0,075	0,40	9,60	●	●	●	●	–	–	–
EG0412M04U04GUP	4	4,125	0,075	0,40	10,19	●	●	●	●	–	–	–
EG0412M04U08GUP	4	4,125	0,075	0,80	10,19	●	●	●	●	–	–	–
EG0512M05U04GUP	5	5,125	0,075	0,40	12,25	●	●	●	●	–	–	–
EG0512M05U08GUP	5	5,125	0,075	0,80	12,25	●	●	●	●	–	–	–
EG0612M06U04GUP	6	6,125	0,075	0,40	14,60	●	●	●	●	–	–	–
EG0612M06U08GUP	6	6,125	0,075	0,80	14,60	●	●	●	●	–	–	–
EG0712M06U08GUP	6	7,125	0,075	0,80	14,60	●	●	●	●	–	–	–
EG0812M08U08GUP	8	8,125	0,075	0,80	17,47	●	●	●	●	–	–	–
EG0812M08U12GUP	8	8,125	0,075	1,18	17,45	●	●	●	●	–	–	–
EG1012M10U12GUP	10	10,125	0,075	1,20	20,80	●	●	●	●	–	–	–

- Positive chipbreaker lowers cutting forces.
- Engineered geometry for chip control in side turning.
- High performance in all materials.
- More precise widths and better repeatability.

● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
P		●	●	●	●	○		
M		●	●				●	○
K		○	○	○	○	●		○
N		●	○					●
S		●	●					●
H		○						





GUP Precision Ground • Metric

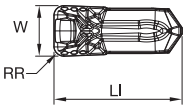
catalogue number	seat size	W	W tol ±	RR	LI	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
EG0200M02P02GUP	2	2,000	0,025	0,20	8,80	●	●	–	–	–	–	●
EG0300M03P02GUP	3	3,000	0,025	0,20	9,40	●	●	–	–	–	–	●
EG0300M03P04GUP	3	3,000	0,025	0,40	9,60	●	●	–	–	–	–	●
EG0400M04P04GUP	4	4,000	0,025	0,40	10,10	●	●	–	–	–	–	●
EG0400M04P08GUP	4	4,000	0,025	0,80	10,10	●	●	–	–	–	–	●
EG0500M05P04GUP	5	5,000	0,025	0,40	12,20	●	●	–	–	–	–	●
EG0500M05P08GUP	5	5,000	0,025	0,80	12,20	●	●	–	–	–	–	●
EG0600M06P04GUP	6	6,000	0,025	0,40	14,50	●	●	–	–	–	–	●
EG0600M06P08GUP	6	6,000	0,025	0,80	14,50	●	●	–	–	–	–	●
EG0700M06P08GUP	6	7,000	0,025	0,80	14,50	●	●	–	–	–	–	●
EG0800M08P08GUP	8	8,000	0,025	0,80	17,40	●	●	–	–	–	–	●
EG0800M08P12GUP	8	8,000	0,025	1,20	17,40	●	●	–	–	–	–	●
EG1000M10P12GUP	10	10,000	0,025	1,20	20,70	●	●	–	–	–	–	●

- Positive chipbreaker lowers cutting forces.
- Engineered geometry for chip control in side turning.
- High performance in all materials.

● first choice
○ alternate choice

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





GUP Precision Moulded • Inch

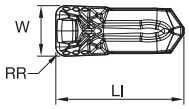
catalogue number	seat size	W	W tol ±	RR	LI	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
EG130I03U05GUP	3	3,301	0,075	0,20	9,60	●	●	●	●	–	–	–
EG130I03U1GUP	3	3,301	0,075	0,40	9,60	●	●	●	●	–	–	–
EG192I04U1GUP	4	4,877	0,075	0,40	10,19	●	●	●	●	–	–	–
EG192I04U2GUP	4	4,877	0,075	0,79	10,19	●	●	●	●	–	–	–
EG255I06U1GUP	6	6,478	0,075	0,40	14,58	●	●	●	●	–	–	–
EG255I06U2GUP	6	6,478	0,075	0,80	14,58	●	●	●	●	–	–	–
EG317I08U3GUP	8	8,051	0,075	1,19	17,46	●	●	●	●	–	–	–
EG380I10U3GUP	10	9,651	0,075	1,19	20,80	●	●	●	●	–	–	–

- Positive chipbreaker lowers cutting forces.
- Engineered geometry for chip control in side turning.
- High performance in all materials.
- More precise widths and better repeatability.

● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
P		●	●	●	●	○		
M		●	●				●	○
K		○	○	○	○	●		○
N		●	○					●
S		●	●					●
H		○						



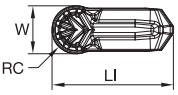


GUP Precision Ground • Inch

catalogue number	seat size	W	W tol ±	RR	LI	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
EG063I1FP05GUP	1F	1,600	0,025	0,20	9,00	●	●	–	–	–	–	●
EG094I02P05GUP	2	2,388	0,025	0,20	8,88	●	●	–	–	–	–	●
EG125I03P05GUP	3	3,175	0,025	0,20	9,40	●	●	–	–	–	–	●
EG125I03P1GUP	3	3,175	0,025	0,40	9,40	●	●	–	–	–	–	●
EG187I04P1GUP	4	4,760	0,025	0,40	10,10	●	●	–	–	–	–	●
EG187I04P2GUP	4	4,762	0,025	0,79	10,10	●	●	–	–	–	–	●
EG250I06P1GUP	6	6,350	0,025	0,40	14,50	●	●	–	–	–	–	●
EG250I06P2GUP	6	6,350	0,025	0,80	14,50	●	●	–	–	–	–	●
EG312I08P3GUP	8	7,920	0,025	1,20	17,40	●	●	–	–	–	–	●
EG375I10P3GUP	10	9,525	0,025	1,20	20,70	●	●	–	–	–	–	●

- First choice in profiling.
- >180° cutting edge.
- High performance in all materials.





GUP Full Radius Precision Moulded • Metric

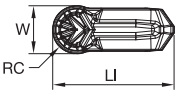
catalogue number	seat size	W	W tol ±	RC	LI	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
ER0312M03U00GUP	3	3,125	0,075	1,560	9,60	●	●	●	●	–	–	–
ER0412M04U00GUP	4	4,125	0,075	2,060	10,20	●	●	●	●	–	–	–
ER0512M05U00GUP	5	5,125	0,075	2,560	12,20	●	●	●	●	–	–	–
ER0612M06U00GUP	6	6,125	0,075	3,060	14,60	●	●	●	●	–	–	–
ER0812M08U00GUP	8	8,125	0,075	4,060	17,50	●	●	●	●	–	–	–

- First choice in profiling.
- >180° cutting edge.
- High performance in all materials.
- More precise widths and better repeatability.

● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
P		●	●	●	●	○		
M		●	●				●	○
K		○	○	○	○	●		○
N		●	○					●
S		●	●					●
H		○						



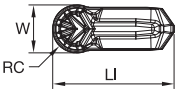


GUP Full Radius Precision Ground • Metric

catalogue number	seat size	W	W tol ±	RC	LI	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
ER0300M03P00GUP	3	3,000	0,025	1,500	9,50	●	●	–	–	–	–	●
ER0400M04P00GUP	4	4,000	0,025	2,000	10,10	●	●	–	–	–	–	●
ER0500M05P00GUP	5	5,000	0,025	2,500	12,20	●	●	–	–	–	–	●
ER0600M06P00GUP	6	6,000	0,025	3,000	14,50	●	●	–	–	–	–	●
ER0800M08P00GUP	8	8,000	0,025	4,000	17,40	●	●	–	–	–	–	●

- First choice in profiling.
- >180° cutting edge.
- High performance in all materials.





GUP Full Radius Precision Moulded • Inch

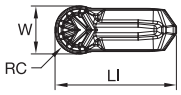
catalogue number	seat size	W	W tol ±	RC	LI	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
ER130I03U00GUP	3	3,302	0,075	1,650	9,60	●	●	●	●	–	–	–
ER192I04U00GUP	4	4,878	0,075	2,440	10,20	●	●	●	●	–	–	–
ER255I06U00GUP	6	6,478	0,075	3,240	14,60	●	●	●	●	–	–	–
ER317I08U00GUP	8	8,052	0,075	4,030	17,50	●	●	●	●	–	–	–

- First choice in profiling.
- >180° cutting edge.
- High performance in all materials.
- More precise widths and better repeatability.

● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
P		●	●	●	●	○		
M		●	●				●	○
K		○	○	○	○	●		○
N		●	○					●
S		●	●					●
H		○						



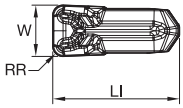


GUP Full Radius Precision Ground • Inch

catalogue number	seat size	W	W tol ±	RC	LI	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
ER125I03P00GUP	3	3,175	0,025	1,590	9,50	●	●	–	–	–	–	●
ER187I04P00GUP	4	4,762	0,025	2,380	10,10	●	●	–	–	–	–	●
ER250I06P00GUP	6	6,350	0,025	3,170	14,50	●	●	–	–	–	–	●
ER312I08P00GUP	8	7,920	0,025	3,960	17,40	●	●	–	–	–	–	●

- Negative rake face for strongest cutting edge.
- More aggressive applications.
- Advantages in low-feed and depth-of-cut applications.





GUN Precision Moulded • Metric

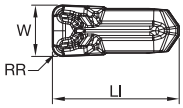
catalogue number	seat size	W	W tol ±	RR	LI	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
EG0212M02U02GUN	2	2,125	0,050	0,20	8,97	●	●	●	●	●	–	–
EG0251M02U02GUN	2	2,510	0,050	0,20	8,97	●	●	●	●	●	–	–
EG0312M03U02GUN	3	3,125	0,075	0,20	9,60	●	●	●	●	●	–	–
EG0312M03U04GUN	3	3,125	0,075	0,40	9,60	●	●	●	●	●	–	–
EG0412M04U04GUN	4	4,125	0,075	0,40	10,19	●	●	●	●	●	–	–
EG0412M04U08GUN	4	4,125	0,075	0,80	10,19	●	●	●	●	●	–	–
EG0512M05U04GUN	5	5,125	0,075	0,40	12,20	●	●	●	●	●	–	–
EG0512M05U08GUN	5	5,125	0,075	0,80	12,20	●	●	●	●	●	–	–
EG0612M06U04GUN	6	6,125	0,075	0,40	14,60	●	●	●	–	●	–	–
EG0612M06U08GUN	6	6,125	0,075	0,80	14,60	●	●	–	●	●	–	–
EG0812M08U08GUN	8	8,125	0,075	0,80	17,50	●	●	●	●	●	–	–
EG0812M08U12GUN	8	8,125	0,075	1,20	17,50	●	●	●	●	●	–	–
EG1012M10U12GUN	10	10,125	0,075	1,20	20,80	●	●	●	●	●	–	–

- Negative rake face for strongest cutting edge.
- More aggressive applications.
- Advantages in low-feed and depth-of-cut applications.

● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
P		●	●	●	●	○		
M		●	●				●	○
K		○	○	○	○	●		○
N		●	○					●
S		●	●					●
H		○						



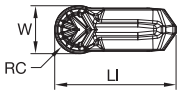


GUN Precision Moulded • Inch

catalogue number	seat size	W	W tol ±	RR	LI	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
EG063I1FU05GUN	1F	1,600	0,050	0,20	9,00	●	●	●	●	●	–	–
EG130I03U05GUN	3	3,302	0,075	0,20	9,60	●	●	●	●	●	–	–
EG130I03U1GUN	3	3,302	0,075	0,40	9,60	●	●	●	●	●	–	–
EG192I04U1GUN	4	4,877	0,075	0,40	10,19	●	●	●	●	●	–	–
EG192I04U2GUN	4	4,878	0,075	0,79	10,19	●	●	●	●	●	–	–
EG255I06U1GUN	6	6,477	0,075	0,40	14,58	●	●	●	●	●	–	–
EG255I06U2GUN	6	6,477	0,075	0,80	14,58	●	●	●	●	●	–	–
EG317I08U3GUN	8	8,052	0,075	1,19	17,46	●	●	●	●	●	–	–
EG380I10U3GUN	10	9,651	0,075	1,20	20,80	●	●	●	●	●	–	–

- Negative rake face for strongest cutting edge.
- First choice in profiling.
- >180° cutting edge.
- High performance in all materials.





GUN Full Radius Precision Moulded • Metric

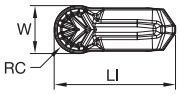
catalogue number	seat size	W	W tol ±	RC	LI	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
ER0312M03U00GUN	3	3,125	0,075	1,560	9,60	●	●	●	●	●	–	–
ER0412M04U00GUN	4	4,125	0,075	2,060	10,20	●	●	●	●	●	–	–
ER0512M05U00GUN	5	5,125	0,075	2,560	12,20	●	●	●	●	●	–	–
ER0612M06U00GUN	6	6,125	0,075	3,060	14,60	●	●	●	●	●	–	–
ER0812M08U00GUN	8	8,125	0,075	4,060	17,47	●	●	●	●	●	–	–

- Negative rake face for strongest cutting edge.
- First choice in profiling.
- >180° cutting edge.
- High performance in all materials.

● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
P		●	●	●	●	○		
M		●	●				●	○
K		○	○	○	○	●		○
N		●	○					●
S		●	●					●
H		○						





GUN Full Radius Precision Moulded • Inch

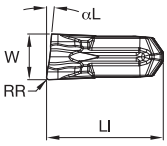
catalogue number	seat size	W	W tol ±	RC	LI	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
ER094I02U00GUN	2	2,387	0,050	1,190	8,97	●	●	●	●	●	–	–
ER125I03U00GUN	3	3,177	0,075	1,590	9,60	●	●	●	●	●	–	–
ER130I03U00GUN	3	3,300	0,075	1,650	9,60	●	●	●	●	●	–	–
ER187I04U00GUN	4	4,750	0,075	2,370	10,20	●	●	●	●	●	–	–
ER192I04U00GUN	4	4,873	0,075	2,440	10,20	●	●	●	●	●	–	–
ER250I06U00GUN	6	6,346	0,075	3,170	14,60	●	●	●	●	●	–	–
ER255I06U00GUN	6	6,473	0,075	3,240	14,60	●	●	●	●	●	–	–
ER312I08U00GUN	8	7,925	0,075	3,960	17,50	●	●	●	●	●	–	–
ER317I08U00GUN	8	8,052	0,075	4,030	17,50	●	●	●	●	●	–	–

- Positive chipbreaker lowers cutting forces.
- First choice for steel and stainless steel.
- Excellent surface finish.

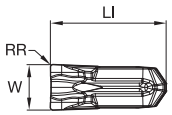

Left Hand


Neutral

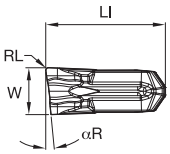

Right Hand



Left Hand



Neutral



Right Hand

CF Precision Moulded • Metric

catalogue number	seat size	W	W tol ±	LI	αR	αL	RR	RL	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
EC014M1BL06CF01	1B	1,404	0,050	9,00	–	6	0,15	–	–	●	–	–	–	●	–
EC014M1BN00CF01	1B	1,400	0,050	9,00	–	–	0,15	0,15	–	●	–	–	–	●	–
EC014M1BR06CF01	1B	1,404	0,050	9,00	6	–	–	0,15	–	●	–	–	–	●	–
EC020M02L06CF02	2	2,000	0,050	8,97	–	6	0,20	–	–	●	–	–	–	●	–
EC020M02N00CF02	2	2,000	0,050	8,97	–	–	0,20	0,20	–	●	–	–	–	●	–
EC020M02R06CF02	2	2,000	0,050	8,97	6	–	–	0,20	–	●	–	–	–	●	–
EC030M03L06CF02	3	3,000	0,075	9,60	–	6	0,20	–	–	●	–	–	–	●	–
EC030M03N00CF02	3	3,000	0,075	9,60	–	–	0,20	0,20	–	●	–	–	–	●	–
EC030M03R06CF02	3	3,000	0,075	9,60	6	–	–	0,20	–	●	–	–	–	●	–
EC040M04L06CF02	4	4,000	0,075	10,19	–	6	0,20	–	–	●	–	–	–	●	–
EC040M04N00CF02	4	4,000	0,075	10,19	–	–	0,20	0,20	–	●	–	–	–	●	–
EC040M04R06CF02	4	4,000	0,075	10,19	6	–	–	0,20	–	●	–	–	–	●	–
EC050M05N00CF03	5	5,000	0,075	12,20	–	–	0,30	0,30	–	●	–	–	–	●	–

- Most aggressive chipbreaker.
- For use in long chipping materials.
- Problem solver.

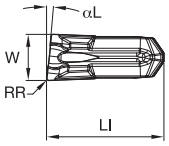
● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
P		●	●	●	●	○		
M		●	●				●	○
K		○	○	○	○	●		○
N		●	○					●
S		●	●					●
H		○						

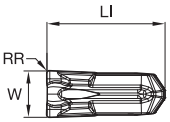

Left Hand


Neutral

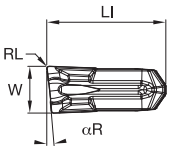

Right Hand



Left Hand



Neutral



Right Hand

CL Precision Moulded • Metric

catalogue number	seat size	W	W tol ±	LI	αR	αL	RR	RL	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
EC014M1BL06CL01	1B	1,400	0,050	9,00	–	6	0,15	–	–	●	–	–	–	●	–
EC014M1BN00CL01	1B	1,400	0,050	9,00	–	–	0,15	0,15	–	●	–	–	–	●	–
EC014M1BR06CL01	1B	1,400	0,050	9,00	6	–	–	0,15	–	●	–	–	–	●	–
EC020M02L06CL02	2	2,000	0,050	8,96	–	6	0,20	–	–	●	–	–	–	●	–
EC020M02N00CL02	2	2,000	0,050	8,97	–	–	0,20	0,20	–	●	–	–	–	●	–
EC020M02R06CL02	2	2,000	0,050	8,96	6	–	–	0,20	–	●	–	–	–	●	–
EC030M03L06CL02	3	3,000	0,075	9,59	–	6	0,20	–	–	●	–	–	–	●	–
EC030M03N00CL02	3	3,000	0,075	9,60	–	–	0,20	0,20	–	●	–	–	–	●	–
EC030M03R06CL02	3	3,000	0,075	9,59	6	–	–	0,20	–	●	–	–	–	●	–
EC040M04L06CL02	4	4,000	0,075	10,19	–	6	0,20	–	–	●	–	–	–	–	–
EC040M04N00CL02	4	4,000	0,075	10,20	–	–	0,20	0,20	–	●	–	–	–	●	–
EC040M04R06CL02	4	4,000	0,075	10,19	6	–	–	0,20	–	●	–	–	–	–	–

- Ultimate solution in edge stability.
- Leverage for interrupted cuts or hardened skin.
- First choice for cast iron.

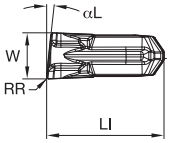
● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
P		●	●	●	●	○		
M		●	●				●	○
K		○	○	○	○	●		○
N		●	○					●
S		●	●					●
H		○						

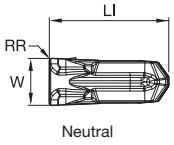

Left Hand


Neutral

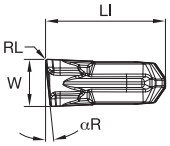

Right Hand



Left Hand



Neutral



Right Hand

CM Precision Moulded • Metric

catalogue number	seat size	W	W tol ±	LI	αR	αL	RR	RL	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
EC014M1BL06CM01	1B	1,400	0,050	9,00	–	6	0,20	–	–	●	–	–	–	–	–
EC014M1BN00CM01	1B	1,400	0,050	9,00	–	–	0,15	0,15	–	●	–	–	–	–	–
EC014M1BR06CM01	1B	1,400	0,050	9,00	6	–	–	0,20	–	●	–	–	–	–	–
EC020M02L06CM02	2	2,000	0,050	9,00	–	6	0,20	–	–	●	–	–	–	–	–
EC020M02N00CM02	2	2,000	0,050	8,98	–	–	0,20	0,20	–	●	–	–	–	–	–
EC020M02R06CM02	2	2,000	0,050	9,00	6	–	–	0,20	–	●	–	–	–	–	–
EC030M03L06CM02	3	3,000	0,075	9,60	–	6	0,20	–	–	●	–	–	–	–	–
EC030M03N00CM02	3	3,000	0,075	9,60	–	–	0,20	0,20	–	●	–	–	–	–	–
EC030M03R06CM02	3	3,000	0,075	9,60	6	–	–	0,20	–	●	–	–	–	–	–
EC040M04L06CM02	4	4,000	0,075	10,20	–	6	0,20	–	–	●	–	–	–	–	–
EC040M04N00CM02	4	4,000	0,075	10,20	–	–	0,20	0,20	–	●	–	–	–	–	–
EC040M04R06CM02	4	4,000	0,075	10,20	6	–	–	0,20	–	●	–	–	–	–	–
EC050M05N00CM03	5	5,000	0,075	12,20	–	–	0,30	0,30	–	●	–	–	–	–	–
EC060M06N00CM03	6	6,000	0,075	14,59	–	–	0,30	0,30	–	●	–	–	–	–	–
EC070M06N00CM04	6	7,000	0,075	14,60	–	–	0,40	0,40	–	●	–	–	–	–	–
EC080M08N00CM04	8	8,000	0,075	17,50	–	–	0,40	0,40	–	●	–	–	–	–	–

- Strong chip control due to concave edge.
- First choice in steel when additional stability is required.
- Can apply most aggressive speed rates.

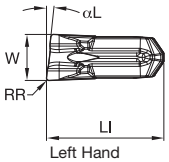
● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
P		●	●	●	●	○		
M		●	●				●	○
K		○	○	○	○	●		○
N		●	○					●
S		●	●					●
H		○						

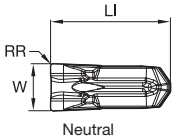

Left Hand


Neutral

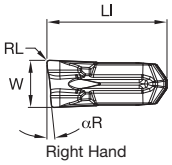

Right Hand



Left Hand



Neutral



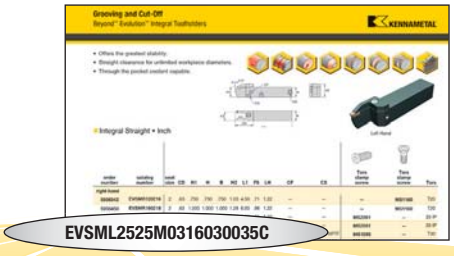
Right Hand

CR Precision Moulded • Metric

catalogue number	seat size	W	W tol ±	LI	αR	αL	RR	RL	KCU10	KCU25	KCP10B	KCP25B	KCK20B	KCM35B	K313
EC020M02L06CR02	2	2,000	0,050	9,00	–	6	0,20	–	–	●	–	–	–	–	–
EC020M02N00CR02	2	2,000	0,050	8,98	–	–	0,20	0,20	–	●	–	–	–	–	–
EC020M02R06CR02	2	2,000	0,050	9,00	6	–	–	0,20	–	●	–	–	–	–	–
EC030M03L06CR02	3	3,000	0,075	9,60	–	6	0,20	–	–	●	–	–	–	–	–
EC030M03N00CR02	3	3,000	0,075	9,60	–	–	0,20	0,20	–	●	–	–	–	–	–
EC030M03R06CR02	3	3,000	0,075	9,60	6	–	–	0,20	–	●	–	–	–	–	–
EC040M04L06CR02	4	4,000	0,075	10,20	–	6	0,20	–	–	●	–	–	–	–	–
EC040M04N00CR02	4	4,000	0,075	10,20	–	–	0,20	0,20	–	●	–	–	–	–	–
EC040M04R06CR02	4	4,000	0,075	10,20	6	–	–	0,20	–	●	–	–	–	–	–
EC050M05N00CR03	5	5,000	0,075	12,25	–	–	0,30	0,30	–	●	–	–	–	–	–
EC060M06L06CR04	6	6,000	0,075	14,59	–	6	0,40	–	–	●	–	–	–	–	–
EC060M06N00CR03	6	6,000	0,075	14,59	–	–	0,30	0,30	–	●	–	–	–	–	–
EC060M06R06CR04	6	6,000	0,075	14,59	6	–	–	0,40	–	●	–	–	–	–	–
EC070M06N00CR04	6	7,000	0,075	14,60	–	–	0,40	0,40	–	●	–	–	–	–	–
EC080M08L06CR04	8	8,000	0,075	17,50	–	6	0,40	–	–	●	–	–	–	–	–
EC080M08N00CR04	8	8,000	0,075	17,50	–	–	0,40	0,40	–	●	–	–	–	–	–
EC080M08R06CR04	8	8,000	0,075	17,50	6	–	–	0,40	–	●	–	–	–	–	–

How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



EV	S	M	L	2525M	03	16	030035	C
Family Name	Tool Style	Support Type	Hand	Shank Size	Seat Size	Max Groove Depth	Face Grooving Diameters	Coolant
Beyond™ Evolution™	**S** = Straight mount		**L** = Left hand **R** = Right hand		**1B** **1F** **02** **03** **04** **05** **06** **08** **10**	in millimetres	**030** = Minimum diameter in mm **035** = Maximum diameter in mm	**C** = Through the pocket coolant capable

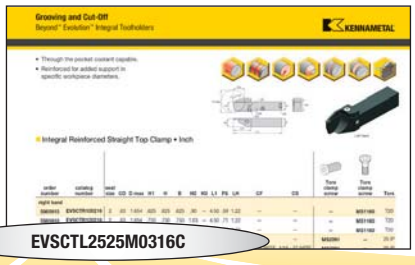
M = Maximum support for specific groove width and straight clearance for unlimited workpiece diameter

A = Face grooving — inboard sweep

B = Face grooving — outboard sweep

Metric = Height x Width in mm letter indicates tool length according to ISO

By referencing this easy-to-use guide, you can identify the correct product to meet your needs.



EVSCTL2525M0316C

EV	S	C	T	L	2525M	03	16	C
Family Name	Tool Style	Support Type	Clamping Screw Position	Hand	Shank Size	Seat Size	Max Groove Depth	Coolant
Beyond™ Evolution™	**S** = Straight mount	**C** = Reinforced support	**T** = Top **F** = Front	**L** = Left hand **R** = Right hand	**Metric** = Height x Width in mm letter indicates tool length according to ISO	**1B** **1F** **02** **03** **04** **05** **06** **08** **10**	in millimetres	**C** = Through the pocket coolant capable

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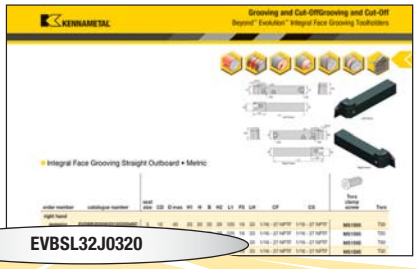
A16REVEMR0310M030035

A	16	R	EV	E	M	R	03	10	M	030035
Steel Bar with Coolant	Bar Diameter	Bar Length	Platform	Tool Type	Support Type	Hand of Tool	Insert Seat Size	Max Cutting Depth	Tool Units	Face Grooving Diameters
Steel boring bar with through coolant capability.	**Metric** = Diameter in mm **Inch** = Diameter in 1/16" increments		Beyond™ Evolution™	**E** = End mount (90°) **S** = Straight Mount	**M** = Maximum support **A** = Face Grooving-inboard sweep	**R** = Right hand **L** = Left hand	**1F** **02** **03** **04** **05** **06** **08** **10**	in millimetres	**M** = Metric **I** = Inch	**030** = Minimum diameter in mm **035** = Maximum diameter in mm

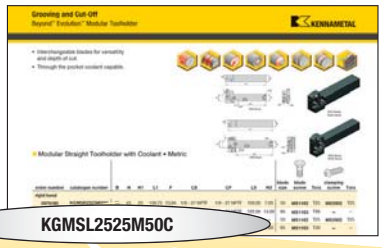
symbol	mm	inch
K	125	5
M	150	6
Q	180	7
R	200	8
S	250	10
T	300	12



EVBSL32J0320

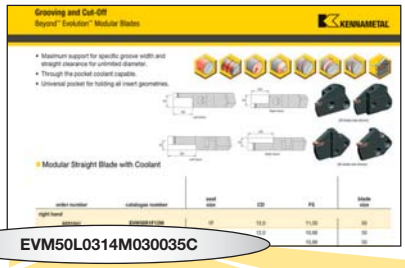
EV	B	S	L	32	J	03	20
Family Name	Tool Style	Support Type	Hand	Blade Height	Overall Length	Seat Size	Max Cutting Depth
Beyond™ Evolution™	**B** = 2 pocket blade	**S** = Standard **C** = Reinforced	**N** = Neutral **L** = Left hand **R** = Right hand	in millimetres	According to ISO **G** = 90mm **J** = 110mm **M** = 150mm **X** = Special	**1B** **1F** **02** **03** **04** **05** **06** **08** **10**	in millimetres

By referencing this easy-to-use guide, you can identify the correct product to meet your needs



KGMSL2525M50C

KGM	S	L	2525M	50	C
Family Name	Tool Style	Hand	Shank Size	Blade Size	Coolant
Grooving Modular System	**S** = Straight mount **E** = End mount (90°)	**L** = Left hand **R** = Right hand	**Metric** = Height x Width in mm letter indicates tool length according to ISO	**50** **65**	**C** = Through coolant capable



EVM50L0314M030035C

EVM	50	L	03	14	M	030035	C
Family Name	Blade Size	Hand	Seat Size	Max Groove Depth	Support Type	Face Grooving Diameters	Coolant
Beyond™ Evolution™ Modular Blade	**50** **65**	**L** = Left hand **R** = Right hand	**1B** **1F** **02** **03** **04** **05** **06** **08** **10**	in millimetres	**M** = Maximum support for specific groove width and straight clearance for unlimited diameter **A** = Face grooving-inboard sweep **B** = Face grooving-outboard sweep	**030** = Minimum diameter in mm **035** = Maximum diameter in mm	**C** = Through the pocket coolant capable

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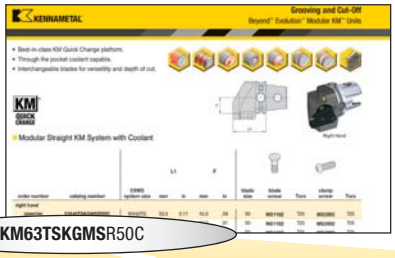
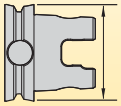
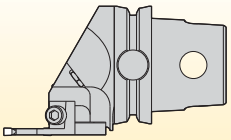
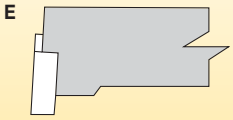


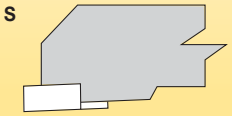
KM63TSKGMSR50C

KM	63	TS	KGM	S
KM™ Quick-Change	System Size	Feature	Insert Holding Method	Insert Location
KM **KM4X™** **PSC**	40 = 40mm 50 = 50mm 63 = 63mm 80 = 80mm 100 = 100mm	**TS** **XMZ**	**KGM** **Modular Grooving**	**E** = End mount **S** = Side mount









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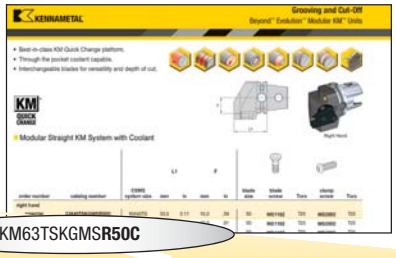
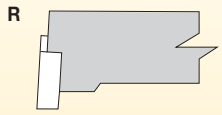
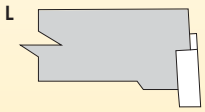


KM63TSKGMS**R50C**

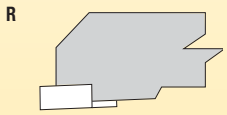
R	50	C	
Hand of Tool	Blade Size	Coolant	Special Features
R = Right hand **L** = Left hand	**50** **60**	**C** = Through the pocket coolant capable	**Y** = Mazak® INTEGREX®

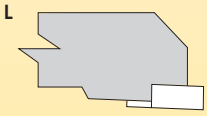
End Mount





Side Mount





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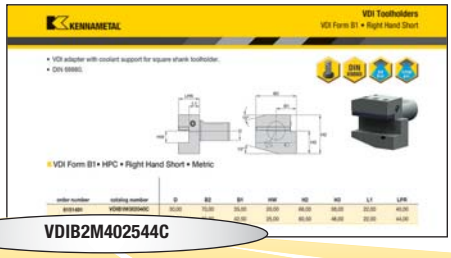


VDIB2M402544C

VDI	B2	M	40	25	44	C
Connection	Style	Metric	VDI Shank Diameter	Toolholder Shank Size	Projection Length	Internal Coolant

NOVO KNOWS SEARCH

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

ADVISE

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

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

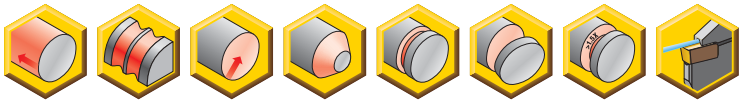
SELECT

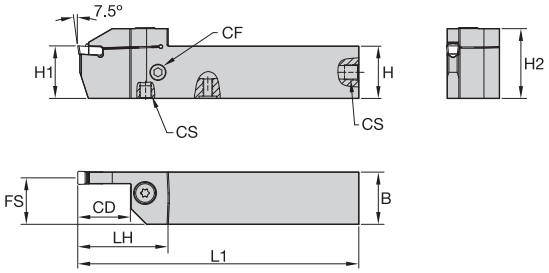
A method of selecting cutting tools from a tree structure via a hierarchy or parametric search:

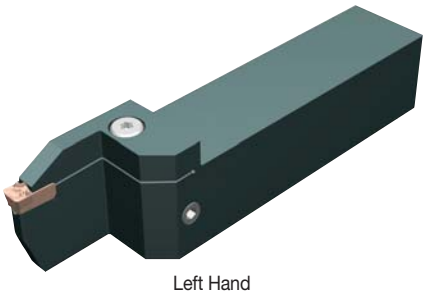
- If you know which product you are looking for, a quick search can be performed by just the catalogue number or product description.
- Smart filters significantly reduce the amount of potential tooling solutions.
- After the tool is selected, NOVO also provides cutting and adaptive item options that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

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

- Offers the greatest stability.
- Straight clearance for unlimited workpiece diameters.
- Through the pocket coolant capable.

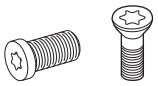






Left Hand

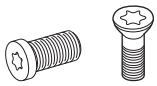
Integral Straight • Metric



order number	catalogue number	seat size	CD	H1	H	B	H2	L1	FS	LH	CF	CS	Torx clamp screw	Torx clamp screw	Torx
right hand															
5953960	**EVSMR2020K0216**	2	16	20	20	20	27	125	19	31	–	–	**–**	**MS1160**	T20
5953958	**EVSMR2525M0216**	2	16	25	25	25	32	150	24	31	–	–	**–**	**MS1160**	T20
6401854	**EVSMR2020K0216C**	2	16	20	20	20	28	125	19	35	M8X1	M8X1	**MS2091**	**–**	25 IP
6401855	**EVSMR2525M0216C**	2	16	25	25	25	33	150	24	35	G1/8 - 28	G1/8 - 28	**MS2091**	**–**	25 IP
5953959	**EVSMR2020K0222**	2	22	20	20	20	29	125	19	38	–	–	**MS2091**	**–**	25 IP
6401857	**EVSMR2020K0222C**	2	22	20	20	20	29	125	19	41	M8X1	M8X1	**MS2091**	**–**	25 IP
5953957	**EVSMR2525M0226**	2	26	25	25	25	34	150	24	42	–	–	**MS2091**	**–**	25 IP
6401856	**EVSMR2525M0226C**	2	26	25	25	25	34	150	24	45	G1/8 - 28	G1/8 - 28	**MS2091**	**–**	25 IP
5939452	**EVSMR2020K0316C**	3	16	20	20	20	29	125	19	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	**–**	T30
5939448	**EVSMR2525M0316C**	3	16	25	25	25	34	150	24	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1595**	**–**	T30
5939451	**EVSMR2020K0322C**	3	22	20	20	20	29	125	19	43	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	**–**	T30
5939447	**EVSMR2525M0326C**	3	26	25	25	25	34	150	24	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1595**	**–**	T30
5939450	**EVSMR2020K0416C**	4	16	20	20	20	29	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	**–**	T30
5939446	**EVSMR2525M0416C**	4	16	25	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1595**	**–**	T30
5939449	**EVSMR2020K0422C**	4	22	20	20	20	29	125	18	43	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	**–**	T30
5939445	**EVSMR2525M0426C**	4	26	25	25	25	34	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1595**	**–**	T30
5939444	**EVSMR3232P0426C**	4	26	32	32	32	42	170	30	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	**–**	T30
5939443	**EVSMR3232P0432C**	4	32	32	32	32	42	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	**–**	T30
5954258	**EVSMR2020K0516C**	5	16	20	20	20	29	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	**–**	T30
5954254	**EVSMR2525M0516C**	5	16	25	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	**–**	T30
5954257	**EVSMR2020K0522C**	5	22	20	20	20	29	125	18	43	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	**–**	T30
5954253	**EVSMR2525M0526C**	5	26	25	25	25	34	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	**–**	T30
5954249	**EVSMR3232P0526C**	5	26	32	32	32	42	170	30	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	**–**	T30

(continued)

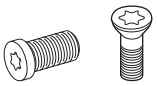
(Integral Straight • Metric — continued)



order number	catalogue number	seat size	CD	H1	H	B	H2	L1	FS	LH	CF	CS	Torx clamp screw	Torx clamp screw	Torx
5954248	EVSMR3232P0532C	5	32	32	32	32	42	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5954256	EVSMR2020K0616C	6	16	20	20	20	29	125	20	37	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5954252	EVSMR2525M0616C	6	16	25	25	25	34	150	25	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5954255	EVSMR2020K0622C	6	22	20	20	20	29	125	20	43	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5954251	EVSMR2525M0626C	6	26	25	25	25	34	150	25	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5954247	EVSMR3232P0626C	6	26	32	32	32	42	170	32	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5954246	EVSMR3232P0632C	6	32	32	32	32	43	170	29	55	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954242	EVSMR4040R0640C	6	40	40	40	40	51	200	37	63	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954250	EVSMR2525M0826C	8	26	25	25	25	35	150	21	49	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954245	EVSMR3232P0826C	8	26	32	32	32	43	170	28	49	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954244	EVSMR3232P0832C	8	32	32	32	32	43	170	28	55	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954241	EVSMR4040R0840C	8	40	40	40	40	51	200	36	63	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954243	EVSMR3232P1032C	10	32	32	32	32	43	170	28	55	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954240	EVSMR4040R1040C	10	40	40	40	40	51	200	36	63	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
left hand															
5953956	EVSML2020K0216	2	16	20	20	20	27	125	19	31	–	–	–	MS1160	T20
5953954	EVSML2525M0216	2	16	25	25	25	32	150	24	31	–	–	–	MS1160	T20
6401881	EVSML2525M0216C	2	16	25	25	25	33	150	24	35	G1/8 - 28	G1/8 - 28	MS2091	–	25 IP
5953955	EVSML2020K0222	2	22	20	20	20	29	125	19	38	–	–	MS2091	–	25 IP
5953953	EVSML2525M0226	2	26	25	25	25	34	150	24	42	–	–	MS2091	–	25 IP
5939442	EVSML2020K0316C	3	16	20	20	20	29	125	19	37	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5939438	EVSML2525M0316C	3	16	25	25	25	34	150	24	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1595	–	T30
5939441	EVSML2020K0322C	3	22	20	20	20	29	125	19	43	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5939437	EVSML2525M0326C	3	26	25	25	25	34	150	24	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1595	–	T30
5939440	EVSML2020K0416C	4	16	20	20	20	29	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5939436	EVSML2525M0416C	4	16	25	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1595	–	T30
5939439	EVSML2020K0422C	4	22	20	20	20	29	125	18	43	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5939435	EVSML2525M0426C	4	26	25	25	25	34	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1595	–	T30
5939433	EVSML3232P0426C	4	26	32	32	32	42	170	30	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5939432	EVSML3232P0432C	4	32	32	32	32	42	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5954239	EVSML2020K0516C	5	16	20	20	20	29	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5954235	EVSML2525M0516C	5	16	25	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5954238	EVSML2020K0522C	5	22	20	20	20	29	125	18	43	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5954234	EVSML2525M0526C	5	26	25	25	25	34	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5954220	EVSML3232P0526C	5	26	32	32	32	42	170	30	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5954219	EVSML3232P0532C	5	32	32	32	32	42	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5954237	EVSML2020K0616C	6	16	20	20	20	29	125	17	37	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5954233	EVSML2525M0616C	6	16	25	25	25	34	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5954236	EVSML2020K0622C	6	22	20	20	20	29	125	17	43	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5954232	EVSML2525M0626C	6	26	25	25	25	34	150	22	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30

(continued)

(Integral Straight • Metric — continued)

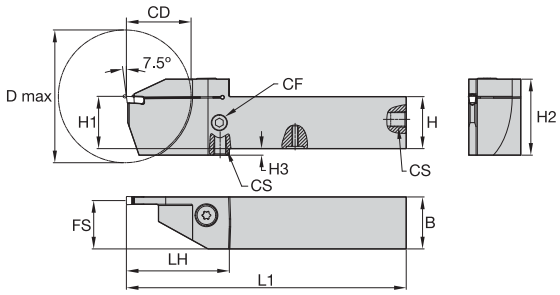


order number	catalogue number	seat size	CD	H1	H	B	H2	L1	FS	LH	CF	CS	Torx clamp screw	Torx clamp screw	Torx
5954218	EVSML3232P0626C	6	26	32	32	32	42	170	29	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5954217	EVSML3232P0632C	6	32	32	32	32	43	170	29	55	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954213	EVSML4040R0640C	6	40	40	40	40	51	200	37	63	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954231	EVSML2525M0826C	8	26	25	25	25	35	150	21	49	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954216	EVSML3232P0826C	8	26	32	32	32	43	170	28	49	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954215	EVSML3232P0832C	8	32	32	32	32	43	170	28	55	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954212	EVSML4040R0840C	8	40	40	40	40	51	200	36	63	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954214	EVSML3232P1032C	10	32	32	32	32	43	170	28	55	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45
5954211	EVSML4040R1040C	10	40	40	40	40	51	200	36	63	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45

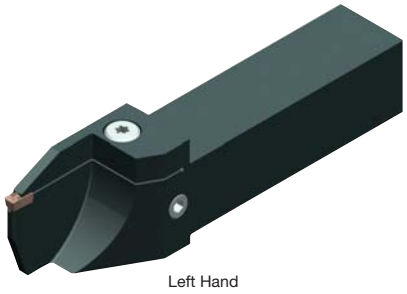
screw	screw	torque				wrench	wrench
catalogue number	order number	Nm	in. lbs.	thread	socket	catalogue number	order number
MS1160	1099645	7	62	M5	T20	KT20	1022703
MS1162	1127019	9	80	M6	T25	KT25	1022725
MS1163	1124104	18	159	M8	T30	KT30L	1099676
MS1273	1020977	4	35.4	M4	T15	KT15	1022701
MS1490	2263299	17	151	M8	T45	KT45	1018227
MS1595	1094300	12	106	M6	T30	KT30	1099676
MS1970	1106668	12	106	M6	T30	KT30	1099676
MS2002	1621087	9	80	M6	T25	KT25	1022725
MS2091	1931147	9	80	M5	25IP	K25IP	2050113

- Through the pocket coolant capable.
- Reinforced for added support in specific workpiece diameters.



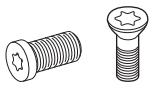


CD = Maximum cut-off depth for solid bars.
D max = Maximum bar diameter for deep grooving or cut-off of tubes.



Left Hand

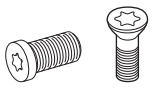
Integral Straight Top Clamp • Metric



order number	catalogue number	seat size	CD	D max	H1	H	B	H2	H3	L1	FS	LH	CF	CS	Torx clamp screw	Torx clamp screw	Torx
right hand																	
6179757	EVSCTR1212K1B16	1B	16	42	12	12	12	23	4	125	11	31	–	–	–	MS1160	T20
6179758	EVSCTR1212K1F16	1F	16	42	12	12	12	23	4	125	11	31	–	–	–	MS1160	T20
6179759	EVSCTR1212K0216	2	16	42	12	12	12	23	4	125	11	31	–	–	–	MS1160	T20
5980139	EVSCTR1616K0216	2	16	42	16	16	16	23	–	125	15	31	–	–	–	MS1160	T20
5980762	EVSCTR2020K0216	2	16	42	20	20	20	27	–	125	19	31	–	–	–	MS1160	T20
5980767	EVSCTR2525M0216	2	16	42	25	25	25	32	–	150	24	31	–	–	–	MS1160	T20
5980768	EVSCTR2525M0226	2	26	62	25	25	25	34	–	150	24	42	–	–	MS2091	–	25 IP
6179755	EVSCTR1212K0316C	3	16	52	12	12	12	23	4	125	11	34	M8X1.25	M8X1.25	MS1944	–	T25
5980140	EVSCTR1616K0316C	3	16	52	16	16	16	24	–	125	15	36	1/16 - 27 NPTF	1/16 - 27 NPTF	MS2091	–	25 IP
5980763	EVSCTR2020K0316C	3	16	52	20	20	20	29	–	125	19	37	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5980138	EVSCTR2525M0316C	3	16	62	25	25	25	34	–	150	24	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1595	–	T30
5980764	EVSCTR2020K0326C	3	26	62	20	20	20	33	4	125	19	47	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5980769	EVSCTR2525M0326C	3	26	62	25	25	25	34	–	150	24	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1595	–	T30
5980761	EVSCTR1616K0416C	4	16	52	16	16	16	24	–	125	14	36	1/16 - 27 NPTF	1/16 - 27 NPTF	MS2091	–	25 IP
5980765	EVSCTR2020K0416C	4	16	52	20	20	20	29	–	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5980766	EVSCTR2020K0426C	4	26	62	20	20	20	33	–	125	18	47	1/16 - 27 NPTF	1/16 - 27 NPTF	MS1595	–	T30
5980770	EVSCTR2525M0426C	4	26	62	25	25	25	34	–	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1595	–	T30
5980771	EVSCTR2525M0432C	4	32	64	25	25	25	38	4	150	23	53	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1595	–	T30
5980774	EVSCTR3232P0432C	4	32	64	32	32	32	42	–	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5980772	EVSCTR2525M0526C	5	26	62	25	25	25	34	–	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5980773	EVSCTR2525M0532C	5	32	64	25	25	25	39	4	150	23	53	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	–	T30
5980775	EVSCTR3232P0540C	5	40	82	32	32	32	47	4	170	30	63	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	–	T45

(*continued*)

(Integral Straight Top Clamp • Metric — continued)

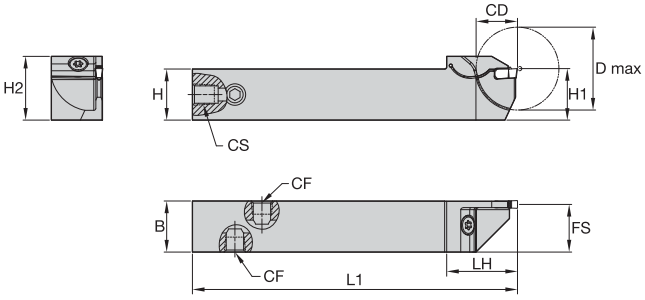


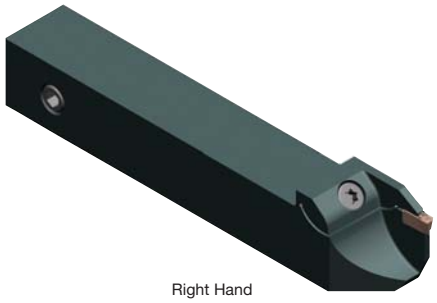
order number	catalogue number	seat size	CD	D max	H1	H	B	H2	H3	L1	FS	LH	CF	CS	Torx clamp screw	Torx clamp screw	Torx
left hand																	
6179760	**EVSCTL1212K1B16**	1B	16	42	12	12	12	23	4	125	11	31	—	—	—	**MS1160**	T20
6179761	**EVSCTL1212K1F16**	1F	16	42	12	12	12	23	4	125	11	31	—	—	—	**MS1160**	T20
6179762	**EVSCTL1212K0216**	2	16	42	12	12	12	23	4	125	11	31	—	—	—	**MS1160**	T20
5980777	**EVSCTL1616K0216**	2	16	42	16	16	16	23	—	125	15	31	—	—	—	**MS1160**	T20
5980780	**EVSCTL2020K0216**	2	16	42	20	20	20	27	—	125	19	31	—	—	—	**MS1160**	T20
5980805	**EVSCTL2525M0216**	2	16	42	25	25	25	32	—	150	24	31	—	—	—	**MS1160**	T20
5980806	**EVSCTL2525M0226**	2	26	62	25	25	25	34	—	150	24	42	—	—	**MS2091**	—	25 IP
6179756	**EVSCTL1212K0316C**	3	16	52	12	12	12	23	4	125	11	34	M8X1.25	M8X1.25	**MS1944**	—	T25
5980778	**EVSCTL1616K0316C**	3	16	52	16	16	16	24	—	125	15	36	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS2091**	—	25 IP
5980801	**EVSCTL2020K0316C**	3	16	52	20	20	20	29	—	125	19	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	—	T30
5980776	**EVSCTL2525M0316C**	3	16	62	25	25	25	34	—	150	24	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1595**	—	T30
5980802	**EVSCTL2020K0326C**	3	26	62	20	20	20	33	4	125	19	47	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	—	T30
5980807	**EVSCTL2525M0326C**	3	26	62	25	25	25	34	—	150	24	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1595**	—	T30
5980779	**EVSCTL1616K0416C**	4	16	52	16	16	16	24	—	125	14	36	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS2091**	—	25 IP
5980803	**EVSCTL2020K0416C**	4	16	52	20	20	20	29	—	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	—	T30
5980804	**EVSCTL2020K0426C**	4	26	62	20	20	20	33	—	125	18	47	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	—	T30
5980808	**EVSCTL2525M0426C**	4	26	62	25	25	25	34	—	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1595**	—	T30
5980809	**EVSCTL2525M0432C**	4	32	64	25	25	25	38	4	150	23	53	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1595**	—	T30
5980812	**EVSCTL3232P0432C**	4	32	64	32	32	32	42	—	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	—	T30
5980810	**EVSCTL2525M0526C**	5	26	62	25	25	25	34	—	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	—	T30
5980811	**EVSCTL2525M0532C**	5	32	64	25	25	25	39	4	150	23	53	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	—	T30
5980813	**EVSCTL3232P0540C**	5	40	82	32	32	32	47	4	170	30	63	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1490**	—	T45

NOTE: Through the pocket coolant available in seat sizes 3 and higher.

screw catalogue number	screw order number	torque Nm	torque in. lbs.	thread	socket	wrench catalogue number	wrench order number
MS1160	**1099645**	7	62	M5	T20	**KT20**	**1022703**
MS1162	**1127019**	9	80	M6	T25	**KT25**	**1022725**
MS1163	**1124104**	18	159	M8	T30	**KT30L**	**1099676**
MS1273	**1020977**	4	35.4	M4	T15	**KT15**	**1022701**
MS1490	**2263299**	17	151	M8	T45	**KT45**	**1018227**
MS1595	**1094300**	12	106	M6	T30	**KT30**	**1099676**
MS1970	**1106668**	12	106	M6	T30	**KT30**	**1099676**
MS2002	**1621087**	9	80	M6	T25	**KT25**	**1022725**
MS2091	**1931147**	9	80	M5	25IP	**K25IP**	**2050113**






Right Hand

CD = Maximum cut-off depth for solid bars.
D max = Maximum bar diameter for deep grooving or cut-off of tubes.

Integral Reinforced Front Clamp • Metric



order number	catalogue number	seat size	CD	D max	H1	H	B	H2	L1	FS	LH	CF	CS	Torx clamp screw	Torx
right hand															
6179763	**EVSCFR1010K1B10**	1B	10	20	10	10	10	14	125	9	21	–	–	**191.916**	T15
6179766	**EVSCFR1212K1B10**	1B	10	20	12	12	12	16	125	11	21	–	–	**191.916**	T15
6179767	**EVSCFR1212K1B13**	1B	13	26	12	12	12	16	125	11	24	–	–	**191.916**	T15
6179774	**EVSCFR1616K1B16**	1B	16	32	16	16	16	21	125	15	27	–	–	**MS1160**	T20
6179778	**EVSCFR2020K1B16**	1B	16	32	20	20	20	25	125	19	27	–	–	**MS1160**	T20
6179764	**EVSCFR1010K1F10**	1F	10	20	10	10	10	14	125	9	21	–	–	**191.916**	T15
6179768	**EVSCFR1212K1F10**	1F	10	20	12	12	12	16	125	11	21	–	–	**191.916**	T15
6179769	**EVSCFR1212K1F13**	1F	13	26	12	12	12	16	125	11	24	–	–	**191.916**	T15
6179775	**EVSCFR1616K1F16**	1F	16	32	16	16	16	21	125	15	27	–	–	**MS1160**	T20
6179779	**EVSCFR2020K1F16**	1F	16	32	20	20	20	25	125	19	27	–	–	**MS1160**	T20
6179765	**EVSCFR1010K0210**	2	10	20	10	10	10	14	125	9	21	–	–	**191.916**	T15
6179770	**EVSCFR1212K0210**	2	10	20	12	12	12	16	125	11	21	–	–	**191.916**	T15
6179771	**EVSCFR1212K0216**	2	16	32	12	12	12	16	125	11	27	–	–	**191.916**	T15
6179776	**EVSCFR1616K0216**	2	16	32	16	16	16	21	125	15	27	–	–	**MS1160**	T20
6179780	**EVSCFR2020K0216**	2	16	32	20	20	20	25	125	19	27	–	–	**MS1160**	T20
6179772	**EVSCFR1212K0310C**	3	10	20	12	12	12	17	125	11	22	M8X1.25	M8X1.25	**191.916**	T15
6179773	**EVSCFR1212K0316C**	3	16	32	12	12	12	17	125	11	28	M8X1.25	M8X1.25	**191.916**	T15
6179777	**EVSCFR1616K0316C**	3	16	32	16	16	16	21	125	15	28	M8X1.25	M8X1.25	**MS1160**	T20
6179781	**EVSCFR2020K0316C**	3	16	32	20	20	20	25	125	19	28	M8X1.25	M8X1.25	**MS1160**	T20

(continued)

(Integral Reinforced Front Clamp • Metric — continued)

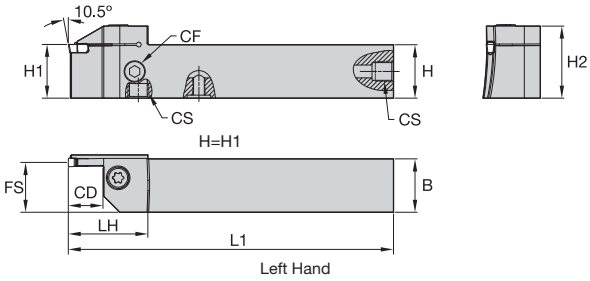


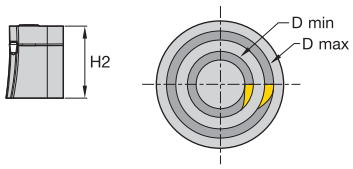
order number	catalogue number	seat size	CD	D max	H1	H	B	H2	L1	FS	LH	CF	CS	Torx clamp screw	Torx
left hand															
6179709	**EVSCFL1010K1B10**	1B	10	20	10	10	10	14	125	9	21	—	—	**191.916**	T15
6179922	**EVSCFL1212K1B10**	1B	10	20	12	12	12	16	125	11	21	—	—	**191.916**	T15
6179923	**EVSCFL1212K1B13**	1B	13	26	12	12	12	16	125	11	24	—	—	**191.916**	T15
6179930	**EVSCFL1616K1B16**	1B	16	32	16	16	16	21	125	15	27	—	—	**MS1160**	T20
6179934	**EVSCFL2020K1B16**	1B	16	32	20	20	20	25	125	19	27	—	—	**MS1160**	T20
6179710	**EVSCFL1010K1F10**	1F	10	20	10	10	10	14	125	9	21	—	—	**191.916**	T15
6179924	**EVSCFL1212K1F10**	1F	10	20	12	12	12	16	125	11	21	—	—	**191.916**	T15
6179925	**EVSCFL1212K1F13**	1F	13	26	12	12	12	16	125	11	24	—	—	**191.916**	T15
6179931	**EVSCFL1616K1F16**	1F	16	32	16	16	16	21	125	15	27	—	—	**MS1160**	T20
6179935	**EVSCFL2020K1F16**	1F	16	32	20	20	20	25	125	19	27	—	—	**MS1160**	T20
6179921	**EVSCFL1010K0210**	2	10	20	10	10	10	14	125	9	21	—	—	**191.916**	T15
6179926	**EVSCFL1212K0210**	2	10	20	12	12	12	16	125	11	21	—	—	**191.916**	T15
6179927	**EVSCFL1212K0216**	2	16	32	12	12	12	16	125	11	27	—	—	**191.916**	T15
6179932	**EVSCFL1616K0216**	2	16	32	16	16	16	21	125	15	27	—	—	**MS1160**	T20
6179936	**EVSCFL2020K0216**	2	16	32	20	20	20	25	125	19	27	—	—	**MS1160**	T20
6179928	**EVSCFL1212K0310C**	3	10	20	12	12	12	17	125	11	22	M8X1.25	M8X1.25	**191.916**	T15
6179929	**EVSCFL1212K0316C**	3	16	32	12	12	12	17	125	11	28	M8X1.25	M8X1.25	**191.916**	T15
6179933	**EVSCFL1616K0316C**	3	16	32	16	16	16	21	125	15	28	M8X1.25	M8X1.25	**MS1160**	T20
6179937	**EVSCFL2020K0316C**	3	16	32	20	20	20	25	125	19	28	M8X1.25	M8X1.25	**MS1160**	T20

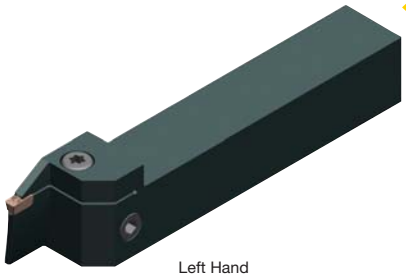
NOTE: Through the pocket coolant available in seat sizes 3 and higher.

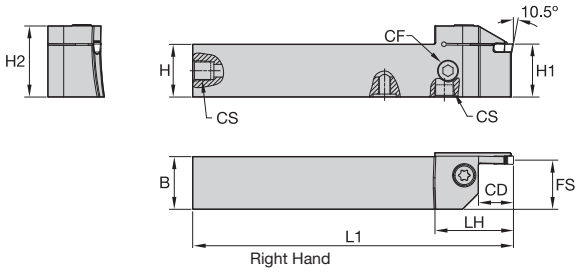
screw	screw	torque				wrench	wrench
catalogue number	order number	Nm	in. lbs.	thread	socket	catalogue number	order number
MS1160	**1099645**	7	62	M5	T20	**KT20**	**1022703**
MS1162	**1127019**	9	80	M6	T25	**KT25**	**1022725**
MS1163	**1124104**	18	159	M8	T30	**KT30L**	**1099676**
MS1273	**1020977**	4	35.4	M4	T15	**KT15**	**1022701**
MS1490	**2263299**	17	151	M8	T45	**KT45**	**1018227**
MS1595	**1094300**	12	106	M6	T30	**KT30**	**1099676**
MS1970	**1106668**	12	106	M6	T30	**KT30**	**1099676**
MS2002	**1621087**	9	80	M6	T25	**KT25**	**1022725**
MS2091	**1931147**	9	80	M5	25IP	**K25IP**	**2050113**

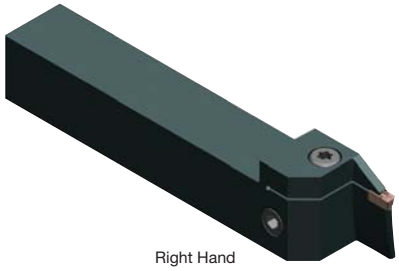







Left Hand




Right Hand

Integral Face Grooving Straight Outboard • Metric



order number	catalogue number	seat size	CD	D max	D min	W min	B	H2	L1	FS	LH	CF	CS	Torx clamp screw	Torx
right hand															
6080031	**EVSBR2020K0312035040C**	3	12	40	35	20	20	29	125	19	33	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116561	**EVSBR2020K0312040050C**	3	12	50	40	20	20	29	125	19	33	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T20
6116563	**EVSBR2020K0312050060C**	3	12	60	50	20	20	29	125	19	33	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116567	**EVSBR2020K0312060075C**	3	12	75	60	20	20	29	125	19	33	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116569	**EVSBR2020K0312075100C**	3	12	100	75	20	20	29	125	19	33	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6080067	**EVSBR2525M0312100180C**	3	12	180	100	25	25	34	150	24	33	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080069	**EVSBR2525M0312180250C**	3	12	250	180	25	25	34	150	24	33	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080053	**EVSBR2525M0320060075C**	3	20	75	60	25	25	34	150	24	41	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080055	**EVSBR2525M0320075100C**	3	20	100	75	25	25	34	150	24	41	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080057	**EVSBR2525M0320100180C**	3	20	180	100	25	25	34	150	24	41	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080060	**EVSBR2525M0320180250C**	3	20	250	180	25	25	35	150	24	41	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080033	**EVSBR2020K0416040050C**	4	16	50	40	20	20	29	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6080040	**EVSBR2020K0416050060C**	4	16	60	50	20	20	29	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116571	**EVSBR2020K0416060075C**	4	16	75	60	20	20	29	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116573	**EVSBR2020K0416075100C**	4	16	100	75	20	20	29	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116587	**EVSBR2525M0416100180C**	4	16	180	100	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6116589	**EVSBR2525M0416180250C**	4	16	250	180	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6116575	**EVSBR2525M0426060075C**	4	26	75	60	25	25	34	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6116577	**EVSBR2525M0426075100C**	4	26	100	75	25	25	34	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6116579	**EVSBR2525M0426100180C**	4	26	180	100	25	25	34	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6116581	**EVSBR2525M0426180250C**	4	26	250	180	25	25	34	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080035	**EVSBR2525M0516050060C**	5	16	60	50	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124200	**EVSBR2525M0516060075C**	5	16	60	60	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30

(continued)

(Integral Face Grooving Straight Outboard • Metric — continued)



order number	catalogue number	seat size	CD	D max	D min	W min	B	H2	L1	FS	LH	CF	CS	Torx clamp screw	Torx
6124214	**EVSBR2525M0516075100C**	5	16	100	75	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124218	**EVSBR2525M0516100180C**	5	16	180	100	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124222	**EVSBR2525M0516180250C**	5	16	250	180	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124226	**EVSBR2525M0516250350C**	5	16	350	250	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124230	**EVSBR2525M0516350999C**	5	16	999	350	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124198	**EVSBR2525M0526050060C**	5	26	60	50	25	25	35	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124212	**EVSBR2525M0526060075C**	5	26	60	60	25	25	35	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124216	**EVSBR2525M0526075100C**	5	26	100	75	25	25	35	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124235	**EVSBR3232P0532100180C**	5	32	180	100	32	32	42	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124237	**EVSBR3232P0532180250C**	5	32	250	180	32	32	42	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124239	**EVSBR3232P0532250350C**	5	32	350	250	32	32	42	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124241	**EVSBR3232P0532350999C**	5	32	999	350	32	32	42	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124605	**EVSBR2525M0616060075C**	6	16	75	60	25	25	35	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124609	**EVSBR2525M0616075100C**	6	16	100	75	25	25	35	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124673	**EVSBR2525M0616100180C**	6	16	180	100	25	25	31	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124677	**EVSBR2525M0616180250C**	6	16	250	180	25	25	34	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124681	**EVSBR2525M0616250350C**	6	16	350	250	25	25	34	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124685	**EVSBR2525M0616350999C**	6	16	999	350	25	25	34	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124607	**EVSBR2525M0626060075C**	6	26	75	60	25	25	35	150	22	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124671	**EVSBR2525M0626075100C**	6	26	100	75	25	25	35	150	22	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6124689	**EVSBR3232P0632100180C**	6	32	180	100	32	32	43	170	29	55	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1490**	T45
6124691	**EVSBR3232P0632180250C**	6	32	250	180	32	32	43	170	29	55	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1490**	T45
6124693	**EVSBR3232P0632250350C**	6	32	350	250	32	32	43	170	29	55	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1490**	T45
6124695	**EVSBR3232P0632350999C**	6	32	999	350	32	32	43	170	29	55	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1490**	T45
left hand															
6080037	**EVSBL2020K0312035040C**	3	12	40	35	20	20	29	125	19	33	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116562	**EVSBL2020K0312040050C**	3	12	50	40	20	20	29	125	19	33	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116564	**EVSBL2020K0312050060C**	3	12	60	50	20	20	29	125	19	33	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116568	**EVSBL2020K0312060075C**	3	12	75	60	20	20	29	125	19	33	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116570	**EVSBL2020K0312075100C**	3	12	100	75	20	20	29	125	19	33	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6080068	**EVSBL2525M0312100180C**	3	12	180	100	25	25	34	150	24	33	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080070	**EVSBL2525M0312180250C**	3	12	250	180	25	25	34	150	24	33	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080054	**EVSBL2525M0320060075C**	3	20	75	60	25	25	35	150	24	41	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080056	**EVSBL2525M0320075100C**	3	20	100	75	25	25	35	150	24	41	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080059	**EVSBL2525M0320100180C**	3	20	180	100	25	25	35	150	24	41	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080061	**EVSBL2525M0320180250C**	3	20	250	180	25	25	35	150	24	41	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6080038	**EVSBL2020K0416040050C**	4	16	50	40	20	20	29	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6080051	**EVSBL2020K0416050060C**	4	16	60	50	20	20	29	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116572	**EVSBL2020K0416060075C**	4	16	75	60	20	20	29	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116574	**EVSBL2020K0416075100C**	4	16	100	75	20	20	29	125	18	37	1/16 - 27 NPTF	1/16 - 27 NPTF	**MS1595**	T30
6116588	**EVSBL2525M0416100180C**	4	16	180	100	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6116590	**EVSBL2525M0416180250C**	4	16	250	180	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6116576	**EVSBL2525M0426060075C**	4	26	75	60	25	25	35	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30
6116578	**EVSBL2525M0426075100C**	4	26	100	75	25	25	35	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	**MS1970**	T30

(continued)

(Integral Face Grooving Straight Outboard • Metric — continued)



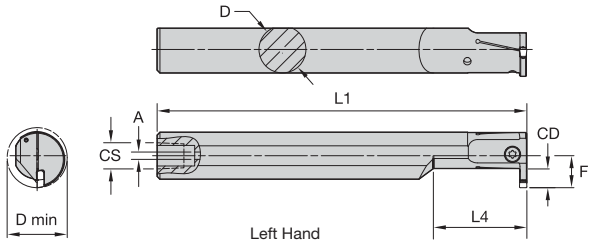
order number	catalogue number	seat size	CD	D max	D min	W min	B	H2	L1	FS	LH	CF	CS	Torx clamp screw	Torx
6116580	EVSBL2525M0426100180C	4	26	180	100	25	25	35	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6116582	EVSBL2525M0426180250C	4	26	250	180	25	25	35	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6080039	EVSBL2525M0516050060C	5	16	60	50	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124211	EVSBL2525M0516060075C	5	16	60	60	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124215	EVSBL2525M0516075100C	5	16	100	75	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124219	EVSBL2525M0516100180C	5	16	180	100	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124223	EVSBL2525M0516180250C	5	16	250	180	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124227	EVSBL2525M0516250350C	5	16	350	250	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124232	EVSBL2525M0516350999C	5	16	999	350	25	25	34	150	23	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124199	EVSBL2525M0526050060C	5	26	60	50	25	25	35	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124213	EVSBL2525M0526060075C	5	26	60	60	25	25	35	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124217	EVSBL2525M0526075100C	5	26	100	75	25	25	35	150	23	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124236	EVSBL3232P0532100180C	5	32	180	100	32	32	42	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124238	EVSBL3232P0532180250C	5	32	250	180	32	32	42	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124240	EVSBL3232P0532250350C	5	32	350	250	32	32	42	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124242	EVSBL3232P0532350999C	5	32	999	350	32	32	42	170	30	53	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124606	EVSBL2525M0616060075C	6	16	75	60	25	25	35	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124610	EVSBL2525M0616075100C	6	16	100	75	25	25	35	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124674	EVSBL2525M0616100180C	6	16	180	100	25	25	35	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124678	EVSBL2525M0616180250C	6	16	250	180	25	25	35	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124682	EVSBL2525M0616250350C	6	16	350	250	25	25	35	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124686	EVSBL2525M0616350999C	6	16	999	350	25	25	35	150	22	37	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124608	EVSBL2525M0626060075C	6	26	75	60	25	25	35	150	22	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124672	EVSBL2525M0626075100C	6	26	100	75	25	25	35	150	22	47	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1970	T30
6124690	EVSBL3232P0632100180C	6	32	180	100	32	32	43	170	29	55	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	T45
6124692	EVSBL3232P0632180250C	6	32	250	180	32	32	43	170	29	55	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	T45
6124694	EVSBL3232P0632250350C	6	32	350	250	32	32	43	170	29	55	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	T45
6124696	EVSBL3232P0632350999C	6	32	999	350	32	32	43	170	29	55	1/8 - 27 NPTF	1/8 - 27 NPTF	MS1490	T45

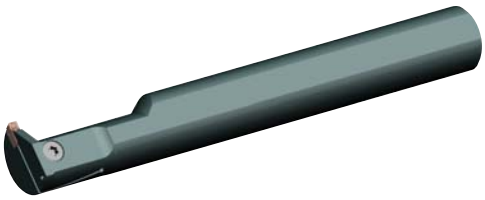
NOTE: Through the pocket coolant available in seat sizes 3 and higher.

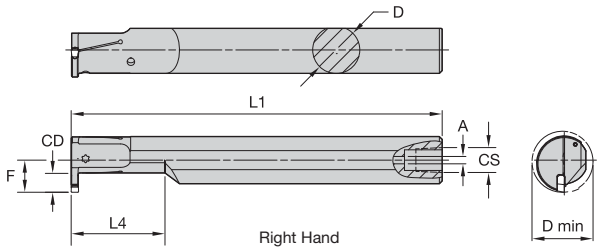
screw catalogue number	screw order number	torque Nm	torque in. lbs.	thread	socket	wrench catalogue number	wrench order number
MS1160	1099645	7	62	M5	T20	KT20	1022703
MS1162	1127019	9	80	M6	T25	KT25	1022725
MS1163	1124104	18	159	M8	T30	KT30L	1099676
MS1273	1020977	4	35.4	M4	T15	KT15	1022701
MS1490	2263299	17	151	M8	T45	KT45	1018227
MS1595	1094300	12	106	M6	T30	KT30	1099676
MS1970	1106668	12	106	M6	T30	KT30	1099676
MS2002	1621087	9	80	M6	T25	KT25	1022725
MS2091	1931147	9	80	M5	25IP	K25IP	2050113

- For use in I.D. grooving applications.
- Maximum support.
- Steel boring bar with through coolant capability.



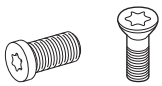



Left Hand




Right Hand

Steel Boring Bar • Metric



order number	catalogue number	seat size	CD	D	D min	L1	F	L4	A	CS	Torx clamp screw	Torx clamp screw	Torx
right hand													
5980518	**A12KEVEMR1F05M**	1F	5,00	12	16	125	9	24,0	4,00	1/16 - 27 NPT	–	**MS1285**	T15
5980520	**A16MEVEMR1F07M**	1F	7,00	16	20	150	11	32,0	4,00	1/8 - 27 NPT	–	**MS1273**	T15
5980622	**A20QEVEMR1F07M**	1F	7,00	20	25	180	13	40,0	4,00	1/8 - 27 NPTF	–	**MS1160**	T20
5980519	**A12KEVEMR0205M**	2	5,00	12	16	125	9	24,0	4,00	1/16 - 27 NPTF	–	**MS1285**	T15
5980621	**A16MEVEMR0207M**	2	7,00	16	20	150	11	32,0	4,00	1/8 - 27 NPTF	–	**MS1273**	T15
5980623	**A20QEVEMR0207M**	2	7,00	20	25	180	13	40,0	4,00	1/8 - 27 NPTF	–	**MS1160**	T20
5980624	**A25REVEMR0210M**	2	10,00	25	32	200	18	50,0	6,40	1/4 - 18 NPT	–	**MS1162**	T25
5954259	**A16MEVEMR0307M**	3	7,00	16	20	150	11	40,3	4,00	1/8 - 27 NPT	–	**MS1273**	T15
5954260	**A20QEVEMR0307M**	3	7,00	20	25	180	13	40,3	4,00	1/8 - 27 NPT	–	**MS1160**	T20
5954281	**A25REVEMR0310M**	3	10,00	25	32	200	17	50,3	6,40	1/4 - 18 NPT	–	**MS1162**	T25
5954283	**A32SEVEMR0312M**	3	12,00	32	40	250	22	64,0	6,40	1/4 - 18 NPT	**MS1595**	–	T30
5954282	**A25REVEMR0410M**	4	10,00	25	32	200	17	50,3	6,40	1/4 - 18 NPT	–	**MS1162**	T25
5954284	**A32SEVEMR0412M**	4	12,00	32	40	250	22	64,0	6,40	1/4 - 18 NPT	**MS1595**	–	T30

(continued)

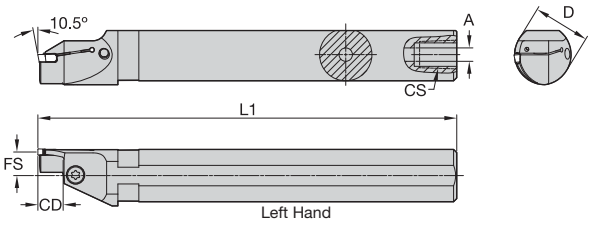
(Steel Boring Bar • Metric — continued)

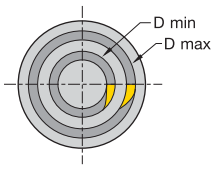



order number	catalogue number	seat size	CD	D	D min	L1	F	L4	A	CS	Torx clamp screw	Torx clamp screw	Torx
left hand													
5980625	A12KEVEML1F05M	1F	5,00	12	16	125	9	24,0	4,00	1/16 - 27 NPTF	–	MS1285	T15
5980627	A16MEVEML1F07M	1F	7,00	16	20	150	11	32,0	4,00	1/8 - 27 NPTF	–	MS1273	T15
5980629	A20QEVEML1F07M	1F	7,00	20	25	180	13	40,0	4,00	1/8 - 27 NPTF	–	MS1160	T20
5980626	A12KEVEML0205M	2	5,00	12	16	125	9	24,0	4,00	1/16 - 27 NPTF	–	MS1285	T15
5980628	A16MEVEML0207M	2	7,00	16	20	150	11	32,0	4,00	1/8 - 27 NPTF	–	MS1273	T15
5980630	A20QEVEML0207M	2	7,00	20	25	180	13	40,0	4,00	1/8 - 27 NPTF	–	MS1160	T20
5980631	A25REVEML0210M	2	10,00	25	32	200	18	50,0	6,40	1/4 - 18 NPT	–	MS1162	T25
5954285	A16MEVEML0307M	3	7,00	16	20	150	11	40,3	4,00	1/8 - 27 NPT	–	MS1273	T15
5954286	A20QEVEML0307M	3	7,00	20	25	180	13	40,3	4,00	1/8 - 27 NPT	–	MS1160	T20
5954287	A25REVEML0310M	3	10,00	25	32	200	17	50,3	6,40	1/4 - 27 NPT	–	MS1162	T25
5954289	A32SEVEML0312M	3	12,00	32	40	250	22	64,0	6,40	1/4 - 27 NPT	MS1595	–	T30
5954288	A25REVEML0410M	4	10,00	25	32	200	17	50,3	6,40	1/4 - 18 NPT	–	MS1162	T25
5954290	A32SEVEML0412M	4	12,00	32	40	250	22	64,0	6,40	1/4 - 18 NPT	MS1595	–	T30

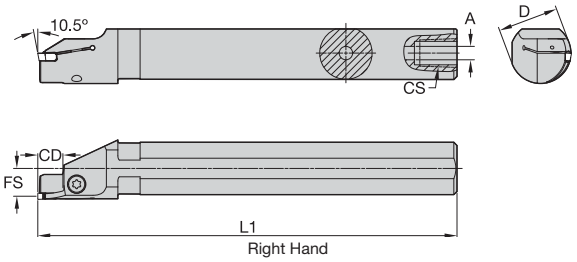
screw catalogue number	screw order number	torque Nm	torque in. lbs.	thread	socket	wrench catalogue number	wrench order number
MS1160	1099645	7	62	M5	T20	KT20	1022703
MS1162	1127019	9	80	M6	T25	KT25	1022725
MS1163	1124104	18	159	M8	T30	KT30L	1099676
MS1273	1020977	4	35.4	M4	T15	KT15	1022701
MS1490	2263299	17	151	M8	T45	KT45	1018227
MS1595	1094300	12	106	M6	T30	KT30	1099676
MS1970	1106668	12	106	M6	T30	KT30	1099676
MS2002	1621087	9	80	M6	T25	KT25	1022725
MS2091	1931147	9	80	M5	25IP	K25IP	2050113








Left Hand




Right Hand

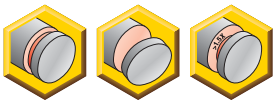
Steel Face Grooving Boring Bar • Metric

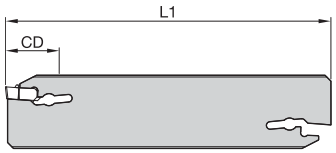


order number	catalogue number	seat size	CD	D	D min	D max	L1	F	CS	Torx clamp screw	Torx
right hand											
6116521	**A25REVSAR0212M026030**	2	12,00	25	26	30	200	13	1/4-18 NPT	**MS1160**	T20
6116522	**A25REVSAR0312M030035**	3	12,00	25	30	35	200	13	–	**MS1162**	T25
6116297	**A32SEVSAR0312M033042**	3	12,00	32	33	42	250	16	1/4-18 NPT	**MS1162**	T25
6116299	**A40TEVSAR0312M041050**	3	12,00	40	41	50	300	20	1/4-18 NPT	**MS1162**	T25
left hand											
6116527	**A25REVSAL0212M026030**	2	12,00	25	26	30	200	13	1/4-18 NPT	**MS1160**	T20
6116528	**A25REVSAL0312M030035**	3	12,00	25	30	35	200	13	1/4-18 NPT	**MS1162**	T25
6116298	**A32SEVSAL0312M033042**	3	12,00	32	33	42	250	16	1/4-18 NPT	–	T25
6116300	**A40TEVSAL0312M041050**	3	12,00	40	41	50	300	20	1/4-18 NPT	**MS1162**	T25

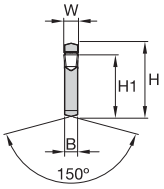
screw catalogue number	screw order number	torque Nm	torque in. lbs.	thread	socket	wrench catalogue number	wrench order number
MS1160	**1099645**	7	62	M5	T20	**KT20**	**1022703**
MS1162	**1127019**	9	80	M6	T25	**KT25**	**1022725**
MS1163	**1124104**	18	159	M8	T30	**KT30L**	**1099676**
MS1273	**1020977**	4	35.4	M4	T15	**KT15**	**1022701**
MS1490	**2263299**	17	151	M8	T45	**KT45**	**1018227**
MS1595	**1094300**	12	106	M6	T30	**KT30**	**1099676**
MS1970	**1106668**	12	106	M6	T30	**KT30**	**1099676**
MS2002	**1621087**	9	80	M6	T25	**KT25**	**1022725**
MS2091	**1931147**	9	80	M5	25IP	**K25IP**	**2050113**

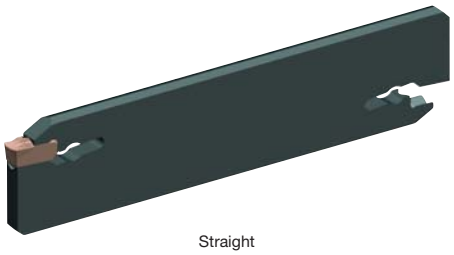
- For deep groove and cut-off applications.
- Universal pocket for holding all insert geometries.



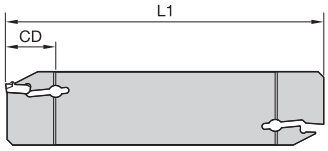


Straight

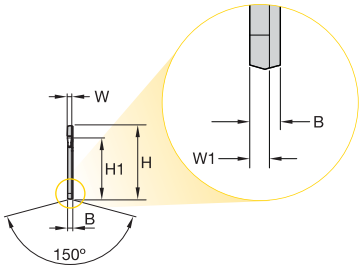


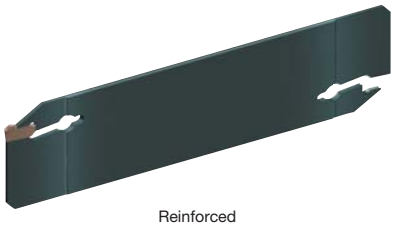


Straight



Reinforced





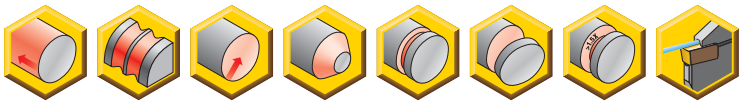
Reinforced

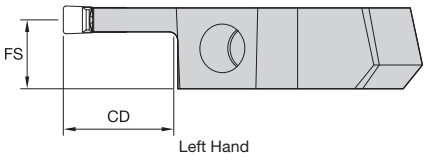
Double-Ended Cut-Off Blade

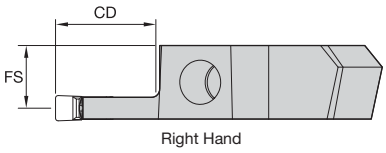
order number	catalogue number	seat size	H	W	W1	H1	L1	B	CD	assembly wrench
left hand										
5941706	**EVBSN19G1B14**	1B	19	1,4	1,15	15,5	90	1,80	14	**SCW5E**
5941708	**EVBSN26J1B15**	1B	26	1,4	1,15	21,5	110	1,80	15	**SCW5E**
5955391	**EVBSN19G1F16**	1F	19	1,6	1,30	15,5	90	1,80	16	**SCW5E**
5955392	**EVBSN26J1F17**	1F	26	1,6	1,30	21,5	110	1,80	17	**SCW5E**
5941707	**EVBSN19G0220**	2	19	2,0	–	15,5	90	1,65	–	**SCW5E**
5941709	**EVBSN26J0230**	2	26	2,0	–	21,5	110	1,65	–	**SCW5E**
5941710	**EVBSN26M0230**	2	26	2,0	–	21,5	150	1,65	–	**SCW5E**
5941724	**EVBSN32M0250**	2	32	2,0	–	25,1	150	1,65	–	**SCW5E**
5941721	**EVBSN26J0340**	3	26	3,0	–	21,5	110	2,40	–	**SCW5E**
5941722	**EVBSN26M0340**	3	26	3,0	–	21,5	150	2,40	–	**SCW5E**
5941725	**EVBSN32M0350**	3	32	3,0	–	25,1	150	2,40	–	**SCW5E**
5941723	**EVBSN26J0440**	4	26	4,0	–	21,5	110	3,40	–	**SCW5E**
5941726	**EVBSN32M0450**	4	32	4,0	–	25,1	150	3,40	–	**SCW5E**
5977635	**EVBSN26J0540**	5	26	5,0	–	21,5	110	4,40	–	**SCW5E**
5977637	**EVBSN32M0560**	5	32	5,0	–	25,1	150	4,40	–	**SCW5E**
5977636	**EVBSN26J0640**	6	26	6,0	–	21,5	110	5,40	–	**SCW8E**
5977638	**EVBSN32M0660**	6	32	6,0	–	25,1	150	5,40	–	**SCW8E**
5977640	**EVBSN52X06120**	6	53	6,0	–	45,3	260	5,40	–	**SCW8E**
5977639	**EVBSN32M0860**	8	32	8,0	–	25,1	150	7,00	–	**SCW8E**
5977721	**EVBSN52X08120**	8	53	8,0	–	45,3	260	7,00	–	**SCW8E**

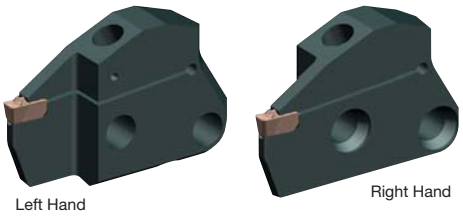
NOTE: Assembly wrench supplied with blade.

- Maximum support for specific groove width and straight clearance for unlimited diameter.
- Through the pocket coolant capable.
- Universal pocket for holding all insert geometries.

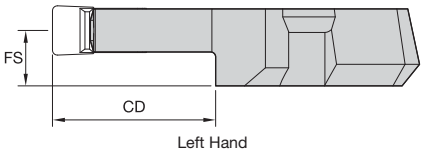


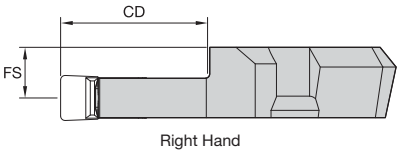


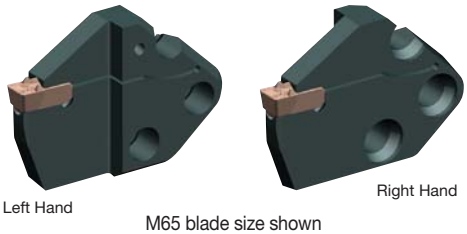




M50 blade size shown







M65 blade size shown

Modular Straight Blade with Coolant

order number	catalogue number	seat size	CD	FS	blade size
right hand					
6031041	**EVM50R1F12M**	1F	12,0	11,00	50
6030969	**EVM50R0212M**	2	12,0	10,88	50
5955423	**EVM50R0216M**	2	16,0	10,88	50
5979200	**EVM50R0312MC**	3	12,0	10,43	50
5979010	**EVM50R0316MC**	3	16,0	10,43	50
5979181	**EVM50R0322MC**	3	22,0	10,43	50
5979201	**EVM50R0412MC**	4	12,0	9,93	50
5979182	**EVM50R0416MC**	4	16,0	9,93	50
5979183	**EVM50R0422MC**	4	22,0	9,93	50
5979198	**EVM50R0426MC**	4	26,0	9,93	50
5979184	**EVM50R0432MC**	4	32,0	9,93	50
6031031	**EVM50R0512MC**	5	12,0	9,43	50
6031033	**EVM50R0516MC**	5	16,0	9,43	50
5955415	**EVM50R0526MC**	5	26,0	9,43	50
5955416	**EVM50R0532MC**	5	32,0	9,43	50
6031035	**EVM65R0616MC**	6	16,0	9,88	65
5955417	**EVM65R0626MC**	6	26,0	9,88	65
6031037	**EVM65R0632MC**	6	32,0	9,88	65
6031039	**EVM65R0816MC**	8	16,0	9,00	65
5955418	**EVM65R0826MC**	8	26,0	9,00	65

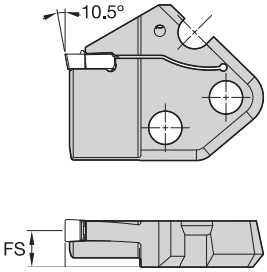
(continued)

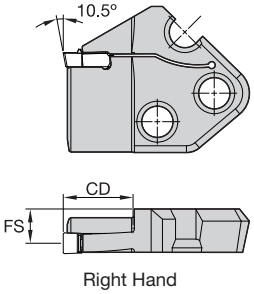
(Modular Straight Blade with Coolant — continued)

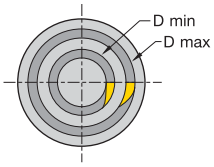
order number	catalogue number	seat size	CD	FS	blade size
left hand					
6031042	**EVM50L1F12M**	1F	12,0	11,00	50
6030970	**EVM50L0212M**	2	12,0	10,88	50
5955424	**EVM50L0216M**	2	16,0	10,88	50
5979202	**EVM50L0312MC**	3	12,0	10,43	50
5979185	**EVM50L0316MC**	3	16,0	10,43	50
5979186	**EVM50L0322MC**	3	22,0	10,43	50
5979203	**EVM50L0412MC**	4	12,0	9,93	50
5979187	**EVM50L0416MC**	4	16,0	9,93	50
5979188	**EVM50L0422MC**	4	22,0	9,93	50
5979199	**EVM50L0426MC**	4	26,0	9,93	50
5979189	**EVM50L0432MC**	4	32,0	9,93	50
6031032	**EVM50L0512MC**	5	12,0	9,93	50
6031034	**EVM50L0516MC**	5	16,0	9,43	50
5955419	**EVM50L0526MC**	5	26,0	9,43	50
5955420	**EVM50L0532MC**	5	32,0	9,43	50
6031036	**EVM65L0616MC**	6	16,0	9,88	65
5955421	**EVM65L0626MC**	6	26,0	9,88	65
6031038	**EVM65L0632MC**	6	32,0	9,88	65
6031040	**EVM65L0816MC**	8	16,0	9,00	65
5955422	**EVM65L0826MC**	8	26,0	9,00	65

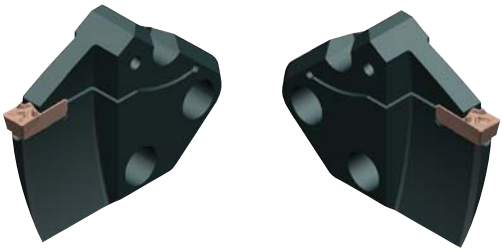
NOTE: Through the pocket coolant available in seat sizes 3 and higher.



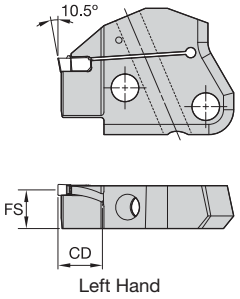


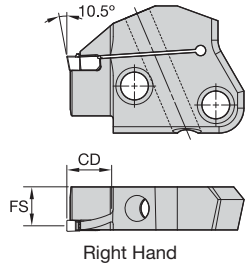


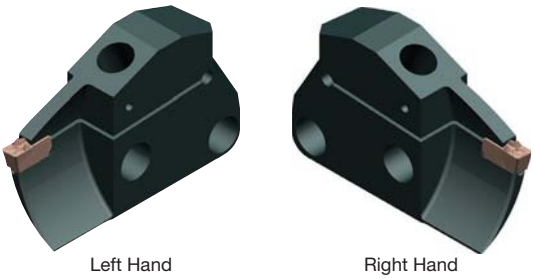




M65 blade size shown







M50 blade size shown

Modular Inboard Face Grooving Blade with Coolant

order number	catalogue number	seat size	D min	D max	CD	FS	blade size
right hand							
6097181	**EVM50R0312A035040C**	3	35	40	12,0	10,50	50
6097182	**EVM50R0312A040050C**	3	40	50	12,0	10,50	50
6097183	**EVM50R0312A050060C**	3	50	60	12,0	10,50	50
6097184	**EVM50R0312A060075C**	3	60	75	12,0	10,50	50
6116789	**EVM50R0312A075100C**	3	75	100	12,0	10,50	50
6117063	**EVM50R0312A100180C**	3	100	180	12,0	10,50	50
6117067	**EVM50R0312A180250C**	3	180	250	12,0	10,50	50
6117071	**EVM50R0312A250350C**	3	250	350	12,0	10,50	50
6117075	**EVM50R0312A350999C**	3	350	999	12,0	10,50	50
6097185	**EVM50R0320A075100C**	3	75	100	20,0	10,50	50
6097186	**EVM50R0320A100180C**	3	100	180	20,0	10,50	50
6097187	**EVM50R0320A180250C**	3	180	250	20,0	10,50	50
6097188	**EVM50R0320A250350C**	3	250	350	20,0	10,50	50
6097189	**EVM50R0320A350999C**	3	350	999	20,0	10,50	50
6079480	**EVM50R0416A040050C**	4	40	50	16,0	10,00	50
6079481	**EVM50R0416A050060C**	4	50	60	16,0	10,00	50
6079482	**EVM50R0416A060075C**	4	60	75	16,0	10,00	50
6079483	**EVM50R0416A075100C**	4	75	100	16,0	10,00	50
6117079	**EVM50R0416A100180C**	4	100	180	16,0	10,00	50
6117093	**EVM50R0416A180250C**	4	180	250	16,0	10,00	50
6117097	**EVM50R0416A250350C**	4	250	350	16,0	10,00	50
6117101	**EVM50R0416A350999C**	4	350	999	16,0	10,00	50
6079484	**EVM50R0426A100180C**	4	100	180	26,0	10,00	50

(continued)

(Modular Inboard Face Grooving Blade with Coolant — continued)

order number	catalogue number	seat size	D min	D max	CD	FS	blade size
6079485	EVM50R0426A180250C	4	180	250	26,0	10,00	50
6079486	EVM50R0426A250350C	4	250	350	26,0	10,00	50
6079487	EVM50R0426A350999C	4	350	999	26,0	10,00	50
6079488	EVM50R0520A050060C	5	50	60	20,0	9,50	50
6079489	EVM50R0520A060075C	5	60	75	20,0	9,50	50
6079490	EVM50R0520A075100C	5	75	100	20,0	9,50	50
6079491	EVM50R0520A100180C	5	100	180	20,0	9,50	50
6079492	EVM50R0520A180250C	5	180	250	20,0	9,50	50
6079493	EVM50R0520A250350C	5	250	350	20,0	9,50	50
6079494	EVM50R0520A350999C	5	350	999	20,0	9,50	50
6079223	EVM65R0620A060075C	6	60	75	20,0	9,88	65
6079224	EVM65R0620A075100C	6	75	100	20,0	9,88	65
6079225	EVM65R0620A100180C	6	100	180	20,0	9,88	65
6079226	EVM65R0620A180250C	6	180	250	20,0	9,88	65
6079227	EVM65R0620A250350C	6	250	350	20,0	9,88	65
6079228	EVM65R0620A350999C	6	350	999	20,0	9,88	65
6079229	EVM65R0820A080180C	8	80	180	20,0	9,00	65
6079230	EVM65R0820A180999C	8	180	999	20,0	9,00	65
left hand							
6097190	EVM50L0312A035040C	3	35	40	12,0	10,50	50
6097191	EVM50L0312A040050C	3	40	50	12,0	10,50	50
6097192	EVM50L0312A050060C	3	50	60	12,0	10,50	50
6097193	EVM50L0312A060075C	3	60	75	12,0	10,50	50
6116790	EVM50L0312A075100C	3	75	100	12,0	10,50	50
6117064	EVM50L0312A100180C	3	100	180	12,0	10,50	50
6117068	EVM50L0312A180250C	3	180	250	12,0	10,50	50
6117072	EVM50L0312A250350C	3	250	350	12,0	10,50	50
6117076	EVM50L0312A350999C	3	350	999	12,0	10,50	50
6097194	EVM50L0320A075100C	3	75	100	20,0	10,50	50
6097195	EVM50L0320A100180C	3	100	180	20,0	10,50	50
6097196	EVM50L0320A180250C	3	180	250	20,0	10,50	50
6097197	EVM50L0320A250350C	3	250	350	20,0	10,50	50
6097198	EVM50L0320A350999C	3	350	999	20,0	10,50	50
6079495	EVM50L0416A040050C	4	40	50	16,0	10,00	50
6079496	EVM50L0416A050060C	4	50	60	16,0	10,00	50
6079497	EVM50L0416A060075C	4	60	75	16,0	10,00	50
6079498	EVM50L0416A075100C	4	75	100	16,0	10,00	50
6117080	EVM50L0416A100180C	4	100	180	16,0	10,00	50
6117094	EVM50L0416A180250C	4	180	250	16,0	10,00	50
6117098	EVM50L0416A250350C	4	250	350	16,0	10,00	50
6117102	EVM50L0416A350999C	4	350	999	16,0	10,00	50
6079499	EVM50L0426A100180C	4	100	180	26,0	10,00	50
6079500	EVM50L0426A180250C	4	180	250	26,0	10,00	50
6079501	EVM50L0426A250350C	4	250	350	26,0	10,00	50

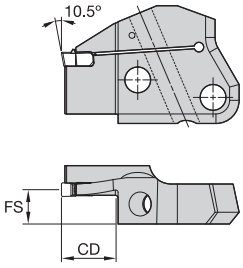
(continued)

(Modular Inboard Face Grooving Blade with Coolant — continued)

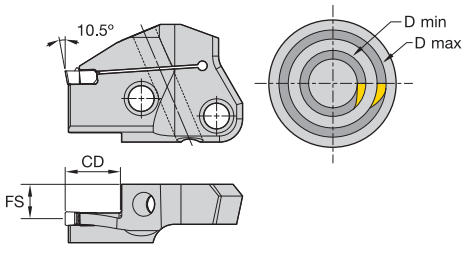
order number	catalogue number	seat size	D min	D max	CD	FS	blade size
6079502	EVM50L0426A350999C	4	350	999	26,0	10,00	50
6079503	EVM50L0520A050060C	5	50	60	20,0	9,50	50
6079504	EVM50L0520A060075C	5	60	75	20,0	9,50	50
6079505	EVM50L0520A075100C	5	75	100	20,0	9,50	50
6079506	EVM50L0520A100180C	5	100	180	20,0	9,50	50
6079507	EVM50L0520A180250C	5	180	250	20,0	9,50	50
6079508	EVM50L0520A250350C	5	250	350	20,0	9,50	50
6079509	EVM50L0520A350999C	5	350	999	20,0	9,50	50
6079234	EVM65L0620A060075C	6	60	75	20,0	9,88	65
6079235	EVM65L0620A075100C	6	75	100	20,0	9,88	65
6079236	EVM65L0620A100180C	6	100	180	20,0	9,88	65
6079237	EVM65L0620A180250C	6	180	250	20,0	9,88	65
6079238	EVM65L0620A250350C	6	250	350	20,0	9,88	65
6079239	EVM65L0620A350999C	6	350	999	20,0	9,88	65
6079240	EVM65L0820A080180C	8	80	180	20,0	9,00	65
6079241	EVM65L0820A180999C	8	180	999	20,0	9,00	65

NOTE: Through the pocket coolant available in seat sizes 3 and higher.

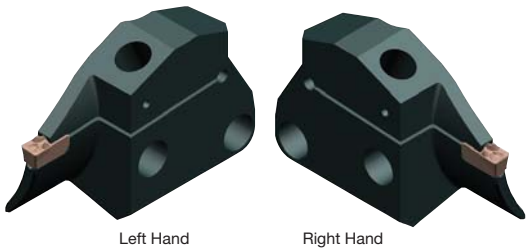




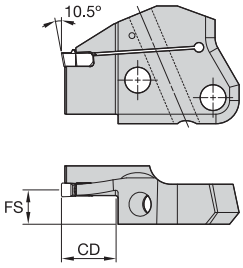
Left Hand



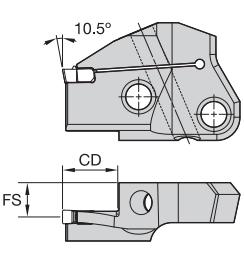
Right Hand


Left Hand Right Hand

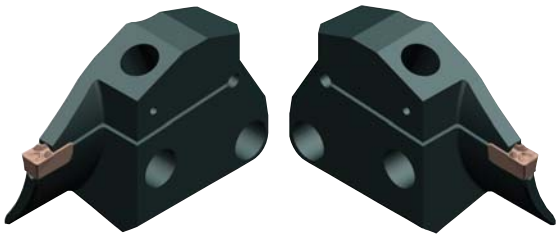
M65 blade size shown



Left Hand



Right Hand


Left Hand Right Hand

M50 blade size shown

Modular Outboard Face Grooving Blade with Coolant

order number	catalogue number	seat size	D min	D max	CD	FS	blade size
right hand							
6079340	**EVM50R0312B035040C**	3	35	40	12,0	10,50	50
6079411	**EVM50R0312B040050C**	3	40	50	12,0	10,50	50
6079412	**EVM50R0312B050060C**	3	50	60	12,0	10,50	50
6079413	**EVM50R0312B060075C**	3	60	75	12,0	10,50	50
6117061	**EVM50R0312B075100C**	3	75	100	12,0	10,50	50
6117065	**EVM50R0312B100180C**	3	100	180	12,0	10,50	50
6117069	**EVM50R0312B180250C**	3	180	250	12,0	10,50	50
6117073	**EVM50R0312B250350C**	3	250	350	12,0	10,50	50
6117077	**EVM50R0312B350999C**	3	350	999	12,0	10,50	50
6079414	**EVM50R0320B075100C**	3	75	100	20,0	10,50	50
6079415	**EVM50R0320B100180C**	3	100	180	20,0	10,50	50
6079416	**EVM50R0320B180250C**	3	180	250	20,0	10,50	50
6079417	**EVM50R0320B250350C**	3	250	350	20,0	10,50	50
6079418	**EVM50R0320B350999C**	3	350	999	20,0	10,50	50
6079429	**EVM50R0416B040050C**	4	40	50	16,0	10,00	50
6079430	**EVM50R0416B050060C**	4	50	60	16,0	10,00	50
6079451	**EVM50R0416B060075C**	4	60	75	16,0	10,00	50
6079452	**EVM50R0416B075100C**	4	75	100	16,0	10,00	50
6117091	**EVM50R0416B100180C**	4	100	180	16,0	10,00	50
6117095	**EVM50R0416B180250C**	4	180	250	16,0	10,00	50
6117099	**EVM50R0416B250350C**	4	250	350	16,0	10,00	50
6117103	**EVM50R0416B350999C**	4	350	999	16,0	10,00	50
6079453	**EVM50R0426B100180C**	4	100	180	26,0	10,00	50

(continued)

(Modular Outboard Face Grooving Blade with Coolant — continued)

order number	catalogue number	seat size	D min	D max	CD	FS	blade size
6079454	EVM50R0426B180250C	4	180	250	26,0	10,00	50
6079455	EVM50R0426B250350C	4	250	350	26,0	10,00	50
6079456	EVM50R0426B350999C	4	350	999	26,0	10,00	50
6079457	EVM50R0520B050060C	5	50	60	20,0	9,50	50
6079458	EVM50R0520B060075C	5	60	75	20,0	9,50	50
6079459	EVM50R0520B075100C	5	75	100	20,0	9,50	50
6079460	EVM50R0520B100180C	5	100	180	20,0	9,50	50
6079461	EVM50R0520B180250C	5	180	250	20,0	9,50	50
6079462	EVM50R0520B250350C	5	250	350	20,0	9,50	50
6079463	EVM50R0520B350999C	5	350	999	20,0	9,50	50
6079246	EVM65R0620B060075C	6	60	75	20,0	9,88	65
6079247	EVM65R0620B075100C	6	75	100	20,0	9,88	65
6079248	EVM65R0620B100180C	6	100	180	20,0	9,88	65
6079249	EVM65R0620B180250C	6	180	250	20,0	9,88	65
6079250	EVM65R0620B250350C	6	250	350	20,0	9,88	65
6079261	EVM65R0620B350999C	6	350	999	20,0	9,88	65
6079262	EVM65R0820B080180C	8	80	180	20,0	9,00	65
6079263	EVM65R0820B180999C	8	180	999	20,0	9,00	65
left hand							
6079420	EVM50L0312B035040C	3	35	40	12,0	10,50	50
6079421	EVM50L0312B040050C	3	40	50	12,0	10,50	50
6079422	EVM50L0312B050060C	3	50	60	12,0	10,50	50
6079423	EVM50L0312B060075C	3	60	75	12,0	10,50	50
6117062	EVM50L0312B075100C	3	75	100	12,0	10,50	50
6117066	EVM50L0312B100180C	3	100	180	12,0	10,50	50
6117070	EVM50L0312B180250C	3	180	250	12,0	10,50	50
6117074	EVM50L0312B250350C	3	250	350	12,0	10,50	50
6117078	EVM50L0312B350999C	3	350	999	12,0	10,50	50
6079424	EVM50L0320B075100C	3	75	100	20,0	10,50	50
6079425	EVM50L0320B100180C	3	100	180	20,0	10,50	50
6079426	EVM50L0320B180250C	3	180	250	20,0	10,50	50
6079427	EVM50L0320B250350C	3	250	350	20,0	10,50	50
6079428	EVM50L0320B350999C	3	350	999	20,0	10,50	50
6079464	EVM50L0416B040050C	4	40	50	16,0	10,00	50
6079465	EVM50L0416B050060C	4	50	60	16,0	10,00	50
6079466	EVM50L0416B060075C	4	60	75	16,0	10,00	50
6079467	EVM50L0416B075100C	4	75	100	16,0	10,00	50
6117092	EVM50L0416B100180C	4	100	180	16,0	10,00	50
6117096	EVM50L0416B180250C	4	180	250	16,0	10,00	50
6117100	EVM50L0416B250350C	4	250	350	16,0	10,00	50
6117104	EVM50L0416B350999C	4	350	999	16,0	10,00	50
6079468	EVM50L0426B100180C	4	100	180	26,0	10,00	50
6079469	EVM50L0426B180250C	4	180	250	26,0	10,00	50
6079470	EVM50L0426B250350C	4	250	350	26,0	10,00	50

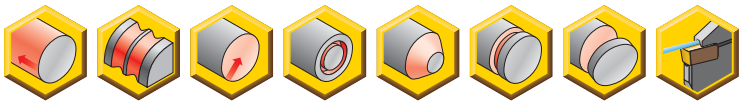
(continued)

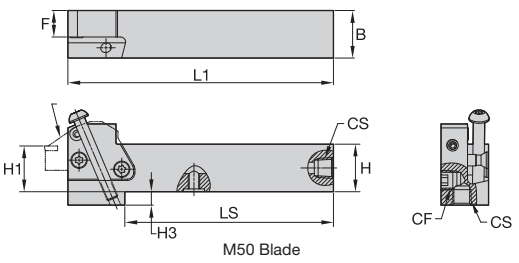
(Modular Outboard Face Grooving Blade with Coolant — continued)

order number	catalogue number	seat size	D min	D max	CD	FS	blade size
6079471	EVM50L0426B350999C	4	350	999	26,0	10,00	50
6079472	EVM50L0520B050060C	5	50	60	20,0	9,50	50
6079473	EVM50L0520B060075C	5	60	75	20,0	9,50	50
6079474	EVM50L0520B075100C	5	75	100	20,0	9,50	50
6079475	EVM50L0520B100180C	5	100	180	20,0	9,50	50
6079476	EVM50L0520B180250C	5	180	250	20,0	9,50	50
6079477	EVM50L0520B250350C	5	250	350	20,0	9,50	50
6079478	EVM50L0520B350999C	5	350	999	20,0	9,50	50
6079266	EVM65L0620B060075C	6	60	75	20,0	9,88	65
6079267	EVM65L0620B075100C	6	75	100	20,0	9,88	65
6079268	EVM65L0620B100180C	6	100	180	20,0	9,88	65
6079269	EVM65L0620B180250C	6	180	250	20,0	9,88	65
6079270	EVM65L0620B250350C	6	250	350	20,0	9,87	65
6079271	EVM65L0620B350999C	6	350	999	20,0	9,88	65
6079272	EVM65L0820B080180C	8	80	180	20,0	9,00	65
6079273	EVM65L0820B180999C	8	180	999	20,0	9,00	65

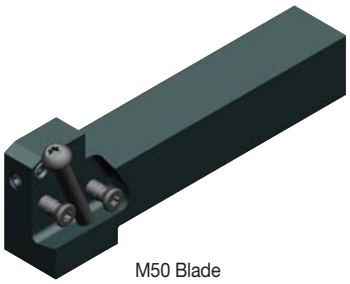
NOTE: Through the pocket coolant available in seat sizes 3 and higher.

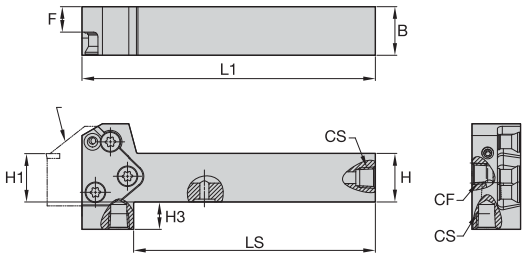
- Interchangeable blades for versatility and depth of cut.
- Through the pocket coolant capable.



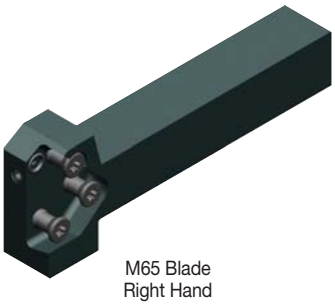


M50 Blade


M50 Blade
Right Hand



M65 Blade


M65 Blade
Right Hand

Modular Straight Toolholder with Coolant • Metric

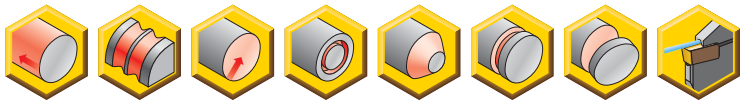


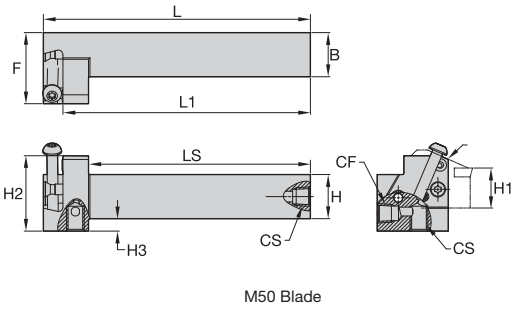
order number	catalogue number	B	H	H1	L1	F	CS	CF	LS	H3	blade size	blade screw	Torx	clamping screw	Torx
right hand															
5979190	**KGMSR2525M50C**	25	25	25	138,75	13,84	G 1/8	G 1/8	109,00	7,00	50	**MS1162**	T25	**MS2002**	T25
5979745	**KGMSR2525M65C**	25	25	25	150,00	13,00	G 1/8	G 1/8	122,00	14,00	65	**MS1163**	T30	**–**	–
5979746	**KGMSR3232P50C**	32	32	32	158,75	20,81	G 1/8	G 1/8	133,62	–	50	**MS1162**	T25	**MS2002**	T25
5979747	**KGMSR3232P65C**	32	32	32	170,00	20,00	G 1/8	G 1/8	138,50	7,00	65	**MS1163**	T30	**–**	–
left hand															
5979191	**KGMSL2525M50C**	25	25	25	138,75	13,84	G 1/8	G 1/8	109,00	7,00	50	**MS1162**	T25	**MS2002**	T25
5979748	**KGMSL2525M65C**	25	25	25	150,00	13,00	G 1/8	G 1/8	122,00	14,00	65	**MS1163**	T30	**–**	–
5979749	**KGMSL3232P50C**	32	32	32	158,75	20,80	G 1/8	G 1/8	133,62	–	50	**MS1162**	T25	**MS2002**	T25
5979750	**KGMSL3232P65C**	32	32	32	170,00	20,00	G 1/8	G 1/8	142,00	7,00	65	**MS1163**	T30	**–**	–

NOTE: KGMS..: Right-hand holder uses right-hand blades.
KGME..: Right-hand holder uses left-hand blades.
M50 blade and clamp screw torque equals 8–10 Nm (71–88 in. lbs.).
M65 blade and clamp screw torque equals 18–20 Nm (159–177 in. lbs.).

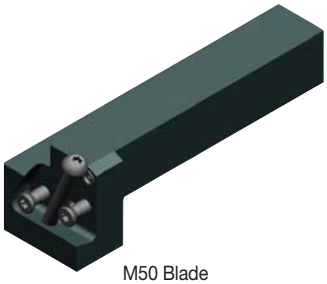
screw catalogue number	screw order number	torque Nm	torque in. lbs.	thread	socket	wrench catalogue number	wrench order number
MS1160	**1099645**	7	62	M5	T20	**KT20**	**1022703**
MS1162	**1127019**	9	80	M6	T25	**KT25**	**1022725**
MS1163	**1124104**	18	159	M8	T30	**KT30L**	**1099676**
MS1273	**1020977**	4	35.4	M4	T15	**KT15**	**1022701**
MS1490	**2263299**	17	151	M8	T45	**KT45**	**1018227**
MS1595	**1094300**	12	106	M6	T30	**KT30**	**1099676**
MS1970	**1106668**	12	106	M6	T30	**KT30**	**1099676**
MS2002	**1621087**	9	80	M6	T25	**KT25**	**1022725**
MS2091	**1931147**	9	80	M5	25IP	**K25IP**	**2050113**

- Interchangeable blades for versatility and depth of cut.
- Through the pocket coolant capable.

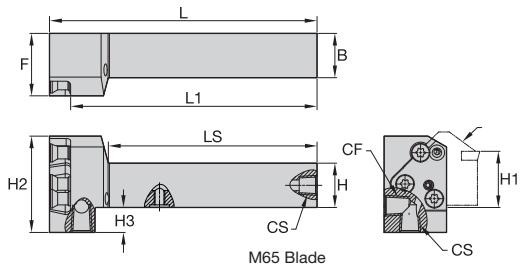




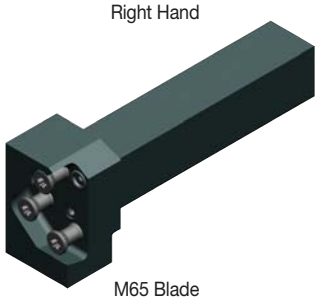
M50 Blade



M50 Blade
Right Hand



M65 Blade



M65 Blade
Right Hand

Modular End Mount Toolholder with Coolant • Metric

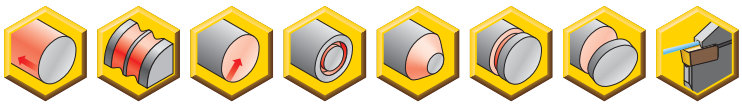


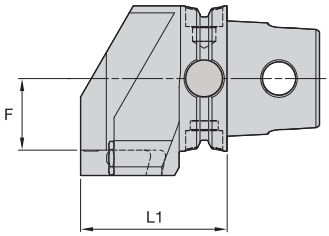
order number	catalogue number	B	H	H1	L1	F	CS	CF	LS	H3	blade size	blade screw	Torx	clamping screw	Torx
right hand															
5979765	**KGMER2525M65C**	25	25	25	138,15	35,00	G 1/8	G 1/8	117,00	14,00	65	**MS1163**	T30	**–**	–
5979192	**KGMER2525M50C**	25	25	25	139,25	40,00	G 1/8	G 1/8	124,85	7,00	50	**MS1162**	T25	**MS2002**	T25
5979767	**KGMER3232P65C**	32	32	32	158,15	35,00	G 1/8	G 1/8	137,00	7,00	65	**MS1163**	T30	**–**	–
5979766	**KGMER3232P50C**	32	32	32	159,25	40,00	G 1/8	G 1/8	145,25	–	50	**MS1162**	T25	**MS2002**	T25
left hand															
5979768	**KGMEL2525M65C**	25	25	25	138,15	35,00	G 1/8	G 1/8	117,00	14,00	65	**MS1163**	T30	**–**	–
5979193	**KGMEL2525M50C**	25	25	25	139,25	40,00	G 1/8	G 1/8	124,85	7,00	50	**MS1162**	T25	**MS2002**	T25
5979770	**KGMEL3232P65C**	32	32	32	158,15	35,00	G 1/8	G 1/8	137,00	7,00	65	**MS1163**	T30	**–**	–
5979769	**KGMEL3232P50C**	32	32	32	159,25	40,00	G 1/8	G 1/8	145,25	–	50	**MS1162**	T25	**MS2002**	T25

NOTE: KGMS..: Right-hand holder uses right-hand blades.
KGME..: Right-hand holder uses left-hand blades.
M50 blade and clamp screw torque equals 8–10 Nm (71–88 in. lbs.).
M65 blade and clamp screw torque equals 18–20 Nm (159–177 in. lbs.).

screw catalogue number	screw order number	torque Nm	torque in. lbs.	thread	socket	wrench catalogue number	wrench order number
MS1160	**1099645**	7	62	M5	T20	**KT20**	**1022703**
MS1162	**1127019**	9	80	M6	T25	**KT25**	**1022725**
MS1163	**1124104**	18	159	M8	T30	**KT30L**	**1099676**
MS1273	**1020977**	4	35.4	M4	T15	**KT15**	**1022701**
MS1490	**2263299**	17	151	M8	T45	**KT45**	**1018227**
MS1595	**1094300**	12	106	M6	T30	**KT30**	**1099676**
MS1970	**1106668**	12	106	M6	T30	**KT30**	**1099676**
MS2002	**1621087**	9	80	M6	T25	**KT25**	**1022725**
MS2091	**1931147**	9	80	M5	25IP	**K25IP**	**2050113**

- Best-in-class KM Quick-Change platform.
- Through the pocket coolant capable.
- Interchangeable blades for versatility and depth of cut.






Right Hand

KM QUICK CHANGE

Modular Straight KM System with Coolant

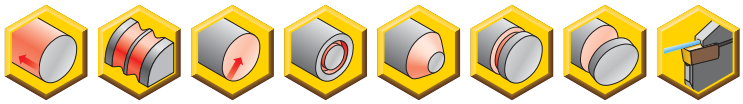


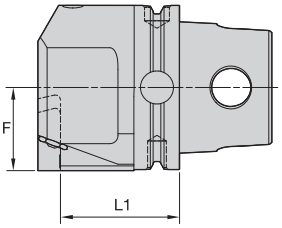


order number	catalogue number	CSMS system size	L1	F	blade size	blade screw	Torx	clamp screw	Torx
right hand									
5999790	**KM40TSKGMSR50C**	KM40TS	53,5	15,0	50	**MS1162**	T25	**MS2002**	T25
6000422	**KM50TSKGMSR65C**	KM50TS	53,5	22,0	65	**MS1163**	T30	**–**	–
5999864	**KM50TSKGMSR50C**	KM50TS	58,5	23,0	50	**MS1162**	T25	**MS2002**	T25
6000431	**KM63TSKGMSR65C**	KM63TS	58,5	30,0	65	**MS1163**	T30	**–**	–
5999948	**KM63TSKGMSR50C**	KM63TS	63,5	31,0	50	**MS1162**	T25	**MS2002**	T25
5999972	**KM63XMZKGMSR50CY**	KM63XMZ	63,5	31,0	50	**MS1162**	T25	**MS2002**	T25
6017695	**KM80TSKGMSR65C**	KM80TS	63,5	40,0	65	**MS1163**	T30	**–**	–
6000018	**KM80ATCKGMSR50C**	KM80ATC	66,5	41,0	50	**MS1162**	T25	**MS2002**	T25
6000014	**KM80TSKGMSR50C**	KM80TS	66,5	41,0	50	**MS1162**	T25	**MS2002**	T25
left hand									
5999861	**KM40TSKGMSL50C**	KM40TS	53,5	15,0	50	**MS1162**	T25	**MS2002**	T25
6000424	**KM50TSKGMSL65C**	KM50TS	53,5	22,0	65	**MS1163**	T30	**–**	–
5999865	**KM50TSKGMSL50C**	KM50TS	58,5	23,0	50	**MS1162**	T25	**MS2002**	T25
6000433	**KM63TSKGMSL65C**	KM63TS	58,5	30,0	65	**MS1163**	T30	**–**	–
5999949	**KM63TSKGMSL50C**	KM63TS	63,5	31,0	50	**MS1162**	T25	**MS2002**	T25
5999973	**KM63XMZKGMSLF50CY**	KM63XMZ	63,5	31,0	50	**MS1162**	T25	**MS2002**	T25
6017696	**KM80TSKGMSL65C**	KM80TS	63,5	40,0	65	**MS1163**	T30	**–**	–
6000019	**KM80ATCKGMSL50C**	KM80ATC	66,5	41,0	50	**MS1162**	T25	**MS2002**	T25
6000015	**KM80TSKGMSL50C**	KM80TS	66,5	41,0	50	**MS1162**	T25	**MS2002**	T25

NOTE: KGMS..: Right-hand holder uses right-hand blades.
KGME..: Right-hand holder uses left-hand blades.
M50 blade and clamp screw torque equals 8–10 Nm (71–88 in. lbs.).
M65 blade and clamp screw torque equals 18–20 Nm (159–177 in. lbs.).

- Best-in-class KM Quick-Change platform.
- Through the pocket coolant capable.
- Interchangeable blades for versatility and depth of cut.






Right Hand

KM QUICK CHANGE

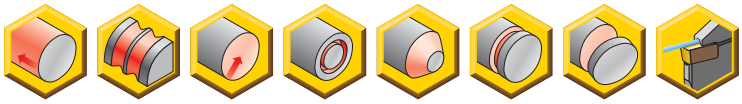
Modular End Mount KM System with Coolant • Metric

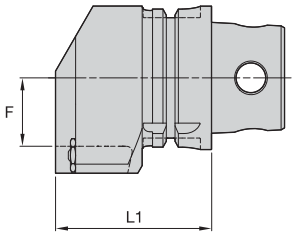


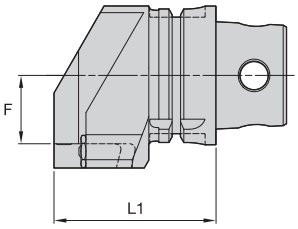

order number	catalogue number	CSMS system size	L1	F	blade size	blade screw	Torx	clamp screw	Torx
right hand									
5999788	**KM40TSKGMER50C**	KM40TS	28,0	20,50	50	**MS1162**	T25	**MS2002**	T25
5999862	**KM50TSKGMER50C**	KM50TS	38,0	25,50	50	**MS1162**	T25	**MS2002**	T25
6000410	**KM50TSKGMER65C**	KM50TS	47,0	25,50	65	**MS1163**	T30	**–**	–
6000425	**KM63TSKGMER65C**	KM63TS	47,0	32,52	65	**MS1163**	T30	**–**	–
5999946	**KM63TSKGMER50C**	KM63TS	48,0	32,50	50	**MS1162**	T25	**MS2002**	T25
6000434	**KM63XMZKGMER65CY**	KM63XMZ	47,0	32,50	65	**MS1163**	T30	**–**	–
5999950	**KM63XMZKGMER50CY**	KM63XMZ	48,0	32,50	50	**MS1162**	T25	**MS2002**	T25
6017697	**KM80ATCKGMER65C**	KM80ATC	57,0	40,50	65	**MS1163**	T30	**–**	–
6000016	**KM80ATCKGMER50C**	KM80ATC	58,0	40,50	50	**MS1162**	T25	**MS2002**	T25
6017693	**KM80TSKGMER65C**	KM80TS	57,0	40,50	65	**MS1163**	T30	**–**	–
6000012	**KM80TSKGMER50C**	KM80TS	58,0	40,50	50	**MS1162**	T25	**MS2002**	T25
left hand									
5999789	**KM40TSKGMEL50C**	KM40TS	28,0	20,50	50	**MS1162**	T25	**MS2002**	T25
5999863	**KM50TSKGMEL50C**	KM50TS	38,0	25,50	50	**MS1162**	T25	**MS2002**	T25
6000421	**KM50TSKGMEL65C**	KM50TS	47,0	25,50	65	**MS1163**	T30	**–**	–
6000430	**KM63TSKGMEL65C**	KM63TS	47,0	32,52	65	**MS1163**	T30	**–**	–
5999947	**KM63TSKGMEL50C**	KM63TS	48,0	32,50	50	**MS1162**	T25	**MS2002**	T25
6000436	**KM63XMZKGMELF65CY**	KM63XMZ	47,0	32,50	65	**MS1163**	T30	**–**	–
5999971	**KM63XMZKGMELF50CY**	KM63XMZ	48,0	32,50	50	**MS1162**	T25	**MS2002**	T25
6017698	**KM80ATCKGMEL65C**	KM80ATC	57,0	40,50	65	**MS1163**	T30	**–**	–
6000017	**KM80ATCKGMEL50C**	KM80ATC	58,0	40,50	50	**MS1162**	T25	**MS2002**	T25
6017694	**KM80TSKGMEL65C**	KM80TS	57,0	40,50	65	**MS1163**	T30	**–**	–
6000013	**KM80TSKGMEL50C**	KM80TS	58,0	40,50	50	**MS1162**	T25	**MS2002**	T25

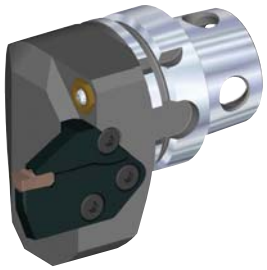
NOTE: KGMS..: Right-hand holder uses right-hand blades.
KGME..: Right-hand holder uses left-hand blades.
M50 blade and clamp screw torque equals 8–10 Nm (71–88 in. lbs.).
M65 blade and clamp screw torque equals 18–20 Nm (159–177 in. lbs.).

- Through the pocket coolant capable.
- Interchangeable blades for versatility and depth of cut.









Right Hand

Modular Straight KM4X™ System with Coolant

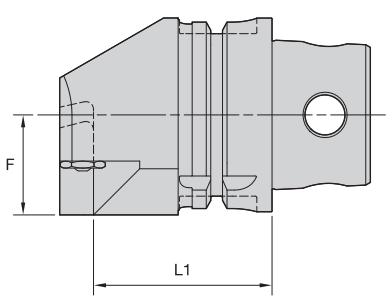


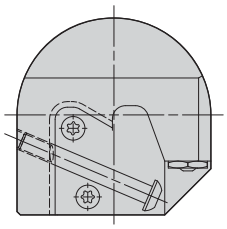


order number	catalogue number	CSMS system size	L1	F	blade size	blade screw	Torx	clamp screw	Torx
right hand									
5543560	**KM4X63KGMSR65C**	KM4X63	68,5	30,0	65	**MS1163**	T30	**–**	–
6000407	**KM4X63KGMSR50C**	KM4X63	73,5	31,0	50	**MS1162**	T25	**MS2002**	T25
left hand									
5543558	**KM4X63KGMSL65C**	KM4X63	68,5	30,0	65	**MS1163**	T30	**–**	–
6000408	**KM4X63KGMSL50C**	KM4X63	73,5	31,0	50	**MS1162**	T25	**MS2002**	T25

NOTE: KGMS..: Right-hand holder uses right-hand blades.
KGME..: Right-hand holder uses left-hand blades.
M50 blade and clamp screw torque equals 8–10 Nm (71–88 in. lbs.).
M65 blade and clamp screw torque equals 18–20 Nm (159–177 in. lbs.).



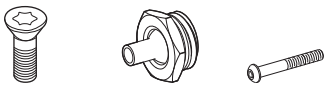






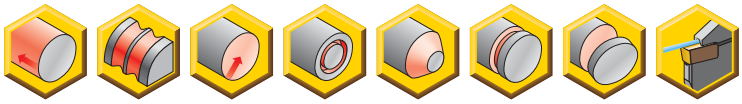
Right Hand

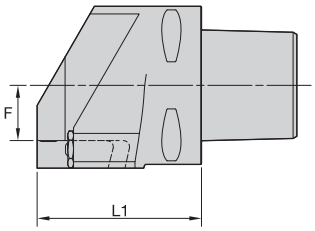
Modular End Mount KM4X™ System with Coolant

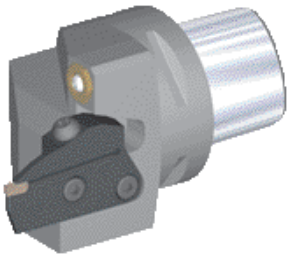


order number	catalogue number	CSMS system size	L1	F	cartridge size	blade screw	nozzle	clamp screw	kg	lbs
right hand										
5543555	**KM4X63KGMER65C**	KM4X63	57,0	32,5	65	**MS1163**	**PMT04525**	**–**	1,87	4.13
6000404	**KM4X63KGMER50C**	KM4X63	58,0	32,5	50	**MS1162**	**PMT04525**	**MS2002**	1,85	4.08
6000407	**KM4X63KGMSR50C**	KM4X63	73,5	31,0	50	**MS1162**	**PMT04525**	**MS2002**	1,86	4.11
left hand										
5543553	**KM4X63KGMEL65C**	KM4X63	57,0	32,5	65	**MS1163**	**PMT04525**	**–**	1,87	4.13
6000405	**KM4X63KGMEL50C**	KM4X63	58,0	32,5	50	**MS1162**	**PMT04525**	**MS2002**	1,85	4.08
6000408	**KM4X63KGMSL50C**	KM4X63	73,5	31,0	50	**MS1162**	**PMT04525**	**MS2002**	1,86	4.11

- Standard PSC Quick-Change platform.
- Through the pocket coolant capable.
- Interchangeable blades for versatility and depth of cut.







Right Hand

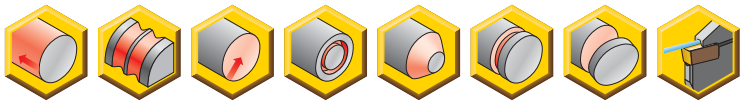
Modular Straight PSC System with Coolant

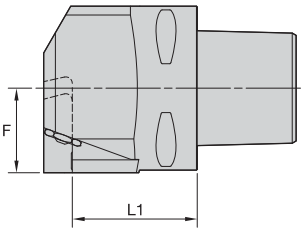


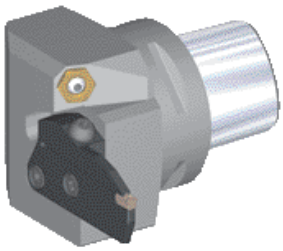


order number	catalogue number	CSMS system size	L1	F	blade size	blade screw	Torx	clamp screw	Torx
right hand									
6000028	**PSC40KGMSR50C**	PSC40	63,5	10,0	50	**MS1162**	T25	**MS2002**	T25
5405654	**PSC50KGMSR65C**	PSC50	49,0	25,5	65	**MS1163**	T30	**–**	–
6000152	**PSC50KGMSR50C**	PSC50	63,5	15,0	50	**MS1162**	T25	**MS2002**	T25
6000464	**PSC63KGMSR65C**	PSC63	60,5	21,0	65	**MS1163**	T30	**–**	–
6000211	**PSC63KGMSR50C**	PSC63	65,5	22,0	50	**MS1162**	T25	**MS2002**	T25
6000468	**PSC80KGMSR65C**	PSC80	68,5	29,0	65	**MS1163**	T30	**–**	–
6000216	**PSC80KGMSR50C**	PSC80	73,5	30,0	50	**MS1162**	T25	**MS2002**	T25
left hand									
6000029	**PSC40KGMSL50C**	PSC40	63,5	10,0	50	**MS1162**	T25	**MS2002**	T25
5405655	**PSC50KGMSL65C**	PSC50	49,0	25,5	65	**MS1163**	T30	**–**	–
6000153	**PSC50KGMSL50C**	PSC50	63,5	15,0	50	**MS1162**	T25	**MS2002**	T25
6000465	**PSC63KGMSL65C**	PSC63	60,5	21,0	65	**MS1163**	T30	**–**	–
6000213	**PSC63KGMSL50C**	PSC63	65,5	22,0	50	**MS1162**	T25	**MS2002**	T25
6000469	**PSC80KGMSL65C**	PSC80	68,5	29,0	65	**MS1163**	T30	**–**	–
6000217	**PSC80KGMSL50C**	PSC80	73,5	30,0	50	**MS1162**	T25	**MS2002**	T25

- Standard PSC Quick-Change platform.
- Through the pocket coolant capable.
- Interchangeable blades for versatility and depth of cut.







Right Hand

Modular End Mount PSC System with Coolant





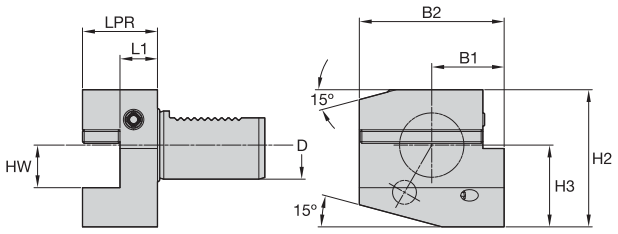
order number	catalogue number	CSMS system size	L1	F	blade size	blade screw	Torx	clamp screw	Torx
right hand									
6000026	**PSC40KGMER50C**	PSC40	33,0	20,5	50	**MS1162**	T25	**MS2002**	T25
6000030	**PSC50KGMER50C**	PSC50	43,0	25,5	50	**MS1162**	T25	**MS2002**	T25
5405652	**PSC50KGMER65C**	PSC50	55,5	22,0	65	**MS1163**	T30	**–**	–
6000159	**PSC63KGMER50C**	PSC63	48,0	32,5	50	**MS1162**	T25	**MS2002**	T25
6000462	**PSC63KGMER65C**	PSC63	49,0	32,5	65	**MS1163**	T30	**–**	–
6000466	**PSC80KGMER65C**	PSC80	57,0	40,5	65	**MS1163**	T30	**–**	–
6000214	**PSC80KGMER50C**	PSC80	58,0	40,5	50	**MS1162**	T25	**MS2002**	T25
left hand									
6000027	**PSC40KGMEL50C**	PSC40	33,0	20,5	50	**MS1162**	T25	**MS2002**	T25
6000151	**PSC50KGMEL50C**	PSC50	43,0	25,5	50	**MS1162**	T25	**MS2002**	T25
5405653	**PSC50KGMEL65C**	PSC50	55,5	22,0	65	**MS1163**	T30	**–**	–
6000160	**PSC63KGMEL50C**	PSC63	48,0	32,5	50	**MS1162**	T25	**MS2002**	T25
6000463	**PSC63KGMEL65C**	PSC63	49,0	32,5	65	**MS1163**	T30	**–**	–
6000467	**PSC80KGMEL65C**	PSC80	57,0	40,5	65	**MS1163**	T30	**–**	–
6000215	**PSC80KGMEL50C**	PSC80	58,0	40,5	50	**MS1162**	T25	**MS2002**	T25

VDI Toolholders



- VDI adaptor with coolant support for square shank toolholder.
- ISO 10889.







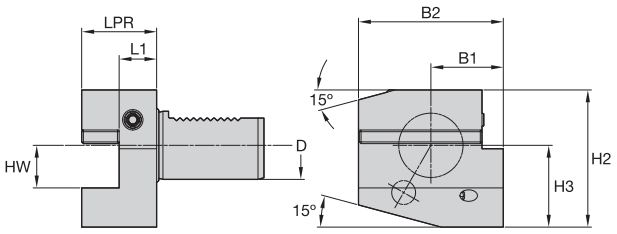
VDI Form B1• HPC • Right Hand Short • Metric

order number	catalogue number	D	B2	B1	HW	H2	H3	L1	LPR
6151491	**VDIB1M302040C**	30,00	70,00	35,00	20,00	66,00	38,00	22,00	40,00
6151492	**VDIB1M402544C**	40,00	85,00	42,50	25,00	80,50	48,00	22,00	44,00

VDI Form B2 • Left Hand Short

- VDI adaptor with coolant support for square shank toolholder.
- ISO 10889.





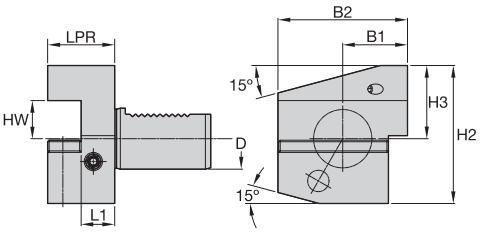


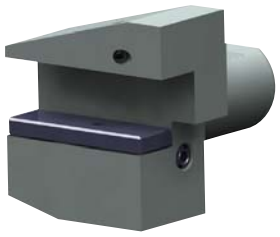
Artwork shows right hand tool.
Left hand tool mirror inverted.

VDI Form B2 • HPC • Left Hand Short • Metric

order number	catalogue number	D	B2	B1	HW	H2	H3	L1	LPR
6151493	**VDIB2M302040C**	30,00	70,00	35,00	20,00	66,00	38,00	22,00	40,00
6151494	**VDIB2M402544C**	40,00	85,00	42,50	25,00	80,50	48,00	22,00	44,00

- VDI adaptor with coolant support for square shank toolholder.
- ISO 10889.



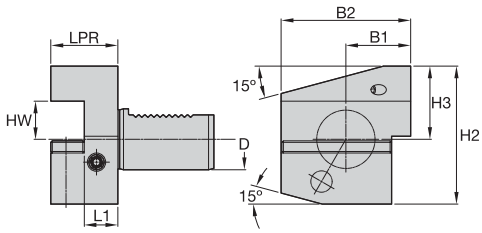


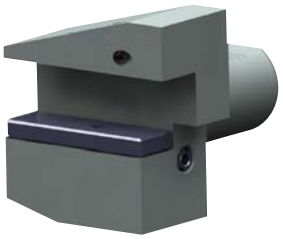
VDI Form B3 • HPC • Right Hand Short Inverted • Metric

order number	catalogue number	D	B2	B1	HW	H2	H3	L1	LPR
6151495	VDIB3M302040C	30,00	70,00	35,00	20,00	73,00	38,00	22,00	40,00
6151497	VDIB3M402544C	40,00	85,00	42,50	25,00	90,50	48,00	22,00	44,00

VDI Form B4 • Left Hand Short Inverted

- VDI adaptor with coolant support for square shank toolholder.
- ISO 10889.





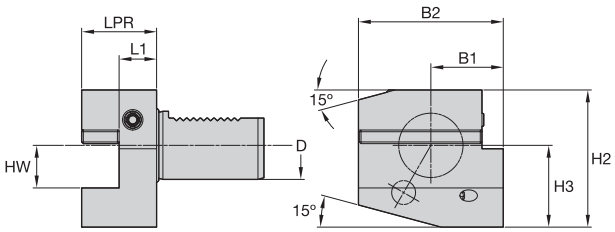
Artwork shows right hand tool.
Left hand tool mirror inverted.

VDI Form B4 • HPC • Left Hand Short Inverted • Metric

order number	catalogue number	D	B2	B1	HW	H2	H3	L1	LPR
6151498	VDIB4M302040C	30,00	70,00	35,00	20,00	73,00	38,00	22,00	40,00
6151499	VDIB4M402544C	40,00	85,00	42,50	25,00	90,50	48,00	22,00	44,00

- VDI adaptor with coolant support for square shank toolholder.
- ISO 10889.







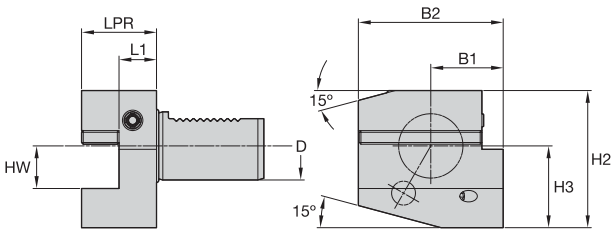
VDI Form B5 • HPC • Right Hand Long • Metric

order number	catalogue number	D	B2	B1	HW	H2	H3	L1	LPR
6151500	VDIB5M302040C	30,00	100,00	65,00	20,00	66,00	38,00	22,00	40,00
6151511	VDIB5M402544C	40,00	118,00	75,50	25,00	80,50	48,00	22,00	44,00

VDI Form B6 • Left Hand Long

- VDI adaptor with coolant support for square shank toolholder.
- ISO 10889.







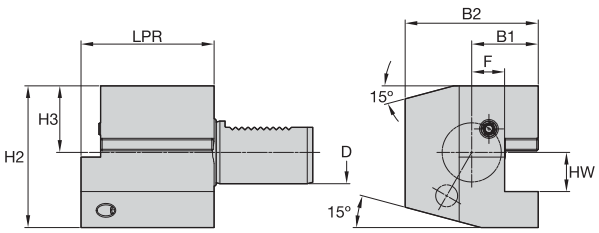
Artwork shows right hand tool.
Left hand tool mirror inverted.

VDI Form B6 • HPC • Left Hand Long • Metric

order number	catalogue number	D	B2	B1	HW	H2	H3	L1	LPR
6151512	VDIB6M302040C	30,00	100,00	65,00	20,00	66,00	38,00	22,00	40,00
6151513	VDIB6M402544C	40,00	118,00	75,50	25,00	80,50	48,00	22,00	44,00

- VDI adaptor with coolant support for square shank toolholder.
- ISO 10889.







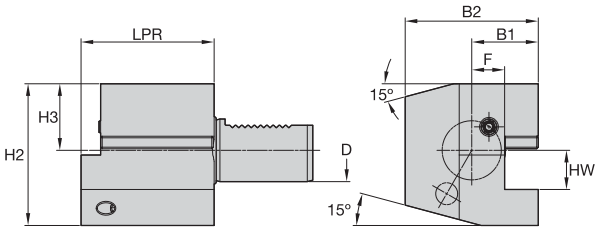
VDI Form C1 • HPC • Right Hand • Metric

order number	catalogue number	D	B2	B1	F	HW	H2	H3	LPR
6151514	**VDIC1M302070C**	30,00	70,00	35,00	17,00	20,00	66,00	38,00	70,00
6151515	**VDIC1M402585C**	40,00	85,00	42,50	21,00	25,00	80,50	48,00	85,00

VDI Form C2 • Left Hand

- VDI adaptor with coolant support for square shank toolholder.
- ISO 10889.







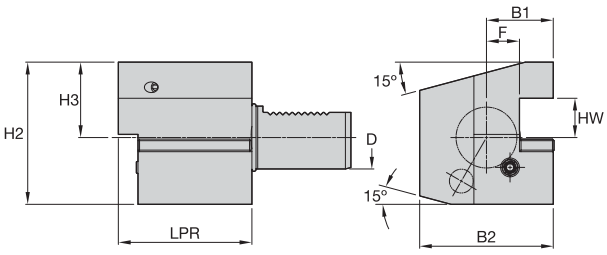
Artwork shows right hand tool.
Left hand tool mirror inverted.

VDI Form C2 • HPC • Left Hand • Metric

order number	catalogue number	D	B2	B1	F	HW	H2	H3	LPR
6151516	**VDIC2M302070C**	30,00	76,00	41,00	23,00	20,00	66,00	38,00	70,00
6151517	**VDIC2M402585C**	40,00	90,00	47,50	25,50	25,00	80,50	48,00	85,00

- VDI adaptor with coolant support for square shank toolholder.
- ISO 10889.





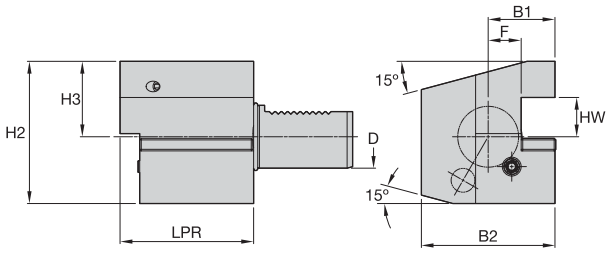


VDI Form C3 • HPC • Right Hand Inverted • Metric

order number	catalogue number	D	B2	B1	F	HW	H2	H3	LPR
6151518	**VDIC3M302070C**	30,00	70,00	35,00	17,00	20,00	73,00	38,00	70,00
6151519	**VDIC3M402585C**	40,00	85,00	42,50	21,00	25,00	90,50	48,00	85,00

- VDI adaptor with coolant support for square shank toolholder.
- ISO 10889.





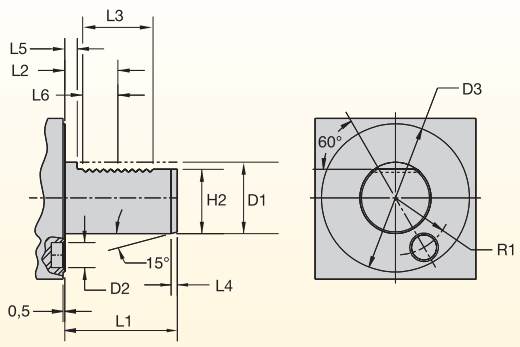


Artwork shows right hand tool.
Left hand tool mirror inverted.

VDI Form C4 • HPC • Left Hand Inverted • Metric

order number	catalogue number	D	B2	B1	F	HW	H2	H3	LPR
6151520	**VDIC4M302070C**	30,00	70,00	35,00	17,00	20,00	73,00	38,00	70,00
6151521	**VDIC4M402585C**	40,00	85,00	42,50	21,00	25,00	90,50	48,00	85,00

Shank Specifications



	D1	D2	D3	L1	L2	L3	L4	L5	L6	H2	R1
30	30,00	14,00	68,00	55,00	29,70	40,00	2,00	7,00	20,00	27,00	25,00
	1.181	0.551	2.677	2.165	1.169	1.575	0.079	0.276	0.787	1.063	0.984
40	40,00	14,00	83,00	63,00	29,70	40,00	3,00	7,00	20,00	36,00	32,00
	1.575	0.551	3.268	2.480	1.169	1.575	0.118	0.276	0.787	1.417	1.260
50	50,00	16,00	98,00	78,00	35,70	48,00	3,00	8,00	24,00	45,00	37,00
	1.969	0.630	3.858	3.071	1.406	1.890	0.118	0.315	0.945	1.772	1.457
60	60,00	16,00	123,00	94,00	43,70	56,00	4,00	10,00	28,00	55,00	48,00
	2.362	0.630	4.843	3.701	1.720	2.205	0.157	0.394	1.102	2.165	1.890

A4™ Tooling and Beyond™ Inserts



Choose A4 tooling for turning, facing, grooving, face grooving, and cut-off applications across a broad range of workpiece materials. The unique clamping system and versatile insert geometry delivers a very high metal removal rate.

FEATURES AND BENEFITS

A4 Grooving and Turning System

- One tool for turning, facing, grooving, face-grooving, and cut-off in O.D. and I.D. applications means exceptionally fast cycle times, no turret indexes!
- Extra-long clamping area, ground 120° bottom prism seating surface, and an exclusive top guide rail combine to deliver unsurpassed grooving and side-turning stability!
- Precise insert positioning is ensured for accurate cuts!
- Rigid clamping securely locks insert in place through the toughest cuts.
- Versatile design enables one system to handle O.D. and I.D. grooving, face grooving, back turning, undercutting, and even threading operations.
- Chip control inserts provide excellent chip evacuation in grooving, and offer better chip control in multidirectional turning.

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

KENNAMETAL®

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beyond™ EVOLUTION™

Connecting the tool to your machine is easy. Just select one of the two available hose packages, and Active Coolant Control will be keeping you cool in no time!

Don't know exactly what you need?

To connect Beyond™ Evolution™ tooling to the industry's most common machines. The Kennametal universal coolant packs are ideal! Each pack contains the most common thread sizes with a variety of fitting styles for maximum flexibility.

Universal 200mm Coolant Pack

order number	catalogue number	quantity	description
6145372	COOL-KIT-101	1	1/16 NPTF male to 7/16 JIC male fitting
		1	1/8 NPTF male to 7/16 JIC male fitting
		1	G1/8 male to 7/16 JIC male fitting
		1	M10 x 1,5 male to 7/16 JIC male fitting
		2	Male JIC to Swivel Female JIC Elbow
		1	200mm Hose Female JIC to Female JIC

Universal 300mm Coolant Pack

order number	catalogue number	quantity	description
6145373	COOL-KIT-201	1	1/16 NPTF male to 7/16 JIC male fitting
		1	1/8 NPTF male to 7/16 JIC male fitting
		1	G1/8 male to 7/16 JIC male fitting
		1	M10 x 1,5 male to 7/16 JIC male fitting
		2	Male JIC to Swivel Female JIC Elbow
		1	300mm Hose Female JIC to Female JIC

Know what you need?

Every component is individually available, including less common fittings.
Knowing the precise components required will allow you to choose only the fittings you need!

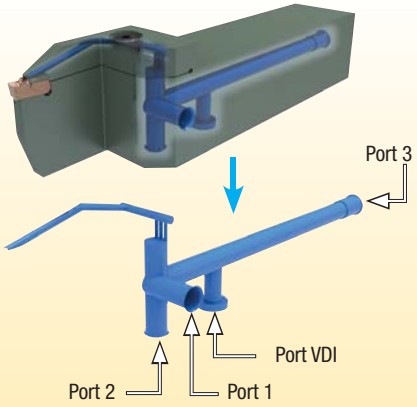
Coolant Hose Accessories

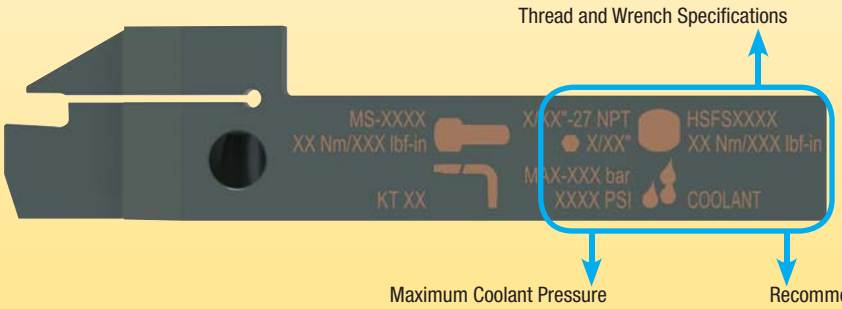
order number	catalogue number	description
6145374	1-16NPTF-JIC	1/16 NPTF male to 7/16 JIC male fitting
6145375	1-8NPTF-JIC	1/8 NPTF male to 7/16 JIC male fitting
6145376	G18-JIC	G1/8 male to 7/16 JIC male fitting
6145377	M10-JIC	M10 x 1,5 male to 7/16 JIC male fitting
6145379	JICM-JICF-ELB	Male JIC to Swivel Female JIC Elbow
6145380	COOL-HOSE-200	200mm Female JIC to Female JIC
6145381	COOL-HOSE-300	300mm Female JIC to Female JIC
6145382	M6-JIC	M6 x 1,0 male to 7/16 JIC male fitting
6145378	M8-JIC	M8 x 1,25 male to 7/16 JIC male fitting
6145383	JICM-JICM-STR	7/16 JIC male to 7/16 JIC male adaptor
6145386	G14-G18-RED	Male G1/4 to Female G1/8 reducer
6432549	COOL-HOSE-200-FLEX	Universal 200mm Flex Coolant Hose
6432550	COOL-HOSE-300-FLEX	Universal 300mm Flex Coolant Hose



Active Coolant Control Guidelines

1. Beyond™ Evolution™ system capable of 350 bar (5076 psi).
2. Toolholder delivered with four entry holes.
3. A quality filtration system is necessary to prevent blockages in the toolholder that will effect coolant flow and performance.
4. Machines without a proper filtering system may require modification or an inline filter.
   - For pressure >70 bar [1015 psi], use 10–20 µm filter.
   - For pressure <70 bar [1015 psi], 50–100 µm.
   - Using fine filters in low-pressure applications may affect flow rate.





General Safety Guidelines

1. All safety doors and mechanisms must be in place before trying out the internal coolant to avoid any danger to the operator in the event of a failure.
2. Use the correct pipe fittings to connect the holders to the system. Ensure the maximum pressure recommended for the fittings are not exceeded.
3. While implementing pressure >80 bar [1160 psi], increase the pressure in steps to ensure proper functioning of insert clamping and leak-free joints.
4. While indexing inserts, ensure the pocket is free from chips and/or dirt. Also, inspect the insert and make sure there are no blockages in the coolant canal.
5. Periodically check all hoses and fittings for damage and wear for proper functioning of the system. This check should also include filters.

Active Coolant Control Performance

Internal coolant offers a clear advantage in tool life and chip forming/evacuation vs. external coolant in difficult conditions and in high-pressure coolant.
Example: Chipbreaking in plunging of steel.

Flood Coolant | Internal Coolant



75 bar
(1,087 psi)

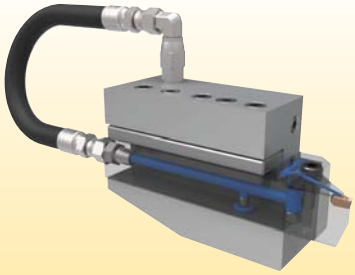
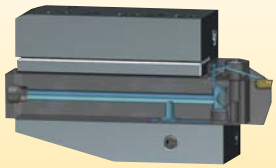
200 bar
(2,900 psi)

Material steel ST52;
Insert size 6mm; f = 0,25 mm/U

Low Pressure — If performance is at risk due to low coolant pressure, apply internal coolant in combination with external coolant to increase volume.

Recommendation to improve tool life and/or productivity: Apply high pressure coolant: 80–350 bar recommended.

VDI Assemblies
The Beyond™ Evolution™ Active Coolant Control can be leveraged with VDI holding systems with both traditional or Quick-Change coolant connections.

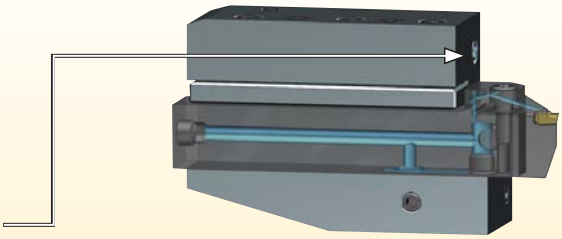




Coolant flow transfer from VDI adaptor to toolholder

A marker on the toolholder must remain within the coolant range indicated on the VDI system for uninterrupted coolant transfer.

Technical Details

Pressure limit 80 bar.



Nozzle set comes pre-assembled.
For the holder application with internal coolant only nozzle can be plugged by M5 screw (delivered). Use Loc Tite light, medium strength, or thread sealant.

Holder	Slide Area	Max. Pressure	Torque (Pressure Screws)
VDI 30	22mm	80 bar	20 Nm
VDI 40	30mm	80 bar	35 Nm

Spare sets	
Nozzle	**PKGNLAL 1205M**
Set Pressure Screw, Pressure Plate, Spring	See separately for each type in BOM

A4™ Tooling and Beyond™ Inserts

For All Your O.D. and I.D. Applications

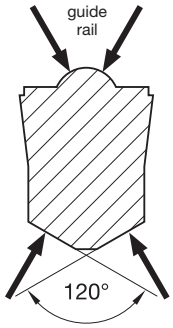
Primary Application

Choose A4 tooling for turning, facing, grooving, face grooving, and cut-off applications across a broad range of workpiece materials. The unique clamping system and versatile insert geometry delivers a very high metal removal rate.

Features and Benefits

A4 Grooving and Turning System

- One tool for turning, facing, grooving, face-grooving, and cut-off in O.D. and I.D. applications means exceptionally fast cycle times, no turret indexes!
- Extra-long clamping area, ground 120° bottom prism seating surface, and an exclusive top guide rail combine to deliver unsurpassed grooving and side-turning stability!
- Precise insert positioning is ensured for accurate cuts!
- Rigid clamping securely locks insert in place through the toughest cuts.
- Versatile design enables one system to handle O.D. and I.D. grooving, face grooving, back turning, undercutting, and even threading operations.
- Chip control inserts provide excellent chip evacuation in grooving, and offer better chip control in multidirectional turning.



A4 Chipbreakers


GMN Chipbreaker


GMP Chipbreaker


GMN Chipbreaker


GMP Chipbreaker


GUP Chipbreaker





The A4™ System Increases Productivity

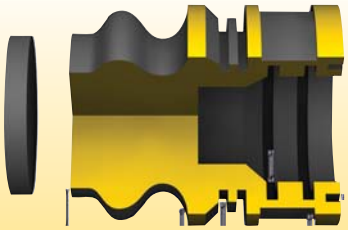
- Covers multiple applications.
- Reduces tool cost.
- Minimises machining time.







Step 1 • Select A4 size for grooving and turning application



What you need to know:

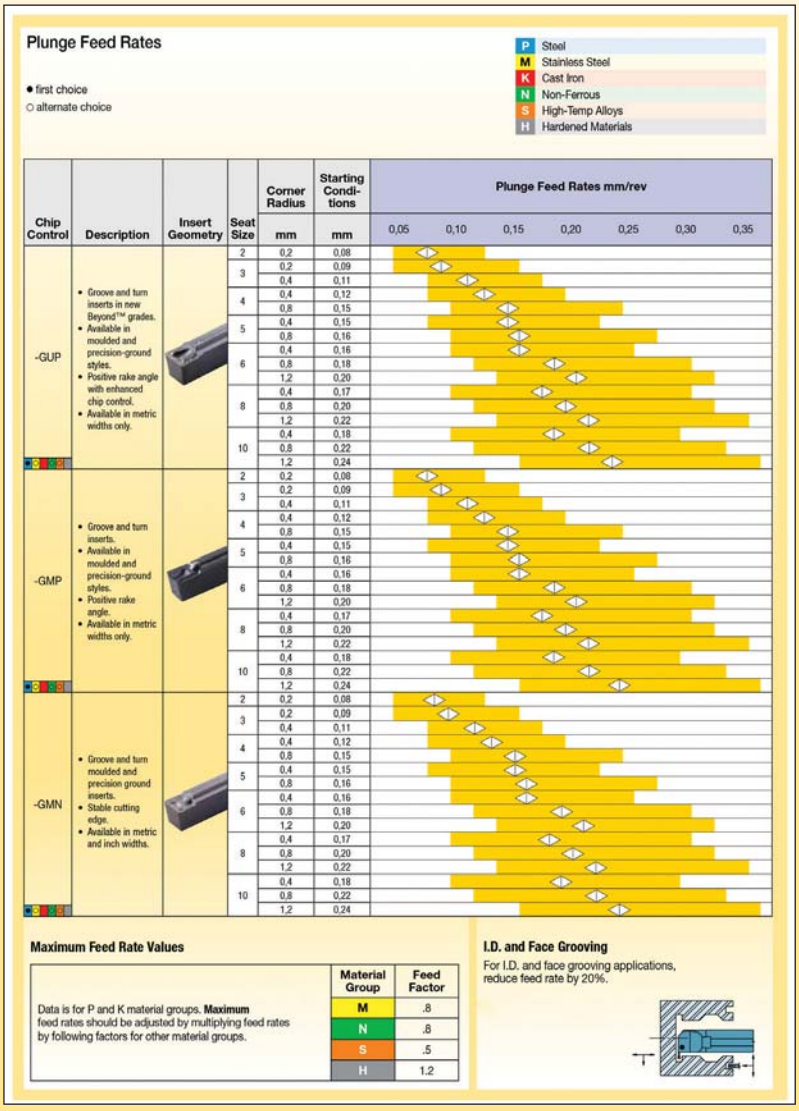
- Groove depth, width, and profile.
- Material being machined.
- Application to be performed (O.D. and I.D. grooving, turning, face grooving, and cut-off).

General Recommendation to Select the Insert Size

for workpiece diameters	insert seat size
<25mm	3
25–50mm	4
>50mm	5–10

Step 2 • Select chipbreaker style and feed rate

Based on the application and seat size, determine the recommended geometry and starting feed rate.



Step 3 • Select the starting speed

Based on material and grade, identify starting speed (vc). First choice is in **bold** type.

A Based on material group and grade, identify starting speed (vc).
B First choice starting speed is in **bold**.

Recommended Starting Speeds [m/min]

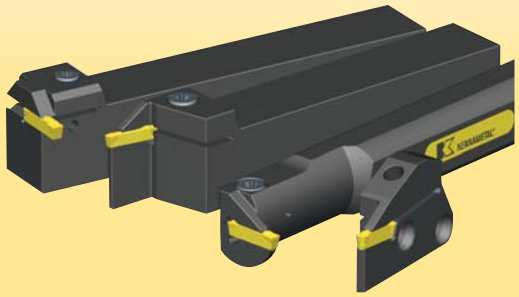
Material Group		K313			KCU10/KC5010			KCU25/KC5025			KCP10			KCP25			KCK20B			KY3500		
P	0-1	–	–	–	140	**280**	335	110	**225**	270	185	**400**	450	145	**290**	365	200	**440**	490	–	–	–
	2	–	–	–	140	**200**	245	110	**160**	195	185	**270**	350	145	**200**	305	200	**300**	380	–	–	–
	3	–	–	–	140	**155**	245	110	**125**	195	170	**190**	260	140	**155**	245	600	**200**	280	–	–	–
	4	–	–	–	75	**110**	170	60	**90**	135	90	**145**	200	75	**110**	180	100	**160**	220	–	–	–
	5	–	–	–	120	**200**	260	100	**160**	210	150	**220**	305	120	**200**	270	165	**240**	330	–	–	–
	6	–	–	–	110	**150**	230	85	**120**	185	120	**180**	275	110	**150**	230	130	**190**	300	–	–	–
M	1	60	**90**	120	140	**210**	260	90	**170**	245	–	–	–	–	–	–	–	–	–	–	–	–
	2	45	**75**	110	120	**200**	245	90	**150**	245	–	–	–	–	–	–	–	–	–	–	–	–
	3	35	**65**	100	120	**180**	245	90	**140**	210	–	–	–	–	–	–	–	–	–	– A	–	–
K	1	30	**75**	120	120	**180**	245	100	**145**	195	170	**245**	440	140	**200**	360	210	**305**	550	180	**760**	1040
	2	25	**70**	110	90	**150**	210	70	**120**	170	120	**195**	340	100	**160**	280	150	**245**	430	275	**365**	500
	3	20	**60**	90	60	**110**	150	50	**85**	120	120	**170**	270	100	**140**	220	150	**210**	335	–	–	–
N	1–2	150	**370**	610	150	**550**	975	120	**440**	780	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	B	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	120	**275**	430	120	**365**	610	100	**290**	490	–	–	–	–	–	–	–	–	–	–	–	–
	5	45	**90**	150	90	**170**	245	70	**135**	195	–	–	–	–	–	–	–	–	–	–	–	–
	6	40	**75**	150	120	**210**	305	100	**170**	245	–	–	–	–	–	–	–	–	–	–	–	–
S	1	8	**30**	75	15	**55**	135	8	**40**	60	–	–	–	–	–	–	–	–	–	–	–	–
	2	8	**35**	75	15	**60**	135	8	**30**	75	–	–	–	–	–	–	–	–	–	–	–	–
	3	8	**40**	75	15	**70**	135	15	**40**	75	–	–	–	–	–	–	–	–	–	–	–	–
	4	8	**45**	75	15	**70**	170	8	**50**	110	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	30	**45**	60	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	15	**30**	45	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Step 4 • Select toolholder based on application

Choose the high-performance holder based on your specific grooving or cut-off application, with the corresponding seat size.

	conventional toolholders	modular blades
O.D. Grooving, Cut-Off, and Turning	1st Choice	2nd Choice
Face Grooving	1st Choice	2nd Choice
I.D. Grooving, Cut-Off, and Turning	1st Choice	—

NOTE: Insert seat size must match the seat size of the toolholder.



Step 5 • Select the insert and holder from catalogue page

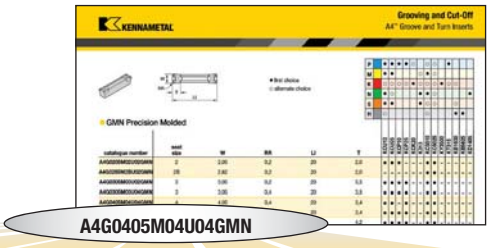


Congratulations!

You have successfully maximised your productivity by selecting the best insert geometry, grade, and cutting specifications for your application!

How Do Catalogue Numbers Work?

Each character in our catalog number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



A4G0405M04U04GMN

Grooving and Turning Inserts

A4	G	0405	M	04	U	04	GMN
Tooling System	Insert Type	Groove Width	Unit of Measurement for Grooving Width	Seat Size	Insert Tolerance	Corner Radii	Chipbreaker Type/Edge Prep
A4 = Grooving and Turning	**G** = Square **R** = Full radius **C** = Cut-off	Expressed in 1/100mm or .00"	**M** = Metric				

pocket seat size	cutting width (mm)
02	2,00–2,62
2B	2,39–2,62
03	3,0–3,05
04	4,0–4,05
05	5,0–5,05
06	6,0–6,05
08	8,0–8,05
10	10,0–10,05
2S	2,00–2,62
3S	3,00–3,05
4S	4,00–4,05
5S	5,00–5,05

P = Precision ground grooving width tolerance:
± .001" (0,025mm)

U = Utility moulded grooving width tolerance:
3,05–4,05: +0,15mm / -0
5,05–10,05: +0,25mm / -0

metric
01 = 0,1
02 = 0,2
04 = 0,4
08 = 0,8
12 = 1,2
full radius = 00

GMN =
Grooving and turning medium machining stable cutting edge

GMP =
Grooving and turning medium machining positive rake angle

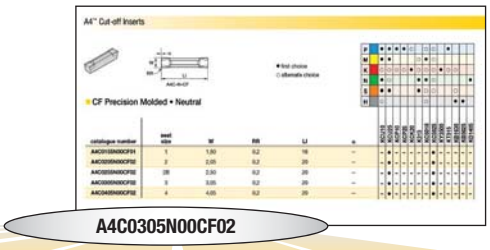
GUP =
Grooving and turning high positive geometry. Especially in stainless steels and high-temp alloys

B =
Flat top for special forms and applications

E =
Flat top, slight honed edge

S =
Negative land plus hone

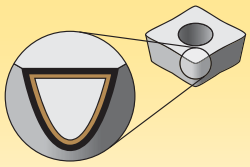
ST =
Single tip



A4C0305N00CF02

Grooving and Cut-Off

A4	C	0305	N	00	CF	02
Tooling System	Insert Type	Cutting Width	Hand of Insert	Main Cutting Edge Lead Angle	Chipbreaker Type	Corner Radius
A4 = Grooving and Turning	**C** = Cut-off	Expressed in 1/100mm	**R** = Right hand **L** = Left hand **N** = Neutral	**00** = Neutral **06** = 6° **10** = 10°	**CF** = Cut-off fine positive rake	metric 02 = 0,2

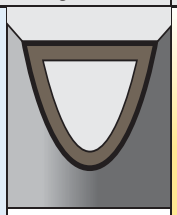
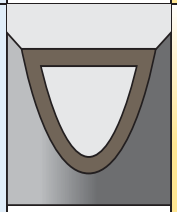
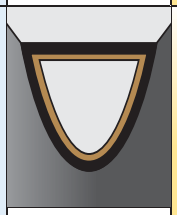
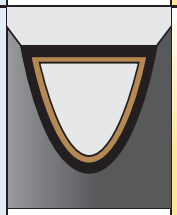
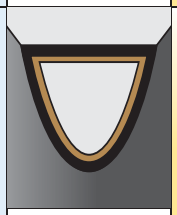


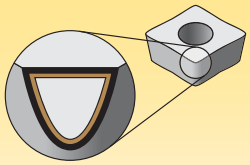
Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

wear resistance ← → toughness

Grades

Coating	Grade Description	05	10	15	20	25	30	35	40	45
KCU10  —	**Composition:** An advanced multilayer PVD coating over a very deformation-resistant unalloyed carbide substrate. The new and improved coating improves edge stability with wide range speed and feed capabilities. **Application:** The KCU10™ grade is ideal for finishing to general machining of most workpiece materials at a wide range of speed and feed capabilities. Excellent for machining most steels, stainless steels, cast irons, non-ferrous materials, and high-temp alloys with improved edge toughness, notch resistance, and higher cutting speed/feed capability.	P	P	P	P					
		M								
		K	K	K	K					
		N								
		S								
		H								
		beyond								
KCU25  —	**Composition:** An advanced PVD grade with hard AlTiN coating and fine-grain unalloyed substrate. The new and improved coating improves edge stability with wide range speed and feed capabilities. **Application:** The KCU25™ grade is ideal for general machining of most steels, stainless steels, high-temp alloys, titanium, irons, and non-ferrous materials in a wide range of speeds and feeds with improved edge toughness for interrupted cut and high feed rates.	P			P	P	P			
		M			M	M	M			
		K			K	K	K			
		N			N	N	N			
		S			S	S	S			
		beyond								
KCP10  —	**Composition:** A specially engineered cobalt-enriched carbide grade with thick MTCVD TiCN-Al_2O_3 coating for maximum wear resistance. **Application:** An excellent finishing to medium machining grade for a variety of workpiece materials, including most steels, ferritic, martensitic, and PH stainless steels, and cast irons. The cobalt-enriched substrate offers a balanced combination of deformation resistance and edge toughness, while the thick coating layers offer outstanding abrasion resistance and crater wear resistance for high-speed machining. Smooth coating provides resistance to edge build-up and microchipping and produces excellent surface finishes.	P	P	P	P					
		K					K	K	K	
		beyond								
KCP25  –	**Composition:** A tough cobalt-enriched carbide grade with a multilayer MTCVD TiCN-Al_2O_3 coating with superior interlayer adhesion. **Application:** Best general-purpose turning grade for most steels and ferritic and martensitic stainless steels. The substrate design ensures adequate deformation resistance with excellent insert edge strength. Coating layers offer good wear resistance over a wide range of machining conditions and the post-coat treatment minimises microchipping and improves coating adhesion to substrate leading to long tool life and improved workpiece finishes.	P	P	P	P	P	P			
		K					K	K	K	
		beyond								
KCK20  —	**Composition**: A specially toughened MTCVD TICN-Al_2O_3 coating over a wear-resistant substrate. **Application:** Specifically engineered to maximise coating adhesion and edge strength making this grade ideal in wet interrupted cutting of grey and ductile irons. It can be used in a wide range of applications from finishing to roughing to maximise productivity wherever strength and reliability are needed.	P	P	P						
		K		K	K	K	K			
		beyond								



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wear resistance ⟷ toughness

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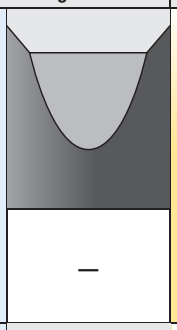
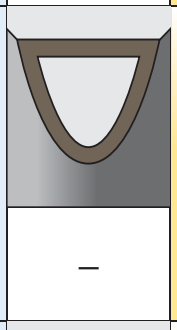
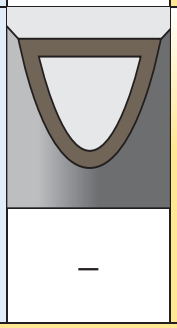
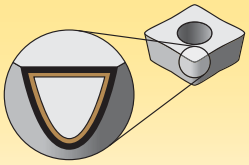
Coating	Grade Description	05	10	15	20	25	30	35	40	45
K313 	**Composition:** A hard, low binder content, unalloyed WC/Co fine-grain grade. **Application:** Exceptional edge wear resistance combined with very high strength for machining titanium, cast irons, austenitic stainless steels, non-ferrous metals, non-metals, and most high-temp alloys. Superior thermal deformation and depth-of-cut notch resistance. The grain structure is well controlled for minimal pits and flaws, which contributes to long, reliable service.									
KC5010 	**Composition:** An advanced PVD AlTiN coating over a very deformation-resistant unalloyed carbide substrate. **Application:** The KC5010™ grade is ideal for finishing to general machining of most workpiece materials at higher speeds. Excellent for machining most steels, stainless steels, cast irons, non-ferrous materials, and high-temp alloys under stable conditions. It also performs well machining hardened and short chipping materials.									
KC5025 	**Composition:** An advanced PVD-AlTiN-coated grade with a tough, ultra-fine-grain unalloyed substrate. **Application:** For general-purpose machining of most steels, stainless steels, high-temp alloys, titanium, irons, and non-ferrous materials. Speeds may vary from low to medium and will handle interruptions and high feed rates.									



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

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

wear resistance ← → toughness

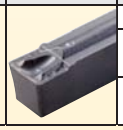
Grades

Coating	Grade Description	05	10	15	20	25	30	35	40	45
KY3500	**Composition:** Pure silicon nitride grade. **Application:** Maximum toughness. Used at high feed rates for rough machining of grey cast iron, including machining through interruptions.									
KT315	**Composition:** A multilayer PVD TiN/TiCN/TiN-coated cermet turning grade. **Application:** Ideal for high-speed finishing to medium machining of most carbon and alloy steels and stainless steels. Performs very well in cast and ductile iron applications, too. Provides long and consistent tool life and will produce excellent workpiece finishes.									
KB1630	**Composition:** An uncoated high content PcBN grade. PcBN tips are brazed onto a carbide insert. **Application:** Designed for roughing to finishing in interrupted cuts on hardened steels (>45 HRC). It can also be applied on grey cast iron, chilled irons, high chrome alloyed steels, high temp alloys and sintered powder metals. The tipped PcBN inserts are available in a wide range of insert styles, including Top Notch™ and Screw-On geometries.									
KB5625	**Composition:** A medium content PcBN with a PVD-TiN/AlTiN coating for added wear resistance. **Application:** Designed for roughing to finishing of hardened steels (>45 HRC). Use on bearing steels, hot and cold work steels, die steels, case hardened steels, carburised and nitrided irons, and some hard coatings.									
KD1405	**Composition:** A pure CVD-deposited diamond-sheet tool brazed directly to a carbide substrate. **Application:** KD1405™ is the best Kennametal abrasion-resistant tool material for non-ferrous and non-metallic materials. Best applied when abrasion resistance is the desired benefit.									

Select the geometry

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

● first choice
○ alternate choice

Chip Control	Description	Insert Geometry	Seat Size	Corner Radius mm	Starting Conditions mm	Plunge Feed Rates mm/rev 0,05 0,10 0,15 0,20 0,25 0,30 0,35
-GUP	Groove and turn inserts in new Beyond™ grades.		2	0,2	0,08	
			3	0,2	0,09	
				0,4	0,11	
			4	0,4	0,12	
				0,8	0,15	

Pictorial View of Insert

Corner Radius

Recommended Starting Feed Rate

Plunge Feed Rates

Seat Size

Recommended Feed Rate Range

Primary Workpiece Material Group

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

● first choice
○ alternate choice

Chip Control Geometry Designation

Maximum Feed Rate Values

	Material Group	Feed Factor
Data above is for P and K material groups. **Maximum** feed rates should be adjusted by multiplying max feed rate values by following factors for shown material groups.	M	.8
	N	1.2
	S	.8
	H	.5

Plunge Feed Rates

● first choice
○ alternate choice

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

Chip Control	Description	Insert Geometry	Seat Size	Corner Radius mm	Starting Conditions mm	Plunge Feed Rates mm/rev 0,05 0,10 0,15 0,20 0,25 0,30 0,35
-GUP	• Groove and turn inserts in new Beyond™ grades. • Available in moulded and precision-ground styles. • Positive rake angle with enhanced chip control. • Available in metric widths only.		2	0,2	0,08	
			3	0,2	0,09	
				0,4	0,11	
			4	0,4	0,12	
				0,8	0,15	
			5	0,4	0,15	
				0,8	0,16	
			6	0,4	0,16	
				0,8	0,18	
				1,2	0,20	
			8	0,4	0,17	
				0,8	0,20	
				1,2	0,22	
			10	0,4	0,18	
				0,8	0,22	
				1,2	0,24	
-GMP	• Groove and turn inserts. • Available in moulded and precision-ground styles. • Positive rake angle. • Available in metric widths only.		2	0,2	0,08	
			3	0,2	0,09	
				0,4	0,11	
			4	0,4	0,12	
				0,8	0,15	
			5	0,4	0,15	
				0,8	0,16	
			6	0,4	0,16	
				0,8	0,18	
				1,2	0,20	
			8	0,4	0,17	
				0,8	0,20	
				1,2	0,22	
			10	0,4	0,18	
				0,8	0,22	
				1,2	0,24	
-GMN	• Groove and turn moulded and precision ground inserts. • Stable cutting edge. • Available in metric and inch widths.		2	0,2	0,08	
			3	0,2	0,09	
				0,4	0,11	
			4	0,4	0,12	
				0,8	0,15	
			5	0,4	0,15	
				0,8	0,16	
			6	0,4	0,16	
				0,8	0,18	
				1,2	0,20	
			8	0,4	0,17	
				0,8	0,20	
				1,2	0,22	
			10	0,4	0,18	
				0,8	0,22	
				1,2	0,24	

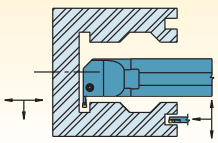
Maximum Feed Rate Values

Data above is for P and K material groups. **Maximum** feed rates should be adjusted by multiplying max feed rate values by following factors for shown material groups.

Material Group	Feed Factor
M	.8
N	.8
S	.5
H	1.2

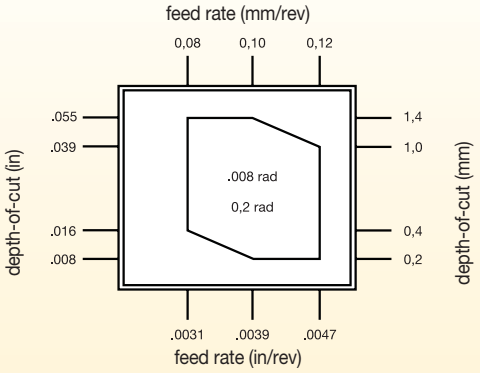
I.D. and Face Grooving

For I.D. and face grooving applications, reduce feed rate by 20%.

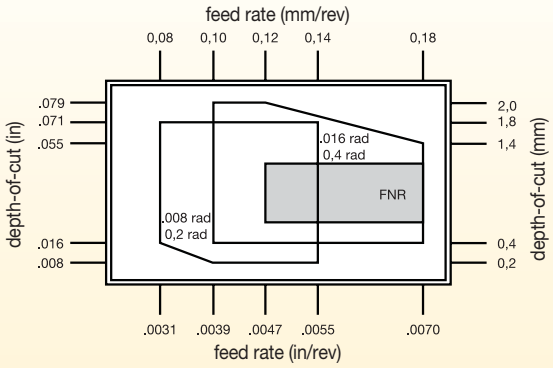


Turn and profile feed rates • GUP/GMP Geometries

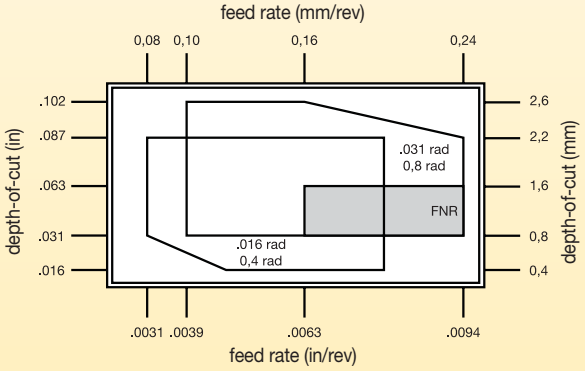
Seat Size 2



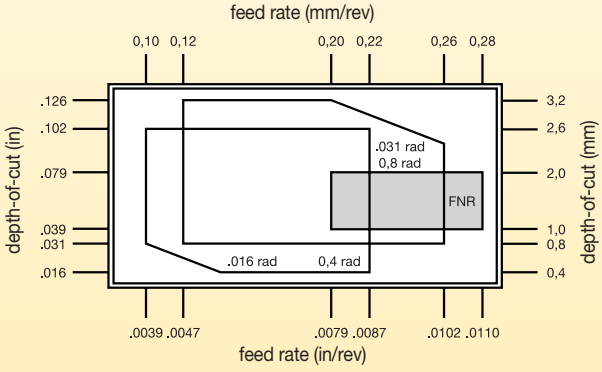
Seat Size 3



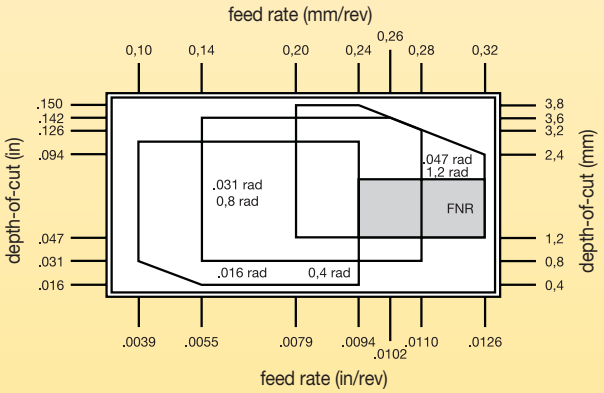
Seat Size 4



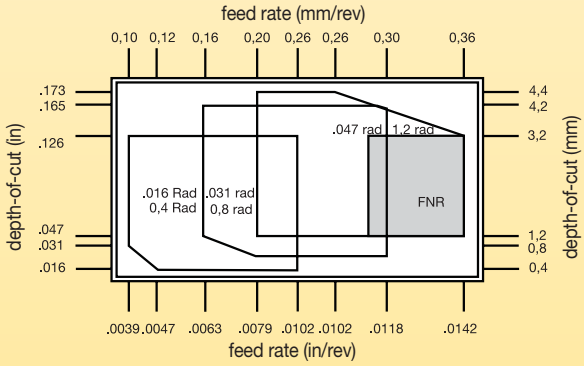
Seat Size 5



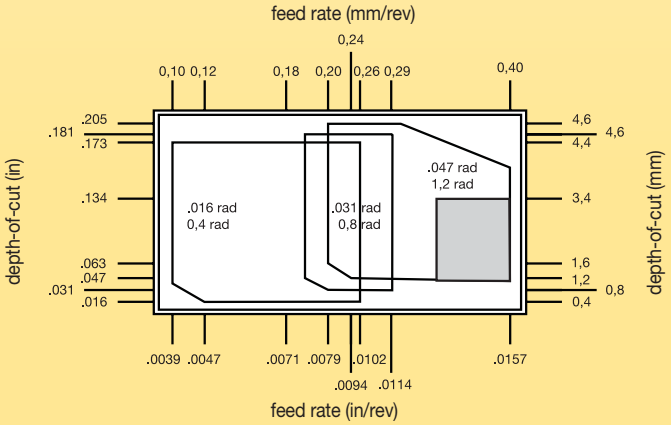
Seat Size 6



Seat Size 8

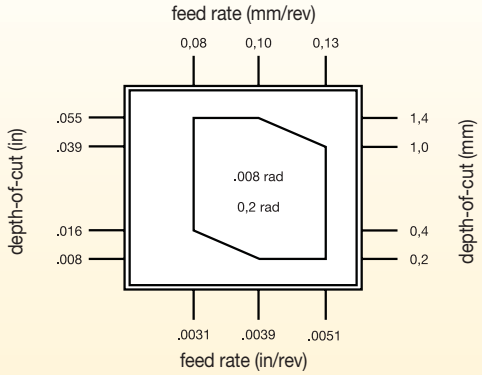


Seat Size 10

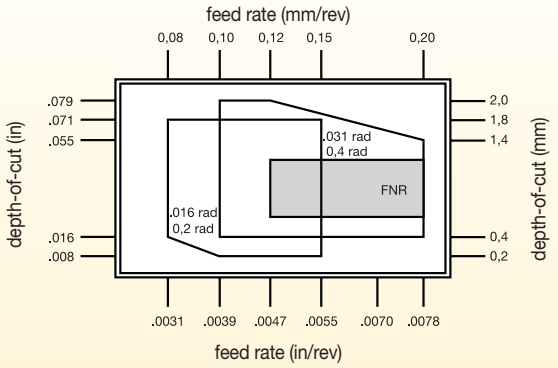


Turn and profile feed rates • GMN Geometries

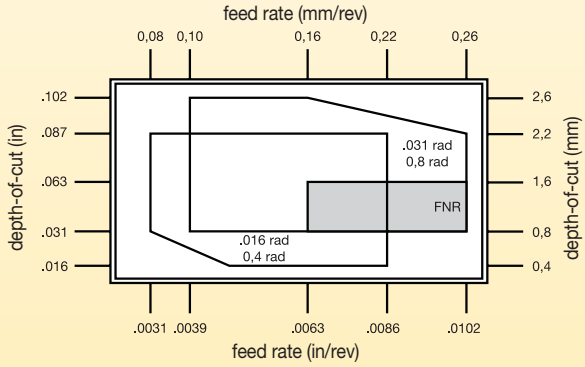
Seat Size 2



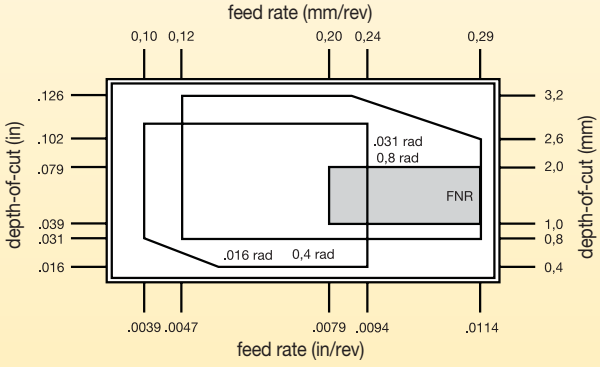
Seat Size 3



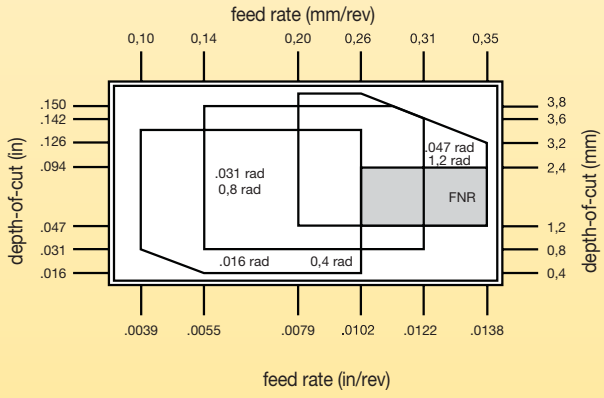
Seat Size 4



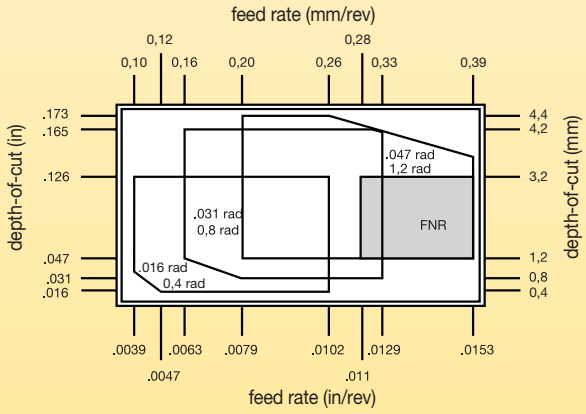
Seat Size 5



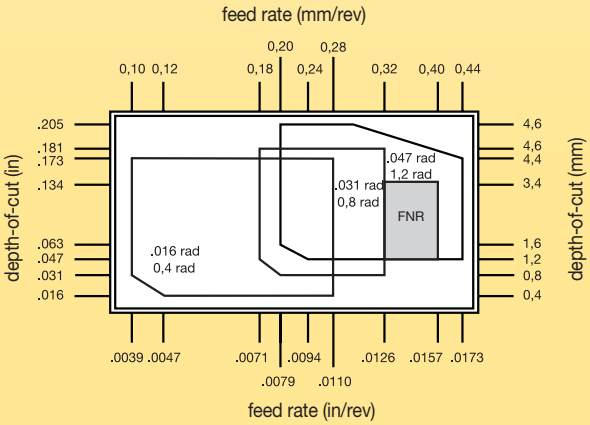
Seat Size 6



Seat Size 8



Seat Size 10



Cut-Off Feed Rates

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

● first choice
○ alternate choice

Chip Control	Description	Insert Geometry	Seat Size	Starting Conditions mm	Cut-Off Feed Rates mm/rev 0,05 0,10 0,15 0,20
-A4C-CF	• High positive rake angle. • Sharp cutting edge. • Available in neutral lead angle in 6° and 10° right- and left-hand styles.		1	0,06	
			2/2B	0,07	
			3	0,09	
			4	0,11	

Maximum Feed Rate Values

Data above is for P and K material groups. **Maximum** feed rates should be adjusted by multiplying max feed rate values by following factors for shown material groups.

Material Group	Feed Factor
M	.8
N	.8
S	.5
H	1.2

Mobile Apps

The Kennametal mobile app provides easy access to product information and calculators on both iPhone® and Android™ devices. We've highlighted a few of the key features...

There's an app for that.



SPEEDS & FEEDS

View speeds and feeds information for metalworking products.

PRODUCT AVAILABILITY

Check global availability of products. View available quantities by providing your Konnect login credentials.

CALCULATORS

Utilise our machining calculators for milling and drilling applications.

By just scanning the bar code on the insert packet, you can find the most productive cutting conditions for tool life, process time, and chip control.

NOTE: The app is currently only available in the English-language version. We have plans to translate the app in different languages with future releases.

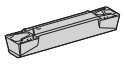
Google play | Available on the App Store

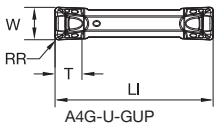
Recommended Starting Speeds [m/min]

Material Group		K313			KCU10/KC5010			KCU25/KC5025			KCP10			KCP25			KCK20B			KY3500		
P	0–1	–	–	–	140	**280**	335	110	**225**	270	185	**400**	450	145	**290**	365	200	**440**	490	–	–	–
	2	–	–	–	140	**200**	245	110	**160**	195	185	**270**	350	145	**200**	305	200	**300**	380	–	–	–
	3	–	–	–	140	**155**	245	110	**125**	195	170	**190**	260	140	**155**	245	600	**200**	280	–	–	–
	4	–	–	–	75	**110**	170	60	**90**	135	90	**145**	200	75	**110**	180	100	**160**	220	–	–	–
	5	–	–	–	120	**200**	260	100	**160**	210	150	**220**	305	120	**200**	270	165	**240**	330	–	–	–
	6	–	–	–	110	**150**	230	85	**120**	185	120	**180**	275	110	**150**	230	130	**190**	300	–	–	–
M	1	60	**90**	120	140	**210**	260	90	**170**	245	–	–	–	–	–	–	–	–	–	–	–	–
	2	45	**75**	110	120	**200**	245	90	**150**	245	–	–	–	–	–	–	–	–	–	–	–	–
	3	35	**65**	100	120	**180**	245	90	**140**	210	–	–	–	–	–	–	–	–	–	–	–	–
K	1	30	**75**	120	120	**180**	245	100	**145**	195	170	**245**	440	140	**200**	360	210	**305**	550	180	**760**	1040
	2	25	**70**	110	90	**150**	210	70	**120**	170	120	**195**	340	100	**160**	280	150	**245**	430	275	**365**	500
	3	20	**60**	90	60	**110**	150	50	**85**	120	120	**170**	270	100	**140**	220	150	**210**	335	–	–	–
N	1–2	150	**370**	610	150	**550**	975	120	**440**	780	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	120	**275**	430	120	**365**	610	100	**290**	490	–	–	–	–	–	–	–	–	–	–	–	–
	5	45	**90**	150	90	**170**	245	70	**135**	195	–	–	–	–	–	–	–	–	–	–	–	–
	6	40	**75**	150	120	**210**	305	100	**170**	245	–	–	–	–	–	–	–	–	–	–	–	–
S	1	8	**30**	75	15	**55**	135	8	**40**	60	–	–	–	–	–	–	–	–	–	–	–	–
	2	8	**35**	75	15	**60**	135	8	**30**	75	–	–	–	–	–	–	–	–	–	–	–	–
	3	8	**40**	75	15	**70**	135	15	**40**	75	–	–	–	–	–	–	–	–	–	–	–	–
	4	8	**45**	75	15	**70**	170	8	**50**	110	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	30	**45**	60	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	15	**30**	45	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Material Group		KT315			KB5625			KB1630			KD1405		
P	0–1	180	**440**	475	–	–	–	–	–	–	–	–	–
	2	195	**270**	400	–	–	–	–	–	–	–	–	–
	3	180	**210**	275	–	–	–	–	–	–	–	–	–
	4	75	**160**	210	–	–	–	–	–	–	–	–	–
	5	150	**250**	310	–	–	–	–	–	–	–	–	–
	6	140	**200**	300	–	–	–	–	–	–	–	–	–
M	1	–	–	–	–	–	–	–	–	–	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–
K	1	60	**275**	550	–	–	–	180	**760**	1040	–	–	–
	2	135	**275**	360	–	–	–	–	–	–	–	–	–
	3	180	**230**	360	–	–	–	–	–	–	–	–	–
N	1–2	–	–	–	–	–	–	–	–	–	365	**610**	1040
	3	–	–	–	–	–	–	–	–	–	275	**480**	800
	4	–	–	–	–	–	–	–	–	–	300	**550**	920
	5	–	–	–	–	–	–	–	–	–	275	**610**	1070
	6	–	–	–	–	–	–	–	–	–	150	**460**	760
S	1	–	–	–	–	–	–	120	**200**	275	–	–	–
	2	–	–	–	–	–	–	120	**215**	275	–	–	–
	3	–	–	–	–	–	–	120	**250**	275	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–
H	1	–	–	–	45	**150**	230	45	**120**	170	–	–	–
	2	–	–	–	45	**140**	230	45	**110**	170	–	–	–
	3	–	–	–	45	**130**	230	45	**100**	170	–	–	–
	4	–	–	–	45	**120**	230	45	**90**	170	–	–	–

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.



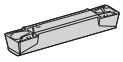


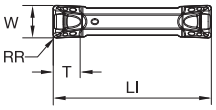
● first choice
○ alternate choice

		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	

GUP Precision Moulded

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0205M02U02GUP	2	2,05	0,2	20	2,0	●	●	●	●	–	–	–	–	–	–	–	–	–
A4G0305M03U02GUP	3	3,05	0,2	20	3,0	●	●	●	●	–	–	–	–	–	–	–	–	–
A4G0305M03U04GUP	3	3,05	0,4	20	3,0	●	●	●	●	–	–	–	–	–	–	–	–	–
A4G0405M04U04GUP	4	4,05	0,4	20	3,4	●	●	●	●	–	–	–	–	–	–	–	–	–
A4G0405M04U08GUP	4	4,05	0,8	20	3,4	●	●	●	●	–	–	–	–	–	–	–	–	–
A4R0405M04U00GUP	4	4,05	–	20	–	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G0505M05U04GUP	5	5,05	0,4	25	4,2	●	●	●	●	–	–	–	–	–	–	–	–	–
A4G0505M05U08GUP	5	5,05	0,8	25	4,2	●	●	●	●	–	–	–	–	–	–	–	–	–
A4G0605M06U04GUP	6	6,05	0,4	30	4,5	●	●	●	●	–	–	–	–	–	–	–	–	–
A4G0605M06U08GUP	6	6,05	0,8	30	4,5	●	●	●	●	–	–	–	–	–	–	–	–	–
A4G0605M06U12GUP	6	6,05	1,2	30	4,5	●	●	●	●	–	–	–	–	–	–	–	–	–
A4R0605M06U00GUP	6	6,05	–	30	4,9	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G0805M08U08GUP	8	8,05	0,8	30	6,0	●	●	●	●	–	–	–	–	–	–	–	–	–
A4G0805M08U12GUP	8	8,05	1,2	30	6,0	●	●	●	●	–	–	–	–	–	–	–	–	–
A4R0805M08U00GUP	8	8,05	–	30	6,5	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G1005M10U08GUP	10	10,05	0,8	30	6,0	●	●	●	–	–	–	–	–	–	–	–	–	–
A4G1005M10U12GUP	10	10,05	1,2	30	6,1	–	●	–	●	–	–	–	–	–	–	–	–	–





A4G-P-GUP

● first choice
○ alternate choice

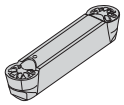
		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	

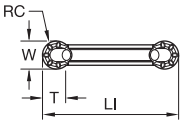
GUP Precision Ground

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0200M02P02GUP	2	2,00	0,2	20	1,9	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G094I2BP05GUP	2B	2,38	0,2	20	1,9	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G0300M03P02GUP	3	3,00	0,2	20	2,9	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0300M03P04GUP	3	3,00	0,4	20	2,9	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G125I03P05GUP	3	3,18	0,2	20	2,9	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G125I03P1GUP	3	3,18	0,4	20	2,9	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G0400M04P02GUP	4	4,00	0,2	20	3,3	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0400M04P04GUP	4	4,00	0,4	20	3,3	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0400M04P08GUP	4	4,00	0,8	20	3,3	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G187I04P1GUP	4	4,76	0,4	20	3,3	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G0500M05P04GUP	5	5,00	0,4	25	4,1	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0500M05P08GUP	5	5,00	0,8	25	4,1	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0600M06P04GUP	6	6,00	0,4	30	4,5	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0600M06P08GUP	6	6,00	0,8	30	4,5	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G250I06P1GUP	6	6,35	0,4	30	4,4	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G250I06P2GUP	6	6,35	0,8	30	4,4	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G312I08P1GUP	8	7,94	0,4	30	5,9	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G0800M08P08GUP	8	8,00	0,8	30	6,0	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0800M08P12GUP	8	8,00	1,2	30	6,0	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G375I10P1GUP	10	9,53	0,4	30	5,9	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G1000M10P08GUP	10	10,00	0,8	30	6,0	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G1000M10P12GUP	10	10,00	1,2	30	6,0	●	●	–	–	–	–	–	–	–	–	–	–	–

● first choice
○ alternate choice

		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	

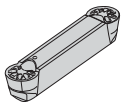


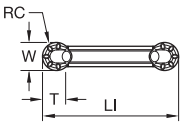


A4R-P-GUP

GUP Full Radius Precision Moulded

catalogue number	seat size	W	RC	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4R0305M03U00GUP	3	3,05	1,5	20	–	●	●	–	–	–	–	–	–	–	–	–	–	–
A4R0505M05U00GUP	5	5,05	2,5	25	–	●	●	–	–	–	–	–	–	–	–	–	–	–
A4R1005M10U00GUP	10	10,05	5,0	30	–	●	●	–	–	–	–	–	–	–	–	–	–	–





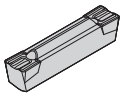
A4R-P-GUP

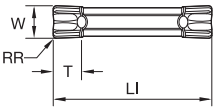
GUP Full Radius Precision Ground

catalogue number	seat size	W	RC	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4R0300M03P00GUP	3	3,00	1,5	20	–	●	●	–	–	–	–	–	–	–	–	–	–	–
A4R125I03P00GUP	3	3,18	1,6	20	–	●	●	–	–	–	–	–	–	–	–	–	–	–
A4R0400M04P00GUP	4	4,00	2,0	20	–	–	●	–	–	–	–	–	–	–	–	–	–	–
A4R187I04P00GUP	4	4,76	2,4	20	–	–	●	–	–	–	–	–	–	–	–	–	–	–
A4R0500M05P00GUP	5	5,00	2,5	25	–	–	●	–	–	–	–	–	–	–	–	–	–	–
A4R0600M06P00GUP	6	6,00	3,0	30	–	●	●	–	–	–	–	–	–	–	–	–	–	–
A4R250I06P00GUP	6	6,35	3,2	30	–	●	●	–	–	–	–	–	–	–	–	–	–	–
A4R312I08P00GUP	8	7,94	4,0	30	–	●	–	–	–	–	–	–	–	–	–	–	–	–
A4R0800M08P00GUP	8	8,00	4,0	30	–	–	●	–	–	–	–	–	–	–	–	–	–	–
A4R1000M10P00GUP	10	10,00	5,0	30	–	●	●	–	–	–	–	–	–	–	–	–	–	–

● first choice
○ alternate choice

		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	

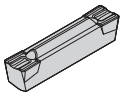


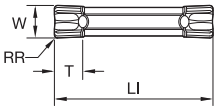


A4G-U-GMP

GMP Precision Moulded

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0205M02U02GMP	2	2,05	0,2	20	2,0	–	●	–	–	–	–	●	●	–	–	–	–	–
A4G0255M2BU02GMP	2B	2,62	0,2	20	2,0	–	●	–	–	–	–	–	●	–	–	–	–	–
A4G0305M03U02GMP	3	3,05	0,2	20	3,5	●	●	–	–	–	–	●	●	–	●	–	–	–
A4G0305M03U04GMP	3	3,05	0,4	20	3,5	●	●	–	–	–	–	●	●	–	●	–	–	–
A4G0405M04U04GMP	4	4,05	0,4	20	3,4	●	●	●	●	–	–	●	●	–	●	–	–	–
A4G0405M04U08GMP	4	4,05	0,8	20	3,4	–	●	–	–	–	–	●	●	–	●	–	–	–
A4G0505M05U04GMP	5	5,05	0,4	25	4,2	●	●	●	–	–	–	●	●	–	–	–	–	–
A4G0505M05U08GMP	5	5,05	0,8	25	4,2	–	●	●	–	–	–	●	●	–	–	–	–	–
A4G0605M06U04GMP	6	6,05	0,4	30	4,9	–	–	–	●	–	–	●	●	–	–	–	–	–
A4G0605M06U08GMP	6	6,05	0,8	30	4,9	–	–	–	–	–	–	●	●	–	–	–	–	–
A4G0805M08U08GMP	8	8,05	0,8	30	6,1	–	●	–	–	–	–	–	●	–	–	–	–	–
A4G1005M10U08GMP	10	10,05	0,8	30	8,1	●	●	–	–	–	–	–	–	–	–	–	–	–

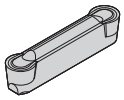


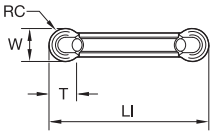


A4G-P-GMP

GMP Precision Ground

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0200M02P02GMP	2	2,00	0,2	20	2,0	●	●	–	–	–	–	●	●	–	–	–	–	–
A4G0250M2BP02GMP	2B	2,50	0,2	20	2,0	●	–	–	–	–	–	●	–	–	–	–	–	–
A4G0300M03P02GMP	3	3,00	0,2	20	3,5	●	●	–	–	–	●	●	●	–	–	–	–	–
A4G0300M03P04GMP	3	3,00	0,4	20	3,5	●	●	–	–	–	●	●	●	–	–	–	–	–
A4G0400M04P02GMP	4	4,00	0,2	20	–	●	●	–	–	–	●	●	●	–	–	–	–	–
A4G0400M04P04GMP	4	4,00	0,4	20	3,5	●	●	–	–	–	●	●	●	–	–	–	–	–
A4G0400M04P08GMP	4	4,00	0,8	20	3,5	●	●	–	–	–	–	●	●	–	–	–	–	–
A4G0500M05P04GMP	5	5,00	0,4	25	–	●	●	–	–	–	●	●	●	–	–	–	–	–
A4G0500M05P08GMP	5	5,00	0,8	25	–	●	–	–	–	–	●	●	●	–	–	–	–	–
A4G0600M06P04GMP	6	6,00	0,4	30	4,9	●	●	–	–	–	–	●	–	–	–	–	–	–
A4G0600M06P08GMP	6	6,00	0,8	30	4,9	●	●	–	–	–	–	●	●	–	–	–	–	–
A4G0800M08P08GMP	8	8,00	0,8	30	6,4	–	●	–	–	–	–	●	–	–	–	–	–	–
A4G0800M08P12GMP	8	8,00	1,2	30	6,4	●	–	–	–	–	–	–	–	–	–	–	–	–





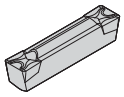
A4R-P-GMP

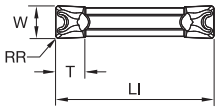
● first choice
○ alternate choice

		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	

GMP Full Radius Precision Ground

catalogue number	seat size	W	RC	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4R0200M02P00GMP	2	2,00	1,0	20	1,7	●	●	–	–	–	–	●	●	–	–	–	–	–
A4R0300M03P00GMP	3	3,00	1,5	20	2,5	●	●	–	–	–	●	●	●	–	–	–	–	–
A4R0400M04P00GMP	4	4,00	2,0	20	–	●	●	–	–	–	●	●	●	–	–	–	–	–
A4R0500M05P00GMP	5	5,00	2,5	25	4,1	●	●	–	–	–	●	●	●	–	–	–	–	–
A4R0600M06P00GMP	6	6,00	3,0	30	4,8	●	●	–	–	–	–	●	●	–	–	–	–	–
A4R0800M08P00GMP	8	8,00	4,0	30	6,4	●	●	–	–	–	–	●	–	–	–	–	–	–

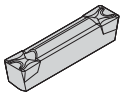


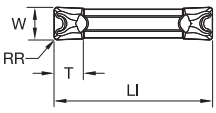


A4G-U-GMN

GMN Precision Moulded

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0205M02U02GMN	2	2,05	0,2	20	2,0	●	●	●	–	–	–	●	●	–	–	–	–	–
A4G0255M2BU02GMN	2B	2,62	0,2	20	2,0	–	–	–	–	–	–	–	●	–	–	–	–	–
A4G0305M03U02GMN	3	3,05	0,2	20	3,5	●	●	●	●	–	–	●	●	–	–	–	–	–
A4G0305M03U04GMN	3	3,05	0,4	20	3,5	●	●	●	●	–	–	●	●	–	–	–	–	–
A4G0405M04U04GMN	4	4,05	0,4	20	3,4	●	●	–	●	–	–	●	●	–	–	–	–	–
A4G0405M04U08GMN	4	4,05	0,8	20	3,4	●	●	●	●	–	–	●	●	–	–	–	–	–
A4G0505M05U04GMN	5	5,05	0,4	25	4,2	●	●	●	●	–	–	●	●	–	–	–	–	–
A4G0505M05U08GMN	5	5,05	0,8	25	4,2	●	●	●	●	–	–	●	●	–	–	–	–	–
A4G0605M06U04GMN	6	6,05	0,4	30	4,9	●	●	●	●	–	–	●	●	–	–	–	–	–
A4G0605M06U08GMN	6	6,05	0,8	30	4,9	●	●	●	●	–	–	●	●	–	●	–	–	–
A4G0605M06U12GMN	6	6,05	1,2	30	4,9	–	–	–	●	–	–	●	●	–	–	–	–	–
A4G0805M08U08GMN	8	8,05	0,8	30	6,4	●	●	●	●	–	–	●	–	–	–	–	–	–
A4G0805M08U12GMN	8	8,05	1,2	30	6,4	–	●	●	●	–	–	●	–	–	–	–	–	–
A4G1005M10U08GMN	10	10,05	0,8	30	8,1	–	●	●	●	–	–	–	●	–	–	–	–	–
A4G1005M10U12GMN	10	10,05	1,2	30	8,1	–	–	–	●	–	–	–	●	–	–	–	–	–





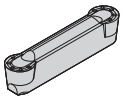
A4G-P-GMN

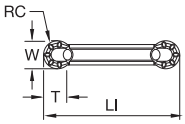
● first choice
○ alternate choice

		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	

GMN Precision Ground

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G094I2BP05GMN	2B	2,39	0,2	20	1,9	●	–	–	–	–	–	●	–	–	–	–	–	–
A4G125I03P05GMN	3	3,18	0,2	20	3,4	●	●	–	–	–	–	●	●	–	–	–	–	–
A4G125I03P1GMN	3	3,18	0,4	20	3,4	●	●	–	–	–	–	●	●	–	–	–	–	–
A4G187I04P1GMN	4	4,76	0,4	20	3,5	●	●	–	–	–	–	●	–	–	–	–	–	–
A4G187I04P2GMN	4	4,76	0,8	20	3,5	●	●	–	–	–	–	●	●	–	–	–	–	–
A4G250I06P1GMN	6	6,35	0,4	30	4,7	●	●	–	–	–	–	●	–	–	–	–	–	–
A4G250I06P2GMN	6	6,35	0,8	30	4,7	●	●	–	–	–	–	●	–	–	–	–	–	–
A4G312I08P1GMN	8	7,94	0,4	30	6,2	–	●	–	–	–	–	●	–	–	–	–	–	–
A4G375I10P1GMN	10	9,53	0,4	30	7,9	–	–	–	–	–	–	●	–	–	–	–	–	–
A4G375I10P2GMN	10	9,53	0,8	30	7,9	●	–	–	–	–	–	●	–	–	–	–	–	–

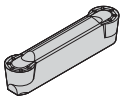


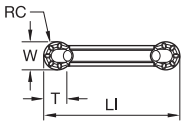


A4R-U-GMN

GMN Full Radius Precision Moulded

catalogue number	seat size	W	RC	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4R0205M02U00GMN	2	2,05	1,1	20	1,8	–	●	●	–	–	–	●	●	–	–	–	–	–
A4R0305M03U00GMN	3	3,05	1,5	20	2,6	●	●	●	●	–	–	●	●	–	–	–	–	–
A4R0405M04U00GMN	4	4,05	2,0	20	3,5	●	●	●	●	–	–	●	●	–	–	–	–	–
A4R0505M05U00GMN	5	5,05	2,5	25	4,2	●	●	●	●	–	–	●	●	–	–	–	–	–
A4R0605M06U00GMN	6	6,05	3,0	30	4,9	●	●	●	●	–	–	●	●	–	–	–	–	–
A4R0805M08U00GMN	8	8,05	4,0	30	6,5	●	●	●	●	–	–	●	●	–	–	–	–	–
A4R1005M10U00GMN	10	10,05	5,0	30	8,2	●	●	–	●	–	–	–	–	–	–	–	–	–

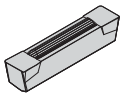


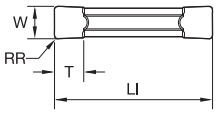


A4R-P-GMN

GMN Full Radius Precision Ground

catalogue number	seat size	W	RC	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4R125I03P00GMN	3	3,18	1,6	20	2,7	●	●	–	–	–	–	●	●	–	–	–	–	–
A4R187I04P00GMN	4	4,76	2,4	20	3,8	●	●	–	–	–	–	●	●	–	–	–	–	–
A4R250I06P00GMN	6	6,35	3,2	30	5,3	●	●	–	–	–	–	●	●	–	–	–	–	–
A4R312I08P00GMN	8	7,94	4,0	30	6,4	●	–	–	–	–	–	–	–	–	–	–	–	–
A4R375I10P00GMN	10	9,53	4,8	30	7,3	–	–	–	–	–	–	–	●	–	–	–	–	–





A4G-U-B

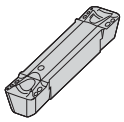
● first choice
○ alternate choice

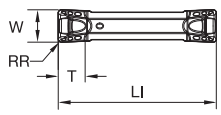
		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	

Flat Top Precision Moulded

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0305M03U02B	3	3,05	0,2	20	3,5	–	●	–	–	●	–	–	●	–	–	–	–	–
A4G0405M04U04B	4	4,05	0,4	20	3,4	–	–	–	–	●	–	–	●	–	–	–	–	–
A4G0505M05U04B	5	5,05	0,4	25	4,2	–	●	–	–	●	–	–	–	–	–	–	–	–
A4G0605M06U04B	6	6,05	0,4	30	4,9	–	●	–	–	●	–	–	–	–	–	–	–	–
A4G0805M08U08B	8	8,05	0,8	30	6,4	–	–	–	–	●	–	–	–	–	–	–	–	–
A4G1005M10U08B	10	10,05	0,8	30	8,1	–	–	–	–	●	–	–	–	–	–	–	–	–

A4™ Groove and Turn Inserts • Small Diameter Face Grooving





A4G-SP-GUP

● first choice
○ alternate choice

		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	

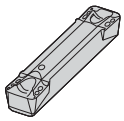
GUP Precision Moulded • Small Diameter Face Grooving

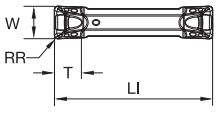
catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0200M2SP02GUP	2S	2,00	0,2	20	1,9	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0300M3SP02GUP	3S	3,00	0,2	20	2,9	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0300M3SP04GUP	3S	3,00	0,4	20	2,9	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0400M4SP04GUP	4S	4,00	0,4	20	3,4	●	–	–	–	–	–	–	–	–	–	–	–	–
A4G0400M4SP08GUP	4S	4,00	0,8	20	3,4	●	–	–	–	–	–	–	–	–	–	–	–	–
A4G0500M5SP04GUP	5S	5,00	0,4	25	4,1	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G0500M5SP08GUP	5S	5,00	0,8	25	4,1	●	–	–	–	–	–	–	–	–	–	–	–	–

NOTE: A4-S inserts are reduced-height A4 inserts. For example, a 2S seat size holder will not accept a seat size 2 insert.

● first choice
○ alternate choice

		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	



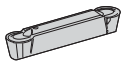


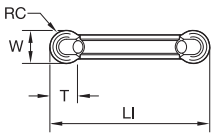
A4G-SU-GUP

GUP Precision Ground • Small Diameter Face Grooving

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0205M2SU02GUP	2S	2,05	0,2	20	2,0	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0305M3SU02GUP	3S	3,05	0,2	20	3,0	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0305M3SU04GUP	3S	3,05	0,4	20	3,0	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0405M4SU04GUP	4S	4,05	0,4	20	3,4	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0505M5SU04GUP	5S	5,05	0,4	25	4,2	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0505M5SU08GUP	5S	5,05	0,8	25	4,2	–	●	–	–	–	–	–	–	–	–	–	–	–

NOTE: A4-S inserts are reduced-height A4 inserts. For example, a 2S seat size holder will not accept a seat size 2 insert.



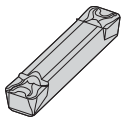


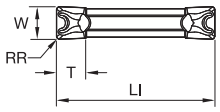
A4R-SP-GMP

GMP Full Radius Precision Ground • Small Diameter Face Grooving

catalogue number	seat size	W	RC	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4R0200M2SP00GMP	2S	2,00	1,0	20	1,6	–	●	–	–	–	–	–	–	–	–	–	–	–
A4R0300M3SP00GMP	3S	3,00	1,5	20	2,5	–	●	–	–	–	–	–	–	–	–	–	–	–
A4R0500M5SP00GMP	5S	5,00	2,5	25	4,1	–	●	–	–	–	–	–	–	–	–	–	–	–

NOTE: A4-S inserts are reduced-height A4 inserts. For example, a 2S seat size holder will not accept a seat size 2 insert.



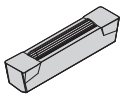


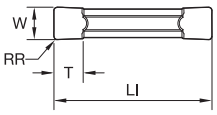
A4G-SU-GMN

GMN Precision Moulded • Small Diameter Face Grooving

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0205M2SU02GMN	2S	2,05	0,2	20	2,0	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0305M3SU02GMN	3S	3,05	0,2	20	3,5	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G0305M3SU04GMN	3S	3,05	0,4	20	3,5	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0405M4SU04GMN	4S	4,05	0,4	20	3,6	●	●	–	–	–	–	–	–	–	–	–	–	–
A4G0405M4SU08GMN	4S	4,05	0,8	20	3,6	–	●	–	–	–	–	–	–	–	–	–	–	–
A4G0505M5SU04GMN	5S	5,05	0,4	25	4,2	●	●	–	–	–	–	–	–	–	–	–	–	–

NOTE: A4-S inserts are reduced-height A4 inserts. For example, a 2S seat size holder will not accept a seat size 2 insert.





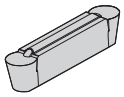
A4G-P-T

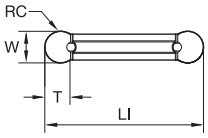
● first choice
○ alternate choice

P	
M	
K	●
N	
S	
H	

Flat Top Precision Ground • Ceramic

ISO catalogue number	seat size	W	RR	LI	T	KY3500
A4G0300M03P04T01025	3	3,00	0,4	20	3,4	●
A4G125I03P1T0425	3	3,18	0,4	20	3,4	●
A4G0400M04P04T01025	4	4,00	0,4	20	3,4	●
A4G0500M05P08T01025	5	5,00	0,8	25	4,2	●
A4G0600M06P08T01025	6	6,00	0,8	30	4,8	●
A4G250I06P2T0425	6	6,35	0,8	30	4,9	●
A4G0800M08P08T01025	8	8,00	0,8	30	6,4	●

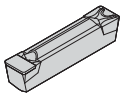


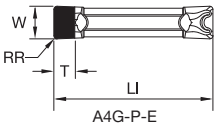


A4R-P-T

Flat Top Full Radius Precision Ground • Ceramic

ISO catalogue number	seat size	W	RC	LI	T	KY3500
A4R0300M03P00T01025	3	3,00	1,5	20	2,4	●
A4R0500M05P00T01025	5	5,00	2,5	25	4,1	●
A4R0600M06P00T01025	6	6,00	3,0	30	4,3	●
A4R250I06P00T0425	6	6,35	3,2	30	4,8	●
A4R0800M08P00T01025	8	8,00	4,0	30	6,4	●





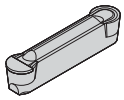
A4G-P-E

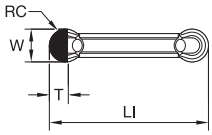
● first choice
○ alternate choice

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

Flat Top Precision Ground • PCD

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0300M03P04E	3	3,00	0,4	20	3,0	–	–	–	–	–	–	–	–	–	–	–	–	●
A4G0400M04P04E	4	4,00	0,4	20	3,0	–	–	–	–	–	–	–	–	–	–	–	–	●
A4G0500M05P08E	5	5,00	0,8	25	3,0	–	–	–	–	–	–	–	–	–	–	–	–	●





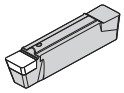
A4R-P-E

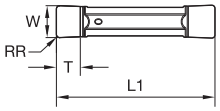
● first choice
○ alternate choice

		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	

Flat Top Full Radius Precision Ground • PCD

catalogue number	seat size	W	RC	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4R0500M05P00E	5	5,00	2,5	25	3,0	–	–	–	–	–	–	–	–	–	–	–	–	●

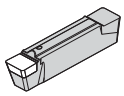


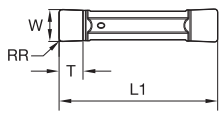


A4G-P-E-ST

Flat Top Precision Ground • PcBN

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0300M03P04EST	3	3,00	0,4	20	3,0	–	–	–	–	–	–	–	–	–	–	●	–	–
A4G0500M05P08EST	5	5,00	0,8	25	3,5	–	–	–	–	–	–	–	–	–	–	●	–	–
A4G0600M06P08EST	6	6,00	0,8	30	4,0	–	–	–	–	–	–	–	–	–	–	●	–	–

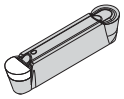


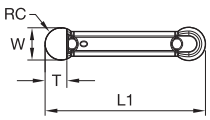


A4G-P-S-ST

Flat Top Precision Ground • T Land • PcBN

catalogue number	seat size	W	RR	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4G0300M03P04S02025ST	3	3,00	0,4	20	3,0	–	–	–	–	–	–	–	–	–	–	●	●	–
A4G0400M04P04S02025ST	4	4,00	0,4	20	3,3	–	–	–	–	–	–	–	–	–	–	●	●	–
A4G0500M05P08S02025ST	5	5,00	0,8	25	3,5	–	–	–	–	–	–	–	–	–	–	–	●	–
A4G0600M06P08S02025ST	6	6,00	0,8	30	4,0	–	–	–	–	–	–	–	–	–	–	–	●	–





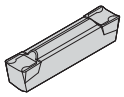
A4R-P-E-ST

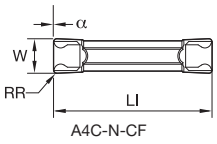
● first choice
○ alternate choice

Flat Top Full Radius Precision Ground • PcBN

catalogue number	seat size	W	RC	LI	T	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P						●	●	●	●	○		○	○		●			
M						●	●				○	●	○					
K						○	○	○	○	●	○	○	○	●	○	○		
N						●	○				●	●	○					●
S						●	●				●	○	○			○		
H						○						○				●	●	
A4R0300M03P00EST	3	3,00	1,5	20	2,2	–	–	–	–	–	–	–	–	–	–	●	–	–
A4R0400M04P00EST	4	4,00	2,0	20	2,9	–	–	–	–	–	–	–	–	–	–	●	–	–
A4R0500M05P00EST	5	5,00	2,5	25	3,7	–	–	–	–	–	–	–	–	–	–	●	–	–
A4R0600M06P00EST	6	6,00	3,0	30	4,4	–	–	–	–	–	–	–	–	–	–	●	–	–

A4™ Cut-off Inserts





A4C-N-CF

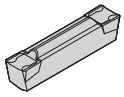
● first choice
○ alternate choice

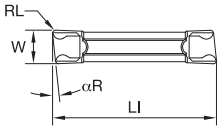
CF Precision Moulded • Neutral

catalogue number	seat size	W	RR	LI	α	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P						●	●	●	●	○		○	○		●			
M						●	●				○	●	○					
K						○	○	○	○	●	○	○	○	●	○	○		
N						●	○				●	●	○					●
S						●	●				●	○	○			○		
H						○						○				●	●	
A4C0155N00CF01	1	1,50	0,2	16	–	–	●	–	–	–	–	–	●	–	–	–	–	–
A4C0205N00CF02	2	2,05	0,2	20	–	–	●	–	–	–	–	–	●	–	–	–	–	–
A4C0255N00CF02	2B	2,50	0,2	20	–	–	●	–	–	–	–	–	●	–	–	–	–	–
A4C0305N00CF02	3	3,05	0,2	20	–	–	●	–	–	–	–	–	●	–	–	–	–	–
A4C0405N00CF02	4	4,05	0,2	20	–	–	●	–	–	–	–	–	●	–	–	–	–	–

● first choice
○ alternate choice

		KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
P		●	●	●	●	○		○	○		●			
M		●	●				○	●	○					
K		○	○	○	○	●	○	○	○	●	○	○		
N		●	○				●	●	○					●
S		●	●				●	○	○			○		
H		○						○				●	●	

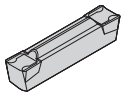


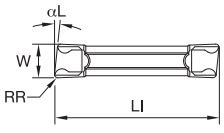


A4C-R-CF

CF Precision Moulded • Right Hand

catalogue number	seat size	W	RL	LI	αR	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4C0155R06CF01	1	1,50	0,2	16	6.0	–	–	–	–	–	–	–	●	–	–	–	–	–
A4C0155R10CF01	1	1,50	0,2	16	10.0	–	●	–	–	–	–	–	–	–	–	–	–	–
A4C0155R16CF01	1	1,50	0,2	16	16.0	–	–	–	–	–	–	–	●	–	–	–	–	–
A4C0205R06CF02	2	1,99	0,2	20	6.0	–	●	–	–	–	–	–	●	–	–	–	–	–
A4C0205R10CF02	2	1,99	0,2	20	10.0	–	●	–	–	–	–	–	–	–	–	–	–	–
A4C0255R06CF02	2B	2,49	0,2	20	6.0	–	–	–	–	–	–	–	●	–	–	–	–	–
A4C0305R06CF02	3	3,05	0,2	20	6.0	–	●	–	–	–	–	–	●	–	–	–	–	–
A4C0305R10CF02	3	3,05	0,2	20	10.0	–	●	–	–	–	–	–	●	–	–	–	–	–
A4C0405R06CF02	4	4,05	0,2	20	6.0	–	●	–	–	–	–	–	–	–	–	–	–	–
A4C0405R10CF02	4	4,05	0,2	20	10.0	–	●	–	–	–	–	–	●	–	–	–	–	–





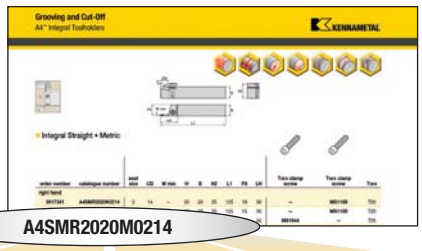
A4C-L-CF

CF Precision Moulded • Left Hand

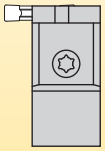
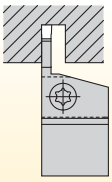
catalogue number	seat size	W	RR	LI	αL	KCU10	KCU25	KCP10	KCP25	KCK20	K313	KC5010	KC5025	KY3500	KT315	KB1630	KB5625	KD1405
A4C0155L06CF01	1	1,50	0,2	16	6.0	–	–	–	–	–	–	–	●	–	–	–	–	–
A4C0205L06CF02	2	1,99	0,2	20	6.0	–	●	–	–	–	–	–	–	–	–	–	–	–
A4C0205L10CF02	2	1,99	0,2	20	10.0	–	–	–	–	–	–	–	●	–	–	–	–	–
A4C0305L06CF02	3	3,05	0,2	20	6.0	–	●	–	–	–	–	–	●	–	–	–	–	–
A4C0305L10CF02	3	3,05	0,2	20	10.0	–	●	–	–	–	–	–	–	–	–	–	–	–
A4C0405L06CF02	4	4,05	0,2	20	6.0	–	●	–	–	–	–	–	–	–	–	–	–	–
A4C0405L10CF02	4	4,05	0,2	20	10.0	–	●	–	–	–	–	–	–	–	–	–	–	–

How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



A4SMR2020M0214

A4	S	M	R	2020M	02	14
Tooling System	Tool Style	Support Type	Hand of Tool	Shank Size	Seat Size	Max Grooving Depth
A4 = Grooving and Turning	 **S** = Straight  **E** = End mounted 90°		 **R** = Right hand **L** = Left hand **N** = Neutral		**02** **03** **04** **05** **06** **08** **10**	in millimetres

M =
Maximum support for specific groove widths and straight clearance for unlimited workpiece diameters

E =
No steel support for face grooving

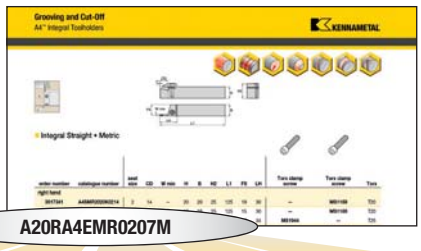
C =
Reinforced Support

metric:
Height x width in mm, letter indicates tool length according to ISO

metric tool length (mm)

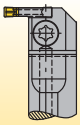
K = 125
M = 150
P = 170

By referencing this easy-to-use guide, you can identify the correct product to meet your needs.

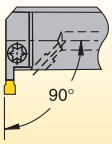


A20RA4EMR0207M

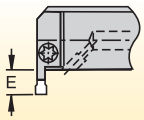
A	20	R	A4	E	M	R	02	07	M
Steel Bar with Coolant	Bar Diameter	Bar Length	A4™ Groove and Turn System	Tool Style	Support Type	Hand of Tool	Insert Seat Size	Grooving Depth in mm	Tool Units



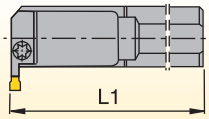
M = Metric



E = End mounted (90°)

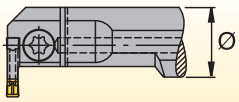


mm
7mm
10mm
12mm
16mm

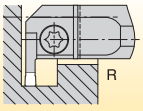


metric bars:
R = 200mm
S = 150mm
T = 300mm

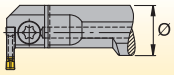
pocket seat size	cutting width (mm)
02	2,00–2,62
2B	2,39–2,62
03	3,0–3,05
04	4,0–4,05
05	5,0–5,05
06	6,0–6,05
08	8,0–8,05
10	10,0–10,05



metric bars:
Bar diameter in millimetres



R = Right hand

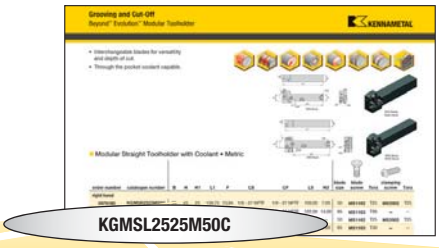


L = Left hand

M = Maximum support

How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



KGM	S	L	2525M	50	C
Family Name	Tool Style	Hand	Shank Size	Blade Size	Coolant
Grooving Modular System	**S** = Straight mount **E** = End mount (90°)	**L** = Left hand **R** = Right hand	**Metric** = Height x Width in mm letter indicates tool length according to ISO	**50** **65**	**C** = Through coolant capable

Grooving Tools and **Beyond**™ Inserts for Your Shallow Groove and Turn Operations

Top Notch™



Top Notch Grooving is the proven solution for high productivity. The Top Notch system provides consistent tool performance, accurate indexing, and superior clamping to provide excellent surface finishing and superior tool life.

FEATURES AND BENEFITS

- The Beyond PVD coated grades are designed to cut a variety of workpiece materials.
- Rigid clamping securely locks insert in place through the toughest cuts.
- Versatile design enables one system to handle O.D. and I.D. grooving, face grooving, back turning, undercutting, and even threading operations.
- Chip control inserts provide excellent chip evacuation in grooving, and offer better chip control in multidirectional turning.

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

KENNAMETAL®

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How Do Catalogue Numbers Work?

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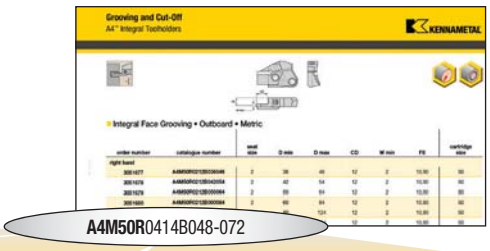
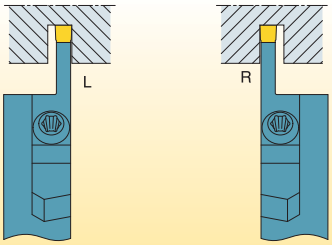
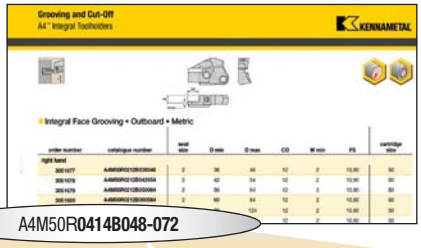


A4M50R0414B048-072

A4M	50	R
Family Name	Modular System Size	Hand of Tool
A4 Modular Blade	**50** **65**	

By referencing this easy-to-use guide, you can identify the correct product to meet your needs.



A4M50R**0414B048-072**

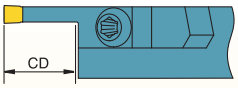
04

Seat Size

pocket seat size	cutting width mm
02	2,00–2,62
2B	2,39–2,62
03	3,0–3,05
04	4,0–4,05
05	5,0–5,05
06	6,0–6,05
08	8,0–8,05
10	10,0–10,05

14

Maximum Groove Depth



mm

14mm

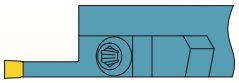
19mm

20mm

26mm

B

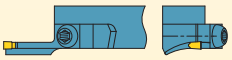
Tool Style



M = Maximum support for specific groove widths and straight clearance for unlimited workpiece diameters



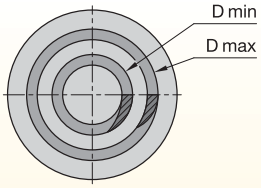
A = Inboard sweep face grooving toolholder



B = Outboard sweep face grooving toolholder

048–072

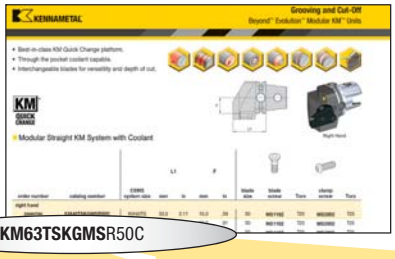
Face Grooving Diameter Range



diameters are min and max for outer face groove dia.
999 = unlimited D max

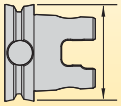
How Do Catalogue Numbers Work?

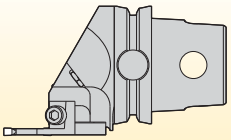
Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



KM63TSKGMSR50C

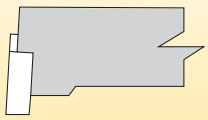
KM	63	TS	KGM	S
KM™ Quick-Change	System Size	Feature	Insert Holding Method	Insert Location
KM **KM4X™** **PSC**	**40** = 40mm **50** = 50mm **63** = 63mm **80** = 80mm **100** = 100mm	**TS** **XMZ**	**KGM**	**E** = End mount **S** = Side mount



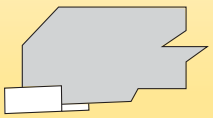


Modular Grooving

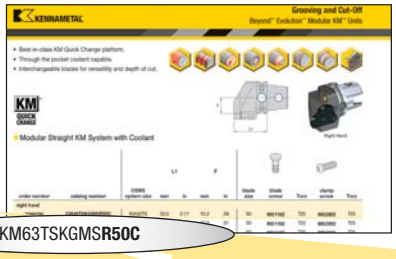
E



S



By referencing this easy-to-use guide, you can identify the correct product to meet your needs.

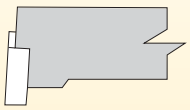


KM63TSKGMS**R50C**

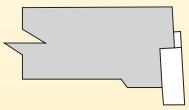
R	50	C	
Hand of Tool	Blade Size	Coolant	Special Features
R = Right hand **L** = Left hand	**50** **60**	**C** = Through the pocket coolant capable	**Y** = Mazak® INTEGREX®

End Mount

R

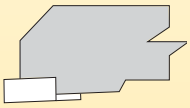


L

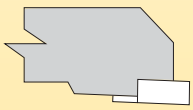


Side Mount

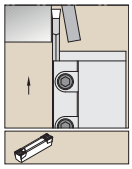
R

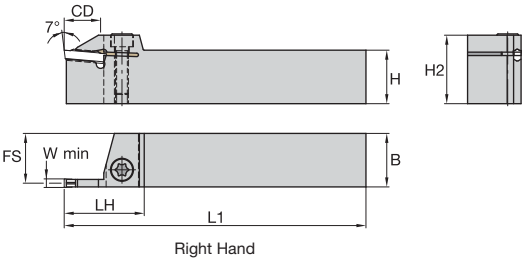


L









Right Hand

Integral Straight • Metric





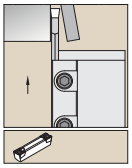
order number	catalogue number	seat size	CD	W min	H	B	H2	L1	FS	LH	clamp screw	clamp screw	Torx
right hand													
3017341	**A4SMR2020K0214**	2	14	–	20	20	25	125	19	30	**–**	**MS1160**	T20
3017342	**A4SMR1616K0214**	2	14	2	16	16	25	125	15	30	**–**	**MS1160**	T20
2974425	**A4SMR2020K0217**	2	17	2	20	20	31	125	19	34	**MS1944**	**–**	T25
3017340	**A4SMR2525M0214**	2	14	2	25	25	30	150	24	30	**–**	**MS1160**	T20
3017339	**A4SMR2525M0217**	2	17	2	25	25	31	150	24	34	**MS1944**	**–**	T25
1949633	**A4SMR1616K0314**	3	14	3	16	16	27	125	15	35	**MS2091**	**–**	T25
2503557	**A4SMR2016K0317**	3	17	3	20	16	32	125	15	37	**MS1970**	**–**	T30
1949635	**A4SMR2020K0314**	3	14	3	20	20	27	125	19	35	**MS1595**	**–**	T30
2503551	**A4SMR2020K0317**	3	17	3	20	20	32	125	19	37	**MS1970**	**–**	T30
1949637	**A4SMR2525M0317**	3	17	3	25	25	32	150	24	37	**MS1970**	**–**	T30
2503559	**A4SMR2016K0417**	4	17	4	20	16	32	125	14	37	**MS1970**	**–**	T30
1949639	**A4SMR2020K0414**	4	14	4	20	20	27	125	18	35	**MS1595**	**–**	T30
2503553	**A4SMR2020K0417**	4	17	4	20	20	32	125	18	37	**MS1970**	**–**	T30
1949641	**A4SMR2525M0417**	4	17	4	25	25	32	150	23	37	**MS1970**	**–**	T30
1949643	**A4SMR3225P0417**	4	17	4	32	25	40	170	23	37	**MS1970**	**–**	T30
1949645	**A4SMR2020K0519**	5	19	5	20	20	28	125	18	40	**MS1595**	**–**	T30
1949647	**A4SMR2525M0520**	5	20	5	25	25	33	150	23	40	**MS1970**	**–**	T30
1949649	**A4SMR3225P0522**	5	22	5	32	25	40	170	23	42	**MS1970**	**–**	T30
2503555	**A4SMR2020K0620**	6	20	6	20	20	33	125	17	40	**MS1970**	**–**	T30
2245484	**A4SMR2525M0620**	6	20	6	25	25	33	150	22	40	**MS1970**	**–**	T30
2263089	**A4SMR3225P0626**	6	26	6	32	25	40	170	22	45	**MS1970**	**–**	T30
2245485	**A4SMR2525M0820**	8	20	8	25	25	34	150	21	43	**MS1490**	**–**	T45
2263091	**A4SMR3225P0826**	8	26	8	32	25	41	170	21	47	**MS1490**	**–**	T45
2263173	**A4SMR3225P1026**	10	26	10	32	25	41	170	21	47	**MS1490**	**–**	T45

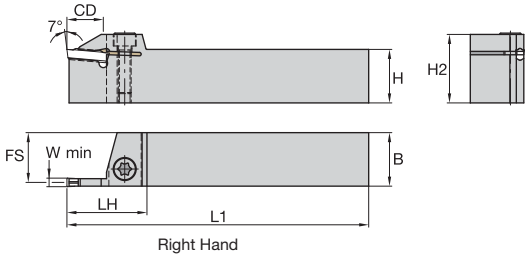
(continued)

(Integral Straight • Metric — continued)



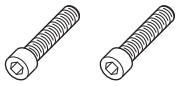

order number	catalogue number	seat size	CD	W min	H	B	H2	L1	FS	LH	clamp screw	clamp screw	Torx
left hand													
3017336	**A4SML2020K0214**	2	14	–	20	20	25	125	19	30	**–**	**MS1160**	T20
3017338	**A4SML1616K0214**	2	14	2	16	16	25	125	15	30	**–**	**MS1160**	T20
3017337	**A4SML2020K0217**	2	17	2	20	20	31	125	19	34	**MS1944**	**–**	T25
3017335	**A4SML2525M0214**	2	14	2	25	25	30	150	24	30	**–**	**MS1160**	T20
3017334	**A4SML2525M0217**	2	17	2	25	25	31	150	24	34	**MS1944**	**–**	T25
1949634	**A4SML1616K0314**	3	14	3	16	16	27	125	15	35	**MS2091**	**–**	T25
2503556	**A4SML2016K0317**	3	17	3	20	16	32	125	15	37	**MS1970**	**–**	T30
1949636	**A4SML2020K0314**	3	14	3	20	20	27	125	19	35	**MS1595**	**–**	T30
2503550	**A4SML2020K0317**	3	17	3	20	20	32	125	19	37	**MS1970**	**–**	T30
1949638	**A4SML2525M0317**	3	17	3	25	25	32	150	24	37	**MS1970**	**–**	T30
1949640	**A4SML2020K0414**	4	14	4	20	20	27	125	18	35	**MS1595**	**–**	T30
2503552	**A4SML2020K0417**	4	17	4	20	20	32	125	18	37	**MS1970**	**–**	T30
1949642	**A4SML2525M0417**	4	17	4	25	25	32	150	23	37	**MS1970**	**–**	T30
1949644	**A4SML3225P0417**	4	17	4	32	25	40	170	23	37	**MS1970**	**–**	T30
1949646	**A4SML2020K0519**	5	19	5	20	20	28	125	18	40	**MS1595**	**–**	T30
1949648	**A4SML2525M0520**	5	20	5	25	25	33	150	23	40	**MS1970**	**–**	T30
1949650	**A4SML3225P0522**	5	22	5	32	25	40	170	23	42	**MS1970**	**–**	T30
2503554	**A4SML2020K0620**	6	20	6	20	20	33	125	17	40	**MS1970**	**–**	T30
2245486	**A4SML2525M0620**	6	20	6	25	25	33	150	22	40	**MS1970**	**–**	T30
2263090	**A4SML3225P0626**	6	26	6	32	25	40	170	22	45	**MS1970**	**–**	T30
2245487	**A4SML2525M0820**	8	20	8	25	25	34	150	21	43	**MS1490**	**–**	T45
2263092	**A4SML3225P0826**	8	26	8	32	25	41	170	21	47	**MS1490**	**–**	T45
2263174	**A4SML3225P1026**	10	26	10	32	25	41	170	21	47	**MS1490**	**–**	T45



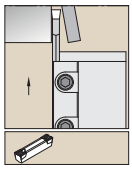


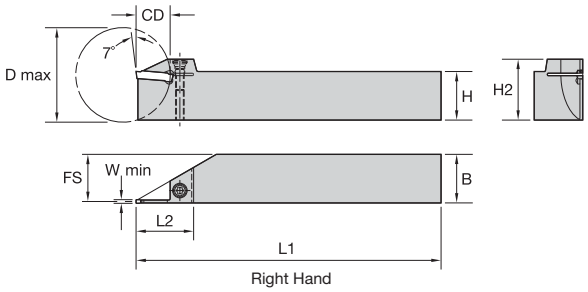


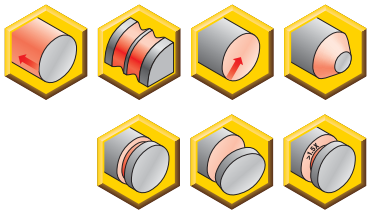
Integral Straight • Short Projection Toolholders • Metric



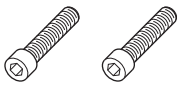
order number	catalogue number	seat size	CD	W min	H	B	H2	L1	FS	LH	clamp screw	clamp screw	Torx
right hand													
3854265	A4SMR2020K0208	2	8	2	20	20	24	125	19	26	–	MS1160	T20
3854267	A4SMR2020K0308	3	8	3	20	20	27	125	19	28	MS1595	–	T30
3854269	A4SMR2020K0408	4	8	4	20	20	27	125	18	28	MS1595	–	T30
3854271	A4SMR2525M0510	5	10	5	25	25	33	150	23	32	MS1970	–	T30
3854273	A4SMR2525M0610	6	10	6	25	25	33	150	22	37	MS1970	–	T30
left hand													
3854266	A4SML2020K0208	2	8	2	20	20	24	125	19	26	–	MS1160	T20
3854268	A4SML2020K0308	3	8	3	20	20	27	125	19	28	MS1595	–	T30
3854270	A4SML2020K0408	4	8	4	20	20	27	125	18	28	MS1595	–	T30
3854272	A4SML2525M0510	5	10	5	25	25	33	150	23	32	MS1970	–	T30
3854274	A4SML2525M0610	6	10	6	25	25	33	150	22	37	MS1970	–	T30



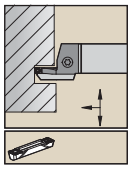


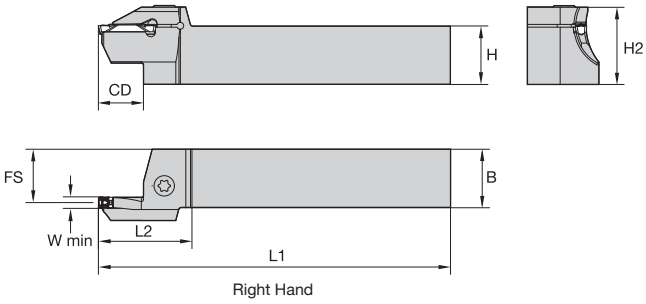


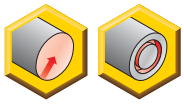
Integral Straight Top Clamp • Metric



order number	catalogue number	seat size	D max	CD	W min	H	B	H2	L1	FS	LH	clamp screw	clamp screw	wrench size clamp screw
right hand														
2982224	A4SCR1010K0113	1	27	13,500	1,50	10	10	21	125	9,40	25	MS1156	–	T15
2978378	A4SCR1212K0113	1	27	13,500	1,50	12	12	21	125	11,40	25	MS1156	–	T15
2982223	A4SCR1616K0113	1	27	13,500	1,50	16	16	21	125	15,40	25	MS1156	–	T15
2982172	A4SCR2020K0113	1	27	13,500	1,50	20	20	25	125	19,40	25	MS1156	–	T15
4169745	A4SCR1212K0214	2	28	14,000	2,00	12	12	21	125	11,17	28	MS1160	–	T20
4169746	A4SCR1616K0217	2	34	17,000	2,00	16	16	26	125	15,20	31	–	MS1944	T25
4169747	A4SCR1212K0314	3	28	14,000	3,00	12	12	23	125	10,72	30	–	MS2091	25 IP
4169748	A4SCR1616K0317	3	34	17,000	3,00	16	16	27	125	14,72	33	–	MS2091	25 IP
left hand														
2982170	A4SCL1212K0113	1	27	13,500	1,50	12	12	21	125	11,40	25	MS1156	–	T15
2982169	A4SCL1616K0113	1	27	13,500	1,50	16	16	21	125	15,40	25	MS1156	–	T15
2982168	A4SCL2020K0113	1	27	13,500	1,50	20	20	25	125	19,40	25	MS1156	–	T15
4169749	A4SCL1212K0214	2	28	14,000	2,00	12	12	21	125	11,17	28	MS1160	–	T20
4169750	A4SCL1616K0217	2	34	17,000	2,00	16	16	26	125	15,20	31	–	MS1944	T25
4169752	A4SCL1616K0317	3	34	17,000	3,00	16	16	27	125	14,72	33	–	MS2091	25 IP


Right hand shown.





Integral Face Grooving • Outboard • Metric



order number	catalogue number	seat size	CD	D min	D max	W min	H	B	H2	L1	FS	LH	clamp screw	Torx
right hand														
3865920	**A4SBR2020K2S12016020**	2S	12	16	20	2,00	20	20	25	125	19,20	28	–	T20
3865921	**A4SBR2020K2S12020025**	2S	12	20	25	2,00	20	20	25	125	19,20	28	–	T20
3865922	**A4SBR2020K2S12025036**	2S	12	25	36	2,00	20	20	25	125	19,20	28	–	T20
3865923	**A4SBR2020K3S14020025**	3S	14	20	25	3,00	20	20	28	125	18,70	35	**MS1595**	T30
3865924	**A4SBR2020K3S14025036**	3S	14	25	36	3,00	20	20	28	125	18,70	35	**MS1595**	T30
3865926	**A4SBR2020K4S14035048**	4S	14	35	48	4,00	20	20	28	125	18,20	35	**MS1595**	T30
3865927	**A4SBR2525M5S19028038**	5S	19	28	38	5,00	25	25	33	150	22,70	40	**MS1970**	T30
3865928	**A4SBR2525M5S19038058**	5S	19	38	58	5,00	25	25	33	150	22,70	40	**MS1970**	T30
left hand														
3865929	**A4SBL2020K2S12016020**	2S	12	16	20	2,00	20	20	25	125	19,20	28	–	T20
3865931	**A4SBL2020K2S12025036**	2S	12	25	36	2,00	20	20	25	125	19,20	28	–	T20
3865932	**A4SBL2020K3S14020025**	3S	14	20	25	3,00	20	20	28	125	18,70	35	**MS1595**	T30
3865934	**A4SBL2020K4S14025035**	4S	14	25	35	4,00	20	20	28	125	18,20	35	**MS1595**	T30
3865937	**A4SBL2525M5S19038058**	5S	19	38	58	5,00	25	25	33	150	22,70	40	**MS1970**	T30

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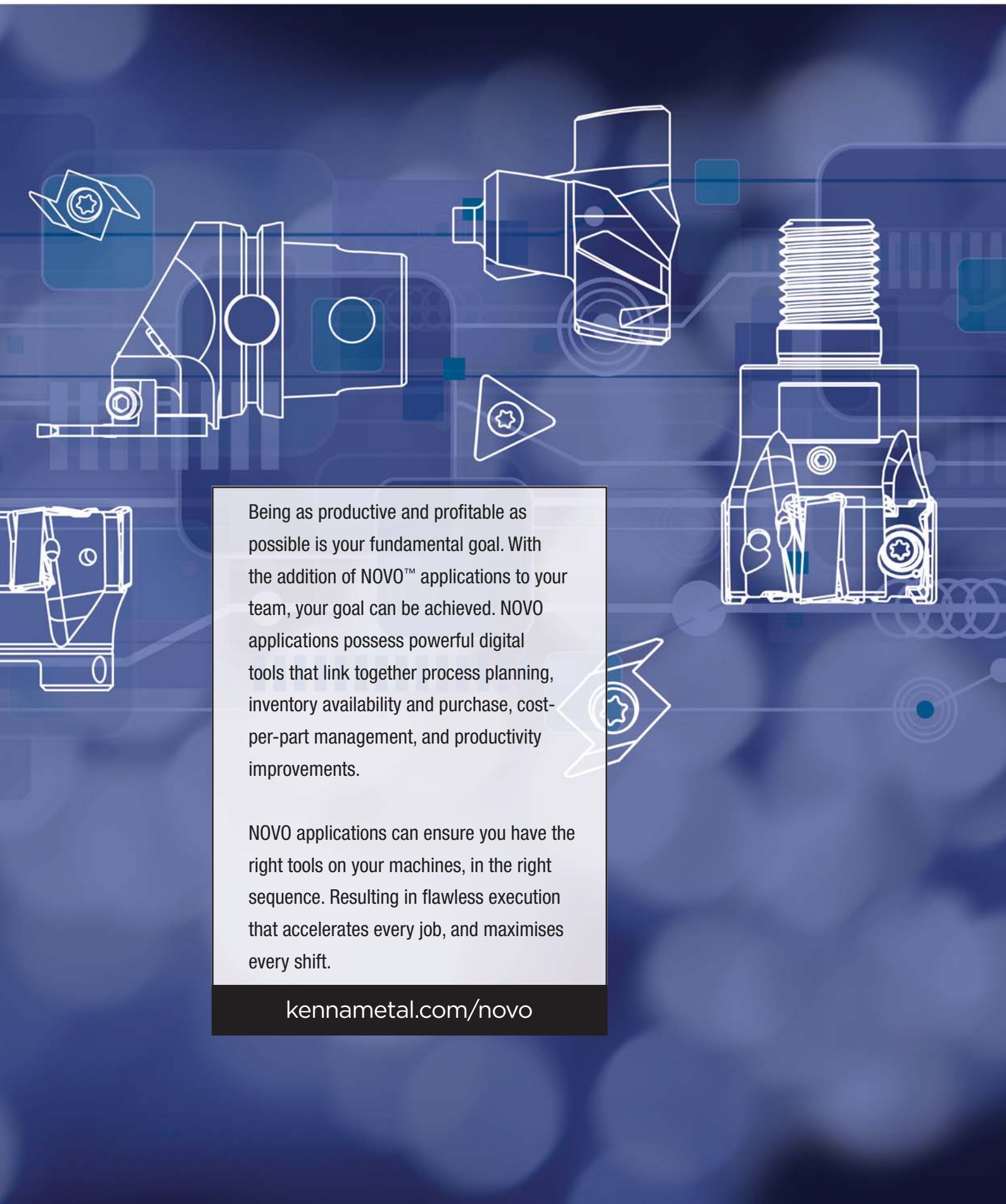

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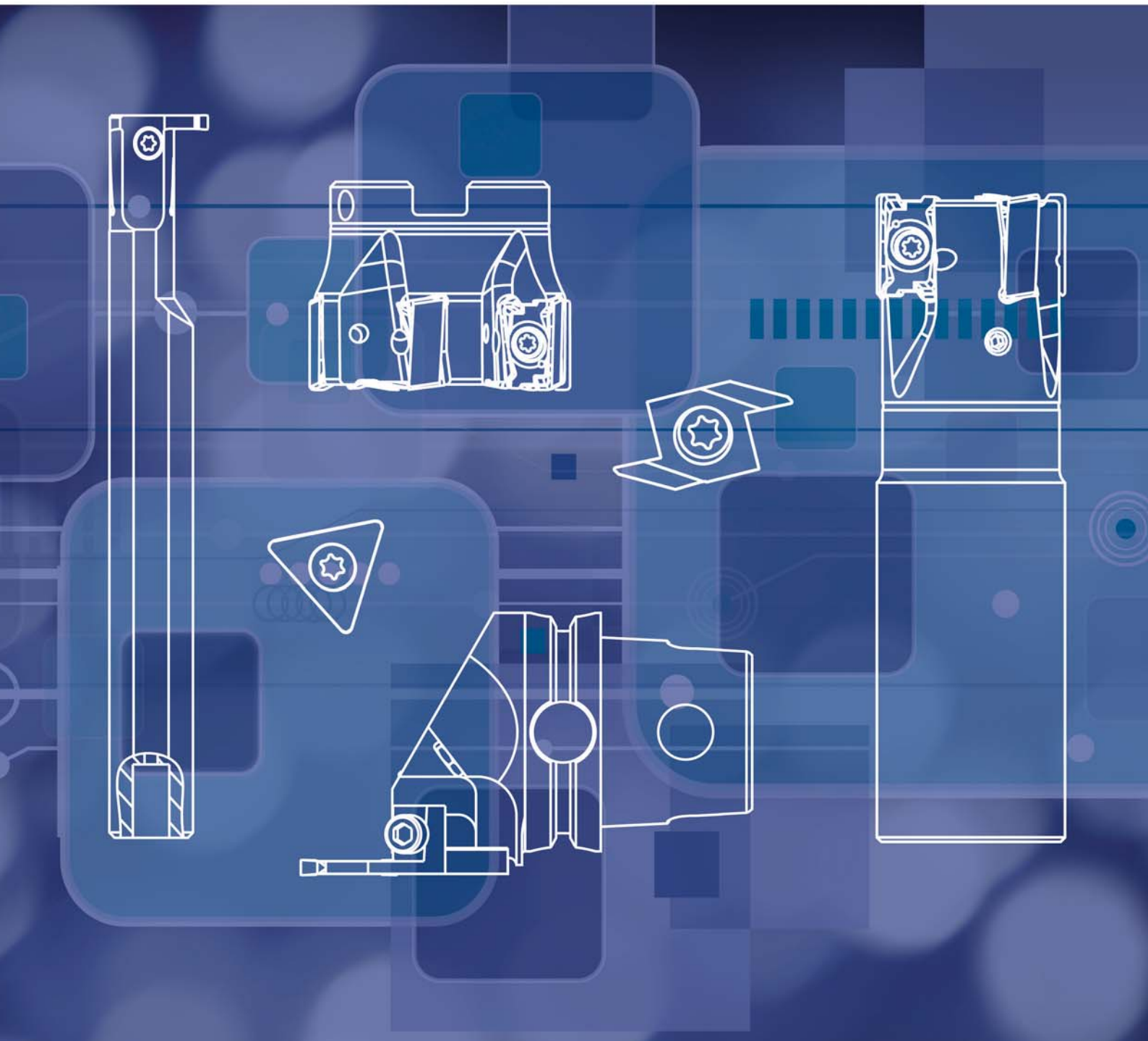

01

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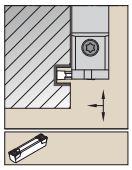
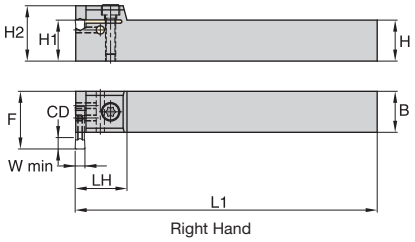
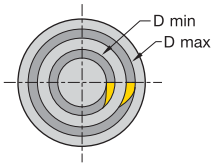
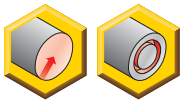








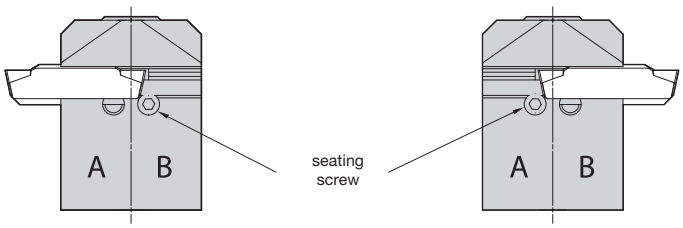
Integral Face Grooving • End Mount • Dua l Handed • Metric



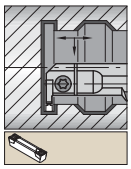

order number	catalogue number	seat size	CD	W min	D min	H1	B	H2	L1	F	LH	clamp screw	Torx	hex seating screw	hex (mm)
2414136	**A4ENN2020K0305**	3	5	3,00	70	20	20	27	125,0	25,4	25	**MS2091**	T25	**MS2090**	1.5 mm
2414137	**A4ENN2525M0305**	3	5	3,00	70	25	25	32	150,0	30,4	25	**MS2091**	T25	**MS2090**	1.5 mm
1949651	**A4ENN2020K0407**	4	7	4,00	90	20	20	27	125,0	27,9	25	**MS2091**	T25	**MS2090**	1.5 mm
1949652	**A4ENN2525M0407**	4	7	4,00	90	25	25	32	150,0	33,1	25	**MS2091**	T25	**MS2090**	1.5 mm
1949654	**A4ENN2525M0509**	5	9	5,00	120	25	25	33	150,0	35,1	34	**MS1970**	T30	**193.297**	1.5 mm
2503543	**A4ENN2020K0611**	6	11	6,00	120	20	20	28	125,0	35,4	34	**MS1595**	T30	**193.297**	2 mm
2503544	**A4ENN2525M0611**	6	11	6,00	120	25	25	33	150,0	38,9	34	**MS1970**	T30	**193.297**	2 mm
2503545	**A4ENN3232P0611**	6	11	6,00	120	32	32	40	170,0	43,4	34	**MS1970**	T30	**193.297**	2 mm

NOTE: D min for face grooving applications.
A4EN-style toolholders are designed without steel support for face grooving capacity. Cutting feed recommendations should be reduced by 25–30%.
Recommended clamp screw torque, 50–70 in. lbs. (6–8 Nm).
Minimum cutting width supplied for reference only; see insert listing for actual width. Always match seat size of insert to seat size of holder.

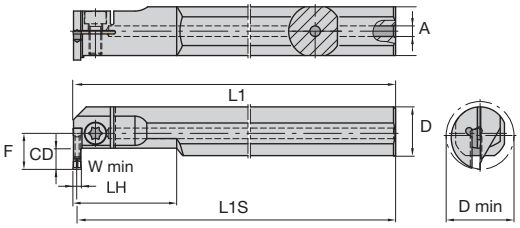
A4EN Insert Mounting



A4EN-style holders can be used for either left- or right-hand applications. The seating screw is to be used in position B for a left-hand cut and in position A for a right-hand cut.



Steel shank with through coolant.



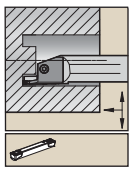
Right Hand

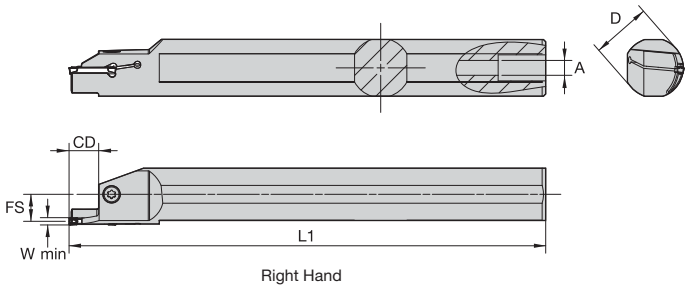


Steel Boring Bar • Metric

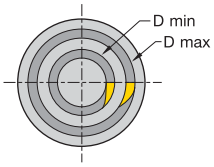


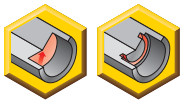
order number	catalogue number	seat size	CD	W min	D	D min	L1	F	L1S	A	clamp screw	wrench size clamp screw
right hand												
2979223	**A20RA4EMR0207M**	2	7,00	2,00	20	25	200	13	199,0	4,00	**MS2089**	25 IP
2979225	**A25RA4EMR0210M**	2	10,00	2,00	25	32	200	17	199,0	5,00	**MS2089**	25 IP
1949655	**A20RA4EMR0307M**	3	7,00	3,00	20	25	200	13	198,5	4,00	**MS2089**	25 IP
1949657	**A25RA4EMR0310M**	3	10,00	3,00	25	32	200	17	198,5	5,00	**MS1595**	T30
1949659	**A32SA4EMR0312M**	3	12,00	3,00	32	40	250	22	248,5	6,00	**MS1595**	T30
1949661	**A20RA4EMR0407M**	4	7,00	4,00	20	25	200	13	198,0	4,00	**MS2089**	25 IP
1949663	**A25RA4EMR0410M**	4	10,00	4,00	25	32	200	17	198,0	5,00	**MS1595**	T30
1949665	**A32SA4EMR0412M**	4	12,00	4,00	32	40	250	22	248,0	6,00	**MS1595**	T30
1949667	**A40TA4EMR0416M**	4	16,00	4,00	40	52	300	30	298,0	6,00	**MS1970**	T30
1949669	**A32SA4EMR0516M**	5	16,00	5,00	32	44	250	26	247,5	6,00	**MS1595**	T30
1949671	**A40TA4EMR0516M**	5	16,00	5,00	40	52	300	30	297,5	6,00	**MS1970**	T30
2263197	**A40TA4EMR0616M**	6	16,00	6,00	40	52	300	30	297,0	6,00	**MS1970**	T30
left hand												
2979192	**A20RA4EML0207M**	2	7,00	2,00	20	25	200	13	199,0	4,00	**MS2089**	25 IP
2979224	**A25RA4EML0210M**	2	10,00	2,00	25	32	200	17	199,0	5,00	**MS2089**	25 IP
1949656	**A20RA4EML0307M**	3	7,00	3,00	20	25	200	13	198,5	4,00	**MS2089**	25 IP
1949658	**A25RA4EML0310M**	3	10,00	3,00	25	32	200	17	198,5	5,00	**MS1595**	T30
1949660	**A32SA4EML0312M**	3	12,00	3,00	32	40	250	22	248,5	6,00	**MS1595**	T30
1949662	**A20RA4EML0407M**	4	7,00	4,00	20	25	200	13	198,0	4,00	**MS2089**	25 IP
1949664	**A25RA4EML0410M**	4	10,00	4,00	25	32	200	17	198,0	5,00	**MS1595**	T30
1949666	**A32SA4EML0412M**	4	12,00	4,00	32	40	250	22	248,0	6,00	**MS1595**	T30
1949668	**A40TA4EML0416M**	4	16,00	4,00	40	52	300	30	298,0	6,00	**MS1970**	T30
1949670	**A32SA4EML0516M**	5	16,00	5,00	32	44	250	26	247,5	6,00	**MS1595**	T30
1949672	**A40TA4EML0516M**	5	16,00	5,00	40	52	300	30	297,5	6,00	**MS1970**	T30
2263198	**A40TA4EML0616M**	6	16,00	6,00	40	52	300	30	297,0	6,00	**MS1970**	T30





Right Hand





Steel Face Grooving Boring Bar • Metric



order number	catalogue number	seat size	CD	D min	D max	W min	D	L1	FS	A	clamp screw	wrench size clamp screw
right hand												
3871038	**A16RA4SAR2S12M017021**	2S	12,00	17	21	2,00	16	201	7	4,00	**MS1160**	T20
3871039	**A20RA4SAR2S12M021026**	2S	12,00	21	23	2,00	20	201	9	4,00	**MS1160**	T20
3871040	**A25RA4SAR2S12M026036**	2S	12,00	26	36	2,00	25	201	12	6,35	**MS1160**	T20
3871041	**A20RA4SAR3S14M021026**	3S	14,00	21	26	3,00	20	201	9	4,00	**MS1160**	T20
3871042	**A25RA4SAR3S14M026036**	3S	14,00	26	36	3,00	25	201	11	6,35	**MS1160**	T20
left hand												
3871033	**A16RA4SAL2S12M017021**	2S	12,00	17	21	2,00	16	201	7	4,00	**MS1160**	T20
3871034	**A20RA4SAL2S12M021026**	2S	12,00	21	26	2,00	20	201	9	4,00	**MS1160**	T20
3871035	**A25RA4SAL2S12M026036**	2S	12,00	26	36	2,00	25	201	12	6,35	**MS1160**	T20
3871037	**A25RA4SAL3S14M026036**	3S	14,00	26	36	3,00	25	201	11	6,35	**MS1160**	T20

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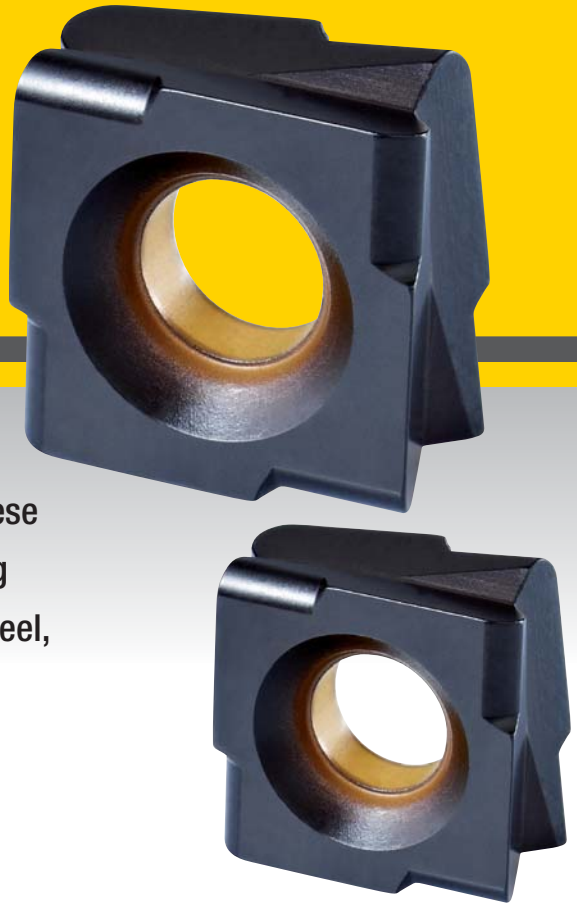

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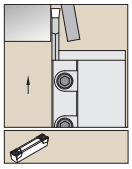
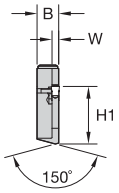
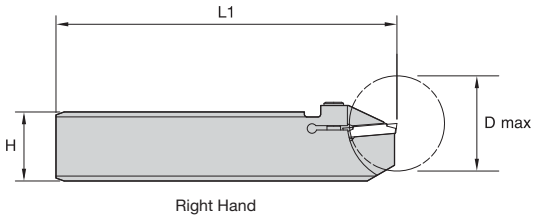
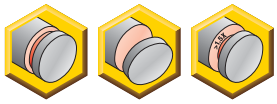






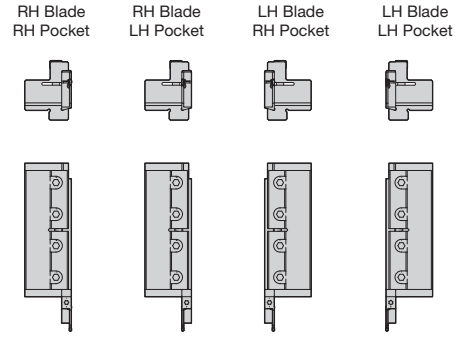


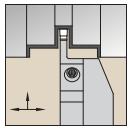
Single-Ended Cut-Off Blade • Metric



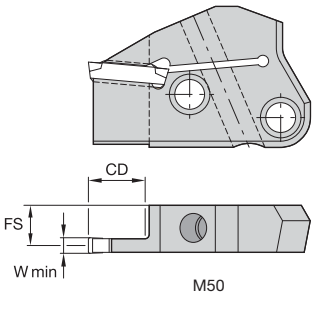
order number	catalogue number	seat size	H	W	H1	L1	B	D max	clamp screw	Torx
right hand										
3967127	**A4BHCL26K0317R**	3	26	3,0	21,4	125	7,95	35	**MS1571**	T20
3967124	**A4BHCL32K0317R**	3	32	3,0	25,0	125	7,95	35	**MS1571**	T20
3967117	**A4BHCR32K0217R**	2	32	2,0	25,0	125	7,95	35	**MS1571**	T20
left hand										
3967136	**A4BHCL32K0217L**	2	32	2,0	25,0	125	7,95	35	**MS1571**	T20
3967137	**A4BHCL32K0317L**	3	32	3,0	25,0	125	7,95	35	**MS1571**	T20
3967134	**A4BHCR26K0317L**	3	26	3,0	21,4	125	7,95	35	**MS1571**	T20

NOTE: Seat size 1 blades only.
Assembly wrenches 170.137 and 170.130 must be ordered separately.

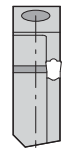


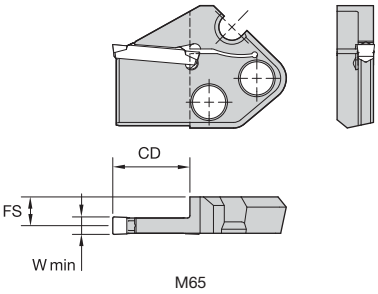

Right hand shown





M50

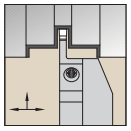

Right Hand



M65

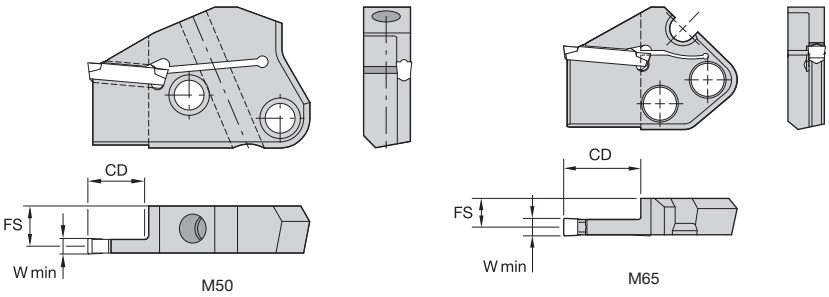
Modular Straight Blade with Coolant

order number	catalogue number	seat size	CD	FS	blade size
right hand					
6401815	**A4M50R0314MC**	3	14,0	10,42	50
6401817	**A4M50R0414MC**	4	14,0	9,92	50
6401819	**A4M50R0519MC**	5	19,0	9,42	50
6401834	**A4M65R0620MC**	6	20,0	9,88	65
6401838	**A4M65R0820MC**	8	20,0	9,00	65
6401852	**A4M65R1020MC**	10	20,0	8,35	65
6401831	**A4M65R0522MC**	5	22,0	10,28	65
6401835	**A4M65R0626MC**	6	26,0	9,88	65
6401839	**A4M65R0826MC**	8	26,0	9,00	65
6401853	**A4M65R1026MC**	10	26,0	8,35	65
left hand					
6401814	**A4M50L0314MC**	3	14,0	10,42	50
6401816	**A4M50L0414MC**	4	14,0	9,92	50
6401818	**A4M50L0519MC**	5	19,0	9,43	50
6401832	**A4M65L0620MC**	6	20,0	9,88	65
6401836	**A4M65L0820MC**	8	20,0	9,00	65
6401840	**A4M65L1020MC**	10	20,0	8,35	65
6401820	**A4M65L0522MC**	5	22,0	10,28	65
6401833	**A4M65L0626MC**	6	26,0	9,88	65
6401837	**A4M65L0826MC**	8	26,0	9,00	65
6401851	**A4M65L1026MC**	10	26,0	8,35	65



Right hand shown.

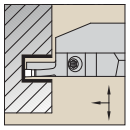




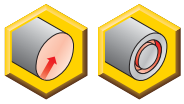
Modular Straight Blade

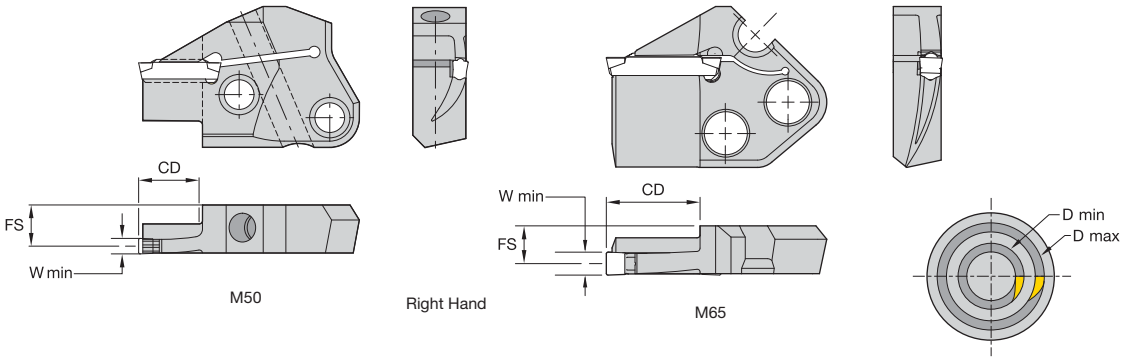
order number	catalogue number	seat size	W min	CD	FS	blade size
right hand						
3051624	**A4M50R0214M**	2	2,00	14,0	10,87	50
1989348	**A4M50R0314M**	3	3,00	14,0	10,43	50
1989350	**A4M50R0414M**	4	4,00	14,0	9,93	50
1989352	**A4M50R0519M**	5	5,00	19,0	9,43	50
3557114	**A4M65R0620M**	6	6,00	20,0	9,88	65
3557116	**A4M65R0626M**	6	6,00	26,0	9,88	65
3557120	**A4M65R0826M**	8	8,00	26,0	9,00	65
3557124	**A4M65R1026M**	10	10,00	26,0	8,35	65
left hand						
3022625	**A4M50L0214M**	2	2,00	14,0	10,87	50
1989347	**A4M50L0314M**	3	3,00	14,0	10,43	50
1989349	**A4M50L0414M**	4	4,00	14,0	9,93	50
3051623	**A4M50L2B14M**	2B	2,50	14,0	10,70	50
1989351	**A4M50L0519M**	5	5,00	19,0	9,43	50
3557115	**A4M65L0620M**	6	6,00	20,0	9,88	65
3557119	**A4M65L0820M**	8	8,00	20,0	9,00	65
3557123	**A4M65L1020M**	10	10,00	20,0	8,35	65
3557117	**A4M65L0626M**	6	6,00	26,0	9,88	65
3557121	**A4M65L0826M**	8	8,00	26,0	9,00	65
3557125	**A4M65L1026M**	10	10,00	26,0	8,35	65

NOTE: Seat size 2B only accepts 2B inserts. Seat size 2 accepts 2 or 2B inserts.



Right hand shown.





Modular Face Grooving Blade • Inboard

order number	catalogue number	seat size	D min	D max	cartridge size
right hand					
3051670	**A4M50R0212A036046**	2	36	46	50
3051671	**A4M50R0212A042054**	2	42	54	50
3051672	**A4M50R0212A050064**	2	50	64	50
3051673	**A4M50R0212A060084**	2	60	84	50
3051674	**A4M50R0212A080124**	2	80	124	50
3051675	**A4M50R0212A120254**	2	120	254	50
3051676	**A4M50R0212A250999**	2	250	–	50
2542517	**A4M50R0314A036048**	3	36	48	50
2542518	**A4M50R0314A042058**	3	42	58	50
2542519	**A4M50R0314A052074**	3	52	74	50
2542520	**A4M50R0314A068100**	3	68	100	50
2542521	**A4M50R0314A090160**	3	90	160	50
2542522	**A4M50R0314A130300**	3	130	300	50
2542523	**A4M50R0314A290999**	3	290	–	50
2542531	**A4M50R0414A048072**	4	48	72	50
2542532	**A4M50R0414A064100**	4	64	100	50
2542533	**A4M50R0414A092150**	4	92	150	50
2542534	**A4M50R0414A132300**	4	132	300	50
2542535	**A4M50R0414A290999**	4	290	–	50
2542541	**A4M50R0519A058094**	5	58	94	50
2542542	**A4M50R0519A080136**	5	80	136	50
2542543	**A4M50R0519A120300**	5	120	300	50
2542544	**A4M50R0519A250999**	5	250	–	50
3557131	**A4M65R0624A070-112**	6	70	112	65
3557163	**A4M65R0624A100-212**	6	100	212	65
3557165	**A4M65R0624A200-999**	6	200	999	65
3557167	**A4M65R0824A090-200**	8	90	200	65
3557169	**A4M65R0824A184-999**	8	184	999	65
3557173	**A4M65R1024A200-999**	10	200	999	65

(*continued*)

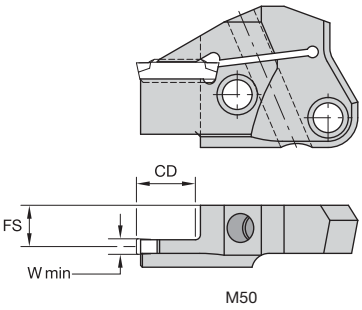
(Modular Face Grooving Blade • Inboard — continued)

order number	catalogue number	seat size	D min	D max	cartridge size
left hand					
3051629	**A4M50L0212A060084**	2	60	84	50
3051631	**A4M50L0212A120254**	2	120	254	50
3051632	**A4M50L0212A250999**	2	250	—	50
2542524	**A4M50L0314A036048**	3	36	48	50
2542527	**A4M50L0314A068100**	3	68	100	50
2542528	**A4M50L0314A090160**	3	90	160	50
2542529	**A4M50L0314A130300**	3	130	300	50
2542530	**A4M50L0314A290999**	3	290	—	50
2542537	**A4M50L0414A064100**	4	64	100	50
2542538	**A4M50L0414A092150**	4	92	150	50
2542539	**A4M50L0414A132300**	4	132	300	50
2542540	**A4M50L0414A290999**	4	290	—	50
2542545	**A4M50L0519A058094**	5	58	94	50
2542546	**A4M50L0519A080136**	5	80	136	50
2542547	**A4M50L0519A120300**	5	120	300	50
2542548	**A4M50L0519A250999**	5	250	—	50
3557132	**A4M65L0624A070-112**	6	70	112	65
3557164	**A4M65L0624A100-212**	6	100	212	65
3557166	**A4M65L0624A200-999**	6	200	999	65
3557174	**A4M65L1024A200-999**	10	200	999	65

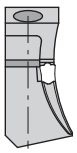


Right hand shown.

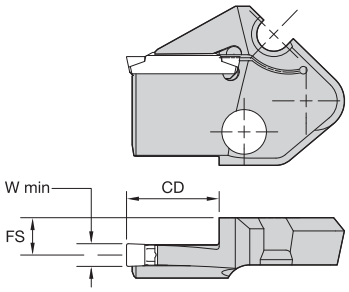




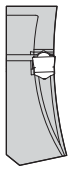
M50

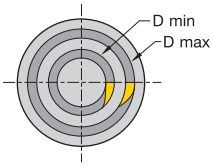


Right Hand



M65





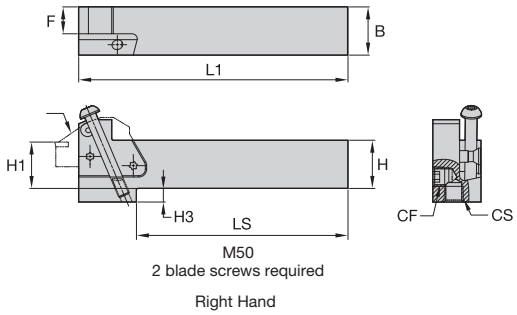
Modular Face Grooving Blade • Outboard

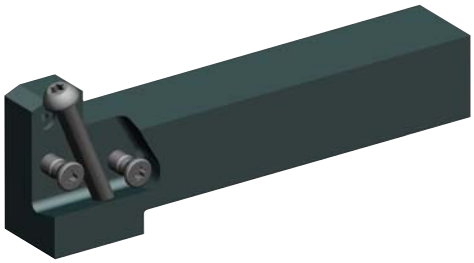
order number	catalogue number	seat size	D min	D max	CD	FS	cartridge size
right hand							
3051677	**A4M50R0212B036046**	2	36	46	12,00	10,900	50
3051678	**A4M50R0212B042054**	2	42	54	12,00	10,900	50
3051679	**A4M50R0212B050064**	2	50	64	12,00	10,900	50
3051680	**A4M50R0212B060084**	2	60	84	12,00	10,900	50
3051681	**A4M50R0212B080124**	2	80	124	12,00	10,900	50
3051682	**A4M50R0212B120254**	2	120	254	12,00	10,900	50
3051683	**A4M50R0212B250999**	2	250	–	12,00	10,900	50
3867457	**A4M50R2S12B016020**	2S	16	20	12,00	10,900	50
3867458	**A4M50R2S12B020025**	2S	20	25	12,00	10,900	50
3867459	**A4M50R2S12B025036**	2S	25	36	12,00	10,900	50
2398751	**A4M50R0314B036048**	3	36	48	14,00	10,500	50
2398752	**A4M50R0314B042058**	3	42	58	14,00	10,500	50
2398763	**A4M50R0314B052074**	3	52	74	14,00	10,500	50
2398764	**A4M50R0314B068100**	3	68	100	14,00	10,500	50
2398765	**A4M50R0314B090160**	3	90	160	14,00	10,500	50
2398766	**A4M50R0314B130300**	3	130	300	14,00	10,500	50
2398767	**A4M50R0314B290999**	3	290	–	14,00	10,500	50
2398775	**A4M50R0414B048072**	4	48	72	14,00	10,000	50
2398776	**A4M50R0414B064100**	4	64	100	14,00	10,000	50
2398777	**A4M50R0414B092150**	4	92	150	14,00	10,000	50
2398778	**A4M50R0414B132300**	4	132	300	14,00	10,000	50
2398779	**A4M50R0414B290999**	4	290	–	14,00	10,000	50
3867460	**A4M50R3S14B020025**	3S	20	25	14,00	10,490	50
3867461	**A4M50R3S14B025036**	3S	25	36	14,00	10,490	50
3867462	**A4M50R4S14B025035**	4S	25	35	14,00	10,000	50
3867464	**A4M50R5S17B028038**	5S	28	38	17,00	9,500	50
2398785	**A4M50R0519B058094**	5	58	94	19,00	9,500	50
2398786	**A4M50R0519B080136**	5	80	136	19,00	9,500	50
2398787	**A4M50R0519B120300**	5	120	300	19,00	9,500	50
2398788	**A4M50R0519B250999**	5	250	–	19,00	9,500	50
3557175	**A4M65R0624B070-112**	6	70	112	24,00	9,870	65
3557177	**A4M65R0624B100-212**	6	100	212	24,00	9,870	65
3557179	**A4M65R0624B200-999**	6	200	999	24,00	9,870	65
3557181	**A4M65R0824B090-200**	8	90	200	24,00	9,000	65
3557193	**A4M65R0824B184-999**	8	184	999	24,00	9,000	65
3557195	**A4M65R1024B100-220**	10	100	220	24,00	8,350	65
3557197	**A4M65R1024B200-999**	10	200	999	24,00	8,350	65

(*continued*)

(Modular Face Grooving Blade • Outboard — continued)

order number	catalogue number	seat size	D min	D max	CD	FS	cartridge size
left hand							
3051663	**A4M50L0212B036046**	2	36	46	12,00	10,900	50
3051664	**A4M50L0212B042054**	2	42	54	12,00	10,900	50
3051665	**A4M50L0212B050064**	2	50	64	12,00	10,900	50
3051666	**A4M50L0212B060084**	2	60	84	12,00	10,900	50
3051667	**A4M50L0212B080124**	2	80	124	12,00	10,900	50
3051668	**A4M50L0212B120254**	2	120	254	12,00	10,900	50
3867466	**A4M50L2S12B016020**	2S	16	20	12,00	10,900	50
3867467	**A4M50L2S12B020025**	2S	20	25	12,00	10,900	50
3867468	**A4M50L2S12B025036**	2S	25	36	12,00	10,900	50
2398768	**A4M50L0314B036048**	3	36	48	14,00	10,500	50
2398769	**A4M50L0314B042058**	3	42	58	14,00	10,500	50
2398770	**A4M50L0314B052074**	3	52	74	14,00	10,500	50
2398771	**A4M50L0314B068100**	3	68	100	14,00	10,500	50
2398772	**A4M50L0314B090160**	3	90	160	14,00	10,500	50
2398773	**A4M50L0314B130300**	3	130	300	14,00	10,500	50
2398774	**A4M50L0314B290999**	3	290	—	14,00	10,500	50
2398780	**A4M50L0414B048072**	4	48	72	14,00	10,000	50
2398781	**A4M50L0414B064100**	4	64	100	14,00	10,000	50
2398782	**A4M50L0414B092150**	4	92	150	14,00	10,000	50
2398783	**A4M50L0414B132300**	4	132	300	14,00	10,000	50
2398784	**A4M50L0414B290999**	4	290	—	14,00	10,000	50
3867469	**A4M50L3S14B020025**	3S	20	25	14,00	10,490	50
3867470	**A4M50L3S14B025036**	3S	25	36	14,00	10,490	50
3867472	**A4M50L4S14B035048**	4S	35	48	14,00	10,000	50
3867484	**A4M50L5S17B028038**	5S	28	38	17,00	9,500	50
2398789	**A4M50L0519B058094**	5	58	94	19,00	9,500	50
2398790	**A4M50L0519B080136**	5	80	136	19,00	9,500	50
2398791	**A4M50L0519B120300**	5	120	300	19,00	9,500	50
2398792	**A4M50L0519B250999**	5	250	—	19,00	9,500	50
3557176	**A4M65L0624B070-112**	6	70	112	24,00	9,870	65
3557178	**A4M65L0624B100-212**	6	100	212	24,00	9,870	65
3557180	**A4M65L0624B200-999**	6	200	999	24,00	9,870	65
3557182	**A4M65L0824B090-200**	8	90	200	24,00	9,000	65
3557194	**A4M65L0824B184-999**	8	184	999	24,00	9,000	65
3557198	**A4M65L1024B200-999**	10	200	999	24,00	8,350	65





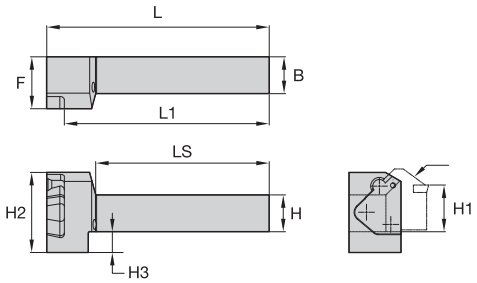
Modular Straight Toolholder • Metric

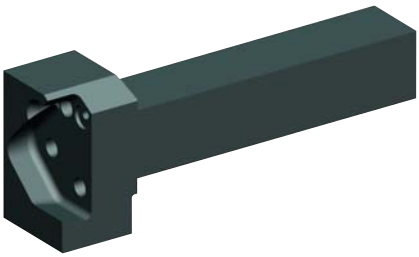
NOTE: For modular straight toolholder with coolant, see page C58.




order number	catalogue number	B	H	L1	F	LS	H3	blade screw	Torx	clamp screw	Torx
right hand											
1600249	**KGMSR2525M50**	25	25	138,75	13,84	109,00	7,00	**MS1162**	T25	**MS2002**	T25
3553429	**KGMSR2525M65**	25	25	150,00	13,00	120,00	14,00	**MS1163**	T30	**–**	–
1621083	**KGMSR3232P50**	32	32	158,75	20,81	–	–	**MS1162**	T25	**MS2002**	T25
3553431	**KGMSR3232P65**	32	32	170,00	20,79	158,00	7,00	**MS1163**	T30	**–**	–
left hand											
1600250	**KGMSL2525M50**	25	25	138,75	13,84	109,00	7,00	**MS1162**	T25	**MS2002**	T25
3553430	**KGMSL2525M65**	25	25	150,00	13,00	120,00	14,00	**MS1163**	T30	**–**	–
1621084	**KGMSL3232P50**	32	32	158,75	20,81	–	–	**MS1162**	T25	**MS2002**	T25
3553432	**KGMSL3232P65**	32	32	170,00	20,79	158,00	7,00	**MS1163**	T30	**–**	–

NOTE: KGMS..: Right-hand holder uses right-hand blades.
KGME..: Right-hand holder uses left-hand blades.
M50 blade and clamp screw torque equals 8–10 Nm (71–88 in. lbs.).
M65 blade and clamp screw torque equals 18–20 Nm (159–177 in. lbs.).





M65
2 blade screws required

Right Hand

Modular End Mount Toolholders • Metric

NOTE: For modular end mount toolholder with coolant, see page C59.

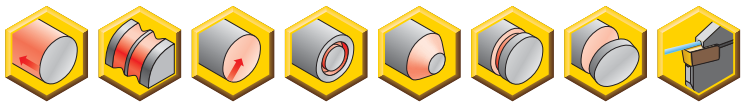


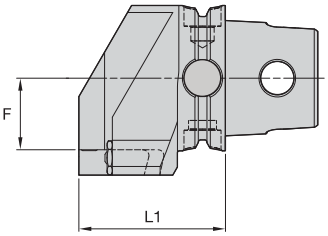


order number	catalogue number	B	H	L1	F	LS	H3	L	blade screw (2 required)	Torx	clamp screw	Torx
right hand												
1600270	**KGMER2525M50**	25	25	139,25	42,75	125,25	6,84	150,25	**MS1162**	T25	**MS2002**	T25
3553453	**KGMER2525M65**	25	25	138,15	35,00	129,00	14,00	150,00	**MS1163**	T30	**–**	–
1621085	**KGMER3232P50**	32	32	159,25	42,75	145,25	–	170,25	**MS1162**	T25	**MS2002**	T25
3553455	**KGMER3232P65**	32	32	158,15	35,00	153,00	7,00	170,00	**MS1163**	T30	**–**	–
left hand												
1600271	**KGMEL2525M50**	25	25	139,25	42,75	125,25	6,84	150,25	**MS1162**	T25	**MS2002**	T25
3553454	**KGMEL2525M65**	25	25	138,15	35,00	129,00	14,00	150,00	**MS1163**	T30	**–**	–
1621086	**KGMEL3232P50**	32	32	159,25	42,75	145,25	–	170,25	**MS1162**	T25	**MS2002**	T25
3553456	**KGMEL3232P65**	32	32	158,15	35,00	153,00	7,00	170,00	**MS1163**	T30	**–**	–

NOTE: KGMS..: Right-hand holder uses right-hand blades.
KGME..: Right-hand holder uses left-hand blades.
M50 blade and clamp screw torque equals 8–10 Nm (71–88 in. lbs.).
M65 blade and clamp screw torque equals 18–20 Nm (159–177 in. lbs.).

- Best-in-class KM Quick-Change platform.
- Through the pocket coolant capable.
- Interchangeable blades for versatility and depth of cut.







Right Hand

KM QUICK CHANGE

Modular Straight KM System with Coolant

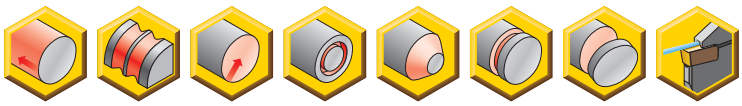


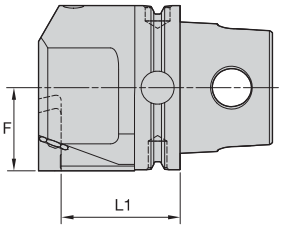


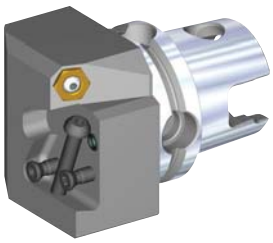
order number	catalogue number	CSMS system size	L1	F	blade size	blade screw	Torx	clamp screw	Torx
right hand									
5999790	**KM40TSKGMSR50C**	KM40TS	53,5	15,0	50	**MS1162**	T25	**MS2002**	T25
6000422	**KM50TSKGMSR65C**	KM50TS	53,5	22,0	65	**MS1163**	T30	**–**	–
5999864	**KM50TSKGMSR50C**	KM50TS	58,5	23,0	50	**MS1162**	T25	**MS2002**	T25
6000431	**KM63TSKGMSR65C**	KM63TS	58,5	30,0	65	**MS1163**	T30	**–**	–
5999948	**KM63TSKGMSR50C**	KM63TS	63,5	31,0	50	**MS1162**	T25	**MS2002**	T25
5999972	**KM63XMZKGMSR50CY**	KM63XMZ	63,5	31,0	50	**MS1162**	T25	**MS2002**	T25
6017695	**KM80TSKGMSR65C**	KM80TS	63,5	40,0	65	**MS1163**	T30	**–**	–
6000018	**KM80ATCKGMSR50C**	KM80ATC	66,5	41,0	50	**MS1162**	T25	**MS2002**	T25
6000014	**KM80TSKGMSR50C**	KM80TS	66,5	41,0	50	**MS1162**	T25	**MS2002**	T25
left hand									
5999861	**KM40TSKGMSL50C**	KM40TS	53,5	15,0	50	**MS1162**	T25	**MS2002**	T25
6000424	**KM50TSKGMSL65C**	KM50TS	53,5	22,0	65	**MS1163**	T30	**–**	–
5999865	**KM50TSKGMSL50C**	KM50TS	58,5	23,0	50	**MS1162**	T25	**MS2002**	T25
6000433	**KM63TSKGMSL65C**	KM63TS	58,5	30,0	65	**MS1163**	T30	**–**	–
5999949	**KM63TSKGMSL50C**	KM63TS	63,5	31,0	50	**MS1162**	T25	**MS2002**	T25
5999973	**KM63XMZKGMSLF50CY**	KM63XMZ	63,5	31,0	50	**MS1162**	T25	**MS2002**	T25
6017696	**KM80TSKGMSL65C**	KM80TS	63,5	40,0	65	**MS1163**	T30	**–**	–
6000019	**KM80ATCKGMSL50C**	KM80ATC	66,5	41,0	50	**MS1162**	T25	**MS2002**	T25
6000015	**KM80TSKGMSL50C**	KM80TS	66,5	41,0	50	**MS1162**	T25	**MS2002**	T25

NOTE: KGMS..: Right-hand holder uses right-hand blades.
KGME..: Right-hand holder uses left-hand blades.
M50 blade and clamp screw torque equals 8–10 Nm (71–88 in. lbs.).
M65 blade and clamp screw torque equals 18–20 Nm (159–177 in. lbs.).

- Best-in-class KM Quick-Change platform.
- Through the pocket coolant capable.
- Interchangeable blades for versatility and depth of cut.






Right Hand

KM QUICK CHANGE

Modular End Mount KM System with Coolant • Metric

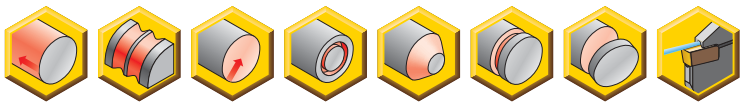


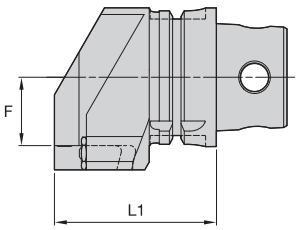


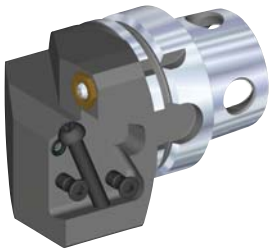
order number	catalogue number	CSMS system size	L1	F	blade size	blade screw	Torx	clamp screw	Torx
right hand									
5999788	**KM40TSKGMER50C**	KM40TS	28,0	20,50	50	**MS1162**	T25	**MS2002**	T25
5999862	**KM50TSKGMER50C**	KM50TS	38,0	25,50	50	**MS1162**	T25	**MS2002**	T25
6000410	**KM50TSKGMER65C**	KM50TS	47,0	25,50	65	**MS1163**	T30	**–**	–
6000425	**KM63TSKGMER65C**	KM63TS	47,0	32,52	65	**MS1163**	T30	**–**	–
5999946	**KM63TSKGMER50C**	KM63TS	48,0	32,50	50	**MS1162**	T25	**MS2002**	T25
6000434	**KM63XMZKGMER65CY**	KM63XMZ	47,0	32,50	65	**MS1163**	T30	**–**	–
5999950	**KM63XMZKGMER50CY**	KM63XMZ	48,0	32,50	50	**MS1162**	T25	**MS2002**	T25
6017697	**KM80ATCKGMER65C**	KM80ATC	57,0	40,50	65	**MS1163**	T30	**–**	–
6000016	**KM80ATCKGMER50C**	KM80ATC	58,0	40,50	50	**MS1162**	T25	**MS2002**	T25
6017693	**KM80TSKGMER65C**	KM80TS	57,0	40,50	65	**MS1163**	T30	**–**	–
6000012	**KM80TSKGMER50C**	KM80TS	58,0	40,50	50	**MS1162**	T25	**MS2002**	T25
left hand									
5999789	**KM40TSKGMEL50C**	KM40TS	28,0	20,50	50	**MS1162**	T25	**MS2002**	T25
5999863	**KM50TSKGMEL50C**	KM50TS	38,0	25,50	50	**MS1162**	T25	**MS2002**	T25
6000421	**KM50TSKGMEL65C**	KM50TS	47,0	25,50	65	**MS1163**	T30	**–**	–
6000430	**KM63TSKGMEL65C**	KM63TS	47,0	32,52	65	**MS1163**	T30	**–**	–
5999947	**KM63TSKGMEL50C**	KM63TS	48,0	32,50	50	**MS1162**	T25	**MS2002**	T25
6000436	**KM63XMZKGMELF65CY**	KM63XMZ	47,0	32,50	65	**MS1163**	T30	**–**	–
5999971	**KM63XMZKGMELF50CY**	KM63XMZ	48,0	32,50	50	**MS1162**	T25	**MS2002**	T25
6017698	**KM80ATCKGMEL65C**	KM80ATC	57,0	40,50	65	**MS1163**	T30	**–**	–
6000017	**KM80ATCKGMEL50C**	KM80ATC	58,0	40,50	50	**MS1162**	T25	**MS2002**	T25
6017694	**KM80TSKGMEL65C**	KM80TS	57,0	40,50	65	**MS1163**	T30	**–**	–
6000013	**KM80TSKGMEL50C**	KM80TS	58,0	40,50	50	**MS1162**	T25	**MS2002**	T25

NOTE: KGMS..: Right-hand holder uses right-hand blades.
KGME..: Right-hand holder uses left-hand blades.
M50 blade and clamp screw torque equals 8–10 Nm (71-88 in. lbs.).
M65 blade and clamp screw torque equals 18–20 Nm (159–177 in. lbs.).

- Through the pocket coolant capable.
- Interchangeable blades for versatility and depth of cut.







Right Hand

Modular Straight KM4X™ System with Coolant

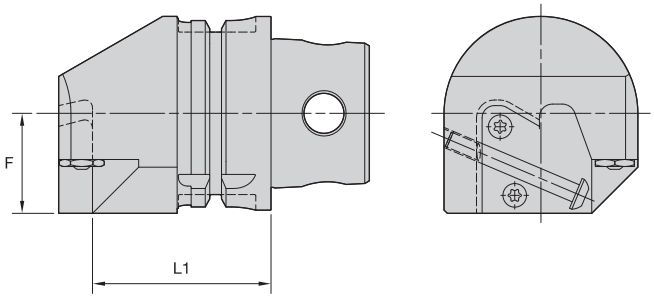


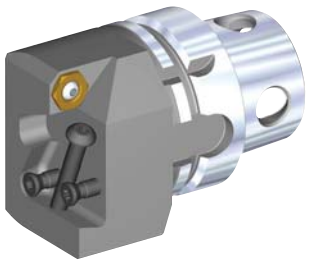


order number	catalogue number	CSMS system size	L1	F	blade size	blade screw	Torx	clamp screw	Torx
right hand									
5543560	**KM4X63KGMSR65C**	KM4X63	68,5	30,0	65	**MS1163**	T30	**–**	–
6000407	**KM4X63KGMSR50C**	KM4X63	73,5	31,0	50	**MS1162**	T25	**MS2002**	T25
left hand									
5543558	**KM4X63KGMSL65C**	KM4X63	68,5	30,0	65	**MS1163**	T30	**–**	–
6000408	**KM4X63KGMSL50C**	KM4X63	73,5	31,0	50	**MS1162**	T25	**MS2002**	T25

NOTE: KGMS..: Right-hand holder uses right-hand blades.
KGME..: Right-hand holder uses left-hand blades.
M50 blade and clamp screw torque equals 8–10 Nm (71-88 in. lbs.).
M65 blade and clamp screw torque equals 18–20 Nm (159–177 in. lbs.).







Right Hand

Modular End Mount KM4X™ System with Coolant

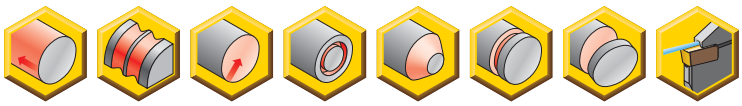


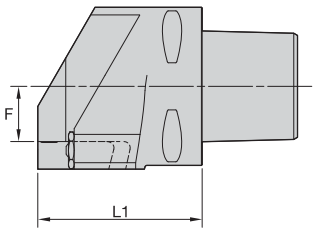


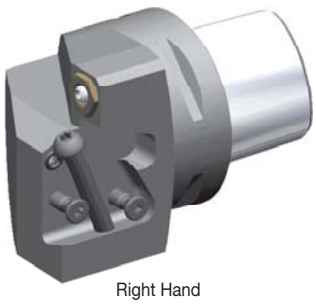


order number	catalogue number	CSMS system size	L1	F	cartridge size	blade screw	nozzle	clamp screw	kg	lbs
right hand										
5543555	**KM4X63KGMER65C**	KM4X63	57,0	32,5	65	**MS1163**	**PMT04525**	**–**	1,87	4.13
6000404	**KM4X63KGMER50C**	KM4X63	58,0	32,5	50	**MS1162**	**PMT04525**	**MS2002**	1,85	4.08
6000407	**KM4X63KGMSR50C**	KM4X63	73,5	31,0	50	**MS1162**	**PMT04525**	**MS2002**	1,86	4.11
left hand										
5543553	**KM4X63KGMEL65C**	KM4X63	57,0	32,5	65	**MS1163**	**PMT04525**	**–**	1,87	4.13
6000405	**KM4X63KGMEL50C**	KM4X63	58,0	32,5	50	**MS1162**	**PMT04525**	**MS2002**	1,85	4.08
6000408	**KM4X63KGMSL50C**	KM4X63	73,5	31,0	50	**MS1162**	**PMT04525**	**MS2002**	1,86	4.11

- Standard PSC Quick-Change platform.
- Through the pocket coolant capable.
- Interchangeable blades for versatility and depth of cut.







Right Hand

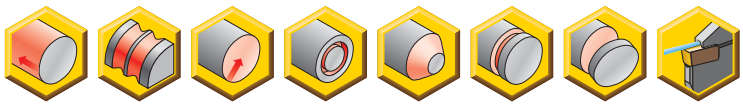
Modular Straight PSC System with Coolant

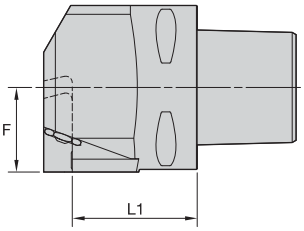




order number	catalogue number	CSMS system size	L1	F	blade size	blade screw	Torx	clamp screw	Torx
right hand									
6000028	**PSC40KGMSR50C**	PSC40	63,5	10,0	50	**MS1162**	T25	**MS2002**	T25
5405654	**PSC50KGMSR65C**	PSC50	49,0	25,5	65	**MS1163**	T30	**–**	–
6000152	**PSC50KGMSR50C**	PSC50	63,5	15,0	50	**MS1162**	T25	**MS2002**	T25
6000464	**PSC63KGMSR65C**	PSC63	60,5	21,0	65	**MS1163**	T30	**–**	–
6000211	**PSC63KGMSR50C**	PSC63	65,5	22,0	50	**MS1162**	T25	**MS2002**	T25
6000468	**PSC80KGMSR65C**	PSC80	68,5	29,0	65	**MS1163**	T30	**–**	–
6000216	**PSC80KGMSR50C**	PSC80	73,5	30,0	50	**MS1162**	T25	**MS2002**	T25
left hand									
6000029	**PSC40KGMSL50C**	PSC40	63,5	10,0	50	**MS1162**	T25	**MS2002**	T25
5405655	**PSC50KGMSL65C**	PSC50	49,0	25,5	65	**MS1163**	T30	**–**	–
6000153	**PSC50KGMSL50C**	PSC50	63,5	15,0	50	**MS1162**	T25	**MS2002**	T25
6000465	**PSC63KGMSL65C**	PSC63	60,5	21,0	65	**MS1163**	T30	**–**	–
6000213	**PSC63KGMSL50C**	PSC63	65,5	22,0	50	**MS1162**	T25	**MS2002**	T25
6000469	**PSC80KGMSL65C**	PSC80	68,5	29,0	65	**MS1163**	T30	**–**	–
6000217	**PSC80KGMSL50C**	PSC80	73,5	30,0	50	**MS1162**	T25	**MS2002**	T25

- Standard PSC Quick-Change platform.
- Through the pocket coolant capable.
- Interchangeable blades for versatility and depth of cut.







Right Hand

Modular End Mount PSC System with Coolant





order number	catalogue number	CSMS system size	L1	F	blade size	blade screw	Torx	clamp screw	Torx
right hand									
6000026	**PSC40KGMER50C**	PSC40	33,0	20,5	50	**MS1162**	T25	**MS2002**	T25
6000030	**PSC50KGMER50C**	PSC50	43,0	25,5	50	**MS1162**	T25	**MS2002**	T25
5405652	**PSC50KGMER65C**	PSC50	55,5	22,0	65	**MS1163**	T30	**–**	–
6000159	**PSC63KGMER50C**	PSC63	48,0	32,5	50	**MS1162**	T25	**MS2002**	T25
6000462	**PSC63KGMER65C**	PSC63	49,0	32,5	65	**MS1163**	T30	**–**	–
6000466	**PSC80KGMER65C**	PSC80	57,0	40,5	65	**MS1163**	T30	**–**	–
6000214	**PSC80KGMER50C**	PSC80	58,0	40,5	50	**MS1162**	T25	**MS2002**	T25
left hand									
6000027	**PSC40KGMEL50C**	PSC40	33,0	20,5	50	**MS1162**	T25	**MS2002**	T25
6000151	**PSC50KGMEL50C**	PSC50	43,0	25,5	50	**MS1162**	T25	**MS2002**	T25
5405653	**PSC50KGMEL65C**	PSC50	55,5	22,0	65	**MS1163**	T30	**–**	–
6000160	**PSC63KGMEL50C**	PSC63	48,0	32,5	50	**MS1162**	T25	**MS2002**	T25
6000463	**PSC63KGMEL65C**	PSC63	49,0	32,5	65	**MS1163**	T30	**–**	–
6000467	**PSC80KGMEL65C**	PSC80	57,0	40,5	65	**MS1163**	T30	**–**	–
6000215	**PSC80KGMEL50C**	PSC80	58,0	40,5	50	**MS1162**	T25	**MS2002**	T25

Top Notch™

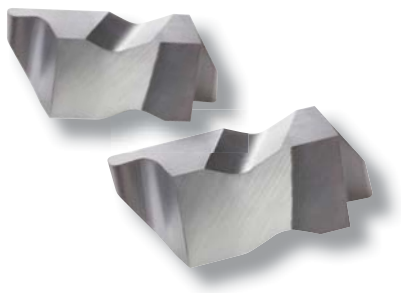
Grooving Tools and Beyond™ Inserts for Your Shallow Groove and Turn Operations

Primary Application

Top Notch Grooving Tools and Beyond Inserts are the proven solution for high productivity. The Top Notch system provides consistent tool performance, accurate indexing, and superior clamping to provide excellent surface finishing and superior tool life.

Features and Benefits

- The Beyond PVD coated grades are designed to cut a variety of workpiece materials.
- Rigid clamping securely locks insert in place through the toughest cuts.
- Versatile design enables one system to handle O.D. and I.D. grooving, face grooving, back turning, undercutting, and even threading operations.
- Chip control inserts provide excellent chip evacuation in grooving, and offer better chip control in multidirectional turning.







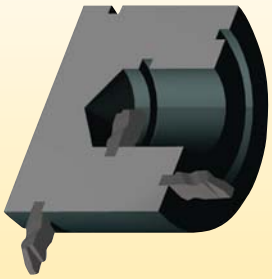
Our rigid clamping design prevents insert movement during high-feed rate applications. This benefit ensures excellent surface finish, improved productivity, and superior tool life and promotes perfect concentricity. The rugged bridge clamp generates locking forces in three directions to provide superior resistance to side thrust and tangential forces.

Step 1 • Select system based on the required groove depth

What you need to know

- Groove depth, width, and profile.
- Material to be machined.
- Application to be performed (face, O.D., or I.D. grooving).
- Toolholder requirements (e.g., KM™, square shank, right/left).

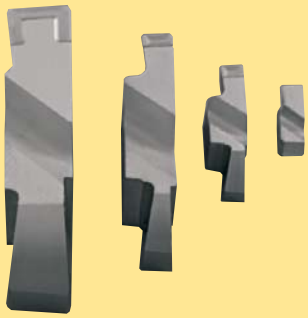
Top Notch™



Grooving
For grooving depth ≤1.5x grooving width, review system capability chart and proceed to Step 2.

Top Notch Grooving for Internal, External, and Face Grooving Applications

system capabilities		minimum in (mm)	maximum in (mm)
O.D./I.D. grooving	width	0.31 (0,79)	.375 (9,53)
	depth	.050 (1,27)	.375 (9,53)
face grooving	width	.125 (3,18)	.375 (9,53)
	depth	.150 (3,81)	.250 (6,35)
internal grooving	diameter	.440 (11,2)	–
face grooving diameter	standard	.940 (23,9)	–
	deep	1.875 (47,6)	–
deep O.D./I/D. grooving	width	.062 (1,57)	.250 (6,35)
	depth	.125 (3,18)	.500 (12,70)
deep face grooving	width	.125 (3,18)	.250 (6,35)
	depth	.250 (6,35)	.500 (12,70)

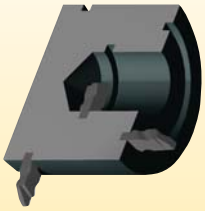


Step 2 • Select toolholder based on the application

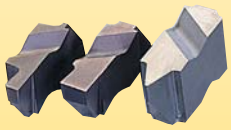
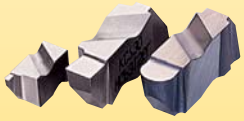
NOTE: Toolholders are available as conventional square shank versions as well as Quick-Change versions. The insert size must match the gage insert of your toolholder selection.

Step 3 • Select chipbreaker style and feed rate

Chipbreaker and Feed Rates • in/rev (mm/rev)



workpiece material and application	P	M	K	N	S	H
first choice	NG-K .003–.011 (0,08–0,28)	NG-K .0025–.008 (0,07–0,20)	NG .004–.012 (0,01–0,30)	NGP .004–.012 (0,01–0,30)	NG-K .0025–.008 (0,07–0,20)	NG-ST CBN tipped .002–.004 (0,05–0,10)
alternate choice	NG .004–.012 (0,10–0,30)	NGP .004–.009 (0,10–0,23)	NG-K .003–.011 (0,08–0,28)	NG-K .003–.012 (0,08–0,30)	NGP .004–.008 (0,10–0,20)	–

_K chipbreaker inserts	flat-top inserts	positive rake inserts
		

Step 4 • Select grade and speed

Recommendations for Grade

Starting speed chart shown under “Application Guide”

machining condition	workpiece material P	M	K	N	S	H
high-performance for optimal conditions (clean cuts, good machine condition, higher speed capability)	**KCP10B** 120–450	**KCU10** 120–260	**KCK20B** 150–550	**KD1425** 150–1500	**KCU10** 15–170	**KB5625** 45–230
general purpose (first choice for general machining)	**KCP25B** 110–365	**KCU25** 120–245	**KCU10** 60–245	**KCU10** 120–975	**KCU10** 15–135	**KB5625** 80–150
unfavourable conditions (roughing, poor machine condition, interrupted cuts, low speed, I.D. grooving)	**KCU25** 85–270	**KCU25** 90–210	**KCU25** 50–195	**K313** 40–610	**KCU25** 8–110	**KB1630** 45–120

Step 5 • Select insert and holder from catalogue page

NOTE: The insert size must match the gage insert size of your toolholder selection.

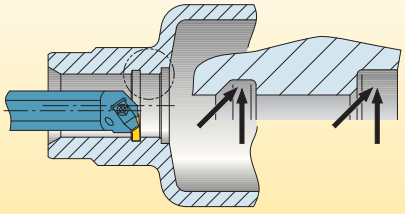
Example for Top Notch • Grooving

Material ..... low-alloyed steel
Groove depth ..... 2mm (.079")
Groove width ..... 3mm (.118")
Operation..... I.D. cut, limited speed capability, plunge groove and chamfer

Recommendation

Insert NG2M300RK
Grade KC5025
Insert width ..... 3mm (.118")
Insert size 2

Toolholder ..... A20QNNT0L2 (metric)
A12NEL2 (inch)
Gage insert N.2R



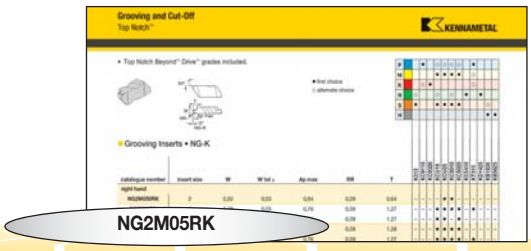
Speed: 120 m/min (400 SFM)
Feed: 0,15 mm/rev (.006 in/rev)

Congratulations!

You have successfully maximised your productivity by selecting the best Top Notch insert geometry, grade, and cutting specifications for your application!

How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



N	G		2	M	05	R		K	
Type of Insert	Insert Style	Additional Information	Insert Size	Size Identification	Groove Size**	Hand of Insert	Cutting Depth	Chipbreaker Design	Definition of Inserts
N = Top Notch	**B** = Blank (for special forms) **F** = Face grooving **G** = Grooving **P** = Back **R** = Full radius **U** = Undercutting (or relieving) **V** = Poly-Vee	**D** = Deep grooving **P** = Positive **C** = Groove and chamfer		**M** = Metric insert groove width **C** = Circlip groove insert width is nominal circlip size ☐ = Blank indicates inch width insert		**L** = Left hand **R** = Right hand	Shown for groove and chamfer inserts in 0,01mm increments.	**E** = Hone only **K** = Standard chip control **S** = T Land and Hone **ST** = STD Tip (PcBN)	Groove size "J" or "L" for Poly-Vee inserts "I" indicates internal face grooving

insert number	W1 mm
1	2,54
2	3,81
3	4,95
4	6,98
5	9,65
6	9,73

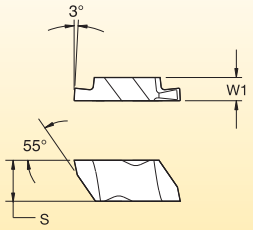
Position pertains to groove width for F-, G-, and U-style inserts, radii for R-style grooving inserts, and circlip size for groove and chamfer inserts. Dimension in 0,01mm.

Metric example: 3,25mm width groove or radius equals "325" catalogue position number.

Width Tolerance: ±0,025mm unless otherwise specified.

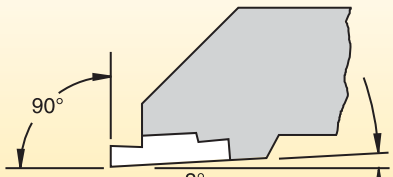
*Kennametal proprietary identification system.
**Omit position for Top Notch NB-style blanks.

Top Notch Threading and Grooving Insert Dimensions



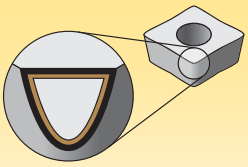
insert size	S mm	W1 mm
1	2,54	2,54
2	5,56	3,81
3	8,74	4,95
4	11,51	6,48
5	17,48	9,65
6	11,51	9,73
8	7,93	11,13

Top Notch Holder Design



NOTE: Holders are designed to locate insert inclined to 3° to provide back clearance down open side.

Kennametal and Top Notch tooling technology combine to bring you the very best threading and grooving system available in the world today.

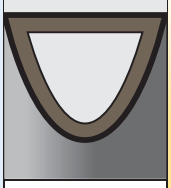
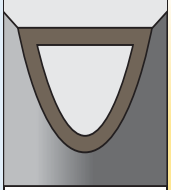
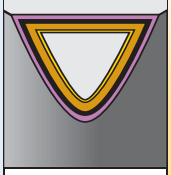
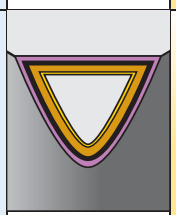
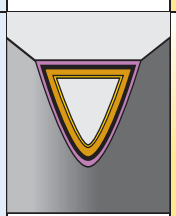


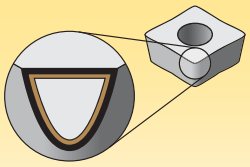
Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

wear resistance ⟷ toughness

Grades

Coating		Grade Description		05	10	15	20	25	30	35	40	45
KCU10		**Composition:** An advanced multilayer PVD coating over a very deformation-resistant unalloyed carbide substrate. The new and improved coating improves edge stability with wide range speed and feed capabilities. **Application:** The KCU10™ grade is ideal for finishing to general machining of most workpiece materials at a wide range of speed and feed capabilities. Excellent for machining most steels, stainless steels, cast irons, non-ferrous materials, and high-temp alloys with improved edge toughness, notch resistance, and higher cutting speed/feed capability.	P		■	■	■					
			M		■	■	■					
			K	■	■	■	■					
			N		■	■	■					
			S		■	■	■					
			H		■							
	—											
												beyond
KCU25		**Composition:** An advanced PVD grade with hard AlTiN coating and fine-grain unalloyed substrate. The new and improved coating improves edge stability with wide range speed and feed capabilities. **Application:** The KCU25™ grade is ideal for general machining of most steels, stainless steels, high-temp alloys, titanium, irons, and non-ferrous materials in a wide range of speeds and feeds with improved edge toughness for interrupted cut and high feed rates.	P				■	■	■			
			M				■	■	■			
			K				■	■	■			
			N				■	■	■			
			S				■	■	■			
	—											
												beyond
KCP10B		**Composition:** A specially engineered cobalt-enriched carbide grade with thick MTCVD TiCN-Al_2O_3-TiOCN coating for maximum wear resistance. **Application:** An excellent finishing to medium machining grade for a variety of workpiece materials, including most steels, ferritic, martensitic, and PH stainless steels, and cast irons. The cobalt-enriched substrate offers a balanced combination of deformation resistance and edge toughness, while the thick coating layers offer outstanding abrasion resistance and crater wear resistance for high-speed machining. Smooth coating provides resistance to edge build-up and microchipping and produces excellent surface finishes.	P		■	■	■					
			K					■	■	■		
	—											
												beyond DRIVE
KCP25B		**Composition:** A tough cobalt-enriched carbide grade with a multilayer MTCVD TiCN-Al_2O_3-TiOCN coating with superior interlayer adhesion. **Application:** Best general-purpose turning grade for most steels and ferritic and martensitic stainless steels. The substrate design ensures adequate deformation resistance with excellent insert edge strength. Coating layers offer good wear resistance over a wide range of machining conditions and the post-coat treatment minimises microchipping and improves coating adhesion to substrate leading to long tool life and improved workpiece finishes.	P				■	■	■			
			K						■	■	■	
	—											
												beyond DRIVE
KCK20B		**Composition:** A specially toughened MTCVD TICN-Al_2O_3-TiOCN coating over a wear-resistant substrate. **Application:** Specifically engineered to maximise coating adhesion and edge strength making this grade ideal in wet interrupted cutting of grey and ductile irons. It can be used in a wide range of applications from finishing to roughing to maximise productivity wherever strength and reliability are needed.	P		■	■						
			K			■	■	■	■			
	—											
												beyond DRIVE



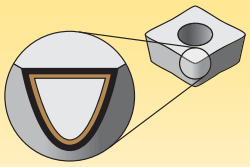
Coatings provide high-speed capability and are engineered for finishing to light roughing.

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

wear resistance ⟷ toughness

Grades

Coating	Grade Description		05	10	15	20	25	30	35	40	45
K313	**Composition:** A hard, low binder content, unalloyed WC/Co fine-grain grade. **Application:** Exceptional edge wear resistance combined with very high strength for machining titanium, cast irons, austenitic stainless steels, non-ferrous metals, non-metals, and most high-temp alloys. Superior thermal deformation and depth-of-cut notch resistance. The grain structure is well controlled for minimal pits and flaws, which contributes to long, reliable service.	M									
		K									
		N									
		S									
KC5010	**Composition:** An advanced PVD AlTiN coating over a very deformation-resistant unalloyed carbide substrate. **Application:** The KC5010™ grade is ideal for finishing to general machining of most workpiece materials at higher speeds. Excellent for machining most steels, stainless steels, cast irons, non-ferrous materials, and high-temp alloys under stable conditions. It also performs well machining hardened and short chipping materials.	P									
		M									
		K									
		N									
		S									
		H									
KC5025	**Composition:** An advanced PVD-AlTiN-coated grade with a tough, ultra-fine-grain unalloyed substrate. **Application:** For general-purpose machining of most steels, stainless steels, high-temp alloys, titanium, irons, and non-ferrous materials. Speeds may vary from low to medium and will handle interruptions and high feed rates.	P									
		M									
		K									
		N									
		S									



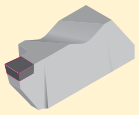
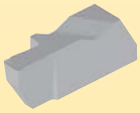
Coatings provide high-speed capability and are engineered for finishing to light roughing.

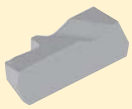
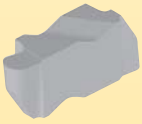
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous
S	High-Temp Alloys
H	Hardened Materials

wear resistance ← → toughness

Grades

Coating	Grade Description	05	10	15	20	25	30	35	40	45
KT315 –	**Composition:** A multilayer PVD TiN/TiCN/TiN-coated cermet turning grade. **Application:** Ideal for high-speed finishing to medium machining of most carbon and alloy steels and stainless steels. Performs very well in cast and ductile iron applications, too. Provides long and consistent tool life and will produce excellent workpiece finishes.	P	P							
		K	K							
KB1630 –	**Composition:** An uncoated high content PcBN grade. PcBN tips are brazed onto a carbide insert. **Application:** Designed for roughing to finishing in interrupted cuts on hardened steels (>45 HRC). It can also be applied on grey cast iron, chilled irons, high chrome alloyed steels, high temp alloys and sintered powder metals. The tipped PcBN inserts are available in a wide range of insert styles, including Top Notch™ and Screw-On geometries.									
		K	K	K						
		S	S	S						
		H				H	H	H		
KB5625 –	**Composition:** A medium content PcBN with a PVD-TiN/AlTiN coating for added wear resistance. **Application:** Designed for roughing to finishing of hardened steels (>45 HRC). Use on bearing steels, hot and cold work steels, die steels, case hardened steels, carburised and nitrided irons, and some hard coatings.									
		H			H	H	H			
KD1425 –	**Composition:** A multimodal PCD grade with a range of grain sizes brazed onto a carbide substrate. **Application:** Engineered for extreme abrasion resistance, combined with good edge strength for demanding applications. An ideal choice for high-silicon aluminium alloys, bi-metallic (AL/GCI) materials, MMC, carbon-fibre reinforced plastics, and other abrasive non-metallic materials.									
		N	N	N	N					

insert style	application	rake angle	page(s)
NG 	• General-purpose grooving. • O-ring grooving. • Circlip grooving.	neutral	C154
NG-K 	• Chip control geometry. • General-purpose grooving. • O-ring grooving. • Circlip grooving. • Light turning.	10° positive	C146
NG-ST 	• Hard turning.	neutral	C163
NGC-K 	• Combined groove and chamfered edge break in one positive plunge with chip control. • Designed for DIN 471/472 standard circlup grooves.	10° positive	C152
NGD 	• Deep grooving.	neutral	C157
NGD-K 	• Chip control geometry. • Deep grooving. • Light turning.	10° positive	C149
NGP 	• General-purpose grooving. • O-ring grooving. • Circlip grooving.	5° positive	C152
NF 	• Face grooving. • Additional side clearance.	neutral	C161
NF-K 	• Face grooving with chip control. • Additional side clearance.	10° positive	C159
NFD-K 	• Deep face grooving with chip control. • Additional side clearance.	10° positive	C160

insert style	application	rake angle	page(s)
NFD-KI 	• Internal deep face grooving with chip control. • For use in boring bars for internal face grooves.	10° positive	C160
NP-K NPD-K 	• Turning. • Back turning positive. • Profiling with chip control.	10° positive	C151
NR 	• Full radius grooving. • Turning and profiling.	neutral	C158
NR-K 	• Chip control geometry. • Full radius grooving, turning, and profiling.	10° positive	C150
NRD 	• Deep grooving. • Full radius end-form.	neutral	C159
NRP 	• Full radius grooving. • Light-turning profiling.	5° positive	C153
NU 	• Undercutting.	neutral	C161
NV 	• Poly-Vee grooving.	neutral	C162
NB/NBD 	• Blanks. • Blanks for deep grooving. • Available in uncoated grades only.	–	C162–C163

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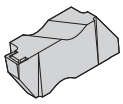
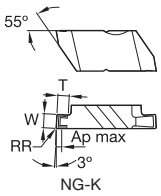
- Top Notch Beyond Drive™ grades included.





● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

Groove and Turn • Chip Control

catalogue number	insert size	W	W tol ±	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																		
NG2M050RK	2	0,50	0,03	0,64	0,09	0,64	●	●	–	●	–	–	●	–	–	–	–	–
NG2031RK	2	0,79	0,03	0,76	0,09	1,27	●	●	●	●	–	–	●	●	●	–	–	–
NG2M080RK	2	0,80	0,03	0,76	0,09	1,27	●	●	●	●	–	–	–	●	–	–	–	–
NG2M100RK	2	1,00	0,03	0,76	0,09	1,28	●	●	●	●	–	–	●	●	–	–	–	–
NG2047RK	2	1,19	0,03	0,76	0,09	1,27	●	●	●	●	–	–	●	●	●	–	–	–
NG2M120RK	2	1,20	0,03	0,76	0,09	1,27	●	●	●	●	–	–	●	●	–	–	–	–
NG2M140RK	2	1,40	0,03	0,76	0,09	1,28	●	●	●	●	–	–	●	●	–	–	–	–
NG2M150RK	2	1,50	0,03	1,09	0,19	2,79	–	●	–	●	–	–	–	●	–	–	–	–
NG2062RK	2	1,56	0,03	1,09	0,19	2,79	●	●	●	●	–	–	●	●	●	–	–	–
NG2M170RK	2	1,70	0,03	1,09	0,19	2,79	●	●	●	●	–	–	●	●	–	–	–	–
NG2M175RK	2	1,75	0,03	1,09	0,19	2,81	–	●	–	●	–	–	–	–	–	–	–	–
NG2M195RK	2	1,95	0,03	1,09	0,19	2,79	●	●	●	●	–	–	●	●	–	–	–	–
NG2M200RK	2	2,00	0,03	1,09	0,19	2,79	●	●	●	●	–	–	●	●	●	–	–	–
NG2M220RK	2	2,20	0,03	1,09	0,19	2,79	–	●	–	●	–	–	–	●	–	–	–	–
NG2M225RK	2	2,25	0,03	1,09	0,19	2,81	●	●	●	●	–	–	–	●	–	–	–	–
NG2094RK	2	2,39	0,03	1,09	0,19	2,79	●	●	●	●	–	–	●	●	●	–	–	–
NG2M250RK	2	2,50	0,03	1,09	0,19	2,79	–	●	–	●	–	–	–	●	–	–	–	–
NG2M275RK	2	2,75	0,03	1,09	0,19	2,79	●	●	●	●	–	–	–	●	–	–	–	–
NG2M300RK	2	3,00	0,03	1,09	0,19	2,79	●	●	●	●	–	–	●	●	–	–	–	–
NG2125RK	2	3,18	0,03	1,09	0,19	2,79	●	●	●	●	–	–	●	●	●	–	–	–
NG2M320RK	2	3,20	0,03	1,09	0,19	2,79	–	–	–	●	–	–	–	–	–	–	–	–
NG2M325RK	2	3,25	0,03	1,09	0,19	2,79	–	●	–	●	–	–	–	●	–	–	–	–
NG3M100RK	3	1,00	0,03	0,76	0,20	1,91	–	●	–	●	–	–	–	●	–	–	–	–
NG3047RK	3	1,19	0,03	0,76	0,19	1,91	●	●	●	●	–	–	●	●	–	–	–	–
NG3M120RK	3	1,20	0,03	0,76	0,19	1,91	●	●	●	●	–	–	–	●	–	–	–	–
NG3M150RK	3	1,50	0,03	1,02	0,19	2,39	–	●	–	●	–	–	–	●	–	–	–	–
NG3062RK	3	1,58	0,03	1,02	0,19	2,39	●	●	●	●	–	–	●	●	●	–	–	–
NG3M175RK	3	1,75	0,03	1,02	0,19	2,39	–	●	–	●	–	–	–	●	–	–	–	–
NG3072RK	3	1,83	0,03	1,02	0,19	2,39	●	●	●	●	–	–	●	●	–	–	–	–
NG3078RK	3	1,98	0,03	1,02	0,19	2,39	●	●	●	●	–	–	●	●	–	–	–	–
NG3M200RK	3	2,00	0,03	1,02	0,19	2,39	–	●	–	●	–	–	–	●	●	–	–	–
NG3M220RK	3	2,20	0,03	1,02	0,19	2,39	–	●	–	●	–	–	–	●	–	–	–	–
NG3M225RK	3	2,24	0,03	1,02	0,19	2,39	●	●	●	●	–	–	●	●	–	–	–	–
NG3094RK	3	2,39	0,03	1,02	0,19	3,81	●	●	●	–	–	–	●	●	●	–	–	–
NG3M250RK	3	2,50	0,03	1,02	0,19	3,81	–	●	–	●	–	–	–	●	–	–	–	–

(continued)

(Groove and Turn • Chip Control — continued)

● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

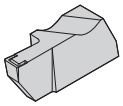
catalogue number	insert size	W	W tol ±	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
NG3M275RK	3	2,75	0,03	1,02	0,19	3,81	●	●	●	●	–	–	●	●	–	–	–	–
NG3M300RK	3	3,00	0,03	1,02	0,19	3,81	●	●	●	●	–	–	●	●	–	–	–	–
NG3125RK	3	3,18	0,03	1,02	0,19	3,81	●	●	●	●	–	–	●	●	●	–	–	–
NG3M320RK	3	3,20	0,03	1,02	0,19	3,81	–	●	–	●	–	–	–	●	–	–	–	–
NG3M325RK	3	3,25	0,03	1,02	0,19	3,81	–	●	–	●	–	–	–	●	–	–	–	–
NG3M350RK	3	3,50	0,03	2,92	0,32	3,81	–	●	–	●	–	–	–	●	–	–	–	–
NG3156RK	3	3,96	0,03	2,92	0,19	3,81	●	●	●	●	–	–	●	●	–	–	–	–
NG3M400RK	3	4,00	0,03	2,92	0,32	3,81	●	●	●	●	–	–	●	●	–	–	–	–
NG3M425RK	3	4,25	0,03	2,92	0,32	3,81	●	●	●	●	–	–	–	●	–	–	–	–
NG3M450RK	3	4,50	0,03	2,92	0,32	3,81	–	●	–	●	–	–	–	–	–	–	–	–
NG3189RK	3	4,80	0,03	2,92	0,57	3,81	●	●	●	●	–	–	●	●	–	–	–	–
NG4M300RK	4	3,00	0,03	1,02	0,19	3,81	–	●	–	●	–	–	–	–	–	–	–	–
NG4125RK	4	3,18	0,03	1,06	0,19	3,81	●	●	●	●	–	–	●	–	–	–	–	–
NG4M350RK	4	3,50	0,03	2,92	0,57	6,35	–	●	–	●	–	–	–	–	–	–	–	–
NG4M400RK	4	4,00	0,03	2,92	0,57	6,35	–	●	●	●	–	–	●	●	–	–	–	–
NG4M450RK	4	4,50	0,03	2,92	0,57	6,35	–	●	–	●	–	–	–	–	–	–	–	–
NG4189RK	4	4,80	0,03	2,92	0,57	6,35	●	●	●	●	–	–	●	●	–	–	–	–
NG4M500RK	4	5,00	0,03	2,92	0,32	6,35	●	●	●	●	–	–	–	–	–	–	–	–
NG4M550RK	4	5,50	0,03	3,81	0,57	6,35	–	–	–	●	–	–	–	–	–	–	–	–
NG4M600RK	4	6,00	0,03	3,81	0,57	6,35	–	●	–	●	–	–	–	–	–	–	–	–
NG4250RK left hand	4	6,35	0,03	3,81	0,57	6,35	–	●	●	●	–	–	●	●	–	–	–	–
NG2M050LK	2	0,50	0,03	0,64	0,09	0,64	●	●	–	●	–	–	●	–	–	–	–	–
NG2031LK	2	0,79	0,03	0,76	0,09	1,27	●	●	●	●	–	–	●	●	–	–	–	–
NG2M080LK	2	0,80	0,03	0,76	0,09	1,27	●	●	●	●	–	–	–	●	–	–	–	–
NG2M100LK	2	1,00	0,03	0,76	0,08	1,27	●	●	●	●	–	–	●	●	–	–	–	–
NG2047LK	2	1,19	0,03	0,76	0,09	1,27	●	●	●	●	–	–	●	●	–	–	–	–
NG2M120LK	2	1,20	0,03	0,76	0,09	1,27	●	●	●	●	–	–	●	●	–	–	–	–
NG2M140LK	2	1,40	0,03	0,76	0,09	1,27	●	●	●	●	–	–	–	●	–	–	–	–
NG2M150LK	2	1,50	0,03	1,09	0,19	2,79	–	●	–	●	–	–	–	●	–	–	–	–
NG2062LK	2	1,58	0,03	1,09	0,19	2,79	●	●	●	●	–	–	●	●	–	–	–	–
NG2M170LK	2	1,70	0,03	1,09	0,19	2,79	–	●	●	●	–	–	●	●	–	–	–	–
NG2M175LK	2	1,75	0,03	1,09	0,19	2,79	–	●	–	●	–	–	–	●	–	–	–	–
NG2M195LK	2	1,95	0,03	1,09	0,19	2,79	–	●	●	●	–	–	●	–	–	–	–	–
NG2M200LK	2	2,00	0,03	1,09	0,19	2,79	●	●	●	●	–	–	●	●	–	–	–	–
NG2M220LK	2	2,20	0,03	1,09	0,19	2,79	–	●	–	●	–	–	–	–	–	–	–	–
NG2M225LK	2	2,25	0,03	1,09	0,19	2,79	●	●	●	●	–	–	–	●	–	–	–	–
NG2094LK	2	2,39	0,03	1,09	0,19	2,79	●	●	●	●	–	–	●	●	–	–	–	–
NG2M250LK	2	2,50	0,03	1,09	0,19	2,79	–	●	–	●	–	–	–	●	–	–	–	–
NG2M275LK	2	2,75	0,03	1,09	0,19	2,79	●	●	–	●	–	–	●	–	–	–	–	–

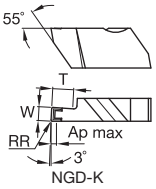
(continued)

(Groove and Turn • Chip Control — continued)

● first choice
○ alternate choice

| | | |





● first choice
○ alternate choice

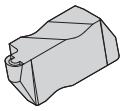
		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

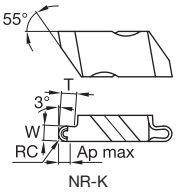
Groove and Turn • Deep Grooving • Chip Control

catalogue number	insert size	W	W tol ±	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																		
NGD2M150RK	2	1,50	0,03	1,09	0,19	4,06	●	●	–	–	–	–	●	●	–	–	–	–
NGD2M200RK	2	2,00	0,03	1,09	0,19	5,08	●	●	–	–	–	–	●	●	–	–	–	–
NGD2M250RK	2	2,50	0,03	1,09	0,19	5,08	●	●	–	–	–	–	–	●	–	–	–	–
NGD3062RK	3	1,58	0,03	1,02	0,19	3,18	●	●	–	–	–	●	●	●	–	–	–	–
NGD3M200RK	3	2,00	0,03	1,02	0,19	4,06	●	●	–	–	–	–	●	●	–	–	–	–
NGD3094RK	3	2,39	0,03	1,02	0,19	6,35	●	●	–	–	–	●	●	●	–	–	–	–
NGD3M250RK	3	2,50	0,03	1,02	0,19	6,35	–	●	–	–	–	–	●	●	–	–	–	–
NGD3M300RK	3	3,00	0,03	1,02	0,19	6,35	●	●	–	–	–	–	●	●	–	–	–	–
NGD3125RK	3	3,18	0,03	1,02	0,19	6,35	●	●	–	–	–	●	●	●	–	–	–	–
NGD3M400RK	3	4,00	0,03	2,92	0,32	6,35	●	●	–	–	–	–	●	●	–	–	–	–
NGD3189RK	3	4,80	0,03	2,92	0,58	6,35	●	●	–	–	–	–	●	●	–	–	–	–
NGD4125RK	4	3,18	0,03	1,02	0,19	6,35	●	●	–	–	–	–	●	●	–	–	–	–
NGD4189RK	4	4,80	0,03	2,92	0,57	9,53	●	●	–	–	–	–	●	●	–	–	–	–
NGD4M550RK	4	5,50	0,03	3,81	0,57	12,70	–	●	–	–	–	–	–	–	–	–	–	–
NGD4250RK	4	6,35	0,03	3,81	0,57	12,70	●	●	–	–	–	–	●	●	–	–	–	–
left hand																		
NGD2M150LK	2	1,50	0,03	1,09	0,19	4,06	●	●	–	–	–	–	–	●	–	–	–	–
NGD2M200LK	2	2,00	0,03	1,09	0,19	5,08	●	●	–	–	–	–	●	●	–	–	–	–
NGD2M250LK	2	2,50	0,03	1,09	0,19	5,08	●	●	–	–	–	–	●	●	–	–	–	–
NGD3062LK	3	1,57	0,03	1,02	0,19	3,18	●	●	–	–	–	–	●	●	–	–	–	–
NGD3M200LK	3	2,00	0,03	1,02	0,19	4,06	–	●	–	–	–	–	–	●	–	–	–	–
NGD3094LK	3	2,39	0,03	1,02	0,19	6,34	●	●	–	–	–	●	●	●	–	–	–	–
NGD3M250LK	3	2,50	0,03	1,02	0,19	6,35	–	●	–	–	–	–	–	●	–	–	–	–
NGD3M300LK	3	3,00	0,03	1,02	0,19	6,35	●	●	–	–	–	–	●	●	–	–	–	–
NGD3125LK	3	3,18	0,03	1,02	0,19	6,35	●	●	–	–	–	●	●	●	–	–	–	–
NGD3M350LK	3	3,50	0,03	2,92	0,32	6,35	–	●	–	–	–	–	–	●	–	–	–	–
NGD3M400LK	3	4,00	0,03	2,92	0,32	6,35	●	●	–	–	–	–	–	●	–	–	–	–
NGD3189LK	3	4,80	0,03	2,92	0,57	6,35	●	●	–	–	–	–	●	●	–	–	–	–
NGD4125LK	4	3,18	0,03	1,02	0,19	6,35	●	●	–	–	–	–	●	●	–	–	–	–
NGD4M400LK	4	4,00	0,03	2,92	0,57	9,53	–	●	–	–	–	–	–	–	–	–	–	–
NGD4189LK	4	4,80	0,03	2,92	0,57	9,53	●	●	–	–	–	–	●	●	–	–	–	–
NGD4M500LK	4	5,00	0,03	2,92	0,57	12,70	–	●	–	–	–	–	–	–	–	–	–	–
NGD4250LK	4	6,35	0,03	3,80	0,57	12,70	●	●	–	–	–	–	●	–	–	–	–	–

NOTE: Inserts have one cutting edge. Right-hand insert shown; left-hand insert is mirror image.
The following inserts are double ended: NGD3062RK, NGD4125RK, NGD3062LK, and NGD4125LK.

- Full radius inserts with chip control.





NR-K

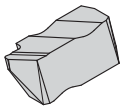
● first choice
○ alternate choice

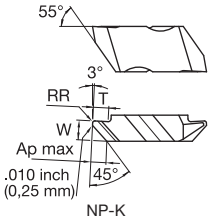
		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

Groove and Turn • Full Radius • Chip Control

catalogue number	insert size	W	Ap max	RC	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																	
NR3031RK	3	1,57	1,97	0,79	2,39	●	●	–	–	–	–	●	●	–	–	–	–
NR3047RK	3	2,39	1,91	1,19	3,81	●	●	–	–	–	–	●	●	–	–	–	–
NR3062RK	3	3,18	2,92	1,59	3,81	●	●	–	–	–	–	●	●	–	–	–	–
NR3078RK	3	3,97	2,54	1,98	3,81	●	●	–	–	–	–	●	–	–	–	–	–
NR4062RK	4	3,18	2,92	1,59	3,81	●	●	–	–	–	–	●	–	–	–	–	–
NR4094RK	4	4,79	3,81	2,39	6,35	●	●	–	–	–	–	●	–	–	–	–	–
NR4125RK	4	6,35	3,81	3,18	6,35	●	●	–	–	–	–	●	●	–	–	–	–
left hand																	
NR3031LK	3	1,58	1,98	0,79	2,39	●	●	–	–	–	–	●	●	–	–	–	–
NR3047LK	3	2,39	1,91	1,19	3,81	●	●	–	–	–	–	●	●	–	–	–	–
NR3062LK	3	3,18	2,92	1,59	3,81	●	●	–	–	–	–	●	●	–	–	–	–
NR3078LK	3	3,96	2,54	1,98	3,81	–	●	–	–	–	–	●	●	–	–	–	–
NR4062LK	4	3,18	2,92	1,59	3,81	●	●	–	–	–	–	●	–	–	–	–	–
NR4094LK	4	4,79	3,81	2,39	6,35	●	●	–	–	–	–	●	●	–	–	–	–
NR4125LK	4	6,36	3,81	3,18	6,35	●	●	–	–	–	–	●	–	–	–	–	–

NOTE: Right-hand insert shown; left-hand insert is mirror image.





NP-K

● first choice
○ alternate choice

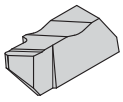
		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

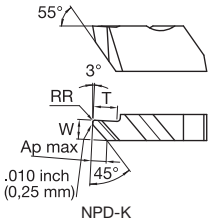
Groove and Profile • Chip Control

catalogue number	insert size	W	W tol ±	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																		
NP2002RK	2	3,82	0,03	—	0,25	2,81	●	●	–	–	–	–	●	●	–	–	–	–
NP2012RK	2	3,82	0,03	—	0,25	2,81	–	●	–	–	–	–	–	–	–	–	–	–
NP3002RK	3	4,95	0,03	—	0,25	5,08	●	●	–	–	–	–	●	–	–	–	–	–
NP3012RK	3	4,95	0,03	—	0,25	5,08	–	●	–	–	–	–	–	●	–	–	–	–

NOTE: Right-hand insert shown; left-hand insert is mirror image.
Tolerance on W ± 0,13mm (± .005").

- Profiling deep positive inserts.



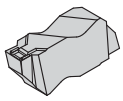


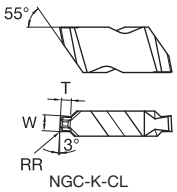
NPD-K

Groove and Profile • Deep Grooving • Chip Control

catalogue number	insert size	W	W tol ±	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																		
NPD2002RK	2	3,68	0,13	—	0,09	5,08	–	●	–	–	–	–	●	–	–	–	–	–
NPD3002RK	3	4,83	0,13	—	0,09	6,35	–	●	–	–	–	–	–	–	–	–	–	–
NPD3012RK	3	4,95	0,03	—	0,25	6,35	●	●	–	–	–	–	●	–	–	–	–	–

NOTE: Right-hand insert shown; left-hand insert is mirror image.
Tolerance on W ± 0,13mm (± .005").





NGC-K-CL

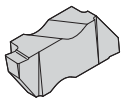
● first choice
○ alternate choice

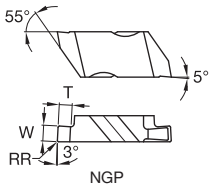
		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

Groove and Chamfer • Chip Control

catalogue number	seat size	circlip size	W	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																	
NGC2C130R055K	2	1,30	1,39	0,08	0,6	–	●	–	–	–	–	–	–	–	–	–	–
NGC2C215R150K	2	2,15	2,24	0,08	1,5	–	●	–	–	–	–	–	–	–	–	–	–
left hand																	
NGC2C130L055K	2	1,30	1,39	0,08	0,6	–	●	–	–	–	–	–	–	–	–	–	–
NGC2C185L125K	2	1,85	1,94	0,08	1,3	–	●	–	–	–	–	–	–	–	–	–	–
NGC2C215L150K	2	2,15	2,24	0,08	1,5	–	●	–	–	–	–	–	–	–	–	–	–

NOTE: Groove and chamfer inserts for circlip grooves to DIN 471/472 specification.
Right-hand insert shown; left-hand insert is mirror image.





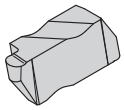
NGP

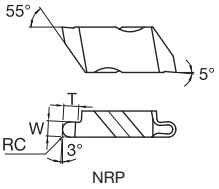
Groove and Turn • Positive

catalogue number	insert size	W	W tol ±	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																		
NGP2031R	2	0,79	0,03	—	0,09	1,27	●	–	–	–	–	–	●	–	–	–	–	–
NGP2062R	2	1,58	0,03	—	0,19	2,79	●	–	–	–	–	–	●	–	–	–	–	–
NGP2125R	2	3,18	0,03	—	0,19	2,79	●	–	–	–	–	–	–	–	–	–	–	–
NGP3088R	3	2,24	0,03	—	0,19	2,39	●	–	–	–	–	–	–	–	–	–	–	●
NGP3125R	3	3,18	0,03	—	0,19	3,81	●	–	–	–	–	–	●	–	–	–	–	●
NGP3156R	3	3,96	0,03	—	0,19	3,81	●	–	–	–	–	–	–	–	–	–	–	–
NGP4189R	4	4,80	0,03	—	0,57	6,35	●	–	–	–	–	–	–	–	–	–	–	–
NGP4250R	4	6,35	0,03	—	0,57	6,35	–	–	–	–	–	–	●	–	–	–	–	–
left hand																		
NGP2031L	2	0,79	0,03	—	0,09	1,27	●	–	–	–	–	–	–	–	–	–	–	–
NGP2062L	2	1,57	0,03	—	0,19	2,79	●	–	–	–	–	–	–	–	–	–	–	–
NGP2125L	2	3,18	0,03	—	0,19	2,79	●	–	–	–	–	–	–	–	–	–	–	–
NGP3088L	3	2,24	0,03	—	0,19	2,39	●	–	–	–	–	–	–	–	–	–	–	–
NGP3125L	3	3,18	0,03	—	0,19	3,81	–	–	–	–	–	–	●	–	–	–	–	–
NGP4250L	4	6,35	0,03	—	0,57	6,35	●	–	–	–	–	–	–	–	–	–	–	–

NOTE: All KD and KB grades are single-ended tipped inserts.
Right-hand insert shown; left-hand insert is mirror image.

- Full radius positive rake inserts.





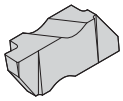
● first choice
○ alternate choice

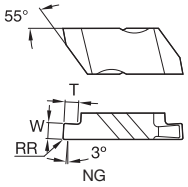
		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

Groove and Turn • Full Radius • Positive

catalogue number	insert size	W	Ap max	RC	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																	
NRP3031R	3	1,58	—	0,79	2,39	●	–	–	–	–	–	●	–	–	–	–	–
NRP3047R	3	2,39	—	1,19	3,81	●	–	–	–	–	●	●	–	–	–	–	–
NRP3062R	3	3,18	—	1,59	3,81	●	–	–	–	–	–	●	–	–	–	–	–
NRP3094R	3	4,78	—	2,39	3,81	●	–	–	–	–	–	●	–	–	–	–	–
left hand																	
NRP3031L	3	1,58	—	0,79	2,39	●	–	–	–	–	–	●	–	–	–	–	–
NRP3047L	3	2,39	—	1,19	3,81	●	–	–	–	–	–	●	–	–	–	–	–
NRP3062L	3	3,18	—	1,59	3,81	–	–	–	–	–	–	●	–	–	–	–	–
NRP3094L	3	4,78	—	2,39	3,81	●	–	–	–	–	–	●	–	–	–	–	–

NOTE: Right-hand insert shown; left-hand insert is mirror image.





● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

Groove and Turn • Flat Top

catalogue number	insert size	W	W tol ±	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																		
NG2031R	2	0,79	0,03	—	0,09	1,27	●	●	–	–	●	●	●	●	–	–	–	–
NG2041R	2	1,04	0,03	—	0,09	1,27	●	●	–	–	●	●	●	●	–	–	–	–
NG2047R	2	1,19	0,03	—	0,09	1,27	●	●	–	–	●	–	●	–	–	–	–	–
NG2058R	2	1,47	0,03	—	0,19	1,27	–	●	–	–	–	–	–	●	–	–	–	–
NG2062R	2	1,58	0,03	—	0,19	2,79	●	●	–	–	●	●	●	●	–	–	–	–
NG2094R	2	2,39	0,03	—	0,19	2,79	●	●	–	–	●	●	●	–	–	–	–	–
NG2125R	2	3,18	0,03	—	0,19	2,79	●	●	–	–	–	–	●	–	–	–	–	–
NG3047R	3	1,19	0,03	—	0,19	1,91	●	●	–	–	●	●	●	●	–	–	–	–
NG3062R	3	1,58	0,03	—	0,19	2,39	●	●	–	–	●	●	●	●	–	–	–	–
NG3072R	3	1,83	0,03	—	0,19	2,39	●	–	–	–	●	–	●	–	–	–	–	–
NG3078R	3	1,98	0,03	—	0,19	2,39	●	–	–	–	●	–	●	–	–	–	–	–
NG3088R	3	2,24	0,03	—	0,19	2,39	●	●	–	–	●	–	●	–	–	–	–	–
NG3094R	3	2,39	0,03	—	0,19	3,81	●	●	–	–	●	●	●	●	–	–	–	–
NG3097R	3	2,46	0,03	—	0,32	3,81	●	●	–	–	●	–	●	–	–	–	–	–
NG3105R	3	2,67	0,03	—	0,19	3,81	●	●	–	–	●	–	●	●	–	–	–	–
NG3110R	3	2,79	0,03	—	0,32	3,81	–	●	–	–	–	–	–	●	–	–	–	–
NG3122R	3	3,10	0,03	—	0,19	3,81	–	●	–	–	–	–	–	–	–	–	–	–
NG3125R	3	3,18	0,03	—	0,19	3,81	●	●	–	–	●	●	●	●	–	–	–	–
NG3142R	3	3,61	0,03	—	0,32	3,81	–	●	–	–	–	–	●	–	–	–	–	–
NG3156R	3	3,96	0,03	—	0,19	3,81	●	●	–	–	●	–	●	●	–	–	–	–
NG3178R	3	4,52	0,03	—	0,19	3,81	–	–	–	–	–	–	–	●	–	–	–	–
NG3185R	3	4,70	0,03	—	0,57	3,81	–	●	–	–	–	–	–	–	–	–	–	–
NG3189R	3	4,80	0,03	—	0,57	3,81	●	●	–	–	●	●	●	●	–	–	–	–
NG4125R	4	3,18	0,03	—	0,19	3,81	●	●	–	–	●	●	–	–	–	–	–	–
NG4189R	4	4,80	0,03	—	0,57	6,35	●	●	–	–	●	●	●	–	–	–	–	–
NG4213R	4	5,41	0,03	—	0,19	6,35	–	●	–	–	–	–	–	–	–	–	–	–
NG4250R	4	6,35	0,03	—	0,57	6,35	●	●	–	–	●	–	●	●	–	–	–	–
NG5312R	5	7,93	0,03	—	0,83	9,52	–	●	–	–	–	–	–	–	–	–	–	–
NG6375R	6	9,53	0,03	—	0,83	6,35	–	●	–	–	–	–	–	–	–	–	–	–

(continued)

(Groove and Turn • Flat Top — continued)

● first choice
○ alternate choice

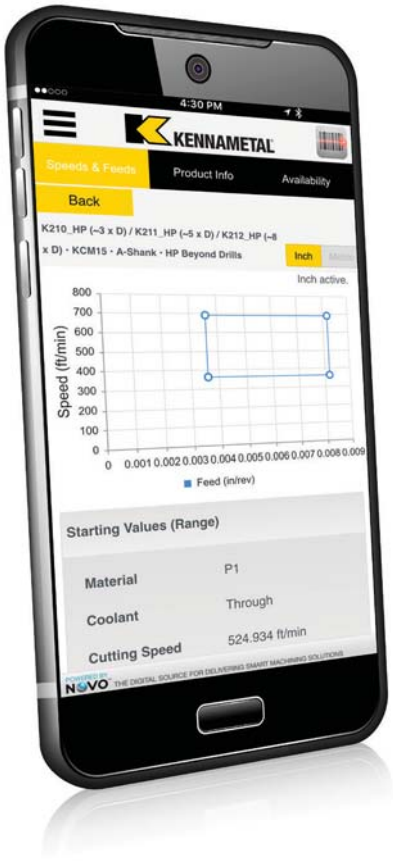
		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

catalogue number	insert size	W	W tol ±	Ap max	RR	T											
left hand																	
NG1031L	1	0,79	0,08	—	0,19	1,27	–	●	–	–	–	–	–	–	–	–	–
NG1047L	1	1,19	0,08	—	0,19	1,91	–	●	–	–	–	–	●	–	–	–	–
NG1062L	1	1,58	0,08	—	0,19	1,91	–	●	–	–	–	–	●	–	–	–	–
NG1094L	1	2,39	0,08	—	0,19	1,91	–	●	–	–	–	–	●	–	–	–	–
NG2031L	2	0,79	0,03	—	0,09	1,27	●	●	–	–	●	●	●	–	–	–	–
NG2041L	2	1,04	0,03	—	0,09	1,27	–	●	–	–	●	–	●	●	–	–	–
NG2047L	2	1,19	0,03	—	0,09	1,27	●	●	–	–	–	–	●	–	–	–	–
NG2058L	2	1,47	0,03	—	0,19	1,27	–	●	–	–	–	–	–	–	–	–	–
NG2062L	2	1,58	0,03	—	0,19	2,79	●	●	–	–	●	●	●	●	–	–	–
NG2094L	2	2,39	0,03	—	0,19	2,79	●	●	–	–	●	●	●	–	–	–	–
NG2125L	2	3,18	0,03	—	0,19	2,79	●	●	–	–	●	–	●	–	–	–	–
NG3047L	3	1,19	0,03	—	0,19	1,91	●	●	–	–	●	●	●	–	–	–	–
NG3062L	3	1,57	0,03	—	0,19	2,38	●	●	–	–	●	●	●	●	–	–	–
NG3072L	3	1,83	0,03	—	0,19	2,39	●	–	–	–	–	–	●	–	–	–	–
NG3078L	3	1,98	0,03	—	0,19	2,39	●	–	–	–	–	–	–	–	–	–	–
NG3088L	3	2,24	0,03	—	0,19	2,39	●	●	–	–	–	–	●	–	–	–	–
NG3094L	3	2,39	0,03	—	0,19	3,81	●	●	–	–	●	●	●	●	–	–	–
NG3097L	3	2,46	0,03	—	0,32	3,81	●	●	–	–	–	–	–	–	–	–	–
NG3105L	3	2,67	0,03	—	0,19	3,81	●	●	–	–	–	–	●	–	–	–	–
NG3110L	3	2,79	0,03	—	0,32	3,81	–	●	–	–	–	–	●	–	–	–	–
NG3122L	3	3,10	0,03	—	0,19	3,81	–	●	–	–	–	–	–	–	–	–	–
NG3125L	3	3,18	0,03	—	0,19	3,81	●	●	–	–	●	●	●	●	–	–	–
NG3142L	3	3,61	0,03	—	0,32	3,81	●	●	–	–	–	–	–	–	–	–	–
NG3156L	3	3,96	0,03	—	0,19	3,81	–	●	–	–	–	–	●	–	–	–	–
NG3178L	3	4,52	—	—	0,19	3,81	–	●	–	–	–	–	–	–	–	–	–
NG3185L	3	4,70	0,03	—	0,57	3,81	–	–	–	–	–	–	●	–	–	–	–
NG3189L	3	4,80	0,03	—	0,57	3,81	●	●	–	–	●	–	●	●	–	–	–
NG4125L	4	3,18	0,03	—	0,19	3,81	●	●	–	–	–	●	–	–	–	–	–
NG4189L	4	4,80	0,03	—	0,57	6,35	●	●	–	–	●	–	●	–	–	–	–
NG4189LEST	4	4,80	0,03	—	0,57	6,35	–	–	–	–	–	–	–	–	●	–	–
NG4250L	4	6,35	0,03	—	0,57	6,35	●	●	–	–	●	–	●	●	–	–	–

NOTE: All KD and KB grades are single-ended tipped inserts.
Right-hand insert shown; left-hand insert is mirror image.

Mobile App

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



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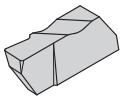
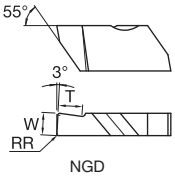
ANDROID APP ON Google play

Available on the App Store

● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	





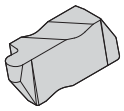
NGD

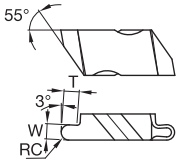
Groove and Turn • Deep Grooving • Flat Top

catalogue number	insert size	W	W tol ±	Ap max	RR	T
right hand						
NGD3189R	3	4,80	0,03	—	0,57	6,35
NGD4250R	4	6,35	0,03	—	0,57	12,70
left hand						
NGD3189L	3	4,80	0,03	—	0,57	6,35
NGD4250L	4	6,35	0,03	—	0,57	12,70

●	–	–	–	–	●	–	–	–	–	–	–	–	
●	–	–	–	–	●	–	–	–	–	–	–	–	
●	–	–	–	–	●	●	–	–	–	–	–	–	
●	–	–	–	–	●	●	–	–	–	–	–	–	

NOTE: Inserts have one cutting edge.
Right-hand insert shown; left-hand insert is mirror image.





NR

● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

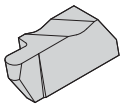
Groove and Turn • Full Radius • Flat Top

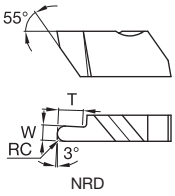
catalogue number	insert size	W	Ap max	RC	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																	
NR2M050R	2	1,00	—	0,50	1,27	●	●	–	–	–	–	●	●	–	–	–	–
NR2M075R	2	1,50	—	0,75	2,79	●	–	–	–	–	–	●	–	–	–	–	–
NR2031R	2	1,58	—	0,79	2,79	●	●	–	–	–	–	●	●	–	–	–	–
NR2M100R	2	2,00	—	1,00	2,79	●	–	–	–	–	–	●	●	–	–	–	–
NR2047R	2	2,39	—	1,19	2,79	–	●	–	–	–	–	–	–	–	–	–	–
NR2M125R	2	2,50	—	1,25	2,79	–	–	–	–	–	–	–	●	–	–	–	–
NR2M150R	2	3,00	—	1,50	2,79	–	–	–	–	–	–	–	●	–	–	–	–
NR2062R	2	3,18	—	1,59	2,79	●	●	–	–	–	–	●	–	–	–	–	–
NR2M175R	2	3,50	—	1,75	2,79	–	–	–	–	–	–	–	●	–	–	–	–
NR3031R	3	1,58	—	0,79	2,39	●	●	–	–	–	●	●	●	–	–	–	–
NR3M100R	3	2,00	—	1,00	2,39	–	–	–	–	–	–	–	●	–	–	–	–
NR3047R	3	2,39	—	1,19	3,81	●	●	–	–	–	●	●	–	–	–	–	–
NR3M150R	3	3,00	—	1,50	3,81	–	–	–	–	–	–	–	●	–	–	–	–
NR3062R	3	3,18	—	1,59	3,81	●	●	–	–	–	●	●	●	–	–	–	–
NR3078R	3	3,96	—	1,98	3,81	–	–	–	–	–	●	–	–	–	–	–	–
NR3M200R	3	4,00	—	2,00	3,81	–	–	–	–	–	–	–	●	–	–	–	–
NR3094R	3	4,78	—	2,39	3,81	●	●	–	–	–	–	●	●	–	–	–	–
NR4094R	4	4,78	—	2,39	6,35	–	–	–	–	–	●	–	–	–	–	–	–
NR4125R	4	6,35	—	3,18	6,35	●	●	–	–	–	–	●	–	–	–	–	–
left hand																	
NR2M050L	2	1,00	—	0,50	1,27	●	●	–	–	–	–	●	–	–	–	–	–
NR2031L	2	1,58	—	0,79	2,79	●	●	–	–	–	–	●	●	–	–	–	–
NR2M100L	2	2,00	—	1,00	2,79	–	–	–	–	–	–	–	●	–	–	–	–
NR2047L	2	2,39	—	1,19	2,79	–	●	–	–	–	–	–	–	–	–	–	–
NR2M150L	2	3,00	—	1,50	2,79	–	–	–	–	–	–	–	●	–	–	–	–
NR2062L	2	3,18	—	1,59	2,79	●	●	–	–	–	–	●	–	–	–	–	–
NR3031L	3	1,58	—	0,79	2,39	●	●	–	–	–	●	●	●	–	–	–	–
NR3M100L	3	2,00	—	1,00	2,39	–	–	–	–	–	–	–	●	–	–	–	–
NR3047L	3	2,39	—	1,19	3,81	●	●	–	–	–	●	●	–	–	–	–	–
NR3M150L	3	3,00	—	1,50	3,81	●	–	–	–	–	–	●	●	–	–	–	–
NR3062L	3	3,18	—	1,59	3,81	●	●	–	–	–	●	●	●	–	–	–	–
NR3M200L	3	4,00	—	2,00	3,81	–	–	–	–	–	–	–	●	–	–	–	–
NR3094L	3	4,78	—	2,39	3,81	–	●	–	–	–	●	●	●	–	–	–	–
NR4125L	4	6,35	—	3,18	6,35	–	●	–	–	–	–	●	–	–	–	–	–

NOTE: Right-hand insert shown; left-hand insert is mirror image.

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

● first choice
○ alternate choice





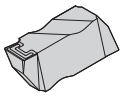
NRD

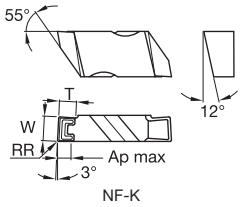
Groove and Turn • Deep Grooving • Full Radius • Flat Top

catalogue number	insert size	W	Ap max	RC	T
right hand					
NRD3031R	3	1,58	—	0,79	3,18
NRD3062R	3	3,17	—	1,59	6,35
NRD4062R	4	3,18	—	1,59	6,35
NRD4094R	4	4,78	—	2,39	12,70
NRD4125R	4	6,35	—	3,18	12,70
left hand					
NRD3031L	3	1,58	—	0,79	3,18
NRD3062L	3	3,17	—	1,59	6,35
NRD4062L	4	3,18	—	1,59	6,35
NRD4094L	4	4,78	—	2,39	12,70
NRD4125L	4	6,35	—	3,18	12,70

KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
●	●	–	–	–	–	●	●	–	–	–	–
●	●	–	–	–	–	●	●	–	–	–	–
●	●	–	–	–	–	●	–	–	–	–	–
●	–	–	–	–	–	●	–	–	–	–	–
–	●	–	–	–	–	●	–	–	–	–	–
●	●	–	–	–	–	●	●	–	–	–	–
●	●	–	–	–	–	●	●	–	–	–	–
●	●	–	–	–	–	●	●	–	–	–	–
●	●	–	–	–	–	●	–	–	–	–	–
●	●	–	–	–	–	●	●	–	–	–	–

NOTE: Inserts have one cutting edge.
Right-hand insert shown; left-hand insert is mirror image.





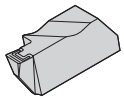
NF-K

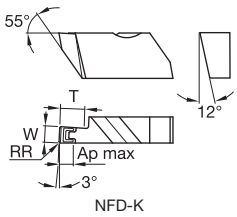
Face Grooving • Chip Control

catalogue number	insert size	W	W tol ±	Ap max	RR	T
right hand						
NF3M200RK	3	2,00	0,03	1,02	0,19	1,78
NF3M300RK	3	3,00	0,03	1,02	0,19	3,81
NF3125RK	3	3,18	0,03	1,02	0,19	3,81
NF3156RK	3	3,96	0,03	2,92	0,19	3,81
left hand						
NF3M200LK	3	2,00	0,03	1,02	0,19	1,78
NF3M300LK	3	3,00	0,03	1,02	0,19	3,81
NF3125LK	3	3,18	0,03	1,02	0,19	3,81
NF3156LK	3	3,96	0,03	2,92	0,19	3,81

KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
–	–	–	–	–	–	–	●	–	–	–	–
–	–	–	–	–	–	–	●	–	–	–	–
–	●	–	–	–	–	–	●	–	–	–	–
–	●	–	–	–	–	–	–	–	–	–	–
–	–	–	–	–	–	–	●	–	–	–	–
–	–	–	–	–	–	–	●	–	–	–	–
–	●	–	–	–	–	–	●	–	–	–	–
–	●	–	–	–	–	–	–	–	–	–	–

NOTE: Right-hand insert shown; left-hand insert is mirror image.





NFD-K

● first choice
○ alternate choice

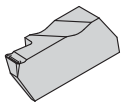
		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

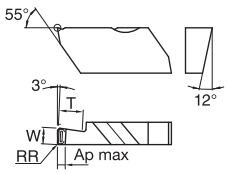
Face Grooving • Deep Grooving • Chip Control

catalogue number	insert size	W	W tol ±	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																		
NFD3M300RK	3	3,00	0,03	1,02	0,19	6,35	–	–	–	–	–	–	–	●	–	–	–	–
NFD3125RK	3	3,18	0,03	1,02	0,19	6,35	–	●	–	–	–	–	–	●	–	–	–	–
NFD4189RK	4	4,80	0,03	2,92	0,57	9,53	–	●	–	–	–	–	–	–	–	–	–	–
NFD4250RK	4	6,35	0,03	3,81	0,57	12,70	–	●	–	–	–	–	–	–	–	–	–	–
left hand																		
NFD3M300LK	3	3,00	0,03	1,02	0,19	6,35	–	–	–	–	–	–	–	●	–	–	–	–
NFD3125LK	3	3,18	0,03	1,02	0,19	6,35	–	●	–	–	–	–	–	●	–	–	–	–
NFD4189LK	4	4,80	0,03	2,92	0,57	9,53	–	●	–	–	–	–	–	●	–	–	–	–
NFD4250LK	4	6,35	0,03	3,81	0,57	12,70	–	●	–	–	–	–	–	–	–	–	–	–

NOTE: Inserts have one cutting edge.
Right-hand insert shown; left-hand insert is mirror image.

- Face grooving deep grooving inserts.



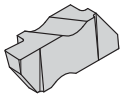


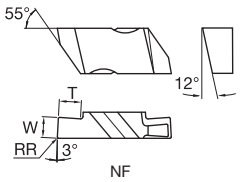
NFD-KI

Face Grooving • Internal Deep Grooving • Chip Control

catalogue number	insert size	W	W tol ±	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																		
NFD3125RKI	3	3,18	0,03	1,02	0,19	6,35	–	●	–	–	–	–	–	●	–	–	–	–
NFD3189RKI	3	4,80	0,03	2,92	0,57	6,35	–	●	–	–	–	–	–	–	–	–	–	–
left hand																		
NFD3125LKI	3	3,18	0,03	1,02	0,19	6,35	–	●	–	–	–	–	–	–	–	–	–	–
NFD3189LKI	3	4,80	0,03	2,92	0,57	6,35	–	●	–	–	–	–	–	–	–	–	–	–

NOTE: Inserts have one cutting edge.
NFD-KI inserts are compatible with NS-style boring bars only.
Right-hand insert shown; left-hand insert is mirror image.





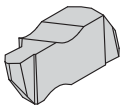
● first choice
○ alternate choice

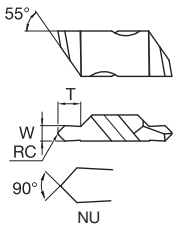
		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

Face Grooving • Flat Top

catalogue number	insert size	W	W tol ±	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																		
NF3125R	3	3,18	0,03	—	0,19	3,81	–	–	–	–	–	●	–	–	–	–	–	–
NF3188R	3	4,78	0,03	—	0,57	3,81	–	●	–	–	–	–	–	–	–	–	–	–
left hand																		
NF3125L	3	3,18	0,03	—	0,19	3,81	–	–	–	–	–	●	–	–	–	–	–	–
NF3188L	3	4,78	0,03	—	0,57	3,81	–	●	–	–	–	–	–	–	–	–	–	–

NOTE: Right-hand insert shown; left-hand insert is mirror image.





Groove and Turn • Flat Top • 90°

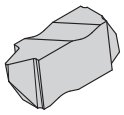
catalogue number	insert size	W	Ap max	RC	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																	
NU3094R	3	2,39	—	0,51	3,18	–	–	–	–	–	–	–	●	–	–	–	–
NU3125R	3	3,18	—	1,19	4,78	–	●	–	–	–	–	–	–	–	–	–	–
left hand																	
NU3094L	3	2,39	—	0,51	3,18	–	●	–	–	–	–	–	●	–	–	–	–
NU3125L	3	3,18	—	1,19	4,78	–	–	–	–	–	–	–	●	–	–	–	–
NU3156L	3	3,96	—	1,19	4,78	–	–	–	–	–	–	–	●	–	–	–	–

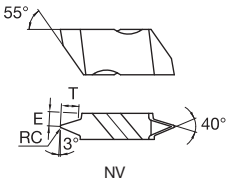
NOTE: Tolerance on W ± 0,13mm (± .005").
Right-hand insert shown; left-hand insert is mirror image.
NU inserts compatible with NR-style inserts.

- Poly-Vee grooving inserts.

● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	



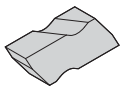


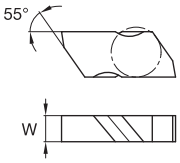
NV

Groove and Turn • Flat Top • Poly-Vee

catalogue number	insert size	E	RC	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																
NV3RJ	3	3,18	0,32	2,21	–	●	–	–	–	–	–	–	–	–	–	–
NV4RL	4	3,00	0,32	5,11	–	●	–	–	–	–	–	–	–	–	–	–
left hand																
NV4LL	4	3,00	0,32	5,11	–	●	–	–	–	–	–	–	–	–	–	–

NOTE: Right-hand insert shown; left-hand insert is mirror image.





NB

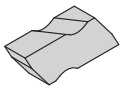
Groove and Turn • Blank

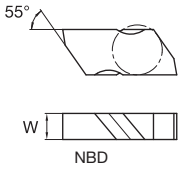
catalogue number	insert size	W	W tol ±	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																		
NB2R	2	3,84	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
NB3R	3	4,95	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
NB4R	4	6,48	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
left hand																		
NB2L	2	3,84	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
NB3L	3	4,95	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
NB4L	4	6,48	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

NOTE: NB and NBD blanks are designed to allow modification of the W-dimension and end form. W-dimension is provided to indicate maximum possible width.
Available only in uncoated grades.
Right-hand insert shown; left-hand insert is mirror image.

● first choice
○ alternate choice

		KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
P		●	●	●	●	○		○	○	●			
M		●	●				○	●	○				
K		○	○	○	○	●	○	○	○	○	○		
N		●	○				○	●	○				●
S		●	●				●	○	○		○		
H		○						○			●	●	

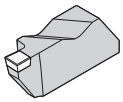


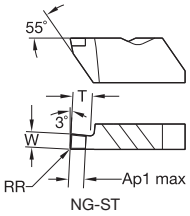


Groove and Turn • Deep Grooving • Blank

catalogue number	insert size	W	W tol ±	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																		
NBD2R	2	3,81	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
NBD3R	3	4,95	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
left hand																		
NBD3L	3	4,95	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–

NOTE: NB and NBD blanks are designed to allow modification of the W-dimension and end form. W-dimension is provided to indicate maximum possible width.
Available only in uncoated grades.
Right-hand insert shown; left-hand insert is mirror image.





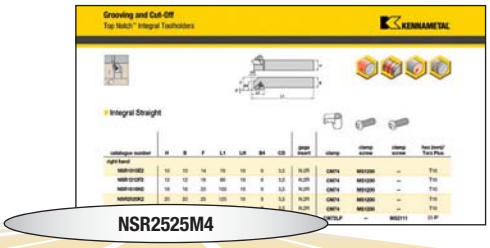
Groove and Turn • Flat Top • PcBN

catalogue number	insert size	W	Ap max	RR	T	KCU10	KCU25	KCP10B	KCP25B	KCK20B	K313	KC5010	KC5025	KT315	KB1630	KB5625	KD1425
right hand																	
NG3062REST	3	1,58	–	0,19	2,39	–	–	–	–	–	–	–	–	–	●	–	●
NG3M200RS02020ST	3	2,00	2,00	0,20	2,39	–	–	–	–	–	–	–	–	–	●	●	–
NG3094REST	3	2,39	–	0,19	3,81	–	–	–	–	–	–	–	–	–	●	–	●
NG3M300RS02020ST	3	3,00	3,00	0,20	3,81	–	–	–	–	–	–	–	–	–	●	●	–
NG3125REST	3	3,18	–	0,19	3,81	–	–	–	–	–	–	–	–	–	●	–	●
NG3125RS0820ST	3	3,18	3,00	0,25	3,81	–	–	–	–	–	–	–	–	–	●	●	–
NG3M400RS02020ST	3	4,00	3,00	0,20	3,81	–	–	–	–	–	–	–	–	–	–	●	–
NG3189REST	3	4,80	–	0,57	3,81	–	–	–	–	–	–	–	–	–	–	–	●
NG4189REST	4	4,80	–	0,57	6,35	–	–	–	–	–	–	–	–	–	●	–	–
left hand																	
NG3062LEST	3	1,58	–	0,19	2,39	–	–	–	–	–	–	–	–	–	●	–	●
NG3M200LS02020ST	3	2,00	2,00	0,20	2,39	–	–	–	–	–	–	–	–	–	–	●	–
NG3094LEST	3	2,39	–	0,19	3,81	–	–	–	–	–	–	–	–	–	●	–	●
NG3125LEST	3	3,18	–	0,19	3,81	–	–	–	–	–	–	–	–	–	●	–	–
NG3125LS0820ST	3	3,18	3,00	0,25	3,81	–	–	–	–	–	–	–	–	–	●	–	–
NG4189LEST	4	4,80	–	0,57	6,35	–	–	–	–	–	–	–	–	–	●	–	–

NOTE: All KB grades are single-ended tipped inserts.
Right-hand insert shown; left-hand insert is mirror image.

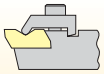
How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.

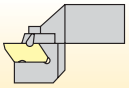


NSR2525M4

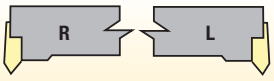
N	S	R		2525	M	4	
Insert Holding Method	Insert Mounting Location	Hand of Tool	Drop Head	Shank Size	Tool Length	Insert Size	Qualified Surface and Length



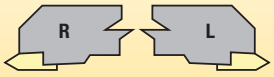
N = Top Notch*



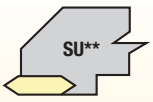
DH = Drop Head



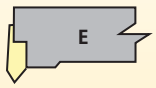
End mount



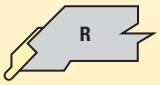
Side mount



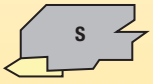
SU = Side mount utility



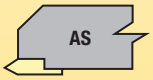
E = End



R = Undercut



S = Side mount, offset

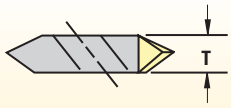


AS = Side mount, no offset

Metric:
Shank height and width in millimetre and holder length according to ISO standard.

L1	ISO
32	A
40	B
50	C
60	D
70	E
80	F
90	G
100	H
110	J
125	K
140	L
150	M
160	N
170	P
180	Q
200	R
250	S
300	T
350	U
400	V
450	W
500	Y
Special Length	X

Q = Qualified metric holder

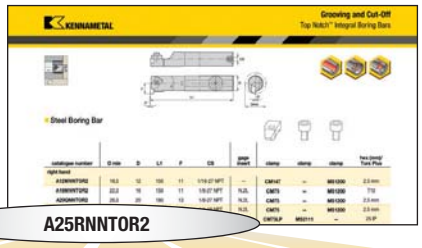


insert size	T mm
2	3,81
3	4,95
4	6,98
5	9,65
6	9,73
8	11,13

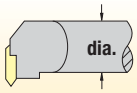
* Kennametal proprietary standard only.
** Side mount utility holder can only use NTU inserts.

How Do Catalogue Numbers Work?

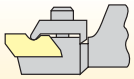
Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



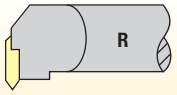
A	25	R	N	N	T	0	R	2
Bar Type	Bar Diameter	Bar Length	Insert Holding Method	Insert Shape	Insert Location	Rake Angle	Hand of Bar	Insert Size



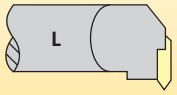
Bar diameter in millimetres



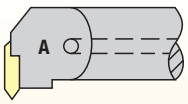
N* = Top Notch



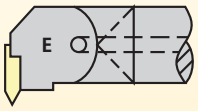
R = Right hand



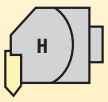
L = Left hand



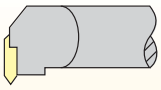
A = Steel with coolant



E = Carbide with coolant

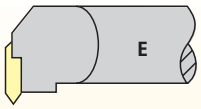


H = Interchangeable head

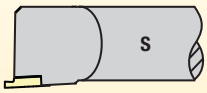


metric bars:

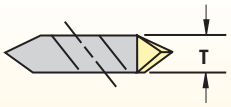
K	=	125mm
M	=	150mm
Q	=	180mm
R	=	200mm
S	=	250mm
T	=	300mm
U	=	350mm



E = End mount

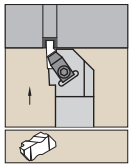


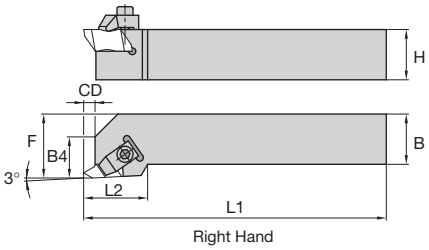
S = Straight mount



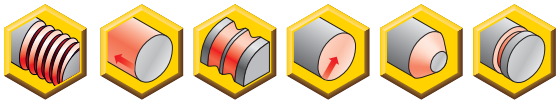
insert size	T mm
1	3,54
2	3,81
3	5,35
4	6,40
5	9,65
6	9,73
8	11,13

*Kennametal standard only.





Right Hand

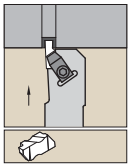


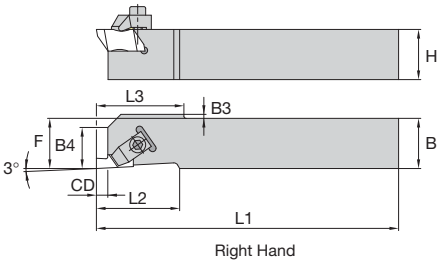
Integral Straight



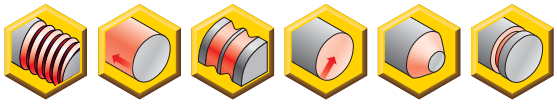
order number	catalogue number	H	B	F	L1	LH	B4	CD	gage insert	clamp	clamp screw	clamp screw	hex (mm)/ Torx Plus
right hand													
1098790	**NSR1010E2**	10	10	14	70	19	9	3,5	N.2R	**CM74**	**MS1200**	**–**	T10
1098791	**NSR1212F2**	12	12	16	80	19	9	3,5	N.2R	**CM74**	**MS1200**	**–**	T10
1098792	**NSR1616H2**	16	16	20	100	19	9	3,5	N.2R	**CM74**	**MS1200**	**–**	T10
1098793	**NSR2020K2**	20	20	25	125	19	9	3,5	N.2R	**CM74**	**MS1200**	**–**	T10
1098794	**NSR2525M2**	25	25	32	150	19	9	3,5	N.2R	**CM74**	**MS1200**	**–**	T10
1098795	**NSR2020K3**	20	20	25	125	32	13	5,3	N.3R	**CM72LP**	**–**	**MS2111**	25 IP
1098796	**NSR2525M3**	25	25	32	150	32	13	5,3	N.3R	**CM72LP**	**–**	**MS2111**	25 IP
1098797	**NSR3225P3**	32	25	32	170	32	13	5,3	N.3R	**CM72LP**	**–**	**MS2111**	25 IP
1098798	**NSR3232P3**	32	32	40	170	32	13	5,3	N.3R	**CM72LP**	**–**	**MS2111**	25 IP
1098799	**NSR2525M4**	25	25	32	150	35	14	7,5	N.4R	**CM72LP**	**–**	**MS2111**	25 IP
1098800	**NSR3225P4**	32	25	32	170	35	14	7,5	N.4R	**CM72LP**	**–**	**MS2111**	25 IP
1098801	**NSR3232P4**	32	32	40	170	35	14	7,5	N.4R	**CM72LP**	**–**	**MS2111**	25 IP
left hand													
1098861	**NSL1010E2**	10	10	14	70	19	9	3,5	N.2L	**CM75**	**MS1200**	**–**	T10
1098862	**NSL1212F2**	12	12	16	80	19	9	3,5	N.2L	**CM75**	**MS1200**	**–**	T10
1098863	**NSL1616H2**	16	16	20	100	19	9	3,5	N.2L	**CM75**	**MS1200**	**–**	T10
1098864	**NSL2020K2**	20	20	25	125	19	9	3,5	N.2L	**CM75**	**MS1200**	**–**	T10
1098865	**NSL2525M2**	25	25	32	150	19	9	3,5	N.2L	**CM75**	**MS1200**	**–**	T10
1098866	**NSL2020K3**	20	20	25	125	32	13	5,3	N.3L	**CM73LP**	**–**	**MS2111**	25 IP
1098867	**NSL2525M3**	25	25	32	150	32	13	5,3	N.3L	**CM73LP**	**–**	**MS2111**	25 IP
1098868	**NSL3225P3**	32	25	32	170	32	13	5,3	N.3L	**CM73LP**	**–**	**MS2111**	25 IP
1098869	**NSL3232P3**	32	32	40	170	32	13	5,3	N.3L	**CM73LP**	**–**	**MS2111**	25 IP
1098870	**NSL2525M4**	25	25	32	150	35	14	7,5	N.4L	**CM73LP**	**–**	**MS2111**	25 IP
1098871	**NSL3225P4**	32	25	32	170	35	14	7,5	N.4L	**CM73LP**	**–**	**MS2111**	25 IP
1098872	**NSL3232P4**	32	32	40	170	35	14	7,5	N.4L	**CM73LP**	**–**	**MS2111**	25 IP

NOTE: F dimension measured over sharp point of N-style threading insert.

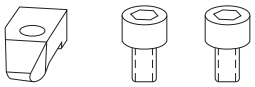




Right Hand



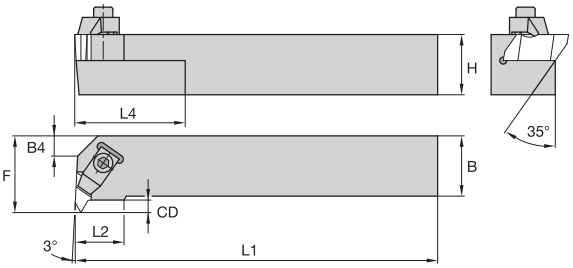
Integral Straight • No Offset



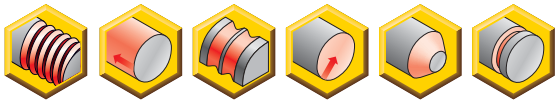
order number	catalogue number	H	B	F	L1	LH	B4	CD	B3	L3	gage insert	clamp	clamp screw	clamp screw	hex (mm)/ Torx Plus
right hand															
1098788	**NASR1010M2Q**	10	10	10	150	19	9	3,5	2,03	19	N.2R	**CM182**	**MS1200**	**–**	T10
1098789	**NASR1212M2Q**	12	12	12	150	19	9	3,5	–	–	N.2R	**CM182**	**MS1200**	**–**	T10
1098786	**NASR1616K3Q**	16	16	16	125	32	13	5,3	–	–	N.3R	**CM184LP**	**–**	**MS2111**	25 IP
left hand															
1098859	**NASL1010M2Q**	10	10	10	150	19	9	3,5	2,03	19	N.2L	**CM183**	**MS1200**	**–**	T10
1098860	**NASL1212M2Q**	12	12	12	150	19	9	6,9	–	–	N.2L	**CM183**	**MS1200**	**–**	T10
1098857	**NASL1616K3Q**	16	16	16	125	32	13	5,3	–	–	N.3L	**CM185LP**	**–**	**MS2111**	25 IP

NOTE: F dimension measured over sharp point of N-style threading insert.

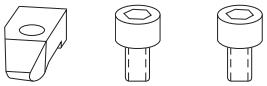




Right Hand

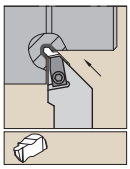


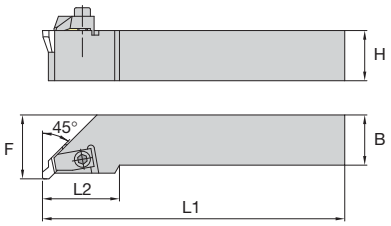
Integral End Mount



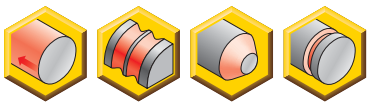
order number	catalogue number	H	B	F	L1	LH	CD	gage insert	clamp	clamp screw	clamp screw	Torx/ Torx Plus
right hand												
1098803	**NER1616H2**	16	16	20	100	15	3,5	N.2L	**CM75**	**MS1200**	–	T10
1098804	**NER2020K2**	20	20	25	125	15	3,5	N.2L	**CM75**	**MS1200**	–	T10
1098805	**NER2525M2**	25	25	32	150	15	3,5	N.2L	**CM75**	**MS1200**	–	T10
1098806	**NER2525M3**	25	25	32	150	22	5,3	N.3L	**CM73LP**	–	**MS2111**	25 IP
1098807	**NER3225P3**	32	25	32	170	22	3,8	N.3L	**CM73LP**	–	**MS2111**	25 IP
1098808	**NER2525M4**	25	25	35	150	24	6,4	N.4L	**CM73LP**	–	**MS2111**	25 IP
1098809	**NER3225P4**	32	25	35	170	24	6,4	N.4L	**CM73LP**	–	**MS2111**	25 IP
1098810	**NER3232P4**	32	32	40	170	24	6,4	N.4L	**CM73LP**	–	**MS2111**	25 IP
left hand												
1098874	**NEL1616H2**	16	16	20	100	15	3,5	N.2R	**CM74**	**MS1200**	–	T10
1098875	**NEL2020K2**	20	20	25	125	15	3,5	N.2R	**CM74**	**MS1200**	–	T10
1098876	**NEL2525M2**	25	25	32	150	15	3,5	N.2R	**CM74**	**MS1200**	–	T10
1098877	**NEL2525M3**	25	25	32	150	22	5,3	N.3R	**CM72LP**	–	**MS2111**	25 IP
1098878	**NEL3225P3**	32	25	32	170	22	3,8	N.3R	**CM72LP**	–	**MS2111**	25 IP
1098879	**NEL2525M4**	25	25	35	150	24	6,4	N.4R	**CM72LP**	–	**MS2111**	25 IP
1098880	**NEL3225P4**	32	25	35	170	24	6,4	N.4R	**CM72LP**	–	**MS2111**	25 IP
1098881	**NEL3232P4**	32	32	40	170	24	6,4	N.4R	**CM72LP**	–	**MS2111**	25 IP

NOTE: F dimension measured over sharp point of N-style threading insert.

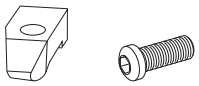




Right Hand

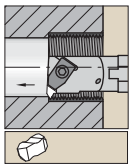


Integral 45° Undercut • Metric

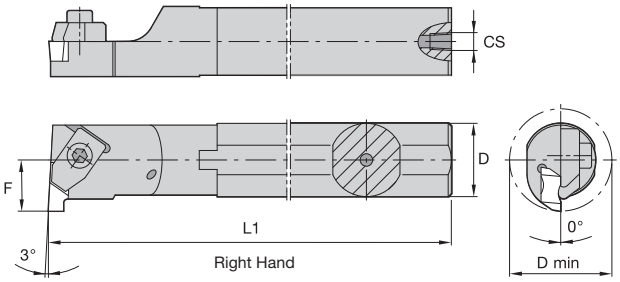


order number	catalogue number	H	B	F	L1	LH	gage insert	clamp	clamp screw	hex (mm)/ Torx Plus
right hand										
1098812	**NRR2020K3**	20	20	25	125	32	NU3125L	**CM73LP**	**MS2111**	25 IP
1098813	**NRR2525M3**	25	25	32	150	32	NU3125L	**CM73LP**	**MS2111**	25 IP
1098814	**NRR3225P3**	32	25	32	170	32	NU3125L	**CM73LP**	**MS2111**	25 IP
left hand										
1098883	**NRL2020K3**	20	20	25	125	32	NU3125R	**CM72LP**	**MS2111**	25 IP
1098884	**NRL2525M3**	25	25	32	150	32	NU3125R	**CM72LP**	**MS2111**	25 IP
1098885	**NRL3225P3**	32	25	32	170	32	NU3125R	**CM72LP**	**MS2111**	25 IP

NOTE: NR-style toolholders are compatible with “NU” style inserts only.



Steel shank with through coolant.



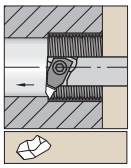


Steel Boring Bar • Metric

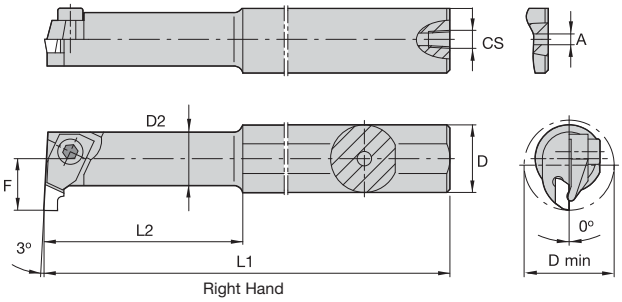


order number	catalogue number	D min	D	L1	F	CS	gage insert	clamp	clamp screw	clamp screw	hex (mm)/ Torx Plus
right hand											
1098945	**A12MNNTOR2**	18,5	12	150	11	1/16-27 NPT	–	**CM147**	–	**MS1200**	2.5 mm
1098947	**A16MNNTOR2**	22,0	16	150	11	1/8-27 NPT	N.2L	**CM75**	–	**MS1200**	T10
1098949	**A20QNNTOR2**	26,0	20	180	13	1/8-27 NPT	N.2L	**CM75**	–	**MS1200**	2.5 mm
1098951	**A25RNNTOR2**	34,0	25	200	17	1/4-18 NPT	N.2L	**CM75**	–	**MS1200**	2.5 mm
1098953	**A25RNNTOR3**	34,0	25	200	17	1/8 - 27 NPT	N.3L	**CM73LP**	**MS2111**	–	25 IP
1098955	**A32SNNTOR3**	44,0	32	250	22	1/4-18 NPT	N.3L	**CM73LP**	**MS2111**	–	25 IP
1098957	**A40TNNTOR3**	54,0	40	300	27	1/4-18 NPT	N.3L	**CM73LP**	**MS2111**	–	25 IP
1099001	**A40TNNTOR4**	54,0	40	300	27	1/4-18 NPT	N.4L	**CM73LP**	**MS2111**	–	25 IP
1099003	**A50UNNTOR4**	70,0	50	350	35	1/4-18 NPT	N.4L	**CM73LP**	**MS2111**	–	25 IP
left hand											
1098946	**A12MNNTOL2**	18,5	12	150	11	1/16-27 NPT	NG2R	**CM146**	–	**MS1200**	2.5 mm
1098948	**A16MNNTOL2**	22,0	16	150	11	1/8-27 NPT	N.2R	**CM74**	–	**MS1200**	T10
1098950	**A20QNNTOL2**	26,0	20	180	13	1/8-27 NPT	NG2R	**CM74**	–	**MS1200**	2.5 mm
1098952	**A25RNNTOL2**	34,0	25	200	17	1/4-18 NPT	N.2R	**CM74**	–	**MS1200**	2.5 mm
1098954	**A25RNNTOL3**	34,0	25	200	17	1/4-18 NPT	N.3R	**CM72LP**	**MS2111**	–	25 IP
1098956	**A32SNNTOL3**	44,0	32	250	22	1/4-18 NPT	N.3R	**CM72LP**	**MS2111**	–	25 IP
1098958	**A40TNNTOL3**	54,0	40	300	27	1/4-18 NPT	N.3R	**CM72LP**	**MS2111**	–	25 IP
1099002	**A40TNNTOL4**	54,0	40	300	27	1/4-18 NPT	N.4R	**CM72LP**	**MS2111**	–	25 IP

NOTE: Minimum bore capability varies with depth of groove. See page C172 for details.

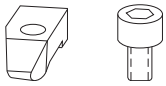


Necked steel shank with through coolant.



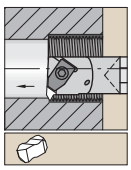


Steel Boring Bar • Small ID • Metric

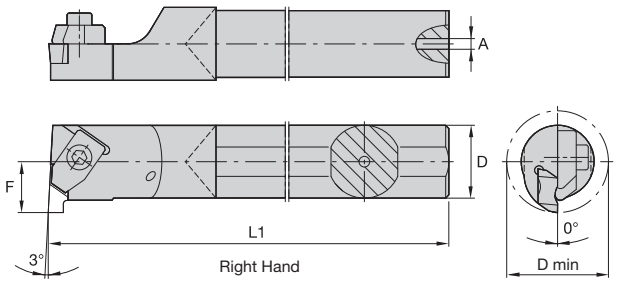


order number	catalogue number	D min	D	D2	L1	L2	F	A	CS	gage insert	clamp	clamp screw	hex (mm)
right hand													
1098944	**A12MNNTOR1**	11,5	12	10,0	150	31,30	7	4,0	1/16-27 NPT	N.1L	**CM109**	**MS1034**	1.5 mm
1098943	**A10KNNTOR1**	11,5	10	10,0	125	—	7	3,2	—	NG1L	**CM109**	**MS1034**	1.5 mm

NOTE: Minimum bore capability varies with depth of groove. See page C172 for details.

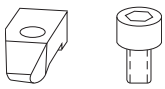


Carbide shank with through coolant.



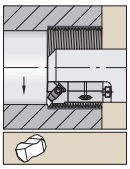


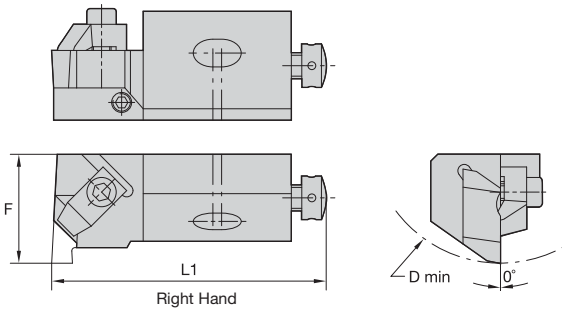
Carbide Boring Bar



order number	catalogue number	D min	D	L1	F	A	gage insert	clamp	clamp screw	Torx/ Torx Plus
right hand										
1152834	**E16RNNTOR2**	22,0	16	200	11	5,537	N.2L	**CM75**	**MS1200**	T10
1152836	**E20SNNTOR2**	26,0	20	250	13	7,137	N.2L	**CM75**	**MS1200**	T10
left hand										
1152835	**E16RNNTOL2**	22,0	16	200	11	5,537	N.2R	**CM74**	**MS1200**	T10

NOTE: Minimum bore capability varies with depth of groove. See page C172 for details.







Steel Boring Cartridge



order number	catalogue number	D min	F	L1	gage insert	clamp	clamp screw	hex (mm)	radial adjusting screw	hex (mm)	axial screw	hex (mm)	washer
right hand													
1098380	**NER12CA2**	50	20	55,7	N.2L	**CM75**	**MS1025**	2.5 mm	**KUAM23**	2.5 mm	**KUAM31**	2.5 mm	**CSWM 060 050**
left hand													
1098624	**NEL12CA2**	50	20	55,0	N.2R	**CM74**	**MS1025**	2.5 mm	**KUAM23**	2.5 mm	**KUAM31**	2.5 mm	**CSWM 060 050**
1098626	**NEL25CA3**	100	32	100,0	N.3R	**CM72LP**	**MS412**	4 mm	**KUAM26**	4 mm	**KUAM33**	4 mm	**CSWM 100 080**

NOTE: Minimum bore diameter (D min) capability varies with thread type and pitch. See page C172 for details.
F dimension measured over sharp point of Top Notch-style threading insert.

Machining Guidelines for Chip Control • Grooving

When the proper cutter diameter is not available,

proper cutter positioning will provide positive results.

- Centre height of insert should be positioned at the centre of the workpiece or up to 0,13mm (.005") above.
- Dwell time in the bottom of the groove (more than three revolutions) is not recommended.
- Chip control is feed rate related and should be adjusted to fit the particular situation. Recommended feed range is 0,08–0,3 mm/rev (.003–.012 IPR).

Machining Guidelines for Chip Control • Turning/Profiling

Maximum depth of cut for side cutting (turning/profiling)
depends on the material being cut and the width of the tool.

- 0,79–1,6mm (.031–.062") wide insert can cut up to 0,6mm (.025" deep).
- 1,7–3,3mm (.067–.128") wide insert can cut up to 1mm (.040" deep).
- 3,5–4,8mm (.138–.189") wide insert can cut up to 2mm (.080" deep).
- 5–6,35mm (.197–.250") wide insert can cut up to 3mm (.120" deep).

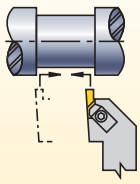
Groove Limits (Maximum Internal Groove Depth vs. Minimum Bore Diameter)

insert catalogue number	maximum internal groove depth mm	minimum bore diameter mm
NG-1094L	1,91	20,32
—	1,02	11,18
NG-2031R/L	1,27	18,54
NG-2041R/L	—	—
NG-2047R/L	—	—
NG-2058R/L	—	—
—	2,79	63,50
NG-2062R/L	2,59	44,45
NG-2094R/L	2,49	38,10
NG-2125R/L	2,03	25,40
—	1,40	18,54
NG-3047R/L	—	—
NG-3062R/L	2,39	44,45
NG-3072R/L	2,29	41,28
NG-3078R/L	1,91	34,93
NG-3088R/L	—	—
NG-3094R/L	—	—
NG-3097R/L	3,81	60,33
NG-3105R/L	—	—
NG-3110R/L	3,68	53,98
NG-3122R/L	—	—
NG-3125R/L	3,51	47,63
NG-3142R/L	—	—
NG-3156R/L	3,18	41,28
NG-3178R/L	—	—
NG-3185R/L	2,79	34,93
NG-3189R/L	—	—
NG-4125R/L	3,81	69,85
—	6,35	146,05
NG-4189R/L	6,22	127,00
NG-4213R/L	6,10	114,30
NG-4219R/L	5,54	82,55
NG-4250R/L	5,08	63,50

NOTE: The same maximum groove depth and minimum bore diameter values also apply to metric, NG-K (chip control), and NR (full radius) inserts of similar size.

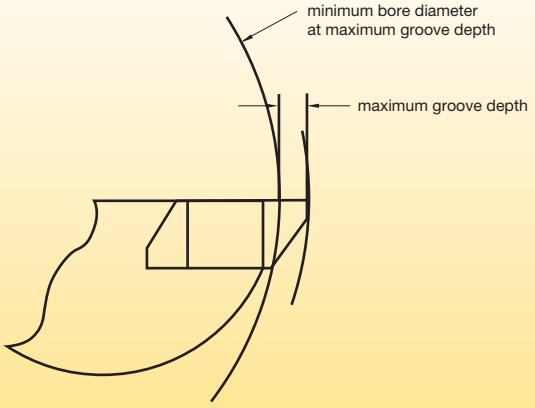
Finish Turning the Groove

1. Plunge both sides of groove width.
2. Plunge centre area to remove web of material remaining.
3. To avoid insert chipping and to achieve groove wall perpendicularity, follow the tool path outlined.
4. Use the lightest depth of cut that still allows good chipbreaking, tool life, and surface finish.



insert catalogue number	maximum internal groove depth mm	minimum bore diameter mm
—	9,53	731,82
NG-5250R/L	9,17	401,62
NG-5281R/L	8,74	274,62
NG-5312R/L	8,31	185,72
NG-5344R/L	7,47	122,22
NG-5375R/L	6,53	90,47
—	5,46	71,42
NG-6250R/L	6,35	146,05
NG-6281R/L	6,22	127,00
NG-6312R/L	6,10	114,30
NG-6344R/L	5,54	82,55
NG-6375R/L	5,08	63,50

Internal Groove Depth versus Bar Interference



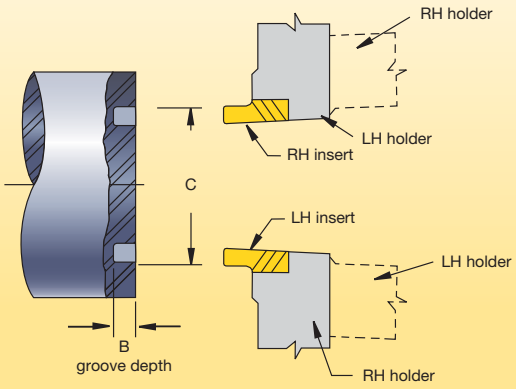
NOTE: Internal grooving depth limits are a function of bar clearance versus bore diameters.

Machining Guidelines for Face Grooving Operations • External

Standard NF/NDF Inserts

insert family	maximum groove depth "B" mm	minimum groove diameter "C" mm
NF-3	1,52	23,90
NF-3	2,39	30,50
NF-3	3,18	36,10
NF-3	3,81	41,30
NFD-3	6,35	47,60
NF-4/6	1,52	23,90
NF-4/6	2,39	30,50
NF-4/6	3,18	36,10
NF-4/6	3,81	41,30
NF-4/6	4,78	47,60
NF-4/6	6,35	57,20
NFD-4	9,53	57,20
NFD-4	12,70	57,20

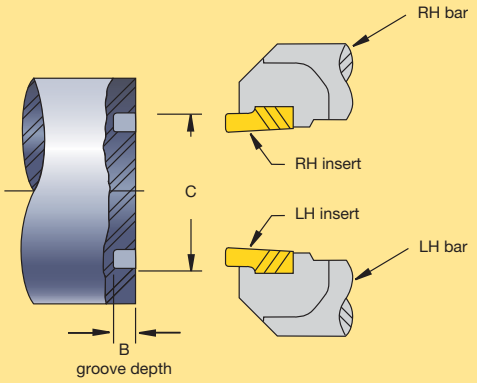
Toolholders



Standard NG/NGD Inserts

insert family	maximum groove depth "B" mm	minimum groove diameter "C" mm
NG-2	1,27	54,0
NG-2	2,79	88,9
NG-3	2,39	101,6
NG-3	3,18	127,0
NG-3	3,81	139,7
NGD-3	6,35	174,6
NG-4	3,81	152,4
NG-4	6,35	209,6
NGD-4	9,53	222,3
NGD-4	12,70	222,3
NG-5	9,53	333,0

Boring Bars

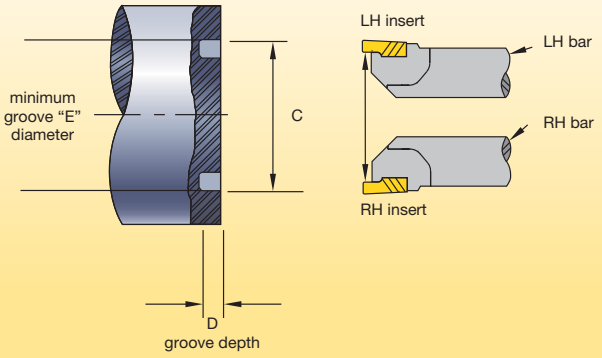


Machining Guidelines for Face Grooving Operations • Internal

insert family	maximum groove depth "D" mm	minimum groove diameter "E" mm
NFD-3-KI	6,35	57,2

NOTE: For internal applications, use only NFD-KI inserts.

Boring Bars

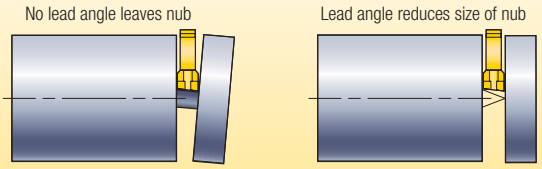


Tool Application Guidelines

- Always use good general machining practices.
- Make the machine and workpiece setup as rigid as possible.
- Integral shank toolholders offer the best rigidity. They should be your first toolholder choice, when possible.
- Use the toolholder with the shortest possible depth of cut for the application ("CD" dimension).
- When changing inserts, make sure the new insert locates securely against the toolholder's positive stop.
- Never tighten the clamping screw without an insert in the pocket.
- Toolholder projection out of the tool block should be as short as possible.
- Inserts should cut as close to centre as possible.
- Dwell time in bottom of groove should be less than three revolutions.
- Recommended cutting speed and feeds are a starting point. Adjust, as necessary, for optimum tool life and chip control.

Definitions and Guidelines

1. Width of cut (W) = width of the insert.
2. Lead angle = 0° (neutral); 6° (RH or LH).

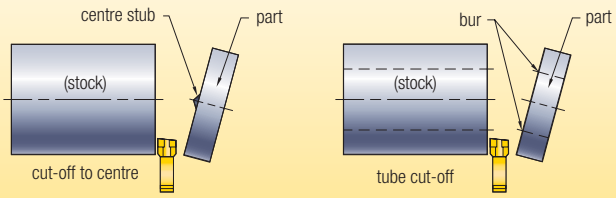


Reduce bur of cut-off faces:

- Use lead angle-type inserts (Figures 1 and 2). Lead angle on a cut-off insert reduces the bur that remains on the part but decreases tool life and increases tool side deflection and possibly cycle time.
- If 0° lead angle is mandatory, use the narrowest possible cut-off insert and blade. This will minimise the centre stub or cut-off bur length.

Figure 1

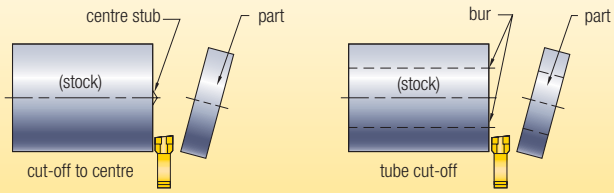
Insert selection **left-hand lead**



Left-hand lead insert leaves centre stub or bur on part and produces clean stock surface.

Figure 2

Insert selection **right-hand lead**



Reduces nub but decreases tool life and productivity

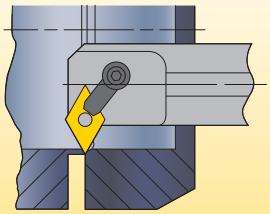
Right-hand lead insert leaves centre stub or bur on stock and produces clean part surface.

- Check total height and maintain on centre with part diameter.
- The cutting edge height should be within ±0,1mm (.004") to the centre; recommended cutting position is 0,05mm (.002") above centre.

Tubing

- On tubing-type parts that require a chamfer on the I.D., align I.D. chamfer tool with cut-off surface. This will enable the chamfering operation to actually separate the part from the bar (see Figure 3). Note the part may drop onto the chamfering bar, which, in this case, will act like a catcher for the part.

Figure 3

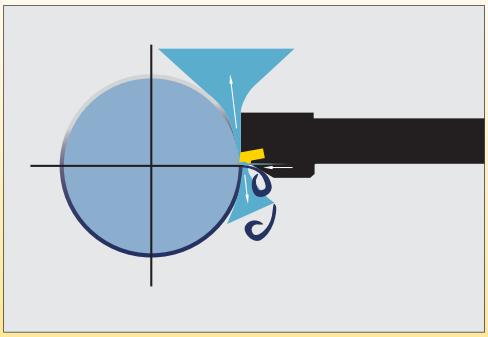


Internal chamfer line up

Improve surface finish of cut-off faces:

- Use insert with 0° lead angle.
- Increase coolant flow or improve application technique, as shown in Figure 4.
- Decrease the feed rate near the break-through point of the cut.
- Check that the grooving tool is set at the correct angle.
- Use blades with the greatest possible face height and smallest possible cutting width.
- Increase the speed.

Figure 4

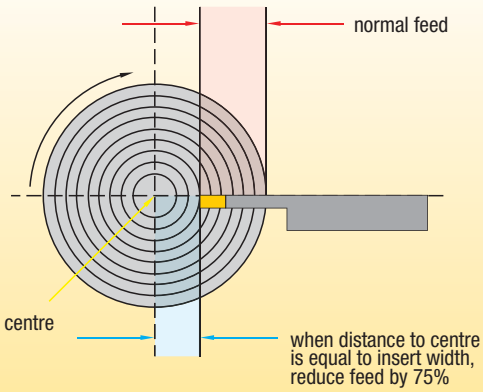


Preferred method for applying coolant

- Mount cut-off tool upside down. This enables gravity to remove chips and avoid cutting the chips twice. Another benefit of mounting the tool upside down is preventing chips from wedging between the tool insert and the groove side walls, which galls the side wall surfaces.

Programming Guidelines

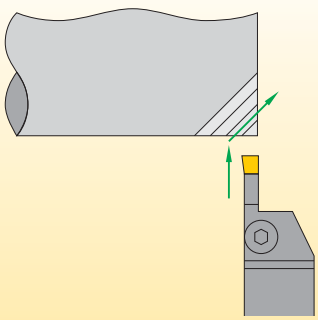
Feed reduction in cut-off



Feed reduction when approaching centre = longer tool life

Chamfering

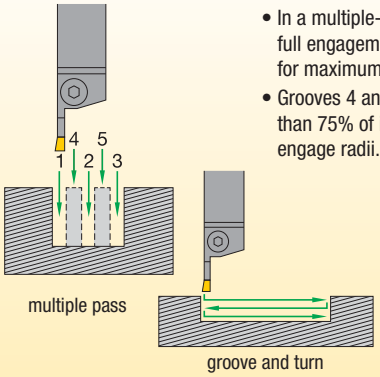
Chamfering with a grooving tool reduced machine index time and tool stations.



(continued)

Programming Guidelines *(continued)*

Pocketing



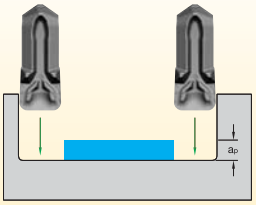
- In a multiple-pass operation, generate full engagement grooves in 1, 2, and 3 for maximum stability.
- Grooves 4 and 5 should be no more than 75% of insert width, so as not to engage radii.

If pocket is deeper than wide = multiple pass

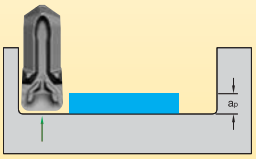
If pocket is wider than deep = groove and turn

Square Pocket

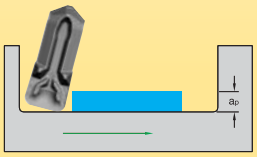
Steps 1 and 2
Plunge the radius and wall on each side to open up two grooves.



Step 3
Retract tool 0,1mm; this is necessary to create a flat bottom.

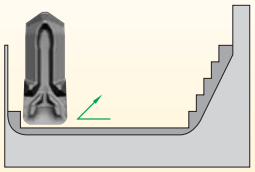


Step 4
Side turn. This tool is designed to deflect, creating the necessary front clearance.

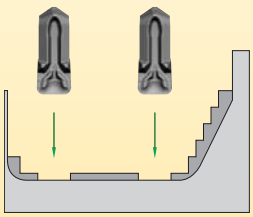


Profile Pocket

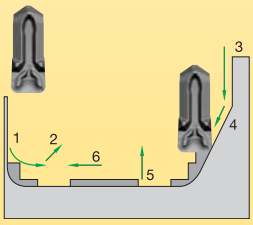
Step 1
Rough to have about the same amount of stock left on all surfaces for finish.



Step 2
Open up two grooves away from wall and radius.

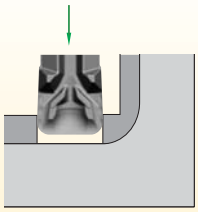


Step 3
(1 and 2) Finish wall and radius.
(3 and 4) Finish wall, angle, and radius on opposite side of pocket.
(5) Retract tool 0,1mm (.004").
(6) Side turn to finish the floor of the pocket.

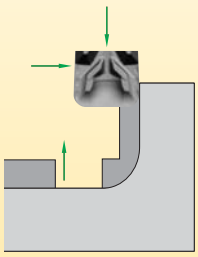


Generating a Radius

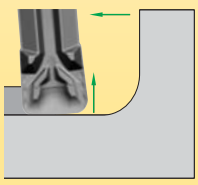
Step 1
Open up a groove away from the radius.



Step 2
Retract and move the material on the wall and generate the radius. By generating the groove in the prior step, only one surface is engaged at a time, reducing the risk of vibrations.

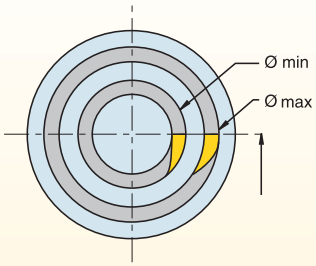


Step 3
Retract the tool 0,1mm (.004") and then side turn.



Grooving Tool Failure and Solution Guide

Face Grooving Application Guidelines



Tool Selection

- When selecting the toolholder, always start at the largest diameter possible and work toward the smaller diameter. This will allow the strongest tool to be used.

Cutting the First Groove

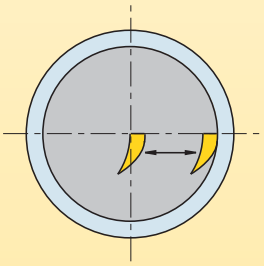
- The outside diameter of the first groove must be between the diameter minimum and diameter maximum capability of the face grooving tool (see illustration above). This creates clearance for the toolholder.

Chip Control

- Adjust speed and feed for good chip control and evacuation from the groove. Chip compaction can cause poor surface finish, tool breakage, and reduced tool life.

Tool Setting

- The tool should be set as close to the centre as possible to avoid extreme formation of burs.
- Align the cutting edge square to the workpiece.



Widening a Face Groove

- After the first groove has been cut, the groove width can be widened in either direction using the same tool. The best practice is to work from the O.D. to the I.D.

Practical Solutions to Grooving Problems

problem	remedy
bur	1. Verify tool centre height. 2. Use sharp tools (index more often). 3. Use positive rake PVD coated insert. 4. Use correct grade for workpiece material. 5. Use correct geometry (e.g., positive rake for workhardening material). 6. Change tool path.
poor surface finish	1. Increase speed. 2. Use sharp tools (index more often). 3. Dwell time in bottom 1–3 revolutions (max). 4. Use proper chip control geometry. 5. Increase coolant flow. 6. Verify proper setup (overhang, shank size). 7. Use correct geometry (e.g., positive rake for workhardening material).
groove bottom not flat	1. Use sharp tools (index more often). 2. Dwell time in bottom 1–3 revolutions (max). 3. Reduce tool overhang (increase rigidity). 4. Reduce feed rate at groove bottom. 5. Use a wider insert. 6. Verify tool centre height.
poor chip control	1. Use sharp tools (index more often). 2. Increase coolant concentration. 3. Adjust feed rate (usually increase first).
chatter	1. Reduce tool and workpiece overhang. 2. Adjust speed (usually increase first). 3. Adjust feed (usually increase first). 4. Verify tool centre height.
insert chipping	1. Use correct grade for workpiece material. 2. Increase speed. 3. Reduce feed. 4. Use a stronger grade. 5. Increase tool and setup rigidity.
built-up edge	1. Use positive rake PVD coated insert. 2. Increase speed. 3. Reduce feed. 4. Increase coolant flow/concentration. 5. Use cermets.
side walls not straight	1. Check tool alignment for square. 2. Reduce workpiece and tool overhang. 3. Use sharp inserts (index more often).

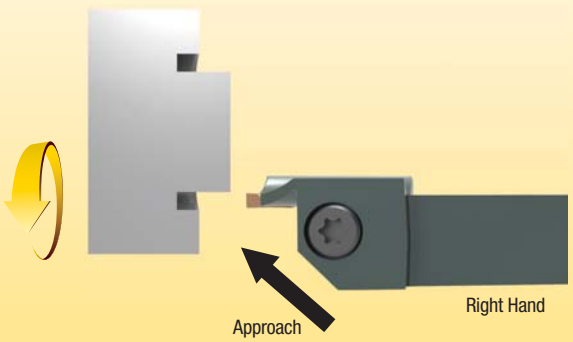
Steps to proper face grooving tool selection

- Step 1: Select your spindle rotation
- Step 2: Select your angle of approach and toolholder orientation

Integral Tooling

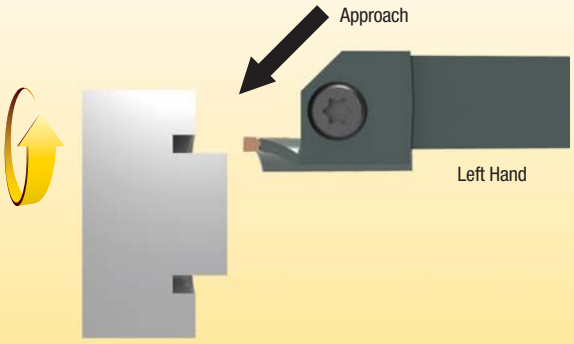
Anti-Clockwise Rotation

Square Shank

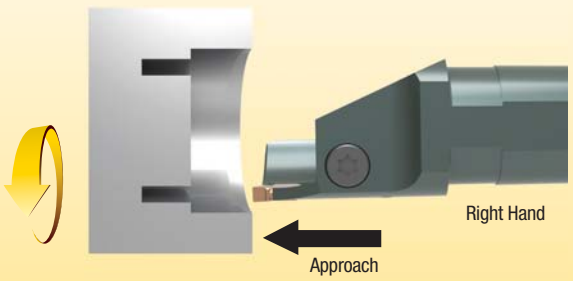


Clockwise Rotation

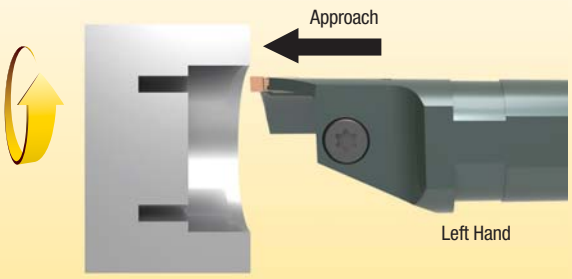
Square Shank



Boring Bar



Boring Bar



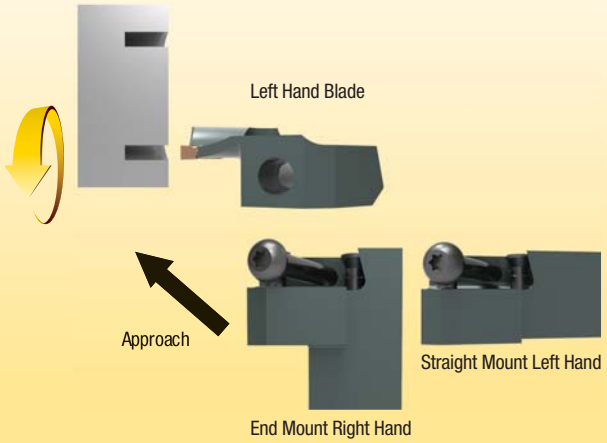
Steps to proper modular face grooving tool selection

- Step 1: Select your spindle rotation
- Step 2: Select your angle of approach and toolholder orientation
- Step 3: Identify combination of blade and shank tool

Modular Tooling

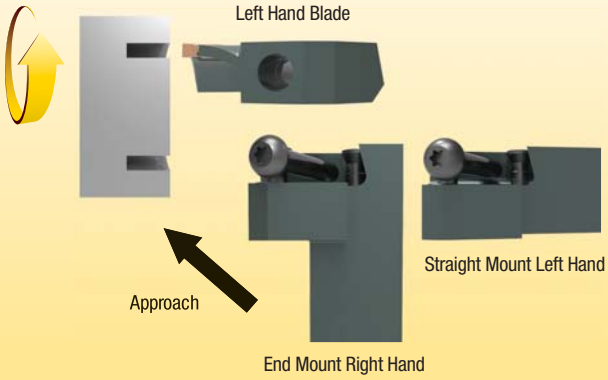
Anti-Clockwise Rotation

Left Hand Outboard Sweep

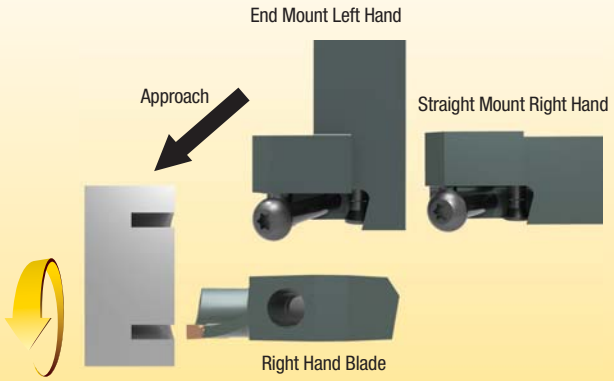


Clockwise Rotation

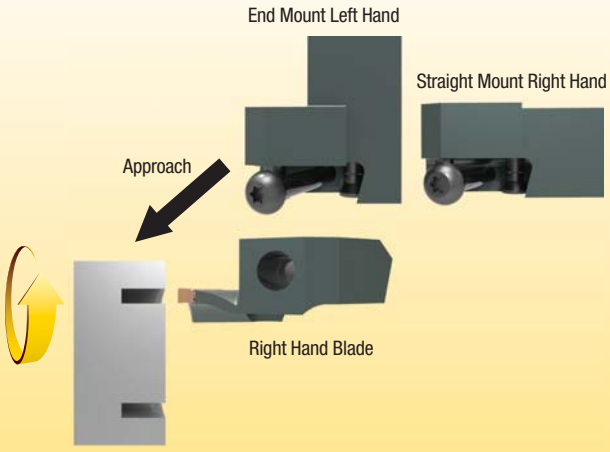
Left Hand Inboard Sweep

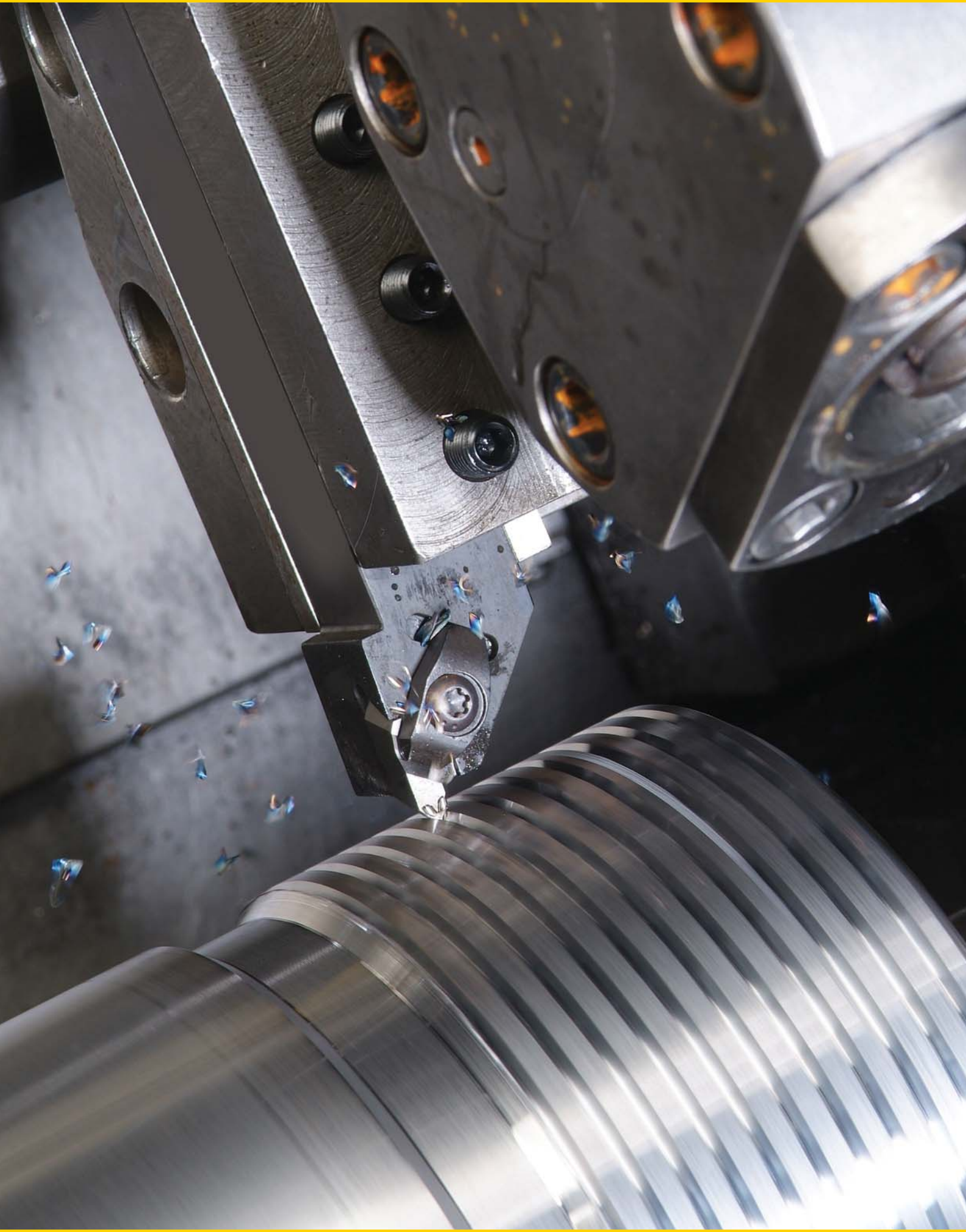


Right Hand Inboard Sweep



Right Hand Outboard Sweep





Threading

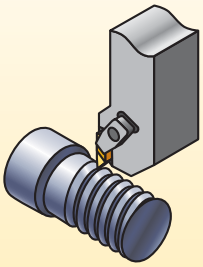
Threading Application Guide D2–D3

Top Notch Threading D4–D43

Laydown Threading D44–D87

Threading Technical Information D88–D110

Top Notch External Threading

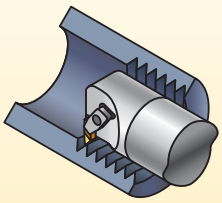


Square Shank Toolholder Sizes:
- Metric — 10–32mm

Cresting (Full Profile):
UN TPI of 32–7
ISO 1,5–3,0mm pitch

60° Partial Profile — Flat Top (NTF and NTK):
UN 44–4.5 TPI
ISO 0,6–5,5mm pitch

Top Notch Internal Threading

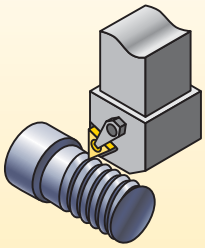


Boring Bar Diameters:
- Metric — 10–50mm
- Minimum bore — 11,5mm
- Steel

Cresting (Full Profile):
UN 16–8 TPI
ISO 1,5–3,0mm pitch

60° Partial Profile — Flat Top (NT-1L, NTF, and NTK):
UN 24–4.5 TPI
ISO 1,0–5,5mm pitch

LT Laydown External Threading

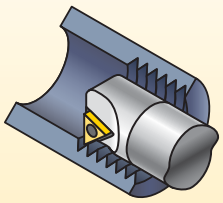


Square Shank Toolholder Sizes:
- Metric — 8–40mm available

Cresting (Full Profile):
UN 48–8 TPI
ISO 0,5–5,0mm pitch

60° Partial Profile:
UN 48–4 TPI
ISO 0,5–6,0mm pitch

LT Laydown Internal Threading



Boring Bar Diameters:
- Metric — 12–50mm
- Minimum bore — 13mm
- Steel and carbide

Cresting (Full Profile) and Partial Profile:
UN 48–8 TPI
ISO 0,5–5,0mm pitch

60° Partial Profile:
UN 48–4 TPI
ISO 0,5–6,0mm pitch

55° Partial Profile:
UN 48–5 TPI
ISO 0,5–5,0mm pitch

Top Notch™ Thread Tooling

The Proven High-Productivity Threading Solution

Top Notch threading with Beyond™ insert technology provides consistent tool performance and superior clamping thread to almost any operation. With the largest selection of grades and geometries in the industry, the Top Notch threading system is a proven solution.

Features and Benefits

Choosing the Top Notch Threading System

- A superior choice for heavy-duty applications like machining of Acme, Buttress, and API threads. Top Notch is also the best system for coarse pitch and multitooth threading applications.
- Largest selection of insert geometries and grades in the industry.
- A very rigid insert clamping design ensures best tool life, surface finish, and workpiece quality.
- Simplicity of the Top Notch design does not require shim selection for thread helix angles. This helps to avoid mistakes on the shop floor.
- Reduce inventory by using the same Top Notch toolholders and boring bars with either threading or grooving inserts.
- Top Notch chipbreaker inserts eliminate long troublesome coils.
- An excellent choice for special thread forms and toolholder designs.

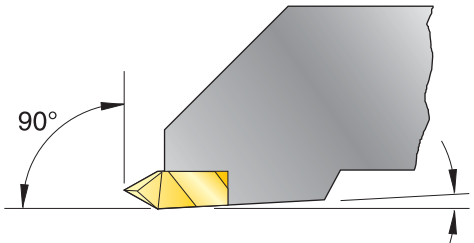
Top Notch inserts are available in KCU10™ and KCU25™ grades to withstand the demands placed on the cutting edge of the threading insert.

The versatility of the Top Notch™ steel enables you to use both threading and grooving inserts in the same toolholder.



Precision-Ground Thread Form

- Minimises built-up edge.
- Precisely cuts most common materials.
- Reduces cutting forces.
- Ensures accurate high-quality threads.



NOTE: Holders are designed to locate inserts inclined to 3° to provide back clearance down open side.

Superior Chip Control

- Eliminates long, troublesome coils.
- Excellent for internal threading operations.
- Available in partial profile inserts for 60° thread forms.

Step 1 • Select Threading Method and Hand of Tooling

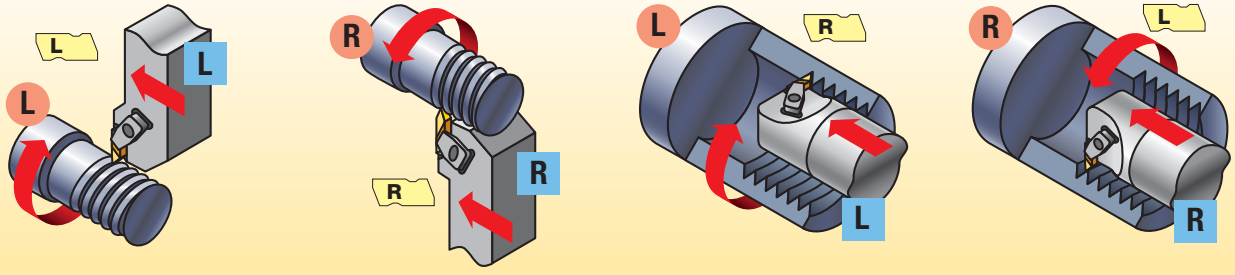
Required Information:

- External/internal operation.
- Spindle rotation/hand of thread.
- Feed direction.



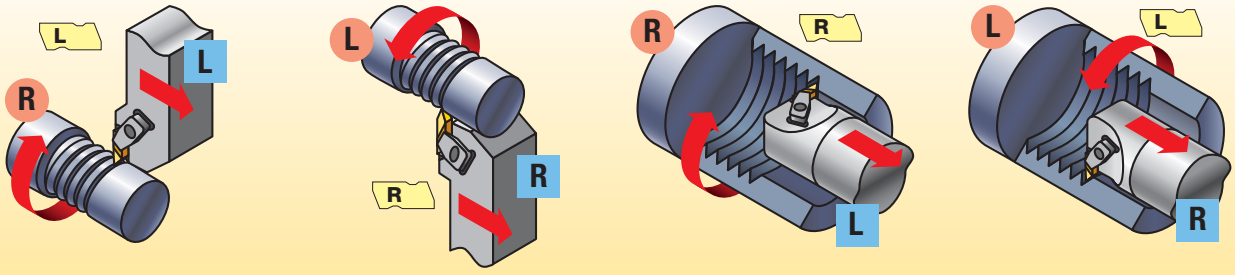
hand of thread | hand of toolholder | hand of insert

Feed direction toward the chuck • RECOMMENDED



external left-hand thread | external right-hand thread | internal left-hand thread | internal right-hand thread

Feed direction away from the chuck



external right-hand thread | external left-hand thread | internal right-hand thread | internal left-hand thread

Step 2 • Select Holder from Catalogue Page

The insert size must match the gage insert size of your toolholder selection:

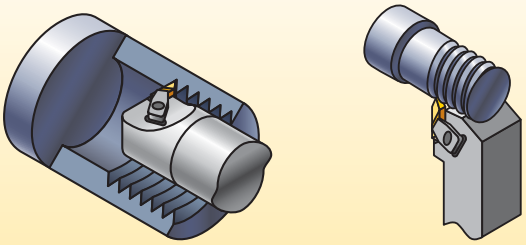
Required Information:

- External/internal operation.
- Minimum bore diameter (for internal operations).
- Hand of tool.
- Insert size (gage insert).

catalogue number	gage insert
NSR-163D	N.3R
NSR-164D	N.4R

NOTE: Top Notch toolholders and boring bars are listed with a gage insert to indicate the size and hand required. They are compatible with both grooving and threading inserts of the same size.

Select the appropriate holder for the insert size and hand:

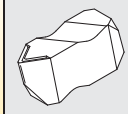


NOTE: Optimise your threading operation by using the proper infeed method and the recommended infeed values.

See the technical section on pages D88–D110 of this catalogue.
For internal threading, minimum bore varies depending on thread type.
See page D102 for details.

Step 3 • Choose Insert for Application

- See threading insert overview on page D11.
- Select cresting inserts for fully controlled thread form including diameter control. Cresting inserts eliminate the need for deburring.
- Non-cresting partial profile inserts can cut a variety of thread pitches.
- Note insert size for toolholder selection.



insert size	catalogue number	KCU25/ KC5025	KCU10/ KC5010
2	**NT-2RK**	●	●
3	**NT-3RK**	●	●
4	**NT-4RK**	●	●

Step 4 • Select Grade and Speed

Recommendations for Grade and Speed Selection — m/min

workpiece material	steel	stainless steel	cast iron	non-ferrous metals	high-temp alloys
insert style	chip control or neutral 	chip control or positive 	neutral 	positive 	positive 
optimum cutting conditions	**KCU10/KC5010** 70–260	**KCU10/KC5010** 90–245	**KCU10/KC5010** 60–245	**KC5410** 90–550	**KCU10/KC5010** 30–150
first choice	**KCU25/KC5025** 50–230	**KCU25/KC5025** 75–230	**KCU25/KC5025** 50–180	**KCU25/KC5025** 60–455	**KCU25/KC5025** 20–120

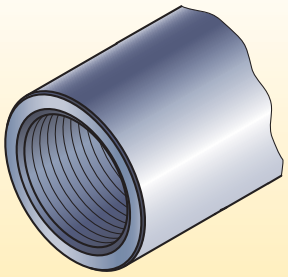
Examples:

Chip Control: NT-K or NT-CK (partial profile only)
Neutral: NT, NT-C, NTF, NTC, NJ, NJF, NDC-V, NA, NDC, NTB-A/B
Positive: NTP, NTK, NJP, NJK

Top Notch Threading Example:

application: 8 TPI Acme internal right-hand thread
material: alloy steel
workpiece diameter: 114,3mm good cutting conditions feed towards the chuck

Recommendation:
insert: NA3L8
grade: KCU10
insert size: 3
boring bar: A40NER3
gage insert: N.3L
speed: 150 m/min
infeed passes*: 12 passes



*Infeed recommendations provided in technical data section on pages D97–D101.

Recommended Starting Speeds [m/min]

Material Group		K68			KCU10/KC5010			KCU25/KC5025			KC5410		
P	0–1	–	**–**	–	135	**200**	260	105	**165**	230	–	**–**	–
	2	–	**–**	–	130	**190**	245	100	**150**	200	–	**–**	–
	3	–	**–**	–	105	**155**	200	75	**125**	170	–	**–**	–
	4	–	**–**	–	70	**120**	160	60	**95**	130	–	**–**	–
	5	–	**–**	–	105	**155**	200	75	**130**	170	–	**–**	–
	6	–	**–**	–	70	**120**	160	50	**90**	130	–	**–**	–
M	1	45	**75**	105	120	**180**	245	90	**170**	230	–	**–**	–
	2	35	**65**	100	90	**165**	210	75	**140**	200	–	**–**	–
	3	35	**65**	100	90	**165**	210	75	**135**	200	–	**–**	–
K	1	30	**75**	120	120	**180**	245	90	**135**	180	–	**–**	–
	2	25	**60**	100	90	**150**	210	70	**120**	170	–	**–**	–
	3	20	**55**	90	60	**105**	150	50	**85**	120	–	**–**	–
N	1–2	90	**245**	365	150	**365**	550	120	**305**	455	245	**425**	610
	3	45	**75**	105	90	**135**	180	60	**105**	150	90	**150**	210
	4	60	**120**	180	120	**305**	455	100	**200**	305	120	**305**	455
	5	45	**90**	150	90	**165**	245	70	**135**	195	120	**210**	305
	6	35	**75**	120	120	**210**	305	100	**170**	245	120	**245**	365
S	1	8	**25**	45	30	**70**	105	20	**40**	60	–	**–**	–
	2	8	**24**	40	30	**65**	100	20	**35**	45	–	**–**	–
	3	8	**24**	40	30	**65**	100	20	**35**	45	–	**–**	–
	4	9	**60**	105	55	**105**	150	45	**85**	120	–	**–**	–
H	1	–	**–**	–	30	**45**	60	–	**–**	–	–	**–**	–
	2	–	**–**	–	15	**30**	45	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–

NOTE: FIRST choice starting speeds are in **bold** type.

NOVO KNOWS CAD/CAM

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

Before NOVO: The programmer would be in their CAD/CAM software, programming a part. Using the tedious method of finding a tool in a catalogue, and then manually inputting the tooling information from the catalogue into the CAD/CAM software.

The concern is that assumptions are made, and only partial tooling information is entered.

With NOVO: The powerful digital intelligence of NOVO applications not only help the programmer find the right tool for the metalcutting job, but also automatically integrates all the tooling data into a complete CAD/CAM solution. The integration of all the tooling data increases the viability of the part being programmed, and is delivered quickly — saving you time.

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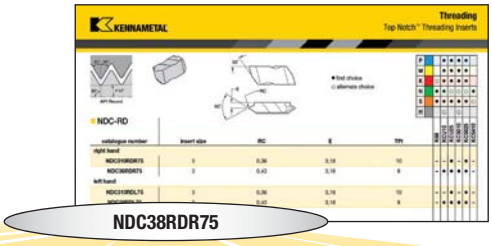
How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



N	D	C	3	8RD	R	75	
Type of Insert	Insert	Additional Information	Insert Size	Industry Thread Identification	Hand of Insert	Definition of Insert	Additional Information

N — Top Notch*



A — Acme

D — API or NPT

J — UNJ thread

T — 60° V thread

W — 55° V Whitworth

B — Buttress

F — Fine pitch

S — Stub Acme

C — Cresting

P — Positive rake

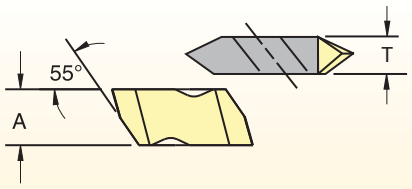
K — Fine pitch, positive

Indicates API or drilling industry form designation (e.g., 10RD, 8RD, .038)
or
controlled root radius threading inserts indicate the root radius in .001" increments (NJ, NJF, NJP, NJK)
or
M indicates metric ISO thread

R — Right hand

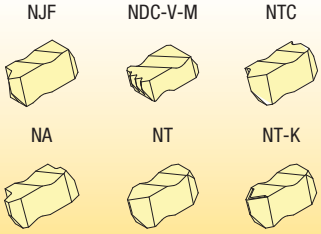
L — Left hand

- Threads per inch or pitch (for metric)
- "A" or "B" type Buttress insert
- Taper per foot — API threads



Top Notch insert dimensions

insert size	A mm	T mm
1	2,54	2,54
2	5,56	3,81
3	8,74	4,95
4	11,51	6,48
5	17,48	9,65
6	11,51	9,73
8	7,93	11,13



I — Internal thread

E — External thread (used only if internal and external thread forms are different)

M — Multiple tooth

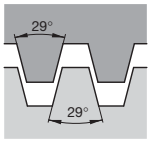
K — Standard chip control

C — Coarse pitch

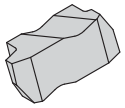
D — Dryseal

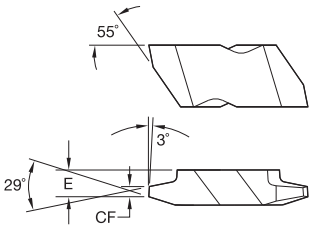
*Kennametal proprietary standard only.

style			thread profile	standard	tolerance class	cresting	application	page(s)
chip control — K	neutral	positive						
NT-K 	NT 	NTP 	Partial Profile 60º	—	—	N	General use for 60° thread forms, such as ISO and UN, where non-cresting inserts are desired to cut a variety of pitches.	D19, D24
NT-CK 			Partial Profile 60º — coarse pitch	—	—	N	Coarse pitch 60° thread forms, such as ISO and UN, where non-cresting inserts are desired to cut a variety of pitches.	D21
	NTF 	NTK 	Partial Profile 60º — fine pitch	—	—	N	Fine pitch 60° thread forms, such as ISO and UN, where non-cresting inserts are desired to cut a variety of pitches — able to thread close to shoulders.	D23
	NTU 		Partial Profile 60º — fine pitch	—	—	N	Four-edged insert for 60º partial profile threading — requires NSU-style toolholder for size 4U insert.	D24
	NTC-M 		Metric ISO	ISO R262, DIN 13	6g/6H	Y	Widely used metric 60° V-form for all industries.	D21
	NTC 		American UN	ANSI B1.1:74	2A/2B	Y	Widely used inch-based 60° V-form for all industries.	D20
	NJ 	NJP 	UNJ	MIL-S-8879C	3A/3B	N	Controlled root radius on external threads for military and aerospace industries.	D17–D18
	NJF 	NJK 	UNJ — fine pitch	MIL-S-8879C	3A/3B	N	Controlled root radius on external threads for military and aerospace industries — able to thread close to shoulders.	D17–D18
	NDC-V 		NPT	ANSI/ACME B1.201: 1983	Standard NPT	Y	National Pipe Thread standard forms for pipe fittings.	D16
	NDC-V-M 		NPT — multi-tooth	ANSI/ACME B1.201: 1983	Standard NPT	Y	High-productivity multi-tooth threading inserts for NPT threads.	D16
	NWC-E 		Whitworth, BSW, BSP	BS 84:1956, ISO 228/1:1982, DIN 259	Medium Class A	Y	Widely used 55° form for gas and water connections.	D25
	ND 		API Rotary Shoulder Connections — partial profile	API SPEC. 7:1990	Standard API	N	60º V-form used for rotary shoulder pipe connections in the oil and gas industry including V-.038R, V-.040, and V-.050 forms.	D14
	NDC 		API Rotary Shoulder Connections — cresting	API SPEC. 7:1990	Standard API	Y	60º V-form used for rotary shoulder pipe connections in the oil and gas industry including V-.038R, V-.040, and V-.050 forms — complete cresting form including taper.	D14
	NDC-RD 		API Round	API STD. 5B:1979	Standard API RD	Y	60° V-form with large radius for casing, tubing, and line pipe in the oil and gas industry, including 8 and 10 round forms.	D15
	NDC-RD-M 		API Round — multi-tooth	API STD. 5B:1979	Standard API RD	Y	High productivity multitooth threading inserts for API round threads.	D15
	NA 		Acme	ANSI B1.5:1988	3G	N	29° truncated thread form for motion applications in a wide variety of industries.	D12
	NAS 		Stub Acme	ANSI B1.8:1988	2G	N	Shallow depth 29° truncated thread form for motion applications in a wide variety of industries.	D13
	NTB-A 		American Buttress — 7° clearance flank leading (Push)	ANSI B1.9:1973	Class 2	N	Sawtooth form for axial load bearing applications in a variety of industries — use the “A” style when the 7° clearance flank is the leading flank.	D19
	NTB-B 		American Buttress — 45° clearance flank leading (Pull)	ANSI B1.9:1973	Class 2	N	Sawtooth form for axial load bearing applications in a variety of industries — use the “B” style when the 45° clearance flank is the leading flank.	D20



Acme



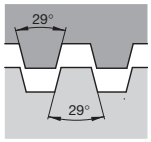


● first choice
○ alternate choice

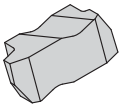
P		●	●	●	●	
M		●	●	●	●	
K	○	●	●	●	●	
N	●	●	○	○	○	●
S	●	●	●	●	●	○
H		○		○		

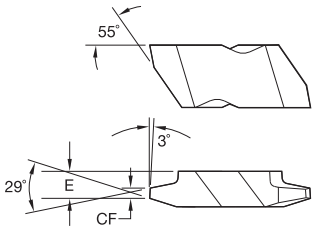
NA

catalogue number	insert size	RC	E	CF	TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand											
NA3R10	3	–	3,79	0,810	10	–	●	●	●	●	–
NA3R12	3	–	3,79	0,719	12	–	●	–	–	●	–
NA3R16	3	–	3,79	0,523	16	–	●	–	–	–	–
NA3R4	3	–	3,38	2,222	4	–	–	●	●	●	–
NA3R5	3	–	3,79	1,750	5	–	●	●	●	●	–
NA3R6	3	–	3,79	1,438	6	–	●	●	●	●	–
NA3R8	3	–	3,79	1,044	8	–	●	●	●	●	–
NA4R4	4	–	5,13	2,223	4	–	–	●	●	●	–
NA4R5	4	–	5,13	1,750	5	–	–	–	–	●	–
NA4R6	4	–	5,13	1,438	6	–	–	–	–	●	–
NA6R25	6	–	7,19	3,635	2.5	–	–	–	–	●	–
NA6R2	6	–	7,19	4,577	2	–	●	●	●	●	–
NA6R3	6	–	7,19	3,007	3	–	–	●	–	●	–
left hand											
NA3L8	3	–	3,79	1,044	8	–	●	●	●	●	–
NA3L10	3	–	3,79	0,810	10	–	–	●	–	●	–
NA3L12	3	–	3,79	0,719	12	–	–	–	●	●	–
NA3L4	3	–	3,38	2,222	4	●	●	●	●	●	–
NA3L5	3	–	3,79	1,750	5	–	–	●	●	●	–
NA3L6	3	–	3,79	1,438	6	–	–	●	●	●	–
NA4L5	4	–	5,13	1,750	5	–	–	–	–	●	–
NA4L6	4	–	5,13	1,438	6	–	–	–	–	●	–
NA4L8	4	–	5,13	1,044	8	–	–	●	–	–	–
NA4L4	4	–	5,13	2,223	4	–	●	–	–	●	–
NA6L3	6	–	7,19	3,007	3	–	–	●	–	●	–
NA6L25	6	–	7,19	3,635	2.5	–	–	●	–	–	–
NA6L2	6	–	7,19	4,577	2	–	–	●	●	●	–
NA3L16	3	–	3,79	0,523	16	–	●	–	–	–	–



Stub Acme



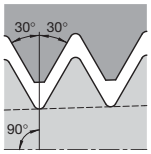


● first choice
○ alternate choice

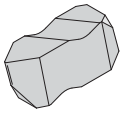
P			●	●	●	●	
M			●	●	●	●	
K		○	●	●	●	●	
N		●	●	○	○	○	●
S		●	●	●	●	●	○
H			○		○		

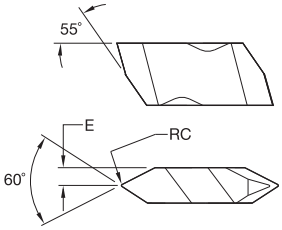
NAS

catalogue number	insert size	RC	E	CF	TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand											
NAS3R10	3	–	3,79	0,940	10	–	●	–	●	●	–
NAS3R12	3	–	3,79	0,828	12	–	–	●	–	●	–
NAS3R16	3	–	3,79	0,605	16	–	–	–	–	●	–
NAS3R4	3	–	3,79	2,550	4	–	–	●	–	●	–
NAS3R5	3	–	3,79	2,014	5	–	●	–	–	●	–
NAS3R6	3	–	3,79	1,656	6	–	●	–	●	●	–
NAS3R8	3	–	3,79	1,209	8	–	●	●	●	●	–
left hand											
NAS3L10	3	–	3,79	0,940	10	–	●	–	–	●	–
NAS3L12	3	–	3,79	0,828	12	–	–	–	–	●	–
NAS3L4	3	–	3,79	2,550	4	–	–	●	–	●	–
NAS3L5	3	–	3,79	2,014	5	–	●	–	–	●	–
NAS3L6	3	–	3,79	1,656	6	–	●	●	●	●	–
NAS3L8	3	–	3,79	1,209	8	–	●	●	●	●	–



API Rotary Shoulder Connections



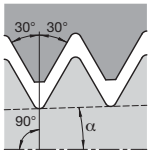


● first choice
○ alternate choice

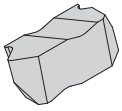
		K68	KCU10	KCU25	KC5010	KC5025	KC5410
P			●	●	●	●	
M			●	●	●	●	
K		○	●	●	●	●	
N		●	●	○	○	○	●
S		●	●	●	●	●	○
H			○		○		

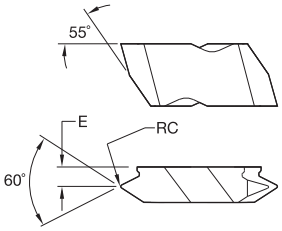
ND • Partial Profile

catalogue number	insert size	RC	E	TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand										
ND3040R	3	0,45	2,08	5	–	–	–	–	●	–
ND3038R	3	0,90	2,08	4	–	–	–	–	●	–
ND4050R	4	0,57	3,25	4	–	–	●	–	–	–
left hand										
ND3038L	3	0,90	2,08	4	–	–	–	–	●	–
ND3040L	3	0,45	2,08	5	–	–	●	–	–	–



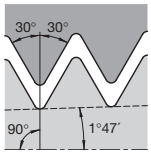
α =1/2arctg (tpf/12)
API Rotary Shoulder Connections



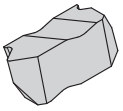


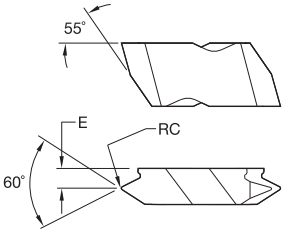
NDC • Cresting

catalogue number	insert size	RC	E	TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand										
NDC3040R3	3	0,45	3,73	5	–	–	–	–	●	–
NDC4040R3	4	0,45	3,73	5	–	–	–	–	●	–
NDC4050R2	4	0,57	4,65	4	–	–	–	–	●	–
NDC4050R3	4	0,57	4,65	4	–	–	–	–	●	–
NDC4038R2	4	0,90	4,65	4	–	–	–	–	●	–
left hand										
NDC3040L3	3	0,45	3,73	5	–	–	–	●	–	–
NDC4050L2	4	0,57	4,65	4	–	–	–	–	●	–
NDC4038L2	4	0,90	4,65	4	–	–	–	–	●	–



API Round



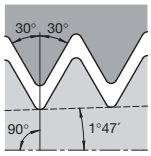


● first choice
○ alternate choice

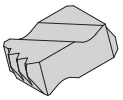
P			●	●	●	●	
M			●	●	●	●	
K		○	●	●	●	●	
N		●	●	○	○	○	●
S		●	●	●	●	●	○
H			○		○		

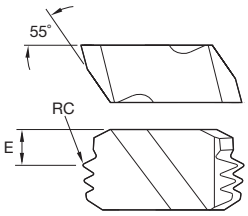
NDC-RD

catalogue number	insert size	RC	E	TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand										
NDC310RDR75	3	0,36	3,18	10	–	–	–	–	●	–
NDC38RDR75	3	0,43	3,18	8	–	–	●	●	●	–
left hand										
NDC310RDL75	3	0,36	3,18	10	–	–	–	–	●	–
NDC38RDL75	3	0,43	3,18	8	–	–	●	●	●	–



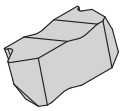
API Round

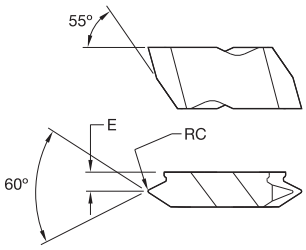




NDC-RD-M • Multitooth

catalogue number	insert size	RC	E	TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand										
NDC68RDR75M	6	0,41	2,62	8	–	●	–	–	–	–



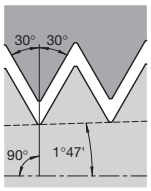


● first choice
○ alternate choice

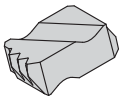
		K68	KCU10	KCU25	KC5010	KC5025	KC5410
P			●	●	●	●	
M			●	●	●	●	
K		○	●	●	●	●	
N		●	●	○	○	○	●
S		●	●	●	●	●	○
H			○		○		

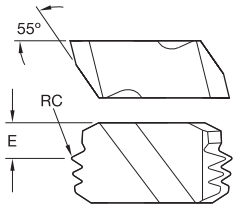
NDC-V

catalogue number	insert size	RC	E	TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand										
NDC327VR75	3	0,05	3,66	27	–	●	–	–	–	–
NDC314VR75	3	0,08	3,66	14	–	●	–	–	–	–
NDC3115VR75	3	0,10	3,66	11.5	–	●	–	●	–	–
NDC38VR75	3	0,13	2,54	8	–	–	–	●	–	–
left hand										
NDC3115VL75	3	0,10	3,66	11.5	–	●	–	●	–	–
NDC38VL75	3	0,13	2,54	8	–	–	–	●	–	–



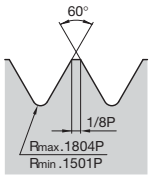
NPT



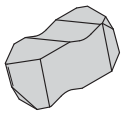


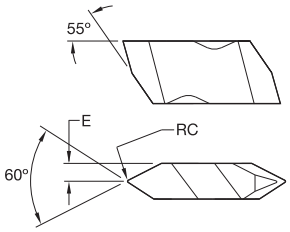
NDC-V-M • Multitooth

catalogue number	insert size	RC	E	TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand										
NDC8115VR75M	8	0,10	2,59	11.5	–	●	–	–	–	–
NDC88VR75M	8	0,13	2,41	8	–	●	–	●	–	–
left hand										
NDC88VL75M	8	0,13	2,41	8	–	–	–	●	–	–



UNJ External



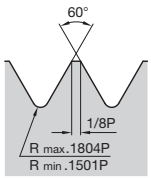


● first choice
○ alternate choice

		K68	KCU10	KCU25	KC5010	KC5025	KC5410
P			●	●	●	●	
M			●	●	●	●	
K		○	●	●	●	●	
N		●	●	○	○	○	●
S		●	●	●	●	●	○
H			○		○		

NJ

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NJ3010R16	3	0,25	2,49	–	–	16	–	●	–	●	–	●	–
NJ3014R12	3	0,33	2,49	–	–	12	–	–	●	●	●	●	–
NJ3020R8	3	0,49	2,49	–	–	8	–	–	–	–	●	●	–
left hand													
NJ3010L16	3	0,25	2,49	–	–	16	–	–	–	–	–	●	–
NJ3014L12	3	0,33	2,49	–	–	12	–	–	–	–	●	●	–
NJ3020L8	3	0,49	2,49	–	–	8	–	–	–	–	–	●	–



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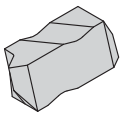
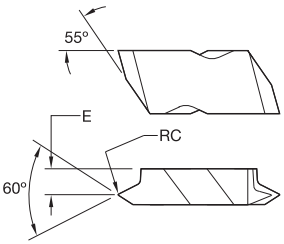


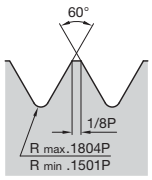


NJF

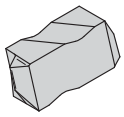
catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NJF3005R32	3	0,13	3,58	–	–	32	–	–	●	–	●	–	–
NJF3006R28	3	0,15	3,58	–	–	28	–	–	–	–	●	●	–
NJF3007R24	3	0,17	3,58	–	–	24	–	–	–	–	●	●	–
NJF3008R20	3	0,20	3,58	–	–	20	–	–	–	–	●	●	–
NJF3009R18	3	0,22	3,58	–	–	18	–	●	–	●	●	●	–
NJF3010R16	3	0,25	3,58	–	–	16	–	–	–	–	●	●	–
NJF3012R14	3	0,28	3,58	–	–	14	–	–	–	●	●	●	–
left hand													
NJF3007L24	3	0,17	3,58	–	–	24	–	–	–	–	●	–	–
NJF3008L20	3	0,20	3,58	–	–	20	–	–	–	–	●	–	–
NJF3010L16	3	0,25	3,58	–	–	16	–	–	–	–	●	–	–

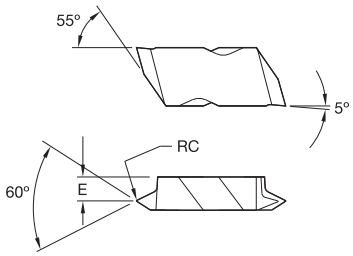
P			●	●	●	●	
M			●	●	●	●	
K		○	●	●	●	●	
N		●	●	○	○	○	●
S		●	●	●	●	●	○
H			○		○		

● first choice
○ alternate choice



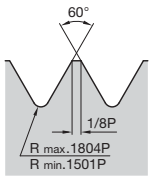
UNJ External



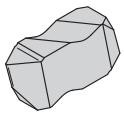


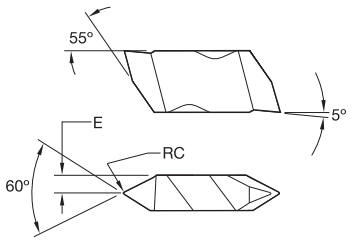
NJK

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NJK3005R32	3	0,13	3,58	–	–	32	–	–	–	–	●	●	–
NJK3006R28	3	0,15	3,58	–	–	28	–	–	–	●	●	–	–
NJK3007R24	3	0,17	3,58	–	–	24	–	–	–	●	●	●	–
NJK3008R20	3	0,20	3,58	–	–	20	–	–	●	●	●	●	–
NJK3009R18	3	0,22	3,58	–	–	18	–	–	–	–	●	●	–
NJK3010R16	3	0,25	3,58	–	–	16	–	–	–	●	●	●	–
NJK3012R14	3	0,28	3,58	–	–	14	–	–	–	–	●	●	–
left hand													
NJK3005L32	3	0,13	3,58	–	–	32	–	–	–	–	–	●	–
NJK3006L28	3	0,15	3,58	–	–	28	–	–	–	–	–	●	–



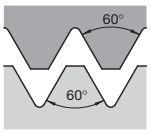
UNJ External



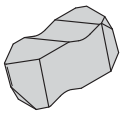


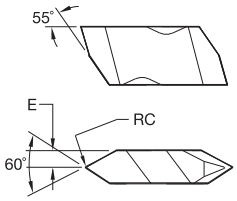
NJP

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NJP3010R16	3	0,25	2,49	–	–	16	–	–	●	–	●	●	–
NJP3014R12	3	0,33	2,49	–	–	12	–	●	●	●	●	●	–
NJP3020R8	3	0,49	2,49	–	–	8	–	–	–	●	●	●	–
left hand													
NJP3010L16	3	0,25	2,49	–	–	16	–	–	–	–	–	●	–
NJP3014L12	3	0,33	2,49	–	–	12	–	–	–	–	●	–	–
NJP3020L8	3	0,49	2,49	–	–	8	–	–	–	–	–	●	–



Partial Profile 60°



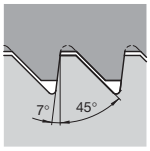


● first choice
○ alternate choice

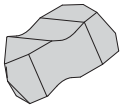
P			●	●	●	●	
M			●	●	●	●	
K		○	●	●	●	●	
N		●	●	○	○	○	●
S		●	●	●	●	●	○
H			○		○		

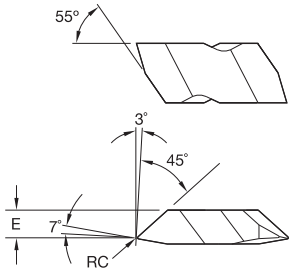
NT

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NT2R	2	0,10	1,90	0,70-3,0	1,25-3,5	8-36	7-20	●	●	●	●	●	–
NT3R	3	0,17	2,49	1,25-4,0	2,0-5,0	6-20	5-12	●	●	●	●	●	–
NT4R	4	0,17	3,25	1,25-6,25	2,0-6,25	4-20	4-12	●	●	●	●	●	–
left hand													
NT2L	2	0,10	1,90	0,70-3,0	1,25-3,5	8-36	7-20	●	●	●	●	●	–
NT3L	3	0,17	2,49	1,25-4,0	2,0-5,0	6-20	5-12	●	●	●	●	●	–
NT4L	4	0,17	3,25	1,25-6,25	2,0-6,25	4-20	4-12	●	●	●	●	●	–



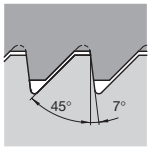
American Buttress-Push



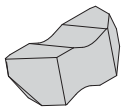


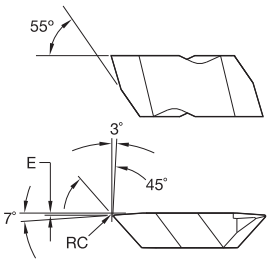
NTB-A

catalogue number	insert size	RC	E	TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand										
NTB2RA	2	0,08	3,20	16-20	●	–	–	–	–	–
NTB3RA	3	0,17	4,17	8-16	–	●	–	–	●	–
NTB4RA	4	0,25	5,23	4-6	–	●	–	–	–	–
left hand										
NTB3LA	3	0,17	4,17	8-16	●	–	–	●	●	–



American
Buttress-Pull



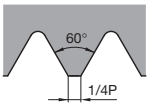


● first choice
○ alternate choice

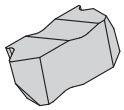
P			●	●	●	●	
M			●	●	●	●	
K		○	●	●	●	●	
N		●	●	○	○	○	●
S		●	●	●	●	●	○
H			○		○		

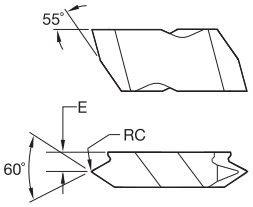
NTB-B

catalogue number	insert size	RC	E	TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand										
NTB2RB	2	0,08	0,25	16-20	–	–	–	●	–	–
NTB3R12B	3	0,16	2,49	12	–	–	–	●	–	–
NTB3RB	3	0,17	0,31	8-16	●	●	●	●	●	–
NTB4RB	4	0,25	0,41	4-6	–	●	–	●	●	–
left hand										
NTB2LB	2	0,08	0,25	16-20	–	●	–	●	–	–
NTB3L12B	3	0,16	2,49	12	–	–	–	●	–	–
NTB3LB	3	0,17	0,31	8-16	●	●	–	●	●	–
NTB4LB	4	0,25	0,41	4-6	–	–	–	●	●	–



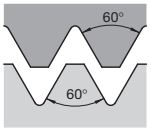
American
UN-Internal



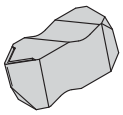


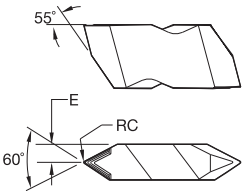
NTC-I

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NTC3R12I	3	0,10	3,76	–	–	–	12	–	–	–	–	●	–
left hand													
NTC3L12I	3	0,10	3,76	–	–	–	12	–	–	–	–	●	–
NTC3L14I	3	0,09	3,76	–	–	–	14	–	–	–	–	●	–
NTC3L16I	3	0,08	3,76	–	–	–	16	–	–	–	–	●	–
NTC3L8I	3	0,18	2,72	–	–	–	8	–	–	–	–	●	–
NTC3L10I	3	0,13	2,72	–	–	–	10	–	–	–	–	●	–



Partial Profile 60°



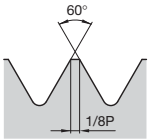


● first choice
○ alternate choice

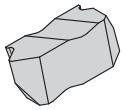
		K68	KCU10	KCU25	KC5010	KC5025	KC5410
P			●	●	●	●	
M			●	●	●	●	
K		○	●	●	●	●	
N		●	●	○	○	○	●
S		●	●	●	●	●	○
H			○		○		

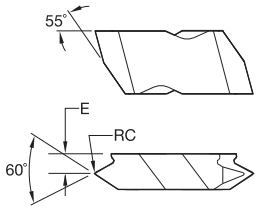
NT-CK

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NT3RCK	3	0,34	2,46	2,5-4,0	4,0	6-11	6	–	●	●	●	●	–
NT4RCK	4	0,34	3,23	2,5-5,5	4,0-5,5	4,5-11	4.5-6	–	–	●	●	●	–
left hand													
NT3LCK	3	0,34	2,46	2,5-4,0	4,0	6-11	6	–	●	●	●	●	–
NT4LCK	4	0,34	3,23	2,5-5,5	4,0-5,5	4,5-11	4.5-6	–	–	●	–	●	–



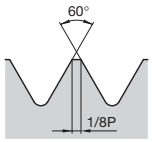
ISO Metric-External



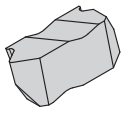


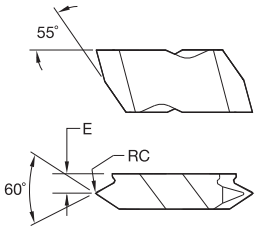
NTC-M-E

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NTC3MR150E	3	0,20	3,68	1,50	–	–	–	–	●	–	●	●	–
NTC3MR200E	3	0,27	3,68	2,00	–	–	–	–	–	–	●	–	–



American
UN-External



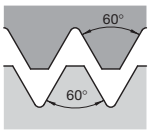


● first choice
○ alternate choice

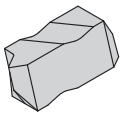
		K68	KCU10	KCU25	KC5010	KC5025	KC5410
P			●	●	●	●	
M			●	●	●	●	
K		○	●	●	●	●	
N		●	●	○	○	○	●
S		●	●	●	●	●	○
H			○		○		

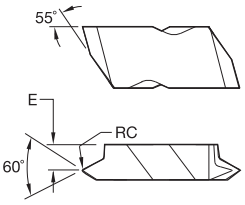
NTC-E

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NTC3R32E	3	0,10	3,76	–	–	32	–	–	●	–	–	●	–
NTC3R28E	3	0,12	3,76	–	–	28	–	–	–	–	–	●	–
NTC3R24E	3	0,13	3,76	–	–	24	–	–	–	–	●	●	–
NTC3R20E	3	0,16	3,76	–	–	20	–	–	●	–	●	●	–
NTC3R18E	3	0,18	3,76	–	–	18	–	–	–	●	●	●	–
NTC3R16E	3	0,19	3,76	–	–	16	–	–	–	–	●	●	–
NTC3R14E	3	0,22	3,76	–	–	14	–	–	–	–	●	●	–
NTC3R13E	3	0,24	3,76	–	–	13	–	–	–	–	●	●	–
NTC3R12E	3	0,25	3,76	–	–	12	–	–	–	●	●	●	–
NTC3R11E	3	0,28	2,72	–	–	11	–	–	●	–	–	●	–
NTC3R10E	3	0,32	2,72	–	–	10	–	–	–	–	●	●	–
NTC3R9E	3	0,36	2,72	–	–	9	–	–	●	–	–	–	–
NTC3R8E	3	0,41	2,72	–	–	8	–	–	●	–	●	●	–
NTC3R7E	3	0,47	2,72	–	–	7	–	–	–	–	–	●	–
left hand													
NTC3L16E	3	0,19	3,76	–	–	16	–	–	●	–	–	–	–
NTC3L12E	3	0,25	3,76	–	–	12	–	–	●	–	–	–	–
NTC3L10E	3	0,32	2,72	–	–	10	–	–	●	–	–	–	–
NTC3L8E	3	0,41	2,72	–	–	8	–	–	–	–	●	–	–



Partial Profile 60°



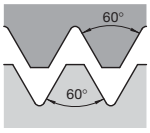


● first choice
○ alternate choice

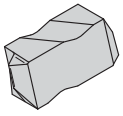
P			●	●	●	●	
M			●	●	●	●	
K		○	●	●	●	●	
N		●	●	○	○	○	●
S		●	●	●	●	●	○
H			○		○		

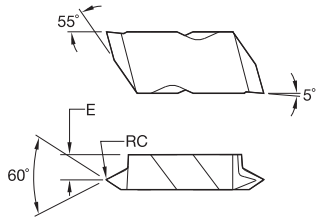
NTF

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NTF2R	2	0,08	2,79	0,60-1,75	1,0-2,0	14-44	12-24	●	●	●	●	●	–
NTF3R	3	0,08	3,58	0,60-2,5	1,0-2,5	10-44	9-24	●	●	●	●	●	–
NTF4R	4	0,08	5,11	0,60-2,5	1,0-2,5	10-44	9-24	–	–	–	–	●	–
left hand													
NTF2L	2	0,08	2,79	0,60-1,75	1,0-2,0	14-44	12-24	●	●	●	●	●	–
NTF3L	3	0,08	3,58	0,60-2,5	1,0-2,5	10-44	9-24	●	●	●	●	●	–



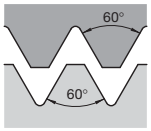
Partial Profile 60°



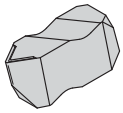


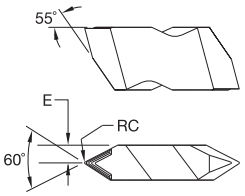
NTK

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NTK2R	2	0,08	2,79	0,60-1,75	1,0-2,0	14-44	12-24	●	●	●	●	●	–
NTK3R	3	0,08	3,58	0,60-2,50	1,0-2,5	10-44	9-24	●	●	●	●	●	–
left hand													
NTK2L	2	0,08	2,79	0,60-1,75	1,0-2,0	14-44	12-24	●	●	●	●	●	–
NTK3L	3	0,08	3,58	0,60-2,50	1,0-2,5	10-44	9-24	●	●	●	●	●	–



Partial Profile 60°



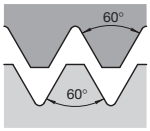


● first choice
○ alternate choice

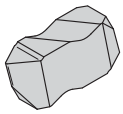
P		●	●	●	●	●	
M		●	●	●	●		
K	○	●	●	●	●		
N	●	●	○	○	○	●	
S	●	●	●	●	●	○	
H		○		○			

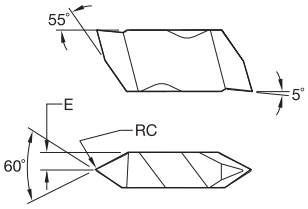
NT-K

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NT2RK	2	0,10	1,90	0,70-3,0	1,25-3,5	8-36	7-20	–	●	●	●	●	–
NT3RK	3	0,17	2,49	1,25-4,0	2,0-5,0	6-20	5-12	–	●	●	●	●	–
NT4RK	4	0,16	3,24	1,25-6,25	2,0-6,25	4-20	4-12	–	●	●	●	●	–
left hand													
NT2LK	2	0,10	1,90	0,70-3,0	1,25-3,5	8-36	7-20	–	●	●	●	●	–
NT3LK	3	0,17	2,49	1,25-4,0	2,0-5,0	6-20	5-12	–	●	●	●	●	–
NT4LK	4	0,16	3,24	1,25-6,25	2,0-6,25	4-20	4-12	–	●	●	●	●	–



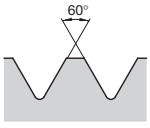
Partial Profile 60°



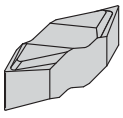


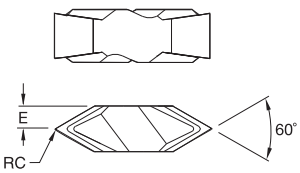
NTP

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NTP2R	2	0,10	1,91	0,70-3,0	1,25-3,5	8-36	7-20	●	●	●	●	●	–
NTP3R	3	0,17	2,49	1,25-4,0	2,0-5,0	6-20	5-12	●	●	●	●	●	●
NTP4R	4	0,17	3,25	1,25-6,25	2,0-6,25	4-20	4-12	–	●	●	●	●	–
left hand													
NTP2L	2	0,10	1,91	0,70-3,0	1,25-3,5	8-36	7-20	●	●	●	●	●	–
NTP3L	3	0,17	2,49	1,25-4,0	2,0-5,0	6-20	5-12	●	●	●	●	●	–
NTP4L	4	0,17	3,25	1,25-6,25	2,0-6,25	4-20	4-12	–	–	–	●	●	–



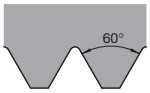
Partial Profile
60° External



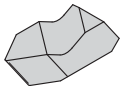


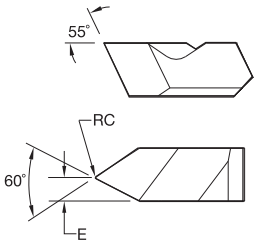
NTU

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand													
NTU4R	4U	0,11	3,18	1,25-6,25	–	4-20	–	–	–	●	–	●	–



Partial Profile
60° Internal



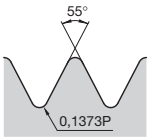


● first choice
○ alternate choice

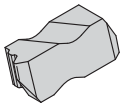
P			●	●	●	●	
M			●	●	●	●	
K		○	●	●	●	●	
N		●	●	○	○	○	●
S		●	●	●	●	●	○
H			○		○		

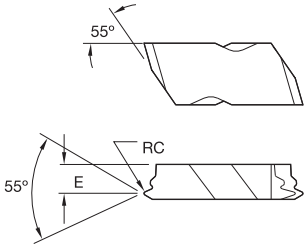
NT-1L

catalogue number	insert size	RC	E	external thread pitch mm	internal thread pitch mm	external TPI	internal TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
left hand													
NT1L	1	0,08	1,09	–	1,0-2,0	–	12-24	●	●	●	●	●	–



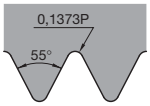
Whitworth BSW,
BSP-External



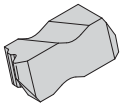


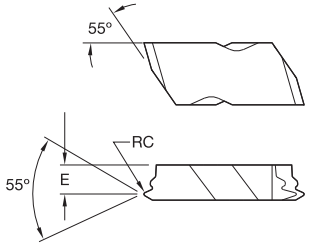
NWC-E

catalogue number	insert size	RC	E	TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
right hand										
NWC3R14E	3	0,24	3,43	14	–	–	●	●	–	–
NWC3R11E	3	0,30	3,43	11	–	–	–	●	●	–



Whitworth BSW,
BSP-Internal



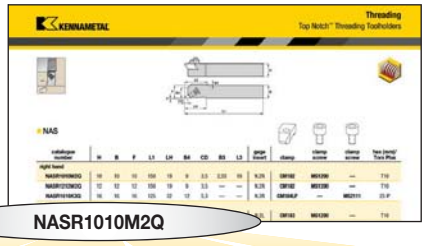


NWC-I

catalogue number	insert size	RC	E	TPI	K68	KCU10	KCU25	KC5010	KC5025	KC5410
left hand										
NWC3L11I	3	0,30	3,43	11	–	–	–	–	●	–

How Do Catalogue Numbers Work?

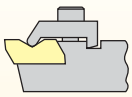
Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



NASR1010M2Q

N	AS	R		1010	M	2	Q
Insert Holding Method	Insert Mounting Location	Hand of Tool	Drop Head	Shank Size	Tool Length	Insert Size	Qualified Holder

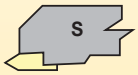
N —
Top Notch™



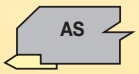
End mount



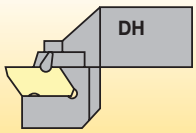
Side mount, offset



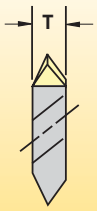
Side mount, no offset



Shank height and width in mm and holder



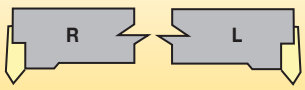
L1	ISO
32	A
40	B
50	C
60	D
70	E
80	F
90	G
100	H
110	J
125	K
140	L
150	M
160	N
170	P
180	Q
200	R
250	S
300	T
350	U
400	V
450	W
500	Y
special length	X



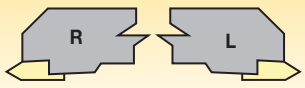
insert size	T
2	3,81
3	4,95
4	6,98
5	9,65
6	9,73
8	11,13

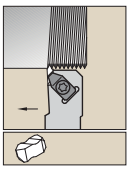
Q — Qualified holder

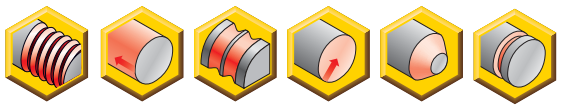
End mount

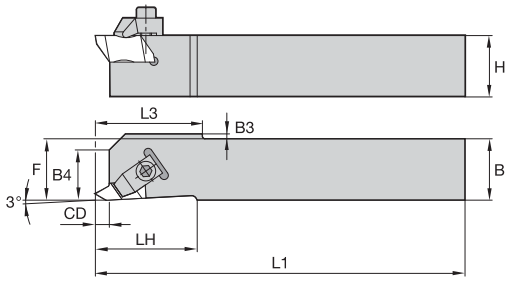


Side mount

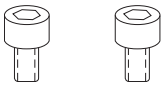






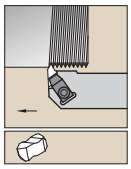


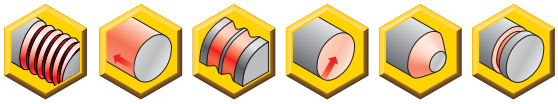
NAS

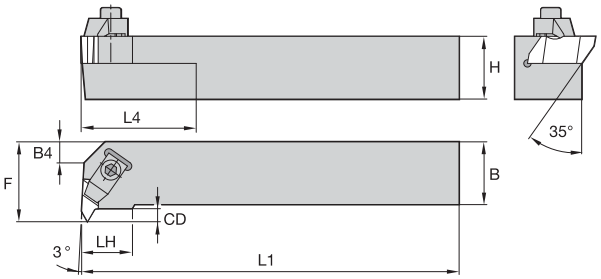


order number	catalogue number	H	B	F	L1	LH	B4	CD	B3	L3	gage insert	clamp screw	clamp screw	clamp	hex (mm)/ Torx Plus
right hand															
1098788	**NASR1010M2Q**	10	10	10	150	19	9	3,5	2,03	19	N.2R	**CM182**	**MS1200**	**–**	T10
1098789	**NASR1212M2Q**	12	12	12	150	19	9	3,5	–	–	N.2R	**CM182**	**MS1200**	**–**	T10
1098786	**NASR1616K3Q**	16	16	16	125	32	13	5,3	–	–	N.3R	**CM184LP**	**–**	**MS2111**	25 IP
left hand															
1098859	**NASL1010M2Q**	10	10	10	150	19	9	3,5	2,03	19	N.2L	**CM183**	**MS1200**	**–**	T10
1098860	**NASL1212M2Q**	12	12	12	150	19	9	6,9	–	–	N.2L	**CM183**	**MS1200**	**–**	T10
1098857	**NASL1616K3Q**	16	16	16	125	32	13	5,3	–	–	N.3L	**CM185LP**	**–**	**MS2111**	25 IP

NOTE: F dimension measured over sharp point of N-style threading insert.





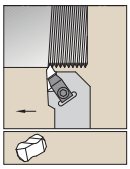


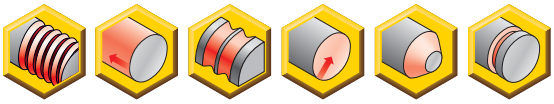
NE

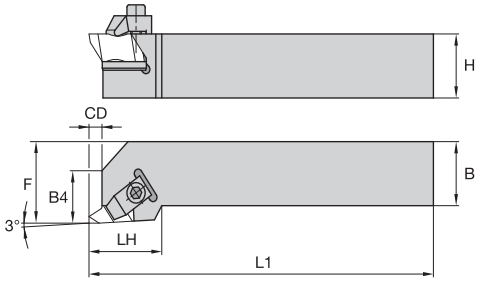



order number	catalogue number	H	B	F	L1	LH	CD	L4	gage insert	clamp screw	clamp screw	clamp	hex (mm)/ Torx Plus
right hand													
1098803	**NER1616H2**	16	16	20	100	15	3,5	–	N.2L	**CM75**	**MS1200**	**–**	T10
1098804	**NER2020K2**	20	20	25	125	15	3,5	–	N.2L	**CM75**	**MS1200**	**–**	T10
1098805	**NER2525M2**	25	25	32	150	15	3,5	25,4	N.2L	**CM75**	**MS1200**	**–**	T10
1098806	**NER2525M3**	25	25	32	150	22	5,3	50,8	N.3L	**CM73LP**	**–**	**MS2111**	25 IP
1098808	**NER2525M4**	25	25	35	150	24	6,4	50,8	N.4L	**CM73LP**	**–**	**MS2111**	25 IP
1098807	**NER3225P3**	32	25	32	170	22	3,8	50,8	N.3L	**CM73LP**	**–**	**MS2111**	25 IP
1098809	**NER3225P4**	32	25	35	170	24	6,4	50,8	N.4L	**CM73LP**	**–**	**MS2111**	25 IP
1098810	**NER3232P4**	32	32	40	170	24	6,4	50,8	N.4L	**CM73LP**	**–**	**MS2111**	25 IP
left hand													
1098874	**NEL1616H2**	16	16	20	100	15	3,5	–	N.2R	**CM74**	**MS1200**	**–**	T10
1098875	**NEL2020K2**	20	20	25	125	15	3,5	–	N.2R	**CM74**	**MS1200**	**–**	T10
1098876	**NEL2525M2**	25	25	32	150	15	3,5	25,4	N.2R	**CM74**	**MS1200**	**–**	T10
1098877	**NEL2525M3**	25	25	32	150	22	5,3	50,8	N.3R	**CM72LP**	**–**	**MS2111**	25 IP
1098879	**NEL2525M4**	25	25	35	150	24	6,4	50,8	N.4R	**CM72LP**	**–**	**MS2111**	25 IP
1098878	**NEL3225P3**	32	25	32	170	22	3,8	50,8	N.3R	**CM72LP**	**–**	**MS2111**	25 IP
1098880	**NEL3225P4**	32	25	35	170	24	6,4	50,8	N.4R	**CM72LP**	**–**	**MS2111**	25 IP
1098881	**NEL3232P4**	32	32	40	170	24	6,4	50,8	N.4R	**CM72LP**	**–**	**MS2111**	25 IP

NOTE: F dimension measured over sharp point of Top Notch-style threading insert.





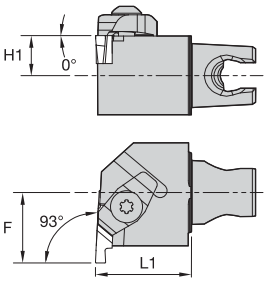


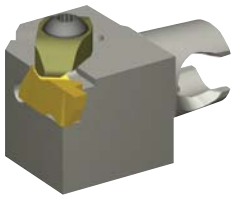
NS



order number	catalogue number	H	B	F	L1	LH	B4	CD	gage insert	clamp	clamp screw	clamp screw	hex (mm)/ Torx Plus
right hand													
1098790	**NSR1010E2**	10	10	14	70	19	9	3,5	N.2R	**CM74**	**MS1200**	–	T10
1098791	**NSR1212F2**	12	12	16	80	19	9	3,5	N.2R	**CM74**	**MS1200**	–	T10
1098792	**NSR1616H2**	16	16	20	100	19	9	3,5	N.2R	**CM74**	**MS1200**	–	T10
1098793	**NSR2020K2**	20	20	25	125	19	9	3,5	N.2R	**CM74**	**MS1200**	–	T10
1098795	**NSR2020K3**	20	20	25	125	32	13	5,3	N.3R	**CM72LP**	–	**MS2111**	25 IP
1098794	**NSR2525M2**	25	25	32	150	19	9	3,5	N.2R	**CM74**	**MS1200**	–	T10
1098796	**NSR2525M3**	25	25	32	150	32	13	5,3	N.3R	**CM72LP**	–	**MS2111**	25 IP
1098799	**NSR2525M4**	25	25	32	150	35	14	7,5	N.4R	**CM72LP**	–	**MS2111**	25 IP
1098797	**NSR3225P3**	32	25	32	170	32	13	5,3	N.3R	**CM72LP**	–	**MS2111**	25 IP
1098800	**NSR3225P4**	32	25	32	170	35	14	7,5	N.4R	**CM72LP**	–	**MS2111**	25 IP
1098798	**NSR3232P3**	32	32	40	170	32	13	5,3	N.3R	**CM72LP**	–	**MS2111**	25 IP
1098801	**NSR3232P4**	32	32	40	170	35	14	7,5	N.4R	**CM72LP**	–	**MS2111**	25 IP
left hand													
1098861	**NSL1010E2**	10	10	14	70	19	9	3,5	N.2L	**CM75**	**MS1200**	–	T10
1098862	**NSL1212F2**	12	12	16	80	19	9	3,5	N.2L	**CM75**	**MS1200**	–	T10
1098863	**NSL1616H2**	16	16	20	100	19	9	3,5	N.2L	**CM75**	**MS1200**	–	T10
1098864	**NSL2020K2**	20	20	25	125	19	9	3,5	N.2L	**CM75**	**MS1200**	–	T10
1098866	**NSL2020K3**	20	20	25	125	32	13	5,3	N.3L	**CM73LP**	–	**MS2111**	25 IP
1098865	**NSL2525M2**	25	25	32	150	19	9	3,5	N.2L	**CM75**	**MS1200**	–	T10
1098867	**NSL2525M3**	25	25	32	150	32	13	5,3	N.3L	**CM73LP**	–	**MS2111**	25 IP
1098870	**NSL2525M4**	25	25	32	150	35	14	7,5	N.4L	**CM73LP**	–	**MS2111**	25 IP
1098868	**NSL3225P3**	32	25	32	170	32	13	5,3	N.3L	**CM73LP**	–	**MS2111**	25 IP
1098871	**NSL3225P4**	32	25	32	170	35	14	7,5	N.4L	**CM73LP**	–	**MS2111**	25 IP
1098869	**NSL3232P3**	32	32	40	170	32	13	5,3	N.3L	**CM73LP**	–	**MS2111**	25 IP
1098872	**NSL3232P4**	32	32	40	170	35	14	7,5	N.4L	**CM73LP**	–	**MS2111**	25 IP

NOTE: F dimension measured over sharp point of Top Notch-style threading and grooving insert.

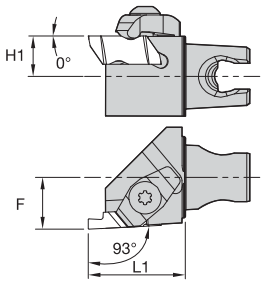


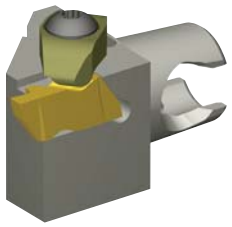


NE 93°

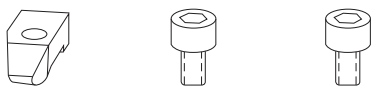


order number	catalogue number	L1	F	H1	gage insert	clamp	clamp screw	clamp screw
right hand								
2399462	**KM25NER230**	30	22	12,5	NG2L	**CM75**	**–**	**MS1200**
2399494	**KM25NER330**	30	22	12,5	NG3L	**CM73LP**	**MS2111**	**–**
2399496	**KM25NER430**	30	24	12,5	NG4L	**CM73LP**	**MS2111**	**–**
left hand								
2399495	**KM25NEL330**	30	22	12,5	NG3R	**CM72LP**	**MS2111**	**–**
2399497	**KM25NEL430**	30	24	12,5	NG4R	**CM72LP**	**MS2111**	**–**



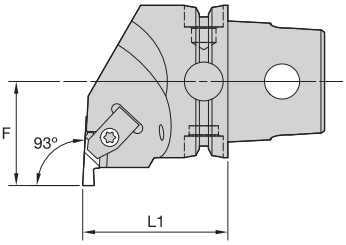


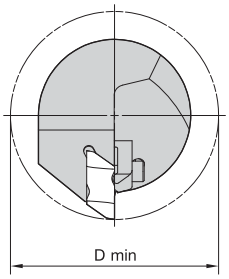
NS 93°

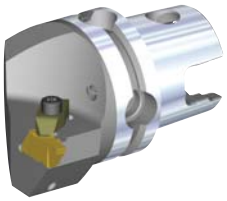


order number	catalogue number	L1	F	H1	gage insert	clamp	clamp screw	clamp screw
right hand								
2399498	**KM25NSR230**	30	16	12,5	NG2R	**CM74**	**–**	**MS1200**
2399500	**KM25NSR330**	30	16	12,5	NG3R	**CM72LP**	**MS2111**	**–**
left hand								
2399499	**KM25NSL230**	30	16	12,5	NG2L	**CM75**	**–**	**MS1200**
2399501	**KM25NSL330**	30	16	12,5	NG3L	**CM73LP**	**MS2111**	**–**
2399503	**KM25NSL430**	30	16	12,5	NG4L	**CM213LP**	**MS2111**	**–**



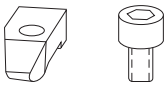




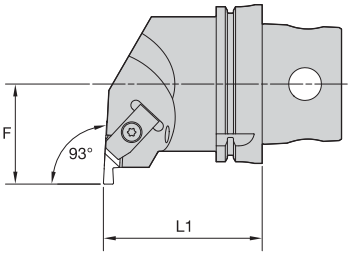


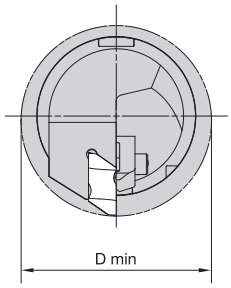
KM QUICK CHANGE

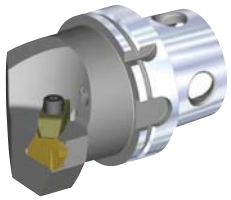
NE 93°



order number	catalogue number	L1 mm	L1 in	F mm	F in	D min mm	D min in	gage insert	clamp	clamp screw	kg	lbs
right hand												
3902285	**KM40TSNER2**	40	1.575	27	1.063	54	2.126	NG2L	**CM75**	**MS1488**	0,30	.66
3902286	**KM40TSNER3**	40	1.575	27	1.063	54	2.126	NG3L	**CM73**	**MS1489**	0,30	.67
3902287	**KM40TSNER4**	40	1.575	27	1.063	54	2.126	NG4L	**CM73**	**MS1489**	0,30	.65
left hand												
3902132	**KM40TSNEL2**	40	1.575	27	1.063	54	2.126	NG2R	**CM74**	**MS1488**	0,30	.66
3902283	**KM40TSNEL3**	40	1.575	27	1.063	54	2.126	NG3R	**CM-72**	**MS1489**	0,30	.67
3902284	**KM40TSNEL4**	40	1.575	27	1.063	54	2.126	NG4R	**CM-72**	**MS1489**	0,30	.65







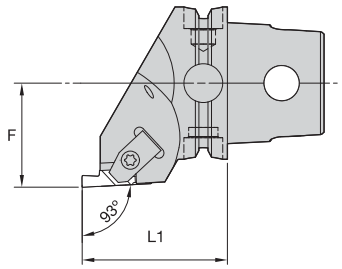
NE

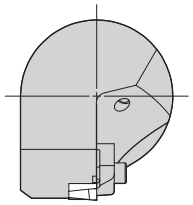


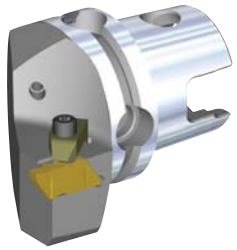


order number	catalogue number	L1 mm	L1 in	F mm	F in	D min mm	D min in	gage insert	clamp	clamp screw	kg	lbs
right hand												
5337758	**KM4X100NER3**	100	3.937	63	2.480	120	4.724	NG3L	**CM73**	**MS1489**	4,45	9.80
5337759	**KM4X100NER4**	100	3.937	63	2.480	120	4.724	NG4L	**CM73**	**MS1489**	4,51	9.93
5337770	**KM4X100NER5**	100	3.937	63	2.480	120	4.724	NG5L	**CM81**	**MS1490**	4,65	10.25
5337771	**KM4X100NER6**	100	3.937	63	2.480	120	4.724	NG6L	**CM121**	**MS1489**	4,48	9.88
left hand												
5337754	**KM4X100NEL3**	100	3.937	63	2.480	120	4.724	NG3R	**CM-72**	**MS1489**	4,45	9.80
5337755	**KM4X100NEL4**	100	3.937	63	2.480	120	4.724	NG4R	**CM-72**	**MS1489**	4,51	9.93
5337756	**KM4X100NEL5**	100	3.937	63	2.480	120	4.724	NG5R	**CM80**	**MS1490**	4,65	10.25
5337757	**KM4X100NEL6**	100	3.937	63	2.480	120	4.724	NG6R	**CM120**	**MS1489**	4,48	9.88



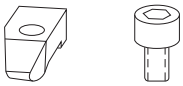






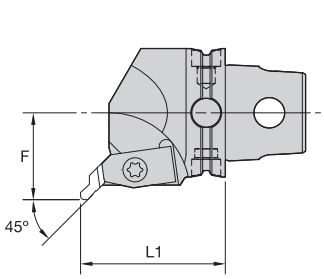
KM QUICK CHANGE

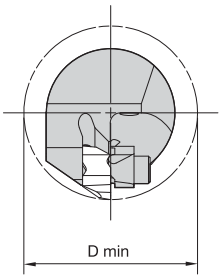
NS 93°

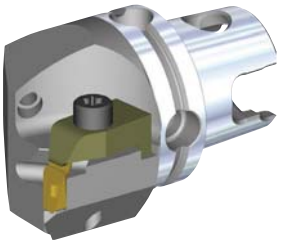


order number	catalogue number	L1 mm	L1 in	F mm	F in	gage insert	clamp	clamp screw	kg	lbs
right hand										
3902293	**KM40TSNSR2**	40	1.575	27	1.063	NG2R	**CM74**	**MS1488**	0,32	.70
3902294	**KM40TSNSR3**	47	1.850	27	1.063	NG3R	**CM-72**	**MS1489**	0,32	.71
3902295	**KM40TSNSR4**	47	1.850	27	1.063	NG4R	**CM-72**	**MS1489**	0,30	.66
left hand										
3902290	**KM40TSNSL2**	40	1.575	27	1.063	NG2L	**CM75**	**MS1488**	0,32	.70
3902291	**KM40TSNSL3**	47	1.850	27	1.063	NG3L	**CM73**	**MS1489**	0,33	.72
3902292	**KM40TSNSL4**	47	1.850	27	1.063	NG4L	**CM73**	**MS1489**	0,30	.66



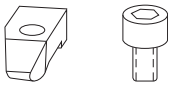






KM QUICK CHANGE

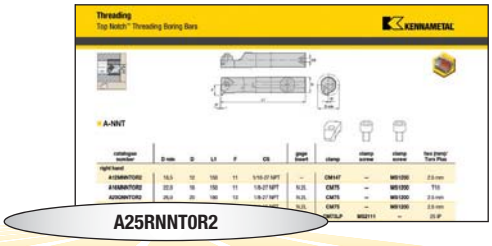
NR 45°



order number	catalogue number	L1 mm	L1 in	F mm	F in	D min mm	D min in	gage insert	clamp	clamp screw	kg	lbs
right hand												
3902289	**KM40TSNRR3045M**	45	1.772	27	1.063	54	2.126	NU3L	**CM73**	**MS1489**	0,34	.75
left hand												
3902288	**KM40TSNRL3045M**	45	1.772	27	1.063	54	2.126	NU3R	**CM-72**	**MS1489**	0,33	.74

How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



A25RNNT0R2

A	25	R	N	N	T	0	R	2
Bar Type	Bar Diameter	Bar Length	Insert Holding Method	Insert Shape	Insert Location	Rake Angle 0 = 0°	Hand of Tool	Insert Size

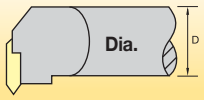
Bar Type

Steel with coolant



Bar Diameter

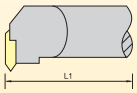
Bar in millimetres



Bar Length

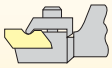
Bars

K = 125,0mm
M = 150,0mm
Q = 180,0mm
R = 200,0mm
S = 250,0mm
T = 300,0mm
U = 350,0mm



Insert Holding Method

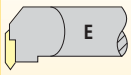
N —
Top Notch*



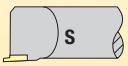
*Proprietary standard only.

Insert Location

End mount

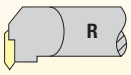


Side mount



Hand of Tool

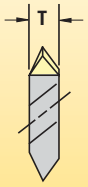
Right hand



Left hand



Insert Size



insert size	T
2	3,81
3	4,95
4	6,98
5	9,65
6	9,73
8	11,13

Beyond™ Top Notch™ Profiling



Top Notch is the proven solution for high productivity. The Top Notch system provides consistent tool performance, accurate indexing, and superior clamping to provide excellent surface finishing and superior tool life.

FEATURES AND BENEFITS

Higher Productivity and Profitability

- Lower cutting forces increase speeds and reduce cycle time.
- Extended tool life.

Reliability

- Predictable tool life/uniform wear.
- Resists chip flow damage.
- Consistent surface finish.

Versatility

- Products can be applied across a wide range of applications.
- Use in low- to high-speed applications.
- Complete portfolio of products.
- For finish to rough turning of steel, cast iron, stainless steel, and high-temp alloys.



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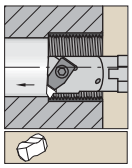
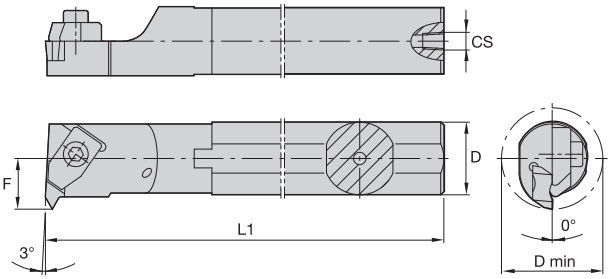
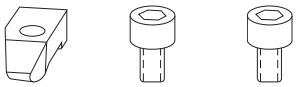


Steel shank with through coolant.



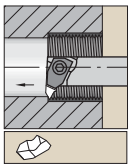


A-NNT

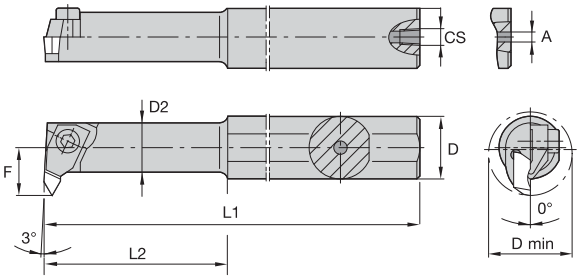


order number	catalogue number	D min	D	L1	F	CS	gage insert	clamp	clamp screw	clamp screw	hex (mm)/ Torx Plus
right hand											
1098945	**A12MNNTOR2**	18,5	12	150	11	1/16-27 NPT	–	**CM147**	–	**MS1200**	2.5 mm
1098947	**A16MNNTOR2**	22,0	16	150	11	1/8-27 NPT	N.2L	**CM75**	–	**MS1200**	T10
1098949	**A20QNNTOR2**	26,0	20	180	13	1/8-27 NPT	N.2L	**CM75**	–	**MS1200**	2.5 mm
1098951	**A25RNNTOR2**	34,0	25	200	17	1/4-18 NPT	N.2L	**CM75**	–	**MS1200**	2.5 mm
1098953	**A25RNNTOR3**	34,0	25	200	17	1/8 - 27 NPT	N.3L	**CM73LP**	**MS2111**	–	25 IP
1098955	**A32SNNTOR3**	44,0	32	250	22	1/4-18 NPT	N.3L	**CM73LP**	**MS2111**	–	25 IP
1098957	**A40TNNTOR3**	54,0	40	300	27	1/4-18 NPT	N.3L	**CM73LP**	**MS2111**	–	25 IP
1099001	**A40TNNTOR4**	54,0	40	300	27	1/4-18 NPT	N.4L	**CM73LP**	**MS2111**	–	25 IP
1099003	**A50UNNTOR4**	70,0	50	350	35	1/4-18 NPT	N.4L	**CM73LP**	**MS2111**	–	25 IP
left hand											
1098946	**A12MNNTOL2**	18,5	12	150	11	1/16-27 NPT	NG2R	**CM146**	–	**MS1200**	2.5 mm
1098948	**A16MNNTOL2**	22,0	16	150	11	1/8-27 NPT	N.2R	**CM74**	–	**MS1200**	T10
1098950	**A20QNNTOL2**	26,0	20	180	13	1/8-27 NPT	NG2R	**CM74**	–	**MS1200**	2.5 mm
1098952	**A25RNNTOL2**	34,0	25	200	17	1/4-18 NPT	N.2R	**CM74**	–	**MS1200**	2.5 mm
1098954	**A25RNNTOL3**	34,0	25	200	17	1/4-18 NPT	N.3R	**CM72LP**	**MS2111**	–	25 IP
1098956	**A32SNNTOL3**	44,0	32	250	22	1/4-18 NPT	N.3R	**CM72LP**	**MS2111**	–	25 IP
1098958	**A40TNNTOL3**	54,0	40	300	27	1/4-18 NPT	N.3R	**CM72LP**	**MS2111**	–	25 IP
1099002	**A40TNNTOL4**	54,0	40	300	27	1/4-18 NPT	N.4R	**CM72LP**	**MS2111**	–	25 IP

NOTE: Minimum bore diameter (D min) capability varies with thread type and pitch. See page D102 for details.
F dimension measured over sharp point of NG-style grooving insert.

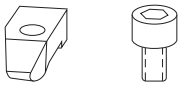


Necked steel shank with through coolant.



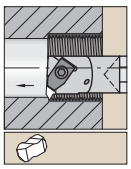


A-NNT -1

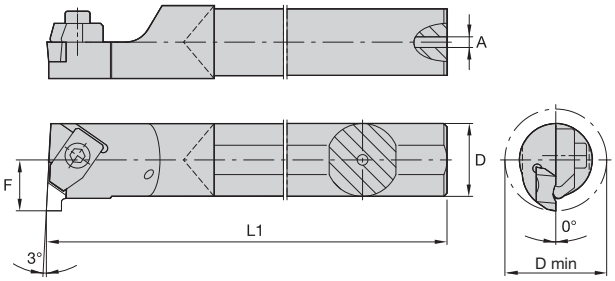


order number	catalogue number	D min	D	HDD	L1	L2	F	A	CS	gage insert	clamp	clamp screw	hex (mm)
right hand													
1098943	**A10KNNTOR1**	11,5	10	10,0	125	—	7	3,2	—	NG1L	**CM109**	**MS1034**	1.5 mm
1098944	**A12MNNTOR1**	11,5	12	10,0	150	31,30	7	4,0	1/16-27 NPT	N.1L	**CM109**	**MS1034**	1.5 mm

NOTE: F dimension measured over sharp point of Top Notch style threading insert.

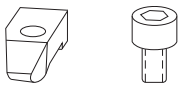


Carbide shank with through coolant.





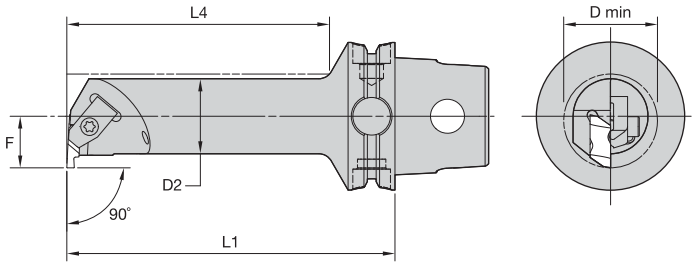
E-NNT

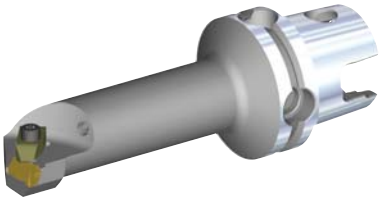


order number	catalogue number	D min	D	L1	F	A	gage insert	clamp	clamp screw	Torx/ Torx Plus
right hand										
1152834	**E16RNNTOR2**	22	16	200	11	5,5	N.2L	**CM75**	**MS1200**	T10
1152836	**E20SNNTOR2**	26	20	250	13	7,1	N.2L	**CM75**	**MS1200**	T10
left hand										
1152835	**E16RNNTOL2**	22	16	200	11	5,5	N.2R	**CM74**	**MS1200**	T10

NOTE: Minimum bore diameter (D min) capability varies with thread type and pitch. See page D102 for details.
F dimension measured over sharp point of Top Notch style threading insert.







KM QUICK CHANGE

NE 90° • Steel

order number	catalogue number	D2 mm	D2 in	D min mm	D min in	F mm	F in	L4 mm	L4 in	L1 mm	L1 in	gage insert	kg	lbs
right hand														
3955481	**KM40TSS12ENER2**	12	.472	19	.73	11	.433	42	1.655	70	2.756	NG2L	0,27	.58
3955483	**KM40TSS16FNER2**	16	.630	20	.79	11	.433	56	2.209	80	3.150	NG2L	0,28	.62
3955485	**KM40TSS20GNER2**	20	.787	25	.98	13	.512	70	2.757	90	3.543	NG2L	0,35	.76
3955487	**KM40TSS25ENER2**	25	.984	32	1.26	17	.669	55	2.169	70	2.756	NG2L	0,34	.75
3955491	**KM40TSS25ENER3**	25	.984	34	1.34	17	.669	55	2.169	70	2.756	NG3L	0,35	.77
3955489	**KM40TSS25HNER2**	25	.984	32	1.26	17	.669	75	2.954	100	3.937	NG2L	0,49	1.08
3955493	**KM40TSS25HNER3**	25	.984	34	1.34	17	.669	75	2.954	100	3.937	NG3L	0,49	1.09
3955497	**KM40TSS32GNER3**	32	1.260	40	1.57	22	.866	76	2.993	90	3.543	NG3L	0,55	1.21
3955495	**KM40TSS32JNER3**	32	1.260	40	1.57	22	.866	96	3.780	110	4.331	NG3L	0,67	1.48
left hand														
3955480	**KM40TSS12ENEL2**	12	.472	19	.73	11	.433	42	1.655	70	2.756	NG2R	0,27	.59
3955482	**KM40TSS16FNEL2**	16	.630	20	.79	11	.433	56	2.209	80	3.150	NG2R	0,28	.62
3955484	**KM40TSS20GNEL2**	20	.787	25	.98	13	.512	70	2.757	90	3.543	NG2R	0,35	.76
3955486	**KM40TSS25ENEL2**	25	.984	32	1.26	17	.669	55	2.169	70	2.756	NG2R	0,34	.75
3955490	**KM40TSS25ENEL3**	25	.984	34	1.34	17	.669	55	2.169	70	2.756	NG3R	0,35	.77
3955492	**KM40TSS25HNEL3**	25	.984	34	1.34	17	.669	75	2.954	100	3.937	NG3R	0,49	1.09
3955496	**KM40TSS32GNEL3**	32	1.260	40	1.57	22	.866	76	2.993	90	3.543	NG3R	0,55	1.21

(continued)

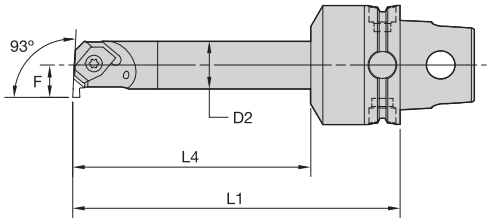
(NE 90° • Steel — continued)

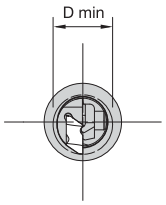
Spare Parts

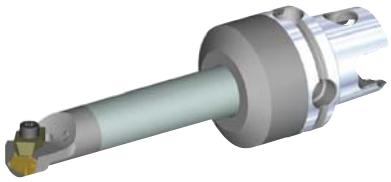



catalogue number	clamp	clamp screw
right hand		
KM40TSS12ENER2	CM147	MS1488
KM40TSS16FNER2	CM147	MS1488
KM40TSS20GNER2	CM75	MS1488
KM40TSS25ENER2	CM75	MS1488
KM40TSS25ENER3	CM73	MS1489
KM40TSS25HNER2	CM75	MS1488
KM40TSS25HNER3	CM73	MS1489
KM40TSS32GNER3	CM73	MS1489
KM40TSS32JNER3	CM73	MS1489
left hand		
KM40TSS12ENEL2	CM146	MS1488
KM40TSS16FNEL2	CM146	MS1488
KM40TSS20GNEL2	CM74	MS1488
KM40TSS25ENEL2	CM74	MS1488
KM40TSS25ENEL3	CM-72	MS1489
KM40TSS25HNEL3	CM-72	MS1489
KM40TSS32GNEL3	CM-72	MS1489









KM QUICK CHANGE

NE 90° • Carbide

order number	catalogue number	D2 mm	D2 in	D min mm	D min in	F mm	F in	L4 mm	L4 in	L1 mm	L1 in	gage insert	kg	lbs
right hand														
3951836	**KM40TSE16JNER2**	16	.630	20	.79	11	.433	80	3.15	110	4.331	NG2L	0,41	.90
left hand														
3951835	**KM40TSE16JNEL2**	16	.630	20	.79	11	.433	80	3.15	110	4.331	NG2R	0,41	.90

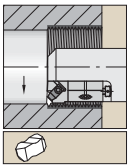
Spare Parts

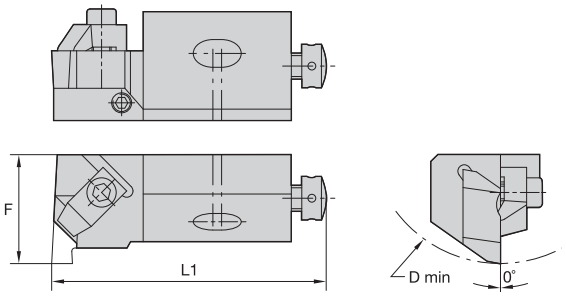




catalogue number	clamp	clamp screw
right hand		
KM40TSE16JNER2	**CM146**	**MS1488**
left hand		
KM40TSE16JNEL2	**CM147**	**MS1488**





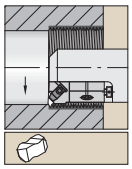


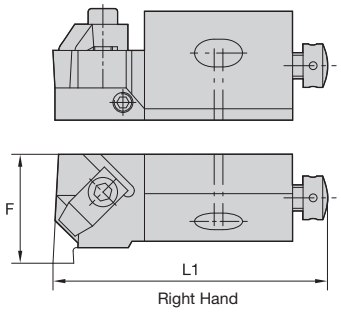
Steel Boring Cartridge



order number	catalogue number	D min	F	L1	gage insert	clamp	clamp screw	hex (mm)	radial adjusting screw	hex (mm)	axial screw	hex (mm)	washer
right hand													
1098380	**NER12CA2**	50	20	55,7	N.2L	**CM75**	**MS1025**	2.5 mm	**KUAM23**	2.5 mm	**KUAM31**	2.5 mm	**CSWM 060 050**
left hand													
1098624	**NEL12CA2**	50	20	55,0	N.2R	**CM74**	**MS1025**	2.5 mm	**KUAM23**	2.5 mm	**KUAM31**	2.5 mm	**CSWM 060 050**
1098626	**NEL25CA3**	100	32	100,0	N.3R	**CM72LP**	**MS412**	4 mm	**KUAM26**	4 mm	**KUAM33**	4 mm	**CSWM 100 080**

NOTE: Minimum bore diameter (D min) capability varies with thread type and pitch. See page D102 for details.
F dimension measured over sharp point of Top Notch-style threading insert.







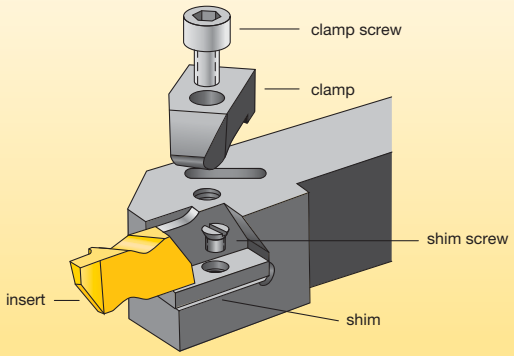
Steel Boring Cartridge



order number	catalogue number	D min	F	L1	gage insert	clamp	clamp screw	hex (mm)	radial adjusting screw	hex (mm)	axial screw	hex (mm)	washer
right hand													
1098380	**NER12CA2**	50	20	55,7	N.2L	**CM75**	**MS1025**	2.5 mm	**KUAM23**	2.5 mm	**KUAM31**	2.5 mm	**CSWM 060 050**
left hand													
1098624	**NEL12CA2**	50	20	55,0	N.2R	**CM74**	**MS1025**	2.5 mm	**KUAM23**	2.5 mm	**KUAM31**	2.5 mm	**CSWM 060 050**
1098626	**NEL25CA3**	100	32	100,0	N.3R	**CM72LP**	**MS412**	4 mm	**KUAM26**	4 mm	**KUAM33**	4 mm	**CSWM 100 080**

NOTE: Minimum bore diameter (D min) capability varies with thread type and pitch. See page D102 for details.
F dimension measured over sharp point of Top Notch style threading insert.

Toolholders and Boring Bars



insert size and style	clamp	clamp screw	shim	shim screw
NG-1L	CM-109	S-304	–	–
NG-2R	CM-182	S-310	–	–
NG-2L	CM-183	S-310	–	–
NG-2R	CM-74	S-310	–	–
NG-2L	CM-75	S-310	–	–
NG-3R	CM-184	S-412	–	–
NG-3L	CM-185	S-412	–	–
NG-3R	CM-72	S-412	–	–
NG-3L	CM-73	S-412	–	–
NG-3R*	CM-78	S-412	–	–
NG-3L*	CM-70	S-412	–	–
NG-4R	CM-72	S-412	SM-420	SL-344
NG-4L	CM-73	S-412	SM-420	SL-344
NG-5R	CM-80	S-352	–	–
NG-5L	CM-81	S-352	–	–
NG-6R	CM-120	S-412	SM-416	S-111
NG-6L	CM-121	S-412	SM-416	S-111
NG-8R	CM-144	S-422	SM-419	S-112
NG-8L	CM-145	S-422	SM-419	S-112
NG-8R**	CM-144	S-422	SM-427	S-111
NG-8L**	CM-145	S-422	SM-427	S-111
Top Notch relief grooving				
NU-3125R	CM-72	S-412	–	–
NU-3125L	CM-73	S-412	–	–
NU-3125R**	CM-72	S-618	–	–
NU-3125L**	CM-73	S-618	–	–

*25mm diameter boring head.
**Boring head.

LT • Laydown Triangle Threading

Primary Application

Laydown triangle (LT) threading is the system of choice for fine-pitch threads, high-helix/multistart threads, and single-point threading in small-diameter bores. With a wide selection of CB-style chip control inserts, you will receive superior chip management for excellent surface finishes and minimal operator intervention. The low-profile design enables unrestricted chip flow — ideal for I.D. threads. Variable shim angles enable proper cutting geometry for high-helix angle and reverse helix angle threading, maximising tool life and improving thread quality.

Features and Benefits

Precision-Ground Thread Form on LT and LT-CB

- Minimises built-up edge.
- Precisely cuts most common materials.
- Reduces cutting forces.
- Ensures accurate, high-quality threads.

KC5010™ and KC5025™ Premium PVD TiAlN-Coated Grades

- Increase tool life at existing machining conditions.
- Increase productivity by outperforming conventional PVD grades with up to a 30% advantage in cutting speeds.

Superior Chip Control

- Eliminates long, troublesome coils.
- Excellent for internal threading operations.
- Available in both partial and full profile inserts for all common thread forms.

Kenna Universal™ Inserts

- Precision moulded LT-K thread form provides outstanding utility and value.
- Excellent chip control combined with the KU25T™ grade enables trouble-free threading on a variety of workpiece materials.


KENNAMETAL S20SLSER16 NX4

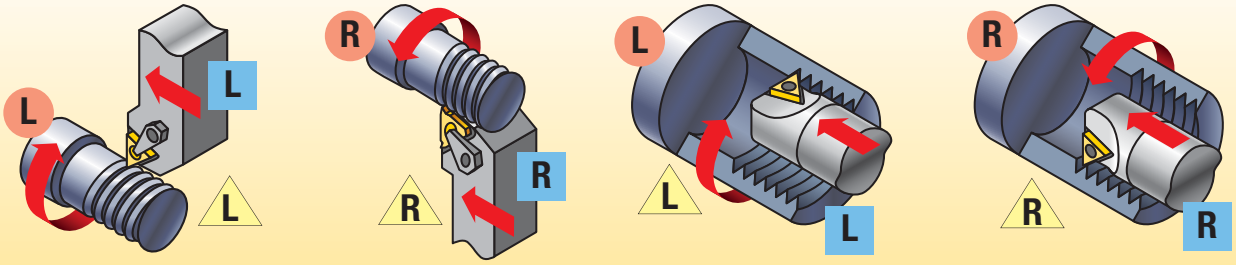
Step 1 • Select Threading Method and Hand of Tooling

Required Information:
- External/internal operation.
- Spindle rotation/hand of thread.
- Feed direction.



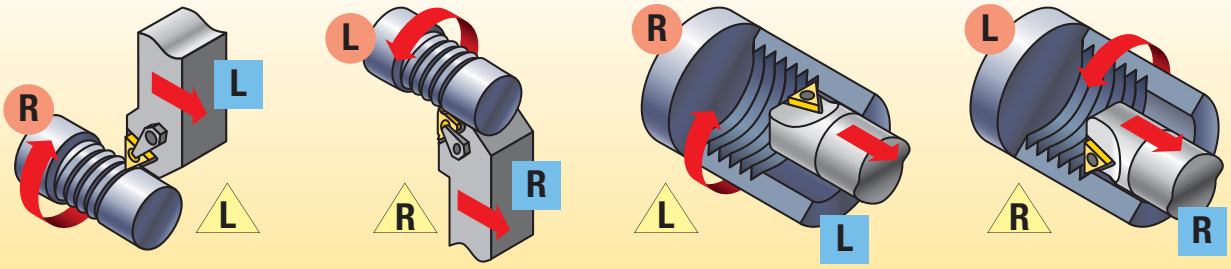
hand of thread | hand of toolholder | hand of insert

Feed direction toward the chuck • standard helix • RECOMMENDED



external left-hand thread | external right-hand thread | internal left-hand thread | internal right-hand thread

Feed direction away from the chuck • reverse helix*



external right-hand thread | external left-hand thread | internal right-hand thread | internal left-hand thread

**Negative shim required*

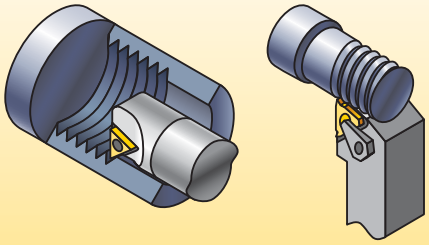
Step 2 • Select Holder from Catalogue Page

Required Information:
- External/internal operation.
- Minimum bore diameter (for internal operations).
- Hand of tool.
- Insert size (gage insert).

The insert size must match the gage insert size of your toolholder selection:

catalogue number	gage insert	minimum bore diameter	shim
S0812LSER2	2IRA60	16,5mm	SM-YI3
S2020LSER3	3IR...	36,8mm	SM-YI3

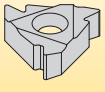
Select the appropriate holder for the insert size and hand:



Step 3 • Choose Insert for Application

- Select cresting inserts for fully controlled thread form including diameter.
- Cresting inserts eliminate the need for deburring and are optimised for the best tool life at that pitch.
- Non-cresting partial profile inserts offer the flexibility to cut a variety of thread pitches with one insert.
- Note insert size for toolholder selection.

NOTE: See threading insert overview on page D50.



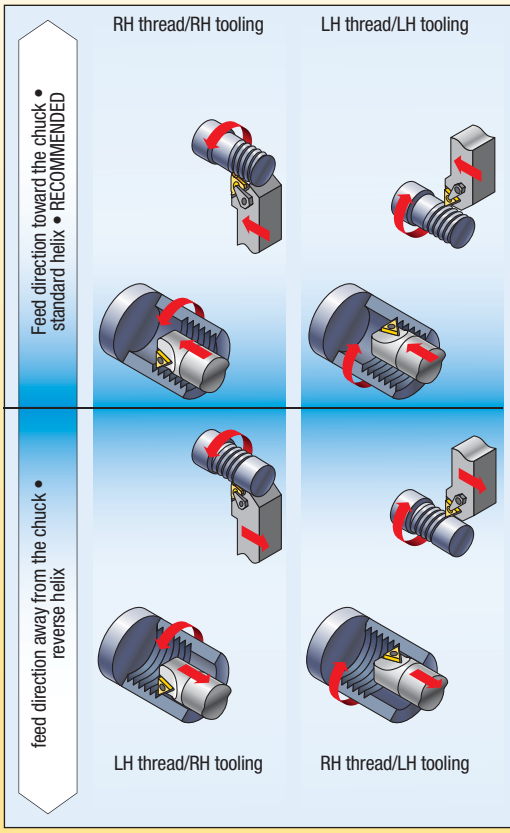
insert size	catalogue number	KCU25/KC5025
11	**2IRA60**	•
16	**3IRAG60**	•

Step 4 • Select Appropriate Shim

Required Information:

- Thread form (TPI or pitch).
- Pitch diameter.
- Helix method (hand of tool, feed direction, hand of thread).
- Number of starts.

Select the proper shim: SMYE... for external RH or internal LH
SMYI... for internal RH or external LH



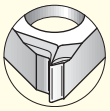
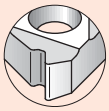
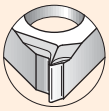
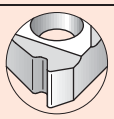
insert size	toolholder external	toolholder internal	shim ordering code (inch)							
						standard				
3 (3/8")	RH	LH	SM-YE3-3P	SM-YE3-2P	SM-YE3-1P	SM-YE3	SM-YE3-1N	SM-YE3-1.5N	SM-YE3-2N	SM-YE3-3N
3 (3/8")	LH	RH	SM-YI3-3P	SM-YI3-2P	SM-YI3-1P	SM-YI3	SM-YI3-1N	SM-YI3-1.5N	SM-YI3-2N	SM-YI3-3N
4 (1/2")	RH	LH	SM-YE4-3P	SM-YE4-2P	SM-YE4-1P	SM-YE4	SM-YE4-1N	SM-YE4-1.5N	SM-YE4-2N	SM-YE4-3N
4 (1/2")	LH	RH	SM-YI4-3P	SM-YI4-2P	SM-YI4-1P	SM-YI4	SM-YI4-1N	SM-YI4-1.5N	SM-YI4-2N	SM-YI4-3N
TPI		pitch (mm)	pitch diameter (inch)							
72		–	–	–	–	0.12–0.31	0.32–0.84	>0.84	0.84–0.32	0.31–0.12
–		0,35	–	–	–	0.12–0.3	0.31–0.84	>0.84	0.84–0.31	0.3–0.12
64		–	–	–	–	0.14–0.35	0.36–0.95	>0.95	0.95–0.36	0.35–0.14
–		0,40	–	–	–	0.14–0.35	0.36–0.96	>0.96	0.96–0.36	0.35–0.14
56		0,45	–	–	–	0.16–0.4	0.41–1.09	>1.09	1.09–0.41	0.4–0.16
–		0,50	–	–	0.11–0.16	0.17–0.44	0.45–1.2	>1.20	1.2–0.45	0.44–0.17
48		–	–	–	0.12–0.17	0.18–0.46	0.47–1.27	>1.27	1.27–0.47	0.46–0.18
44		–	–	–	0.13–0.19	0.2–0.51	0.52–1.38	>1.38	1.38–0.52	0.51–0.2
–		0,60	–	0.1–0.12	0.13–0.2	0.21–0.53	0.54–1.44	>1.44	1.44–0.54	0.53–0.21
40		–	–	0.11–0.13	0.14–0.21	0.22–0.56	0.57–1.52	>1.52	1.52–0.57	0.56–0.22
–		0,70	–	0.12–0.15	0.16–0.23	0.24–0.62	0.63–1.68	>1.68	1.68–0.63	0.62–0.24
36		–	–	0.12–0.15	0.16–0.23	0.24–0.62	0.63–1.69	>1.69	1.69–0.63	0.62–0.24
–		0,75	0.11–0.12	0.13–0.16	0.17–0.25	0.26–0.66	0.67–1.8	>1.80	1.8–0.67	0.66–0.26
32		–	0.12–0.13	0.14–0.17	0.18–0.26	0.27–0.7	0.71–1.9	>1.90	1.9–0.71	0.7–0.27
–		0,80	0.12–0.13	0.14–0.17	0.18–0.26	0.27–0.71	0.72–1.91	>1.91	1.91–0.72	0.71–0.27
28		–	0.14–0.14	0.15–0.19	0.2–0.3	0.31–0.8	0.81–2.17	>2.17	2.17–0.81	0.8–0.31
27		–	0.14–0.15	0.16–0.2	0.21–0.31	0.32–0.83	0.84–2.25	>2.25	2.25–0.84	0.83–0.32
–		1,00	0.15–0.16	0.17–0.21	0.22–0.33	0.34–0.89	0.9–2.39	>2.39	2.39–0.9	0.89–0.34
24		–	0.16–0.17	0.18–0.23	0.24–0.35	0.36–0.94	0.95–2.53	>2.53	2.53–0.95	0.94–0.36
–		1,25	0.19–0.2	0.21–0.27	0.28–0.42	0.43–1.11	1.12–2.99	>2.99	2.99–1.12	1.11–0.43
20		–	0.19–0.21	0.22–0.27	0.28–0.42	0.43–1.13	1.14–3.04	>3.04	3.04–1.14	1.13–0.43
18		–	0.21–0.23	0.24–0.31	0.32–0.47	0.48–1.26	1.277–3.38	>3.38	3.38–1.27	1.26–0.48
–		1,50	0.22–0.25	0.26–0.33	0.34–0.5	0.51–1.34	1.35–3.59	>3.59	3.59–1.35	1.34–0.51
16		–	0.24–0.26	0.27–0.35	0.36–0.53	0.54–1.41	1.42–3.8	>3.80	3.8–1.42	1.41–0.54
–		1,75	0.26–0.29	0.3–0.38	0.39–0.59	0.6–1.56	1.57–4.19	>4.19	4.19–1.57	1.56–0.6
14		–	0.27–0.3	0.31–0.4	0.41–0.61	0.62–1.62	1.63–4.34	>4.34	4.34–1.63	1.62–0.62
13		–	0.29–0.32	0.33–0.43	0.44–0.66	0.67–1.74	1.75–4.68	>4.68	4.68–1.75	1.74–0.67
–		2,00	0.3–0.33	0.34–0.44	0.45–0.67	0.68–1.78	1.79–4.79	>4.79	4.79–1.79	1.78–0.68
12		–	0.32–0.35	0.36–0.46	0.47–0.71	0.72–1.89	1.9–5.07	>5.07	5.07–1.9	1.89–0.72
11.5		–	0.33–0.37	0.38–0.49	0.5–0.74	0.75–1.97	1.98–5.29	>5.29	5.29–1.98	1.97–0.75
11		–	0.34–0.38	0.39–0.51	0.52–0.78	0.79–2.06	2.07–5.53	>5.53	5.53–2.07	2.06–0.79
–		2,50	0.37–0.42	0.43–0.55	0.56–0.84	0.85–2.23	2.24–5.98	>5.98	5.98–2.24	2.23–0.85
10		–	0.38–0.42	0.43–0.56	0.57–0.86	0.87–2.27	2.28–6.08	>6.08	6.08–2.28	2.27–0.87
9		–	0.42–0.47	0.48–0.62	0.63–0.95	0.96–2.52	2.53–6.75	>6.75	6.75–2.53	2.52–0.96
–		3,00	0.45–0.5	0.51–0.66	0.67–1.02	1.03–2.68	2.69–7.18	>7.18	7.18–2.69	2.68–1.03
8		–	0.47–0.53	0.54–0.7	0.71–1.08	1.09–2.84	2.85–7.6	>7.60	7.6–2.85	2.84–1.09
–		3,50	0.52–0.59	0.6–0.77	0.78–1.19	1.2–3.13	3.14–8.38	>8.38	8.38–3.14	3.13–1.2
7		–	0.524–0.61	0.62–0.8	0.81–1.23	1.24–3.25	3.26–8.68	>8.68	8.68–3.26	3.25–1.24
–		4,00	0.6–0.67	0.68–0.89	0.9–1.36	1.37–3.58	3.59–9.57	>9.57	9.57–3.59	3.58–1.37
6		–	0.63–0.71	0.72–0.94	0.95–1.44	1.45–3.79	3.8–10.13	>10.13	10.13–3.8	3.79–1.45
–		5,00	0.75–0.84	0.85–1.11	1.12–1.7	1.71–4.48	4.49–11.97	>11.97	11.97–4.49	4.48–1.71
5		–	0.76–0.86	0.87–1.13	1.14–1.73	1.74–4.55	4.56–12.16	>12.16	12.16–4.56	4.55–1.74
4.5		–	0.84–0.95	0.96–1.26	1.27–1.92	1.93–5.06	5.07–13.51	>13.51	13.51–5.07	5.06–1.93
–		6,00	0.9–1.01	1.02–1.33	1.34–2.04	2.05–5.37	5.38–14.36	>14.36	14.36–5.38	5.37–2.05
4		–	0.95–1.07	1.08–1.41	1.42–2.16	2.17–5.69	5.7–15.2	>15.20	15.2–5.7	5.69–2.17
inclination angle			4.5	3.5	2.5	1.5	0.5	0.0	-0.5	-1.5
			standard helix (feed toward the chuck)						reverse helix (feed away from the chuck)	

If recommended shim is different from shim supplied with toolholder, order shim separately.

NOTE: Optimise your threading operation by using the proper infeed angle and the recommended infeed values.
See the Technical Section on pages D88–D110.
Also see detailed shim selection information on pages D109–D110.

Step 5 • Select Grade and Speed

Recommendations for Grade and Speed Selection – m/min

	workpiece material	P	M	K	N	S
Kenna Perfect™	insert style	CB chipbreaker			CB chipbreaker	
	optimum cutting conditions	**KC5010** 70–260	**KC5010** 90–245	**KC5010** 60–245	**KC5010** 90–550	**KC5010** 30–150
	first choice	**KC5025** 50–230	**KC5025** 75–230	**KC5025** 50–180	**KC5025** 60–455	**KC5025** 20–120
Kenna Universal™	insert style	-K chipbreaker				
	selection	**KU25T** 45–210	**KU25T** 70–205	**KU25T** 45–160	**KU25T** 55–410	**KU25T** 20–110

NOTE: See threading insert overview on page D50.

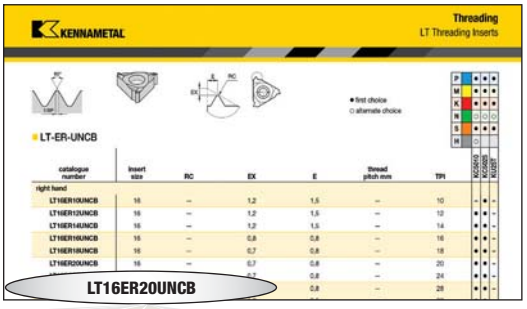
Recommended Starting Speeds [m/min]

Material Group		KC5010			KC5025			KU25T		
P	0–1	135	**200**	260	105	**165**	230	95	**150**	210
	2	130	**190**	245	100	**150**	200	90	**135**	180
	3	105	**155**	200	75	**125**	170	70	**115**	155
	4	70	**120**	160	60	**95**	130	55	**85**	115
	5	105	**155**	200	75	**130**	170	70	**115**	155
	6	70	**120**	160	50	**90**	130	45	**80**	115
M	1	120	**180**	245	90	**170**	230	80	**155**	205
	2	90	**165**	210	75	**140**	200	70	**125**	180
	3	90	**165**	210	75	**135**	200	70	**120**	180
K	1	120	**180**	245	90	**135**	180	80	**120**	160
	2	90	**150**	210	70	**120**	170	65	**110**	155
	3	60	**105**	150	50	**85**	120	45	**75**	110
N	1–2	150	**365**	550	120	**305**	455	110	**275**	410
	3	90	**135**	180	60	**105**	150	55	**95**	135
	4	120	**305**	455	100	**200**	305	90	**180**	275
	5	90	**165**	245	70	**135**	195	65	**120**	175
	6	120	**210**	305	100	**170**	245	90	**155**	220
S	1	30	**70**	105	20	**40**	60	20	**35**	55
	2	30	**65**	100	20	**35**	45	20	**30**	40
	3	30	**65**	100	20	**35**	45	20	**30**	40
	4	55	**105**	150	45	**85**	120	40	**75**	110
H	1	30	**45**	60	–	**–**	–	–	**–**	–
	2	15	**30**	45	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–	–	**–**	–

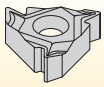
NOTE: FIRST choice starting speeds are in **bold** type.

How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding image to easily identify which attributes apply.



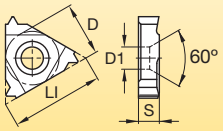
LT — Type of Insert



LT = Laydown triangle threading

16 — Cutting Edge Length *(Size)*

insert size	LI (mm)	D (mm)	S (mm)	D1 (mm)
11	11,0	6,35	3,20	3,25
16	16,5	9,52	3,63	3,94
22	22,0	12,70	4,78	4,88



ER — Hand of Insert

ER = External right hand

EL = External left hand

NR = Internal right hand

NL = Internal left hand

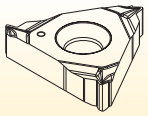
20 — Thread Pitch

partial profile		
designation	**thread pitch (mm)**	**TPI**
A	0,50–1,5	48–16
AG	0,50–3,0	48–8
G	1,75–3,0	14–8
N	3,50–5,0	7–5
full profile		
actual TPI or pitch in mm is designated	0,5–4,0	48–8

UN — Thread Profile

ISO = ISO metric 60°
UN = American UN 60°
60 = Partial profile non-cresting 60°
55 = Partial profile non-cresting 55°
W = Whitworth 55°
BSPT = British Standard Pipe Thread 55°
NPT = American National Pipe Thread 60°
ACME = American Acme
STACME = American Stub Acme
TR = Trapez DIN 103
RD = Round DIN 405
UNJ = Controlled root radius 60°
NPTF = Dryseal 60°
API = American Petroleum Institute Threads
BUT = API Buttress Casing
APIRD = API Round

CB — Chip Control



☐ = Flat top

CB = Chipbreaker

K = Kenna Universal™ chipbreaker



The Kennametal LT Advantage

Every box of 10 inserts includes a free Torx wrench and spare locking screw, except LT-K inserts.

style			thread profile	standard	tolerance class	cresting	application	page(s)
CB	K	flat top						
 LT-60CB	 LT-60K	 LT-60	Partial profile 60º	—	—	N	General use for 60° thread forms, such as ISO and UN, where non-cresting inserts are desired to cut a variety of pitches.	D53–D54, D66–D67
 LT-ISOCB	 LT-ISOK	 LT-ISO	Metric ISO	ISO R262, DIN 13	6g/6H	Y	Widely used metric 60° V-form for all industries.	D57–D58, D70–D71
 LT-UNCB	 LT-UNK	 LT-UN	American UN	ANSI B1.1:74	2A/2B	Y	Widely used inch-based 60° V-form for all industries.	D62–D63, D74–D75
		 LT-UNJ	UNJ	MIL-S-8879C	3A/3B	Y	Controlled root radius on external threads for military and aerospace industries, 60° thread form.	D63, D75
 LT-NPTCB		 LT-NPT	NPT	USAS B2.1:1968	Standard NPT	Y	National Pipe Thread standard 60° thread form for pipe fittings.	D59, D72
 LT-NPTFCB		 LT-NPTF	NPTF	ANSI B1.20.3-1976	Class 2	Y	Dryseal-type NPT 60° thread form for pipe fittings.	D60, D72
	 LT-55K	 LT-55	Partial profile 55º	—	—	N	General use for 55° thread forms such as Whitworth, BSW, and BSP where non-cresting inserts are desired to cut a variety of pitches.	D52, D65–D66
		 LT-BSPT	BSPT	BS 21:1985	Standard BSPT	Y	55° form for pipe fittings.	D56, D69
 LT-WCB	 LT-WK	 LT-W	Whitworth, BSW, BSF, BSP	BS 84:1956, ISO 228/1:1985, DIN 259	Medium Class A	Y	Widely used 55° form for gas and water connections.	D64–D65, D76
		 LT-API	API Rotary Shoulder Connections	API SPEC. 7:1990	Standard API	Y	60° V-form used for rotary shoulder pipe connections in the oil and gas industry including V-.038R, V-.040, and V-.050 forms.	D55, D68
		 LT-APIRD	API round	API STD. 5B:1979	Standard API RD	Y	60° V-form with large radius for casing, tubing, and line pipe in the oil and gas industry, including 8 and 10 round forms.	D55, D69
		 LT-BUT	API Buttress Casing	API SPEC. 7:1990	Standard API	Y	45° buttress-style form used for pipe casing connections in the oil and gas industry.	D56, D69
		 LT-ACME	Acme	ANSI B1.5:1988	3G	N	29° truncated thread form for motion applications in a wide variety of industries.	D54, D68
		 LT-STACME	Stub Acme	ANSI B1.8:1988	2G	N	Shallow depth 29° truncated thread form for motion applications in a wide variety of industries.	D61, D73
		 LT-RD	Round	DIN 405	7h/7H	Y	Round thread form for tube fittings in the chemical and food industries.	D60, D73
		 LT-TR	Trapez	DIN 103	7e/7H	N	30° truncated metric thread form for motion applications.	D61, D73

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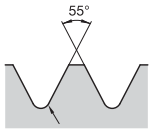
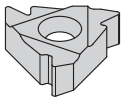
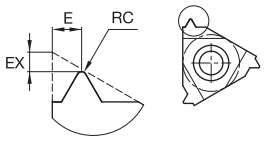


Partial Profile 55°
External



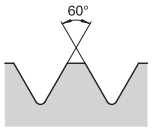


● first choice
○ alternate choice

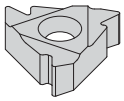
		KC5010	KC5025	KU25T
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

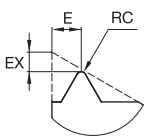
LT-ER/L-55

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ERA55	16	0,05	0,8	0,89	0,50-1,50	16-48	–	●	–
LT16ERAG55	16	0,08	1,2	1,70	0,50-3,00	8-48	●	●	–
16ERG55	16	0,20	1,2	1,70	1,75-3,00	8-14	–	●	–
LT22ERN55	22	0,43	1,7	2,49	3,50-5,00	5-7	–	●	–
left hand									
LT16ELAG55	16	0,08	1,2	1,70	0,50-3,00	8-48	–	●	–



Partial Profile 60°
External





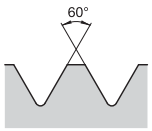


● first choice
○ alternate choice

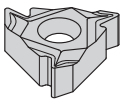
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

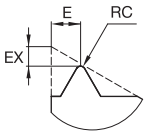
LT-ER/L-60

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ERA60	16	0,05	0,8	0,9	0,50-1,50	16-48	●	●	–
16ERAG60	16	0,08	1,2	1,7	0,50-3,0	8-48	–	●	–
LT16ERAG60	16	0,08	1,2	1,7	0,50-3,0	8-48	●	–	–
LT16ERG60	16	0,28	1,2	1,7	1,75-3,0	8-14	●	●	–
LT22ERN60	22	0,53	1,7	2,5	3,5-5,0	5-7	–	●	–
left hand									
LT16ELA60	16	0,05	0,8	0,9	0,50-1,50	16-48	–	●	–
LT16ELAG60	16	0,08	1,2	1,7	0,50-3,0	8-48	–	●	–
LT16ELG60	16	0,28	1,2	1,7	1,75-3,0	8-14	–	●	–
LT22ELN60	22	0,53	1,7	2,5	3,5-5,0	5-7	–	●	–



Partial Profile 60°
External





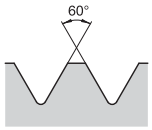


LT-ER-60CB

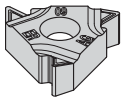
catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ERAG60CB	16	0,08	0,9	1,5	0,50-3,0	8-48	●	●	–

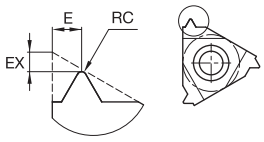
● first choice
○ alternate choice

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



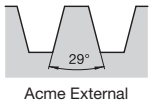
Partial Profile 60°
External



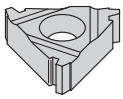


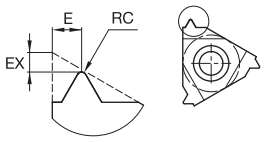
LT-ER-60K

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ERAG60K	16	0,08	1,2	1,7	0,50-3,0	8-48	–	–	●



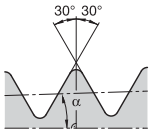
Acme External



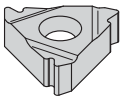


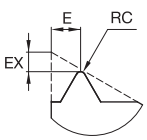
LT-ER/L-ACME

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER10ACME	16	–	1,3	1,40	–	10	–	●	–
LT16ER12ACME	16	–	1,1	1,19	–	12	–	●	–
LT16ER16ACME	16	–	1,0	1,09	–	16	–	●	–
LT16ER8ACME	16	–	1,4	1,50	–	8	–	●	–
LT22ER5ACME	22	–	2,0	2,29	–	5	–	●	–
LT22ER6ACME	22	–	1,8	2,11	–	6	–	●	–



API Rotary Shoulder Connections-External
α = 1/2 arctan (TPF/12)





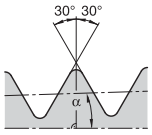


● first choice
○ alternate choice

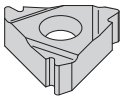
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

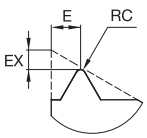
LT-ER/L-API

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT22ER4API382	22	–	2,1	2,79	–	4	–	●	–
LT22ER4API502	22	–	2,0	2,90	–	4	●	●	–
LT22ER4API503	22	–	2,0	2,90	–	4	●	–	–
LT22ER5API403	22	–	1,8	2,60	–	5	●	–	–
LT27ER4API502	28	0,64	2,0	2,79	–	4	–	●	–
LT27ER4API382	28	0,97	2,0	2,79	–	4	–	●	–



API Round-External

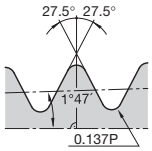




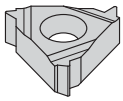


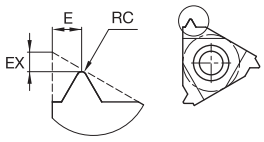
LT-ER/L-APIRD

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER10APIRD	16	–	1,2	1,40	–	10	–	●	–
LT16ER8APIRD	16	–	1,3	1,50	–	8	–	●	–
left hand									
LT16EL8APIRD	16	–	1,3	1,50	–	8	–	●	–



BSPT-External



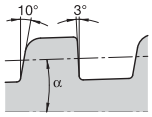


● first choice
○ alternate choice

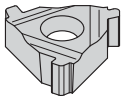
P	●	●	●	
M	●	●	●	
K	●	●	●	
N	○	○	○	
S	●	●	●	
H	○			

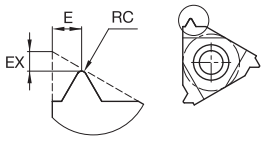
LT-ER/L-BSPT

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER11BSPT	16	–	1,1	1,50	–	11	–	●	–
LT16ER14BSPT	16	–	1,0	1,19	–	14	–	●	–



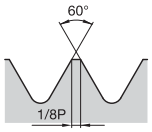
API Buttress
Casing-External
α = 1/2 arctan
(TPF/12)



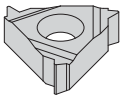


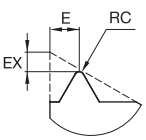
LT-ER/L-BUT

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT22ER5BUT75	22	–	3,1	1,91	–	5	–	●	–



ISO Metric-External





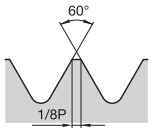


● first choice
○ alternate choice

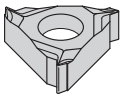
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

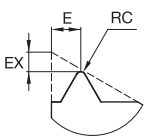
LT-ER/L-ISO

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER05ISO	16	–	0,6	0,4	0,50	–	–	●	–
LT16ER075ISO	16	–	0,6	0,6	0,75	–	–	●	–
LT16ER10ISO	16	–	0,7	0,7	1,0	–	●	●	–
LT16ER125ISO	16	–	0,8	0,9	1,25	–	●	●	–
LT16ER15ISO	16	–	0,8	1,0	1,5	–	●	●	–
LT16ER175ISO	16	–	0,9	1,2	1,75	–	●	●	–
LT16ER20ISO	16	–	1,0	1,3	2,0	–	●	●	–
LT16ER25ISO	16	–	1,1	1,5	2,5	–	●	●	–
LT16ER30ISO	16	–	1,2	1,6	3,0	–	●	●	–
LT22ER35ISO	22	–	1,6	2,3	3,5	–	–	●	–
LT22ER40ISO	22	–	1,6	2,3	4,0	–	–	●	–
LT22ER45ISO	22	–	1,7	2,4	4,5	–	–	●	–
LT22ER50ISO	22	–	1,7	2,5	5,0	–	–	●	–
left hand									
LT16EL15ISO	16	–	0,8	1,0	1,5	–	●	●	–
LT16EL175ISO	16	–	0,9	1,2	1,75	–	–	●	–
LT16EL20ISO	16	–	1,0	1,3	2,0	–	–	●	–
LT16EL25ISO	16	–	1,1	1,5	2,5	–	–	●	–
LT16EL30ISO	16	–	1,2	1,6	3,0	–	–	●	–
LT16EL05ISO	16	–	0,6	0,4	0,50	–	–	●	–
LT16EL075ISO	16	–	0,6	0,6	0,75	–	–	●	–
LT16EL10ISO	16	–	0,7	0,7	1,0	–	–	●	–
LT16EL125ISO	16	–	0,8	0,9	1,25	–	–	●	–
LT22EL35ISO	22	–	1,6	2,3	3,5	–	–	●	–



ISO Metric-External





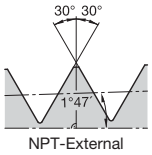


● first choice
○ alternate choice

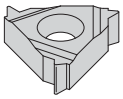
		KC5010	KC5025	KU25T
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

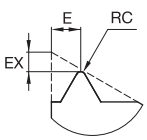
LT-ER-ISOCB

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER05ISOCB	16	–	1,2	0,5	0,50	–	●	●	–
LT16ER075ISOCB	16	–	1,2	0,6	0,75	–	●	●	–
LT16ER10ISOCB	16	–	0,7	0,8	1,0	–	●	●	–
LT16ER125ISOCB	16	–	0,7	0,8	1,25	–	●	●	–
LT16ER15ISOCB	16	–	0,7	0,8	1,5	–	●	●	–
LT16ER175ISOCB	16	–	1,2	1,5	1,75	–	●	●	–
LT16ER20ISOCB	16	–	1,2	1,5	2,0	–	●	●	–
LT16ER25ISOCB	16	–	1,2	1,5	2,5	–	–	●	–
LT16ER30ISOCB	16	–	1,3	1,5	3,0	–	●	●	–



NPT-External





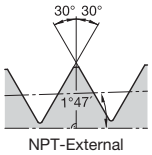


● first choice
○ alternate choice

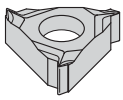
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

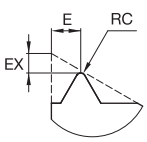
LT-ER/L-NPT

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER115NPT	16	–	1,1	1,5	–	11.5	●	●	–
LT16ER14NPT	16	–	0,9	1,2	–	14	●	●	–
LT16ER18NPT	16	–	0,8	1,0	–	18	●	●	–
LT16ER27NPT	16	–	0,7	0,8	–	27	–	●	–
LT16ER8NPT	16	–	1,3	1,8	–	8	–	●	–



NPT-External





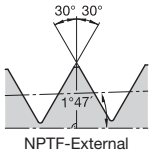


LT-ER-NPTCB

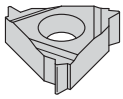
catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER14NPTCB	16	–	1,1	1,5	–	14	●	●	–

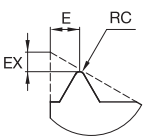
P	●	●	●
M	●	●	●
K	●	●	●
N	○	○	○
S	●	●	●
H	○		

● first choice
○ alternate choice



NPTF-External

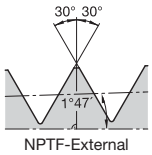




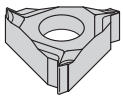


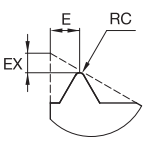
LT-ER/L-NPTF

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER115NPTF	16	–	1,1	1,5	–	11.5	–	●	–
LT16ER14NPTF	16	–	0,9	1,2	–	14	–	●	–



NPTF-External

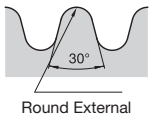




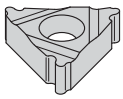


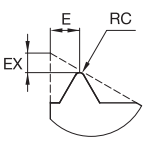
LT-ER-NPTFCB

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER115NPTFCB	16	–	1,1	1,5	–	11.5	–	●	–



Round External

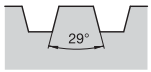




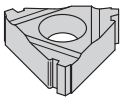


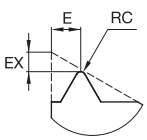
LT-ER/L-RD

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER8RD	16	0,76	1,4	1,30	–	8	–	●	–
LT22ER6RD	22	1,01	1,5	1,70	–	6	–	●	–



Stub Acme-External





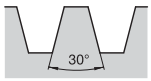


● first choice
○ alternate choice

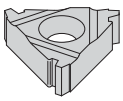
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

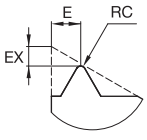
LT-ER/L-STACME

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER10STACME	16	–	1,2	1,30	–	10	–	●	–
LT16ER12STACME	16	–	1,2	1,19	–	12	–	●	–
LT16ER16STACME	16	–	1,0	0,99	–	16	–	●	–
LT16ER6STACME	16	–	1,7	1,80	–	6	–	●	–
LT16ER8STACME	16	–	1,4	1,50	–	8	–	●	–
LT22ER5STACME	22	–	2,1	2,29	–	5	–	●	–



Trapez-External

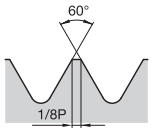




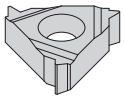


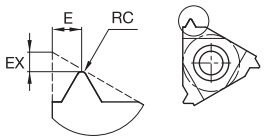
LT-ER/L-TR

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER2TR	16	–	1,1	1,30	2,0	–	–	●	–
LT16ER3TR	16	–	1,3	1,50	3,0	–	–	●	–
LT22ER4TR	22	–	1,7	1,91	4,0	–	–	●	–
LT22ER5TR	22	–	2,1	2,50	5,0	–	–	●	–



American
UN-External



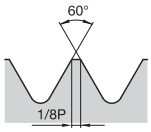


● first choice
○ alternate choice

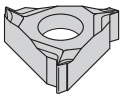
		KC5010	KC5025	KU25T
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

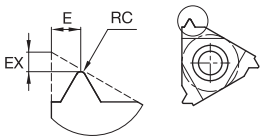
LT-ER/L-UN

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER10UN	16	–	1,1	1,5	–	10	–	●	–
LT16ER12UN	16	–	1,1	1,4	–	12	●	●	–
LT16ER14UN	16	–	1,0	1,2	–	14	●	●	–
LT16ER16UN	16	–	0,9	1,1	–	16	●	●	–
LT16ER18UN	16	–	0,8	1,0	–	18	●	●	–
LT16ER20UN	16	–	0,8	0,9	–	20	●	●	–
LT16ER24UN	16	–	0,7	0,8	–	24	●	●	–
LT16ER28UN	16	–	0,6	0,7	–	28	●	●	–
LT16ER32UN	16	–	0,6	0,6	–	32	●	●	–
LT16ER36UN	16	–	0,6	0,6	–	36	–	●	–
LT16ER40UN	16	–	0,6	0,6	–	40	–	●	–
LT16ER48UN	16	–	0,6	0,6	–	48	–	●	–
LT16ER8UN	16	–	1,2	1,6	–	8	–	●	–
left hand									
LT16EL24UN	16	–	0,7	0,8	–	24	–	●	–
LT16EL28UN	16	–	0,6	0,7	–	28	–	●	–
LT16EL8UN	16	–	1,2	1,6	–	8	–	●	–
LT16EL12UN	16	–	1,1	1,4	–	12	–	●	–
LT16EL14UN	16	–	1,0	1,2	–	14	–	●	–
LT16EL16UN	16	–	0,9	1,1	–	16	–	●	–
LT16EL18UN	16	–	0,8	1,0	–	18	–	●	–
LT16EL20UN	16	–	0,8	0,9	–	20	–	●	–



American
UN-External



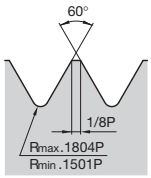


● first choice
○ alternate choice

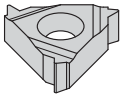
P	●	●	●	
M	●	●	●	
K	●	●	●	
N	○	○	○	
S	●	●	●	
H	○			

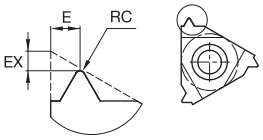
LT-ER-UNCB

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER10UNCB	16	–	1,2	1,5	–	10	–	●	–
LT16ER12UNCB	16	–	1,2	1,5	–	12	●	●	–
LT16ER14UNCB	16	–	1,2	1,5	–	14	●	●	–
LT16ER16UNCB	16	–	0,8	0,8	–	16	●	●	–
LT16ER18UNCB	16	–	0,7	0,8	–	18	●	●	–
LT16ER20UNCB	16	–	0,7	0,8	–	20	●	●	–
LT16ER24UNCB	16	–	0,7	0,8	–	24	●	●	–
LT16ER28UNCB	16	–	0,7	0,8	–	28	●	●	–
LT16ER32UNCB	16	–	1,2	0,5	–	32	●	●	–
LT16ER8UNCB	16	–	1,3	1,5	–	8	●	●	–



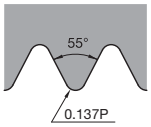
UNJ-External



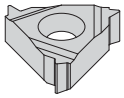


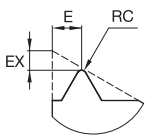
LT-ER/L-UNJ

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER12UNJ	16	–	1,1	1,3	–	12	●	●	–
LT16ER14UNJ	16	–	1,0	1,2	–	14	●	●	–
LT16ER16UNJ	16	–	0,9	1,1	–	16	●	●	–
LT16ER18UNJ	16	–	0,8	1,0	–	18	●	●	–
LT16ER20UNJ	16	–	0,8	0,9	–	20	●	●	–
LT16ER24UNJ	16	–	0,7	0,8	–	24	–	●	–
LT16ER28UNJ	16	–	0,7	0,7	–	28	–	●	–
LT16ER32UNJ	16	–	0,6	0,7	–	32	–	●	–
left hand									
LT16EL16UNJ	16	–	0,9	1,1	–	16	–	●	–



Whitworth BSW,
BSF, BSP-Internal





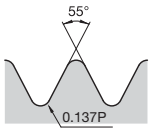


● first choice
○ alternate choice

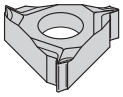
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

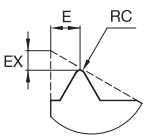
LT-ER/L-W

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER10W	16	–	1,1	1,50	–	10	–	●	–
LT16ER11W	16	–	1,1	1,50	–	11	●	●	–
LT16ER12W	16	–	1,1	1,40	–	12	–	●	–
LT16ER14W	16	–	1,0	1,19	–	14	●	●	–
LT16ER16W	16	–	0,9	1,09	–	16	–	●	–
LT16ER18W	16	–	0,8	0,99	–	18	–	●	–
LT16ER19W	16	–	0,8	0,99	–	19	●	●	–
LT16ER20W	16	–	0,8	0,89	–	20	–	●	–
LT16ER24W	16	–	0,7	0,79	–	24	–	●	–
LT16ER28W	16	–	0,6	0,69	–	28	–	●	–
LT16ER8W	16	–	1,2	1,50	–	8	–	●	–
LT16ER9W	16	–	1,2	1,70	–	9	–	●	–
LT22ER6W	22	–	1,6	2,29	–	6	–	●	–
LT22ER7W	22	–	1,6	2,29	–	7	–	●	–
left hand									
LT16EL11W	16	–	1,1	1,50	–	11	–	●	–
LT16EL14W	16	–	1,0	1,19	–	14	–	●	–



Whitworth BSW,
BSF, BSP-External





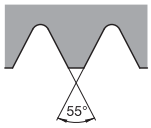


● first choice
○ alternate choice

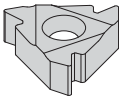
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

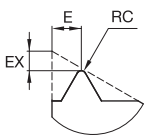
LT-ER-WCB

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16ER11WCB	16	–	1,3	1,50	–	11	–	●	–
LT16ER14WCB	16	–	1,3	1,50	–	14	●	●	–



Partial Profile 55°
Internal

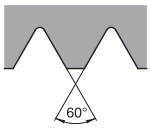




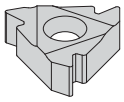


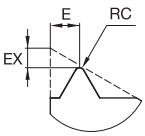
LT-NR/L-55

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT11NRA55	11	0,05	0,8	0,89	0,50-1,50	16-48	–	●	–
LT16NRA55	16	0,05	0,8	0,89	0,50-1,50	16-48	–	●	–
LT16NRAG55	16	0,07	1,2	1,70	0,50-3,00	8-48	–	●	–
LT16NRG55	16	0,21	1,2	1,70	1,75-3,00	8-14	–	●	–
LT22NRN55	22	0,43	1,7	2,49	3,50-5,00	5-7	–	●	–



Partial Profile 60°
Internal





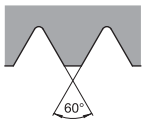


● first choice
○ alternate choice

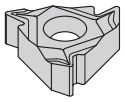
		KC5010	KC5025	KU25T
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

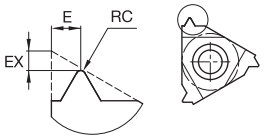
LT-NR/L-60

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT11NRA60	11	0,05	0,8	0,9	0,50-1,5	48-16	●	●	–
LT16NRA60	16	0,05	0,8	0,9	0,50-1,5	48-16	●	●	–
LT16NRAG60	16	0,05	1,2	1,7	0,50-3,0	48-8	●	●	–
LT16NRG60	16	0,15	1,2	1,7	1,75-3,0	14-8	●	●	–
LT22NRN60	22	0,31	1,7	2,5	3,5-5,0	7-5	–	●	–
left hand									
LT11NLA60	11	0,05	0,8	0,9	0,50-1,5	48-16	–	●	–
LT16NLA60	16	0,05	0,8	0,9	0,50-1,5	48-16	–	●	–
LT16NLAG60	16	0,05	1,2	1,7	0,50-3,0	48-8	–	●	–
LT16NLG60	16	0,15	1,2	1,7	1,75-3,0	14-8	–	●	–
LT22NLN60	22	0,31	1,7	2,5	3,5-5,0	7-5	–	●	–



Partial Profile 60°
Internal



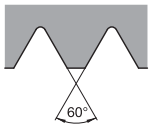


● first choice
○ alternate choice

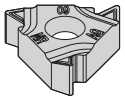
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

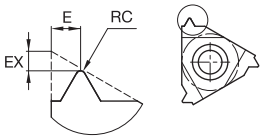
LT-NR-60CB

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT11NRA60CB	11	0,05	0,6	0,8	0,50-1,50	48-16	–	●	–
LT16NRAG60CB	16	0,05	0,9	1,5	0,50-3,0	48-8	–	●	–
LT16NRG60CB	16	0,16	1,0	1,5	1,75-3,0	14-8	–	●	–



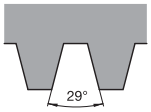
Partial Profile 60°
Internal



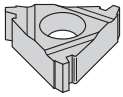


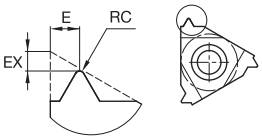
LT-NR-60K

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16NRAG60K	16	0,04	1,2	1,7	0,50-3,0	48-8	–	–	●



Acme Internal



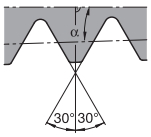


● first choice
○ alternate choice

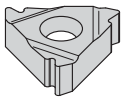
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

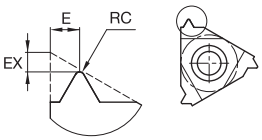
LT-NR/L-ACME

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16NR10ACME	16	–	1,2	1,30	–	10	–	●	–
LT16NR12ACME	16	–	1,2	1,30	–	12	–	●	–
LT16NR8ACME	16	–	1,4	1,50	–	8	–	●	–
LT22NR5ACME	22	–	2,0	2,29	–	5	–	●	–
LT22NR6ACME	22	–	1,8	2,11	–	6	–	●	–



API Rotary Shoulder Connections-Internal
α = 1/2 arctan (TPF/12)



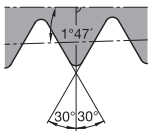


LT-NR/L-API

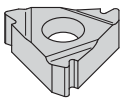
catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT22NR4API382	22	–	2,1	2,79	–	4	–	●	–
LT22NR4API502	22	–	2,1	3,10	–	4	–	●	–
LT22NR5API403	22	–	1,8	2,60	–	5	–	●	–
LT27NR4API502	28	0,65	2,0	3,79	–	4	–	●	–
LT27NR4API382	28	0,99	2,0	2,79	–	4	–	●	–

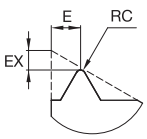
P	●	●	●
M	●	●	●
K	●	●	●
N	○	○	○
S	●	●	●
H	○		

● first choice
○ alternate choice



API Round-Internal

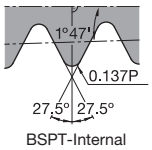




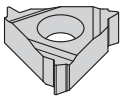


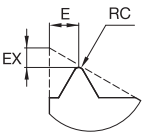
LT-NR/L-APIRD

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16NR10APIRD	16	–	1,2	1,40	–	10	–	●	–
LT16NR8APIRD	16	–	1,3	1,50	–	8	–	●	–



BSPT-Internal

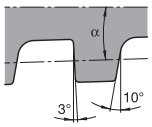




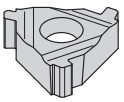


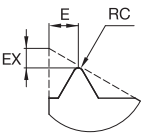
LT-NR/L-BSPT

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT11NR14BSPT	11	–	0,9	0,99	–	14	–	●	–
LT16NR11BSPT	16	–	1,1	1,50	–	11	–	●	–
LT16NR14BSPT	16	–	1,0	1,19	–	14	–	●	–



API Buttress
Casing-Internal
α = 1/2 arctan
(TPF/12)

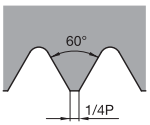




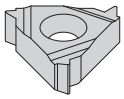


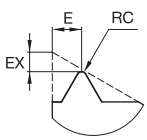
LT-NR/L-BUT

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT22NR5BUT1	22	–	2,8	1,91	–	5	–	●	–
LT22NR5BUT75	22	–	2,8	1,91	–	5	–	●	–



ISO Metric-Internal





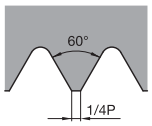


● first choice
○ alternate choice

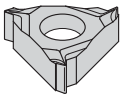
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

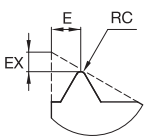
LT-NR/L-ISO

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT11NR05ISO	11	–	0,6	0,4	0,50	–	–	●	–
LT11NR075ISO	11	–	0,6	0,6	0,75	–	–	●	–
LT11NR10ISO	11	–	0,6	0,7	1,0	–	–	●	–
LT11NR125ISO	11	–	0,8	0,9	1,25	–	–	●	–
LT11NR15ISO	11	–	0,8	1,0	1,5	–	●	●	–
LT11NR175ISO	11	–	0,9	1,1	1,75	–	–	●	–
LT11NR20ISO	11	–	0,9	1,1	2,0	–	–	●	–
LT16NR05ISO	16	–	0,6	0,4	0,50	–	–	●	–
LT16NR075ISO	16	–	0,6	0,6	0,75	–	–	●	–
LT16NR10ISO	16	–	0,6	0,7	1,0	–	●	●	–
LT16NR125ISO	16	–	0,8	0,9	1,25	–	–	●	–
LT16NR15ISO	16	–	0,8	1,0	1,5	–	●	●	–
LT16NR175ISO	16	–	0,9	1,2	1,75	–	–	●	–
LT16NR20ISO	16	–	1,0	1,3	2,0	–	●	●	–
LT16NR25ISO	16	–	1,1	1,5	2,5	–	–	●	–
LT16NR30ISO	16	–	1,1	1,5	3,0	–	●	●	–
LT22NR35ISO	22	–	1,6	2,3	3,5	–	–	●	–
LT22NR40ISO	22	–	1,6	2,3	4,0	–	–	●	–
LT22NR45ISO	22	–	1,6	2,4	4,5	–	–	●	–
LT22NR50ISO	22	–	1,6	2,3	5,0	–	–	●	–
left hand									
LT11NL15ISO	11	–	0,8	1,0	1,5	–	–	●	–
LT11NL10ISO	11	–	0,6	0,7	1,0	–	–	●	–
LT16NL30ISO	16	–	1,1	1,5	3,0	–	–	●	–
LT16NL10ISO	16	–	0,6	0,7	1,0	–	–	●	–
LT16NL15ISO	16	–	0,8	1,0	1,5	–	–	●	–
LT16NL20ISO	16	–	1,0	1,3	2,0	–	–	●	–
LT16NL25ISO	16	–	1,1	1,5	2,5	–	–	●	–



ISO Metric-Internal







● first choice
○ alternate choice

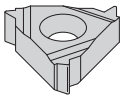
		KC5010	KC5025	KU25T
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

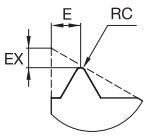
LT-NR-ISOCB

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT11NR075ISOCB	11	–	1,2	0,5	0,75	–	–	●	–
LT11NR10ISOCB	11	–	0,7	0,8	1,0	–	–	●	–
LT11NR125ISOCB	11	–	0,7	0,8	1,25	–	–	●	–
LT11NR15ISOCB	11	–	0,7	0,8	1,5	–	–	●	–
LT16NR10ISOCB	16	–	0,7	0,8	1,0	–	–	●	–
LT16NR15ISOCB	16	–	0,7	0,8	1,5	–	–	●	–
LT16NR20ISOCB	16	–	1,1	1,5	2,0	–	–	●	–
LT16NR25ISOCB	16	–	1,1	1,5	2,5	–	–	●	–

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

● first choice
○ alternate choice

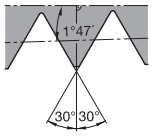




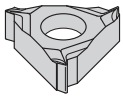


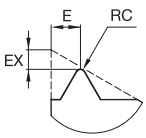
LT-NR/L-NPT

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT11NR14NPT	11	–	0,8	1,0	–	14	●	●	–
LT11NR18NPT	11	–	0,8	1,0	–	18	–	●	–
LT16NR115NPT	16	–	1,1	1,5	–	11.5	●	●	–
LT16NR14NPT	16	–	0,9	1,2	–	14	–	●	–
LT16NR8NPT	16	–	1,3	1,8	–	8	–	●	–



NPT-Internal

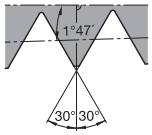




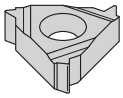


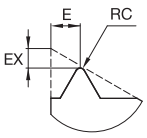
LT-NR-NPTCB

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16NR115NPTCB	16	–	1,1	1,5	–	11.5	–	●	–
LT16NR14NPTCB	16	–	1,4	1,2	–	14	–	●	–



NPTF-Internal





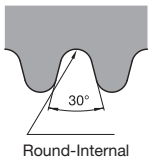


LT-NR/L-NPTF

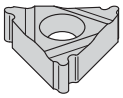
catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT11NR14NPTF	11	–	0,8	0,99	–	14	–	●	–
LT16NR14NPTF	16	–	0,9	1,19	–	14	–	●	–

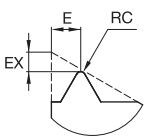
● first choice
○ alternate choice

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



Round-Internal

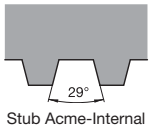




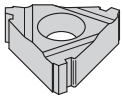


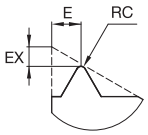
LT-NR/L-RD

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16NR8RD	16	0,70	1,4	1,40	–	8	–	●	–
LT22NR6RD	22	0,93	1,5	1,70	–	6	–	●	–



Stub Acme-Internal

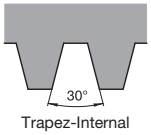




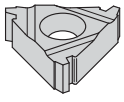


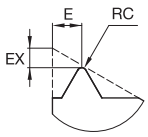
LT-NR/L-STACME

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16NR10STACME	16	–	1,2	1,30	–	10	–	●	–
LT16NR12STACME	16	–	1,1	1,19	–	12	–	●	–
LT16NR14STACME	16	–	1,1	1,09	–	14	–	●	–
LT16NR16STACME	16	–	1,0	0,99	–	16	–	●	–
LT16NR6STACME	16	–	1,7	1,80	–	6	–	●	–
LT16NR8STACME	16	–	1,4	1,50	–	8	–	●	–



Trapez-Internal

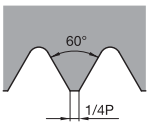




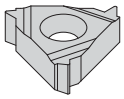


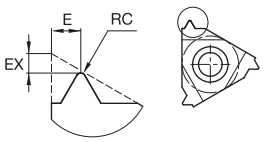
LT-NR/L-TR

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16NR2TR	16	–	1,1	1,30	2,0	–	–	●	–
LT16NR3TR	16	–	1,3	1,50	3,0	–	–	●	–
LT22NR4TR	22	–	1,7	1,91	4,0	–	–	●	–
LT22NR5TR	22	–	2,1	2,50	5,0	–	–	●	–



American
UN-Internal



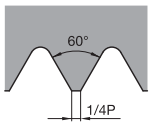


● first choice
○ alternate choice

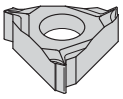
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

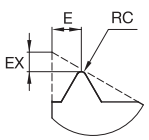
LT-NR/L-UN

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT11NR16UN	11	–	0,9	1,1	–	16	●	●	–
LT11NR18UN	11	–	0,8	1,0	–	18	–	●	–
LT11NR20UN	11	–	0,8	0,9	–	20	–	●	–
LT11NR24UN	11	–	0,7	0,8	–	24	–	●	–
LT11NR28UN	11	–	0,6	0,7	–	28	–	●	–
LT11NR32UN	11	–	0,6	0,6	–	32	–	●	–
LT11NR40UN	11	–	0,6	0,6	–	40	–	●	–
LT16NR10UN	16	–	1,1	1,5	–	10	–	●	–
LT16NR12UN	16	–	1,1	1,4	–	12	●	●	–
LT16NR14UN	16	–	0,9	1,2	–	14	–	●	–
LT16NR16UN	16	–	0,9	1,1	–	16	–	●	–
LT16NR18UN	16	–	0,8	1,0	–	18	–	●	–
LT16NR20UN	16	–	0,8	0,9	–	20	–	●	–
LT16NR24UN	16	–	0,7	0,8	–	24	–	●	–
LT16NR28UN	16	–	0,6	0,7	–	28	–	●	–
LT16NR32UN	16	–	0,6	0,6	–	32	–	●	–
LT16NR8UN	16	–	1,1	1,5	–	8	–	●	–
left hand									
LT11NL32UN	11	–	0,6	0,6	–	32	–	●	–
LT16NL10UN	16	–	1,1	1,5	–	10	–	●	–
LT16NL12UN	16	–	1,1	1,4	–	12	–	●	–
LT16NL16UN	16	–	0,9	1,1	–	16	–	●	–



American
UN-Internal





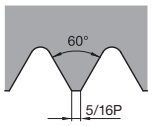


● first choice
○ alternate choice

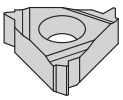
P		●	●	●
M		●	●	●
K		●	●	●
N		○	○	○
S		●	●	●
H		○		

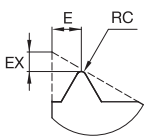
LT-NR-UNCB

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT11NR16UNCB	11	–	0,7	0,8	–	16	–	●	–
LT11NR18UNCB	11	–	0,6	0,8	–	18	–	●	–
LT11NR20UNCB	11	–	0,6	0,8	–	20	–	●	–
LT11NR24UNCB	11	–	0,7	0,8	–	24	–	●	–
LT11NR32UNCB	11	–	1,2	0,5	–	32	–	●	–
LT16NR10UNCB	16	–	1,1	1,5	–	10	–	●	–
LT16NR12UNCB	16	–	1,1	1,5	–	12	–	●	–
LT16NR14UNCB	16	–	1,1	1,5	–	14	–	●	–
LT16NR16UNCB	16	–	0,7	0,8	–	16	–	●	–
LT16NR18UNCB	16	–	0,6	0,8	–	18	–	●	–
LT16NR20UNCB	16	–	0,7	0,6	–	20	–	●	–
LT16NR8UNCB	16	–	1,1	1,5	–	8	–	●	–



UNJ-Internal





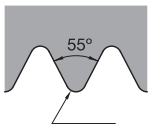


LT-NR/L-UNJ

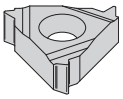
catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT11NR14UNJ	11	–	1,0	1,2	–	14	–	●	–
LT11NR16UNJ	11	–	0,9	1,1	–	16	–	●	–
LT11NR18UNJ	11	–	0,8	1,0	–	18	–	●	–
LT16NR12UNJ	16	–	1,1	1,3	–	12	–	●	–
LT16NR16UNJ	16	–	0,9	1,1	–	16	–	●	–

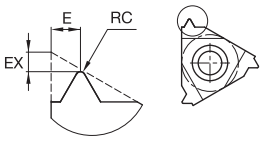
● first choice
○ alternate choice

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



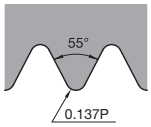
Whitworth BSW,
BSF, BSP-Internal



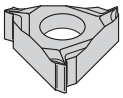


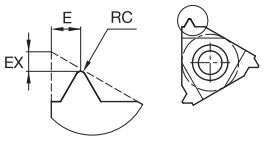
LT-NR/L-W

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT11NR14W	11	–	0,9	1,09	–	14	–	●	–
LT11NR19W	11	–	0,8	0,99	–	19	–	●	–
LT16NR10W	16	–	1,1	1,50	–	10	–	●	–
LT16NR11W	16	–	1,1	1,50	–	11	●	●	–
LT16NR12W	16	–	1,1	1,40	–	12	–	●	–
LT16NR14W	16	–	1,0	1,19	–	14	–	●	–
LT16NR16W	16	–	0,9	1,09	–	16	–	●	–
LT16NR19W	16	–	0,8	0,99	–	19	–	●	–
LT16NR20W	16	–	0,8	0,89	–	20	–	●	–
LT16NR8W	16	–	1,2	1,50	–	8	–	●	–
LT22NR7W	22	–	1,6	2,29	–	7	–	●	–
left hand									
LT16NL11W	16	–	1,1	1,50	–	11	–	●	–



Whitworth BSW,
BSF, BSP-Internal





LT-NR-WCB

catalogue number	insert size	RC	EX	E	thread pitch mm	TPI	KC5010	KC5025	KU25T
right hand									
LT16NR11WCB	16	–	1,3	1,50	–	11	–	●	–
LT16NR14WCB	16	–	1,3	1,50	–	14	–	●	–

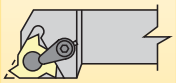
How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding image to easily identify which attributes apply.

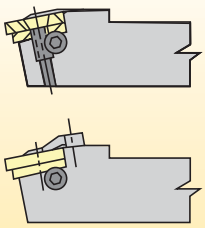


L	S	AS	R		2525M	16	
Insert Style	Insert Holding Method	Tool Style	Hand of Tool	Drop Head	Shank Size	Insert Size	Qualified Surface and Length

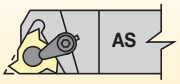
L — Laydown triangle



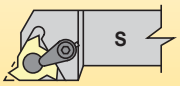
S — Insert screw or clamp only



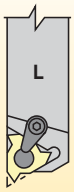
Straight shank



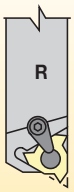
Offset shank

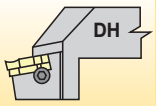


Left hand



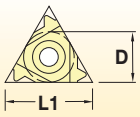
Right hand





Metric:
Shank height and width in mm and holder length according to ISO standard.

Size equals number of 1/8" increments of IC.



inch insert size	metric insert size	D mm	L1 mm
2	11	6,4	11,0
3	16	9,5	16,5
4	22	12,7	22,0

C — qualified back and end, 5" long

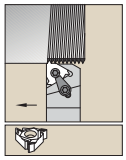
D — qualified back and end, 6" long

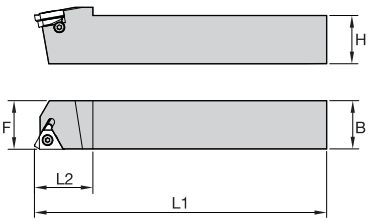
E — qualified back and end, 7" long

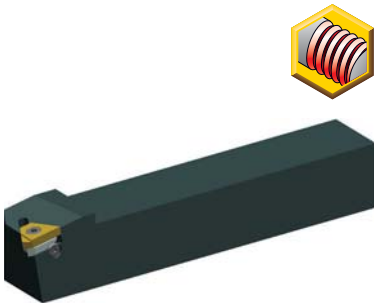
T — qualified back and end, 3.25" long

Q — qualified metric holder

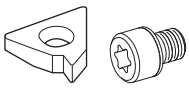
NOTE: Toolholders with primary shank sizes larger than 1/2" or 12mm are supplied with clamp and insert screw. Secure the insert with either the clamp or insert screw. **Do not use both.**
For Threading Shim Catalogue Numbering System, please see page D80.





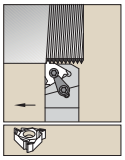


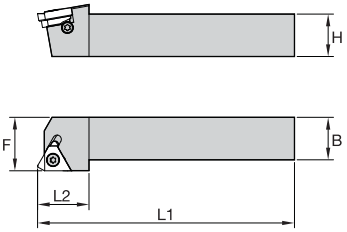
LSA

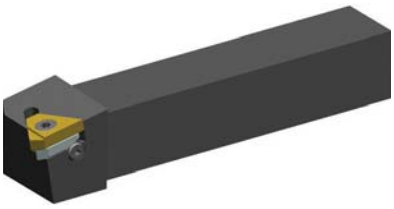




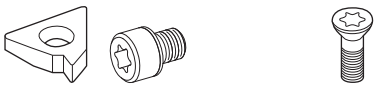
order number	catalogue number	H	B	F	L1	gage insert	shim	shim screw	Torx	Torx	insert screw	Torx
right hand												
1136965	**LSASR1212N16**	12	12	16	85	LT16ER	**–**	**–**	–	–	**SSA3T**	T10
1136984	**LSASR1616H16**	16	16	16	100	LT16ER	**SMYE3**	**SSY3T**	T10	T15	**SSA3T**	T10
1136992	**LSASR2020K16**	20	20	20	125	LT16ER	**SMYE3**	**SSY3T**	T10	T15	**SSA3T**	T10
1137000	**LSASR2525M16**	25	25	25	150	LT16ER	**SMYE3**	**SSY3T**	T10	T15	**SSA3T**	T10
1137007	**LSASR2525M22**	25	25	25	150	LT22ER	**SMYE4**	**SSY4T**	T20	T20	**SSA4T**	T20
1125454	**LSASR3232P16**	32	32	32	170	LT16ER	**SMYE3**	**SSY3T**	T10	T15	**SSA3T**	T10
1611931	**LSASR3232P22**	32	32	32	170	LT22ER	**SMYE4**	**SSY4T**	T20	T20	**SSA4T**	T20
left hand												
1136926	**LSASL1212N16**	12	12	16	85	LT16EL	**–**	**–**	–	–	**SSA3T**	T10
1136935	**LSASL1616H16**	16	16	16	100	LT16EL	**SMYI3**	**SSY3T**	T10	T15	**SSA3T**	T10
1136943	**LSASL2020K16**	20	20	20	125	LT16EL	**SMYI3**	**SSY3T**	T10	T15	**SSA3T**	T10
1136951	**LSASL2525M16**	25	25	25	150	LT16EL	**SMYI3**	**SSY3T**	T10	T15	**SSA3T**	T10
1136959	**LSASL2525M22**	25	25	25	150	LT22EL	**SMYI4**	**SSY4T**	T20	T20	**SSA4T**	T20



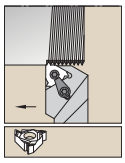


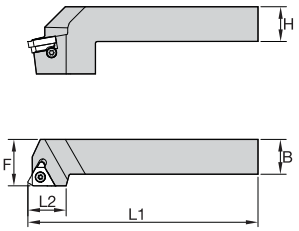


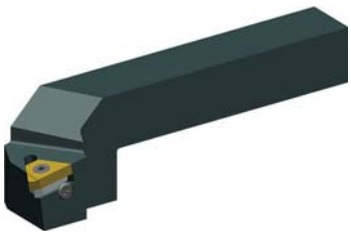
LSS



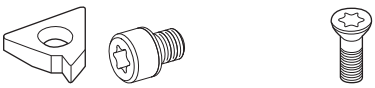
order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	Torx	insert screw	Torx
right hand												
1137054	**LSSR2020K16Q**	20	20	25	125	25	LT16ER	**SMYE3**	**SSY3T**	T10	**SSA3T**	T10
1137063	**LSSR2525M16Q**	25	25	32	150	25	LT16ER	**SMYE3**	**SSY3T**	T10	**SSA3T**	T10
1137069	**LSSR2525M22Q**	25	25	32	150	30	LT22ER	**SMYE4**	**SSY4T**	T20	**SSA4T**	T20
1611933	**LSSR3232P16Q**	32	32	40	170	32	LT16ER	**SMYE3**	**SSY3T**	T10	**SSA3T**	T10
1611935	**LSSR3232P22Q**	32	32	40	170	30	LT22ER	**SMYE4**	**SSY4T**	T20	**SSA4T**	T20
left hand												
1192325	**LSSL2020K16Q**	20	20	25	125	25	LT16EL	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10
1137022	**LSSL2525M16Q**	25	25	32	150	25	LT16EL	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10
1137029	**LSSL2525M22Q**	25	25	32	150	30	LT22EL	**SMYI4**	**SSY4T**	T20	**SSA4T**	T20
1611934	**LSSL3232P16Q**	32	32	40	170	32	LT16EL	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10







LSS-DH



order number	catalogue number	H	B	F	L1	LH	gage insert	shim	shim screw	Torx	insert screw	Torx
right hand												
1174502	**LSSRDH2020K16Q**	20	20	25	125	38	LT16ER	**SMYE3**	**SSY3T**	T10	**SSA3T**	T10
1611938	**LSSRDH2525M16**	25	25	32	150	38	LT16ER	**SMYE3**	**SSY3T**	T10	**SSA3T**	T10
1137036	**LSSRDH2525M22Q**	25	25	32	150	38	LT22ER	**SMYE4**	**SSY4T**	T20	**SSA4T**	T20
left hand												
1611939	**LSSLDH2525M16**	25	25	32	150	38	LT16EL	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10

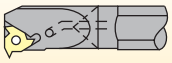
How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding image to easily identify which attributes apply.

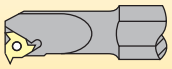


E	16		L	S	E	R	16
Bar Type	Primary Necked Shank Bar Diameter	Secondary (mounting) Bar Diameter	Insert Style	Insert Holding Method	Bar Style	Hand of Tool	Insert Size

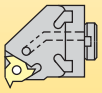
E — Carbide with coolant



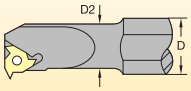
S — Steel shank without coolant



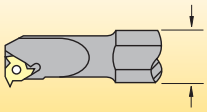
H — Interchangeable head with coolant



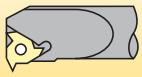
Metric diameter in mm.



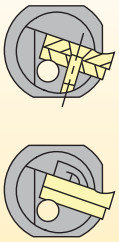
Metric diameter in mm.



L — Laydown triangle



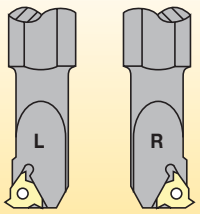
S — Insert screw



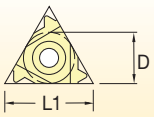
End cutting edge mount



Left Hand / Right Hand



Size equals number of 1/8" increments of IC.



inch insert size	metric insert size	D mm	L1 mm
2	11	6,4	11,0
3	16	9,5	16,5
4	22	12,7	22,0

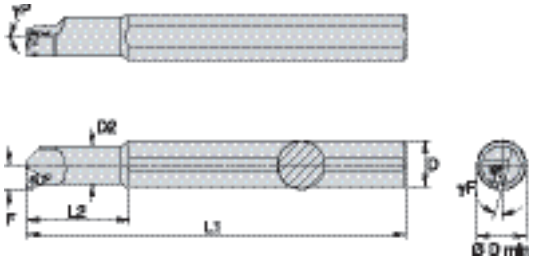
LT Threading Shim Catalogue Numbering System

SM	Y	E	3	2P
Shim	Shim for LT Standard Inserts	Insert Threading	Insert Size	Shim Angle
		E = External **I** = Internal	D value in 1/8"	**2P** = 2º positive **1P** = 1º positive **—** = 0º neutral **1N** = 1º negative **2N** = 2º negative **3N** = 3º negative

For shims and shim kits, see pages D109–D110.

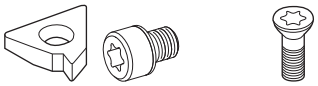


Steel shank with through coolant.

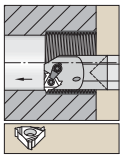




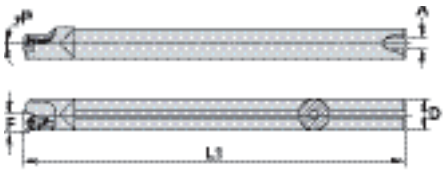
A-LSE



order number	catalogue number	D	D min	D2	F	L1	L2	γF°	γP°	gage insert	shim	shim screw	Torx	insert screw	Torx
right hand															
1131468	**A1020LSER11**	20	13	–	7,3	180	25	-15.0	-1.5	LT11NR	–	–	–	**SSN2T**	T8
1131481	**A1320LSER11**	20	16	–	8,9	180	32	-15.0	-1.5	LT11NR	–	–	–	**SSN2T**	T8
1612581	**A1320LSER16**	20	17	–	10,3	180	32	-15.0	-1.5	LT16NR	–	–	–	**SSA3T**	T10
1798921	**A1616LSER16**	16	20	16,0	11,3	150	32	-15.0	-1.5	LT16NR	–	–	–	**SSA3T**	T10
1131509	**A1620LSER16**	20	20	–	11,7	180	36	-15.0	-1.5	LT16NR	–	–	–	**SSA3T**	T10
1131524	**A2020LSER16**	20	24	20,0	13,4	180	40	-15.0	-1.5	LT16NR	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10
1131547	**A2525LSER16**	25	29	–	16,1	200	45	-15.0	-1.5	LT16NR	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10
1131566	**A2525LSER22**	25	32	–	17,2	200	45	-15.0	-1.5	LT22NR	**SMYI4**	**SSY4T**	T20	**SSA4T**	T20
1612584	**A2020LSER22**	20	27	20,0	15,6	180	50	-15.0	-1.5	LT22NR	–	–	–	**SSA4T**	T20
1131574	**A2532LSER16**	32	29	–	16,3	250	60	-15.0	-1.5	LT16NR	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10
1131582	**A2532LSER22**	32	32	–	17,4	250	60	-15.0	-1.5	LT22NR	**SMYI4**	**SSY4T**	T20	**SSA4T**	T20
1612587	**A3232LSER22**	32	39	32,0	21,5	250	60	-15.0	-1.5	LT22NR	**SMYI4**	**SSY4T**	T20	**SSA4T**	T20
1798922	**A4040LSER22**	40	47	40,0	25,8	300	60	-15.0	-1.5	LT22NR	**SMYI4**	**SSY4T**	T20	**SSA4T**	T20
1798920	**A1010LSER11**	10	13	10,0	7,3	100	100	-15.0	-1.5	LT11NR	–	–	–	**SSN2T**	T8
left hand															
1612586	**A2532LSEL16**	32	29	–	16,3	250	–	-15.0	-1.5	LT16NL	**SMYE3**	**SSY3T**	T10	**SSA3T**	T10
1131458	**A1020LSEL11**	20	13	–	7,3	180	25	-15.0	-1.5	LT11NL	–	–	–	**SSN2T**	T8
1131476	**A1320LSEL11**	20	16	–	8,9	180	32	-15.0	-1.5	LT11NL	–	–	–	**SSN2T**	T8
1798980	**A1616LSEL16**	16	20	16,0	11,3	150	32	-15.0	-1.5	LT16NL	–	–	–	**SSA3T**	T10
1131499	**A1620LSEL16**	20	20	–	11,5	180	40	-15.0	-1.5	LT16NL	–	–	–	**SSA3T**	T10
1131516	**A2020LSEL16**	20	24	20,0	13,4	180	40	-15.0	-1.5	LT16NL	**SMYE3**	**SSY3T**	T10	**SSA3T**	T10
1131532	**A2525LSEL16**	25	29	–	16,1	200	45	-15.0	-1.5	LT16NL	**SMYE3**	**SSY3T**	T10	**SSA3T**	T10
1131540	**A2525LSEL22**	25	32	–	17,2	200	45	-15.0	-1.5	LT22NL	**SMYE4**	**SSY4T**	T20	**SSA4T**	T20
1612585	**A2020LSEL22**	20	27	20,0	15,6	180	50	-15.0	-1.5	LT22NL	–	–	–	**SSA4T**	T20
1612588	**A3232LSEL22**	32	39	32,0	21,5	250	60	-15.0	-1.5	LT22NL	**SMYE4**	**SSY4T**	T20	**SSA4T**	T20
1799093	**A4040LSEL22**	40	47	40,0	25,8	300	60	-15.0	-1.5	LT22NL	**SMYE4**	**SSY4T**	T20	**SSA4T**	T20
1798979	**A1010LSEL11**	10	13	10,0	7,3	100	100	-15.0	-1.5	LT11NL	–	–	–	**SSN2T**	T8

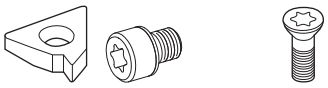


Carbide shank with through coolant.



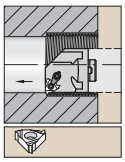


E-LSE

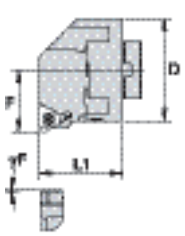


order number	catalogue number	D	D min	F	L1	A	γF°	γP°	gage insert	shim	shim screw	Torx	insert screw	Torx
right hand														
1152844	**E16RLSER16**	16	20	11,5	200,0	6	-15	-1.5	LT16NR	**—**	**—**	—	**SN3TPKG**	T10
1152846	**E20SLSER16**	20	24	13,4	250,0	7	-15	-1.5	LT16NR	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10
1152848	**E25TLSER16**	25	29	15,8	300,0	8	-15	-1.5	LT16NR	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10

NOTE: Items listed without a shim are designed for a 1.5° inclination angle.

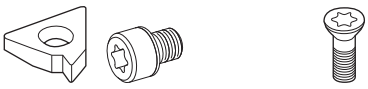


With through coolant.



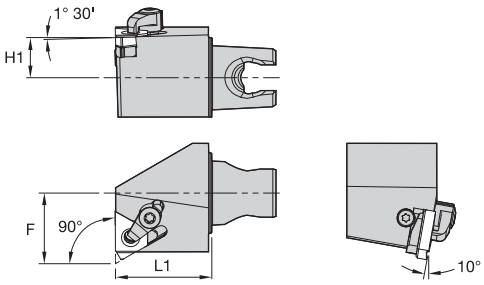


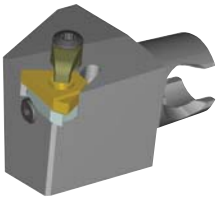
H-LSE



order number	catalogue number	D	D min	L1	F	γF°	γP°	gage insert	shim	shim screw	Torx	insert screw	Torx
right hand													
1095216	**H16LSER3**	25	30,5	41,3	16,4	-15.0	-1.5	LT16NR	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10
1095218	**H20LSER3**	32	36,8	41,3	19,3	-15.0	-1.5	LT16NR	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10
1095220	**H24LSER3**	38	44,7	41,3	22,5	-15.0	-1.5	LT16NR	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10
1095224	**H24LSER4**	38	45,3	41,3	24,7	-15.0	-1.5	LT22NR	**SMYI4**	**SSY4T**	T20	**SSA4T**	T20
1803997	**H40LSER22**	40	47,0	41,3	25,9	-15.0	-1.5	LT22NR	**SMYI4**	**SSY4T**	T20	**SSA4T**	T20
1803995	**H50LSER16**	50	54,0	41,3	28,6	-15.0	-1.5	LT16NR	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10
1803999	**H50LSER22**	50	56,0	41,3	30,5	-15.0	-1.5	LT22NR	**SMYI4**	**SSY4T**	T20	**SSA4T**	T20
3842905	**H50LSER27**	50	58,0	41,3	31,4	-15.0	-1.5	LT27NR	**SMYI5**	**SSY5T**	T25	**SSA5T**	T25
1095222	**H32LSER3**	51	61,0	41,3	32,4	-15.0	-1.5	LT16NR	**SMYI3**	**SSY3T**	T10	**SSA3T**	T10
1095226	**H32LSER4**	51	61,0	41,3	32,4	-15.0	-1.5	LT22NR	**SMYI4**	**SSY4T**	T20	**SSA4T**	T20
3842895	**H32LSER5**	51	61,0	41,3	32,5	-15.0	-1.5	LT27NR	**SMYI5**	**SSY5T**	T25	**SSA5T**	T25
3842897	**H40LSER5**	64	77,0	41,3	38,9	-15.0	-1.5	LT27NR	**SMYI5**	**SSY5T**	T25	**SSA5T**	T25

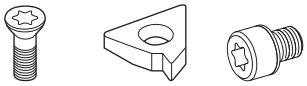
NOTE: For boring adaptors, see pages B386.



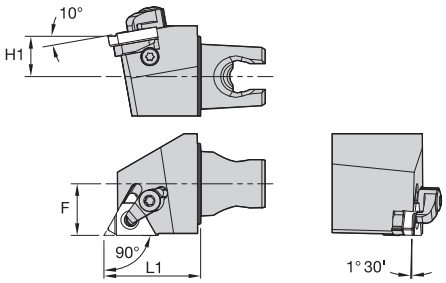


Clamp shown in images is no longer available.

LSE • End Mount



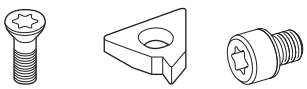
order number	catalogue number	L1	F	H1	gage insert	insert screw	shim	shim screw
right hand								
2399506	**KM25LSER1630**	30	22	12,5	LT16EL	**SSA3T**	**SMYI3**	**SSY3T**
left hand								
2399507	**KM25LSEL1630**	30	22	12,5	LT16ER	**SSA3T**	**SMYE3**	**SSY3T**





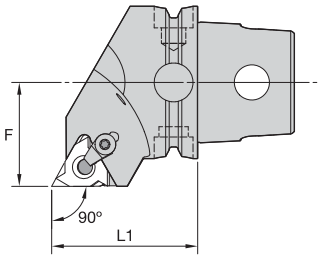
Clamp shown in images is no longer available.

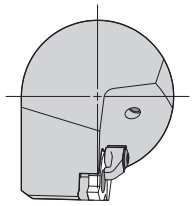
LSS • Side Mount

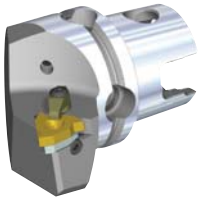


order number	catalogue number	L1	F	H1	gage insert	insert screw	shim	shim screw
right hand								
2399504	**KM25LSSR1630**	30	16	12,5	LT16ER	**SSA3T**	**SMYE3**	**SSY3T**
3176219	**KM25LSSR2230**	30	16	12,5	LT22ER	**SSA4T**	**SMYE4**	**SSY4T**
left hand								
2399505	**KM25LSSL1630**	30	16	12,5	LT16EL	**SSA3T**	**SMYI3**	**SSY3T**
3176220	**KM25LSSL2230**	30	16	12,5	LT22EL	**SSA4T**	**SMYI4**	**SSY4T**

KM QUICK CHANGE







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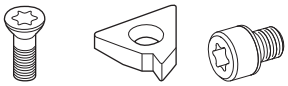
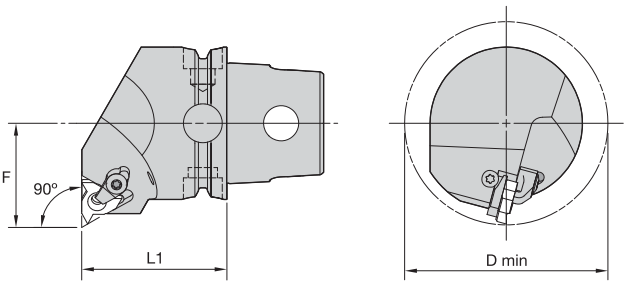
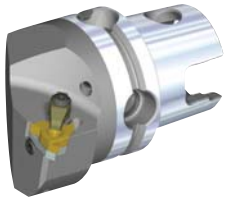
LSS 90°



order number	catalogue number	L1 mm	L1 in	F mm	F in	gage insert	insert screw	shim	shim screw	kg	lbs
right hand											
3950857	**KM40TSLSSR16**	40	1.575	27	1.063	LT16ER	**SSA3T**	**SMYE3**	**SSY3T**	0,31	.68
3950858	**KM40TSLSSR22**	40	1.575	27	1.063	LT22ER	**SSA4T**	**SMYE4**	**SSY4T**	0,30	.66
3959401	**KM40TSLSSR27**	45	1.772	27	1.063	LT27ER	**SSA5T**	**SMYE5**	**SSY5T**	0,37	.82
left hand											
3950855	**KM40TSLSSL16**	40	1.575	27	1.063	LT16EL	**SSA3T**	**SMYI3**	**SSY3T**	0,32	.70
3950856	**KM40TSLSSL22**	40	1.575	27	1.063	LT22EL	**SSA4T**	**SMYI4**	**SSY4T**	0,31	.68
3959400	**KM40TSLSSL27**	45	1.772	27	1.063	LT27EL	**SSA5T**	**SMYI5**	**SSY5T**	0,37	.82







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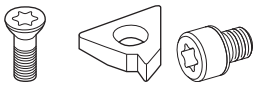
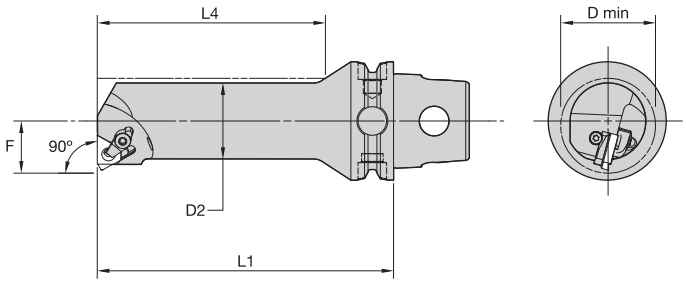
KM QUICK CHANGE

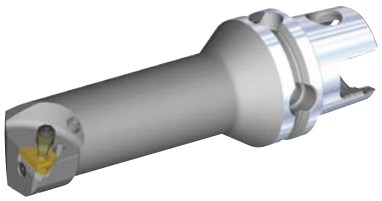
LSE-N 90° • Internal Only



order number	catalogue number	L1 mm	L1 in	F mm	F in	D min mm	D min in	gage insert	insert screw	shim	shim screw	kg	lbs
right hand													
3950832	**KM40TSLSER16N**	40	1.575	27	1.063	54	2.126	LT16NR	**SSA3T**	**SMYI3**	**SSY3T**	0,35	.77
3950854	**KM40TSLSER22N**	40	1.575	27	1.063	54	2.126	LT22NR	**SSA4T**	**SMYI4**	**SSY4T**	0,35	.77
3959399	**KM40TSLSER27N**	45	1.772	27	1.063	54	2.126	LT27NR	**SSA5T**	**SMYI5**	**SSY5T**	0,39	.86
left hand													
3950831	**KM40TSLSEL16N**	40	1.575	27	1.063	54	2.126	LT16NL	**SSA3T**	**SMYE3**	**SSY3T**	0,35	.77







Clamp shown in images is no longer available.

KM QUICK CHANGE

LSE 90°

order number	catalogue number	D2 mm	D2 in	D min mm	D min in	F mm	F in	L4 mm	L4 in	L1 mm	L1 in	gage insert	kg	lbs
right hand														
3955464	**KM40TSS10DLSER11**	10	.39	13	.51	7	.276	35	1.38	60	2.362	LT11NR	0,22	.49
3955466	**KM40TSS12ELSER11**	12	.47	16	.63	9	.354	42	1.66	70	2.756	LT11NR	0,25	.56
3955468	**KM40TSS16FLSER16**	16	.63	20	.79	11	.433	56	2.21	80	3.150	LT16NR	0,28	.61
3955470	**KM40TSS20GLSER16**	20	.79	25	.98	13	.512	70	2.76	90	3.543	LT16NR	0,34	.75
3955472	**KM40TSS25HLSER16**	25	.98	32	1.26	17	.669	75	2.95	100	3.937	LT16NR	0,50	1.11
3955474	**KM40TSS32JLSER16**	32	1.26	40	1.57	22	.866	96	3.78	110	4.331	LT16NR	0,72	1.58
3955476	**KM40TSS32JLSER22**	32	1.26	40	1.57	22	.866	96	3.78	110	4.331	LT22NR	0,71	1.56
left hand														
3955463	**KM40TSS10DLSEL11**	10	.39	13	.51	7	.276	35	1.38	60	2.362	LT11NL	0,22	.49
3955465	**KM40TSS12ELSEL11**	12	.47	16	.63	9	.354	42	1.65	70	2.756	LT11NL	0,25	.55
3955469	**KM40TSS20GLSEL16**	20	.79	25	.98	13	.512	70	2.76	90	3.543	LT16NL	0,34	.75
3955471	**KM40TSS25HLSEL16**	25	.98	32	1.26	17	.669	75	2.95	100	3.937	LT16NL	0,50	1.11
3955473	**KM40TSS32JLSEL16**	32	1.26	40	1.57	22	.866	96	3.78	110	4.331	LT16NL	0,72	1.58
3955475	**KM40TSS32JLSEL22**	32	1.26	40	1.57	22	.866	96	3.78	110	4.331	LT22NL	0,71	1.56

NOTE: Items listed without a shim are designed for a 1,5° inclination angle.

Spare Parts



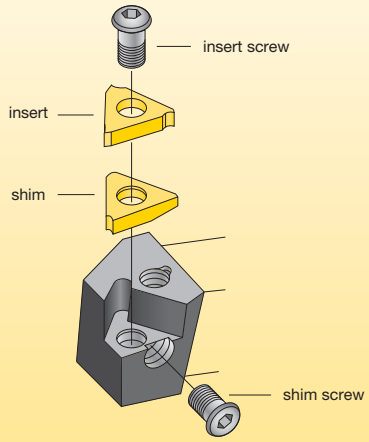


catalogue number	insert screw	shim	shim screw
right hand			
KM40TSS10DLSER11	**SSN2T**	**–**	**–**
KM40TSS12ELSER11	**SSN2T**	**–**	**–**
KM40TSS16FLSER16	**SN3TPKG**	**–**	**–**
KM40TSS20GLSER16	**SSA3T**	**SMYI3**	**SSY3T**
KM40TSS25HLSER16	**SSA3T**	**SMYI3**	**SSY3T**
KM40TSS32JLSER16	**SSA3T**	**SMYI3**	**SSY3T**
KM40TSS32JLSER22	**SSA4T**	**SMYI4**	**SSY4T**
left hand			
KM40TSS10DLSEL11	**SSN2T**	**–**	**–**
KM40TSS12ELSEL11	**SSN2T**	**–**	**–**
KM40TSS20GLSEL16	**SSA3T**	**SMYE3**	**SSY3T**
KM40TSS25HLSEL16	**SSA3T**	**SMYE3**	**SSY3T**
KM40TSS32JLSEL16	**SSA3T**	**SMYE3**	**SSY3T**
KM40TSS32JLSEL22	**SSA4T**	**SMYE4**	**SSY4T**

Laydown Threading Toolholders

In all cases, the proper shim selection is important.

Kennametal toolholders are supplied with a shim for a 1.5° lead angle. Change the shim if your thread is more than 1° different.
For more details on proper shim selections, see pages D109–D110.



insert size and screw	insert screw	shim	shim screw and washer
3ER	SS-A3T	SM-YIE3	SS-Y3T
3EL	SS-A3T	SM-YI3	SS-Y3T
4ER	SS-A4T	SM-YIE4	SS-Y4T
4EL	SS-A4T	SM-YI4	SS-Y4T
Laydown Threading boring bars			
2IR	SS-N2T	–	–
2IL	SS-N2T	–	–
3IR	SS-A3T	SM-YI3	SS-Y3T
3IL	SS-A3T	SM-YIE3	SS-Y3T
4IR	SS-A4T	SM-YI4	SS-Y4T
4IL	SS-A4T	SM-YIE4	SS-Y4T

SM	—	Y	E	3	—	2N
Shim		Y-shim for Laydown standard inserts	E – External I – Internal	IC –16mm		Shim Angle

2P	2° positive
1P	1° positive
–	0°
1N	1° negative
2N	2° negative
3N	3° negative

resultant angle		3.5°	2.5°	1.5°	0.5°	-0.5°	-1.5°
insert size (IC)	toolholder	shim ordering code					
16mm	ex. RH/in. LH ex. LH/in. RH	SM-YE3-2P SM-YI3-2P	SM-YE3-1P SM-YI3-1P	SM-YE3 SM-YI3	SM-YE3-1N SM-YI3-1N	SM-YE3-2N SM-YI3-2N	SM-YE3-3N SM-YI3-3N
22mm	ex. RH/in. LH ex. LH/in. RH	SM-YE4-2P SM-YI4-2P	SM-YE4-1P SM-YI4-1P	SM-YE4 SM-YI4	SM-YE4-1N SM-YI4-1N	SM-YE4-2N SM-YI4-2N	SM-YE4-3N SM-YI4-3N

Slanted Shim Kit

Because you might occasionally need different shims than those supplied with our standard toolholders, we strongly recommend that shim kits be readily available in every tool shop.

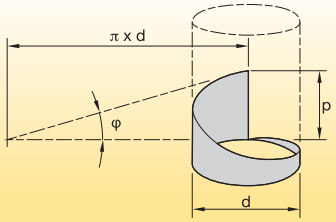
insert size	shim size (D)	ordering code	contains slanted shims
3x	16mm	ABY3SET	SM-YE3-2P, 1P, 1N, 2N, 3N SM-YI3-2P, 1P, 1N, 2N, 3N
4x	22mm	ABY4	SM-YE4-2P, 1P, 1N, 2N, 3N SM-YI4-2P, 1P, 1N, 2N, 3N

The Helix Angle

Example:
d = 48,06mm (1.892")
p = 3,175mm (.125")

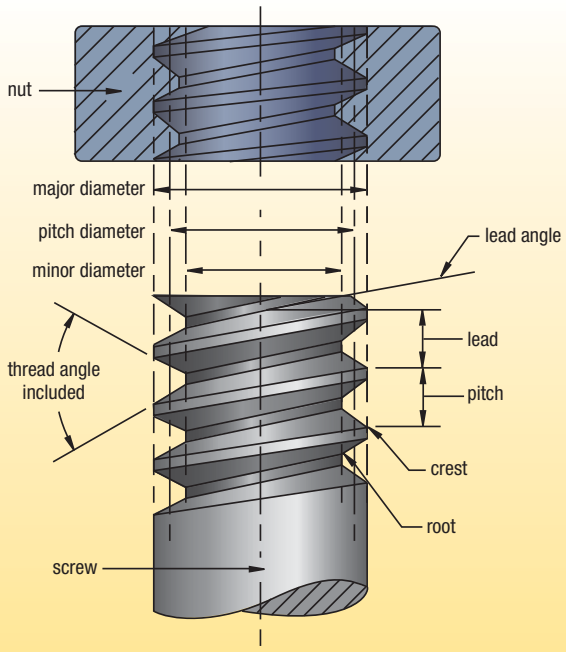
ϕ = Helix angle
p = pitch
d = pitch diameter

$$\phi = \arctan\left(\frac{p * starts}{\pi * \varnothing}\right) = 1.13°$$



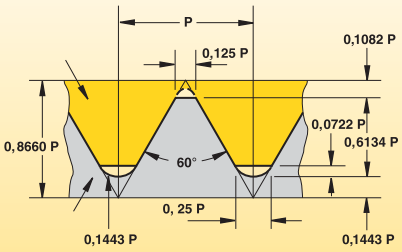
Screw Thread Definitions

1. **Major diameter** — The largest diameter of a straight screw thread. This applies to both internal and external threads.
2. **Pitch diameter** — On a straight thread, it is the diameter which passes through the thread profiles at such points which make the thread width of the groove equal to one-half of the basic pitch. On a "perfect thread," this occurs at the point where the widths of the thread and groove are equal.
3. **Thread angle (included)** — The included angle between the individual flanks of the thread form.
4. **Minor diameter** — The smallest diameter of a straight screw thread. This applies to both internal and external threads.
5. **Lead angle** — On a straight thread, the lead angle is the angle created by the helix of the thread at the pitch diameter with a plane perpendicular to the axis.
6. **Lead** — The distance a screw thread advances axially in one revolution. On a single start, the pitch and lead are identical. The lead is equal to the pitch times the number of starts.
7. **Pitch** — The distance from a point on a screw thread to a corresponding point on the next thread measured parallel to the thread axis.
8. **Crest** — The outer most surface of the thread form which joins the flanks.
9. **Root** — The inner most surface of the thread form which joins the flanks.



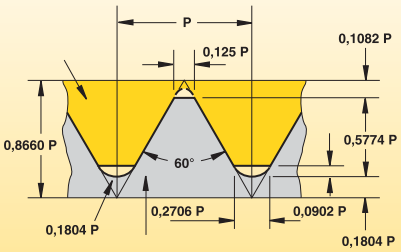
NOTE: Threads per inch (TPI) not shown:
The number of threads per inch measured axially.
The terms pitch and TPI are often used interchangeably. TPI = 1/pitch

ISO M (Metric) and UN (Unified National)



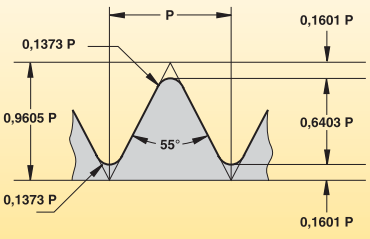
Use: All branches of mechanical industry.

UNJ (controlled root radius)



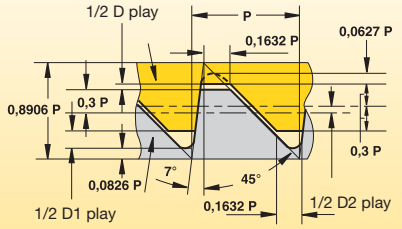
Use: Aircraft and space industry.

Whitworth (BSW)



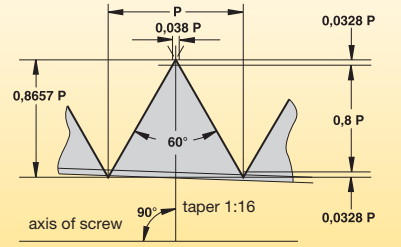
Use: Fittings and pipe couplings for gas, water, and sewer lines (replaced by ISO).

American Buttress



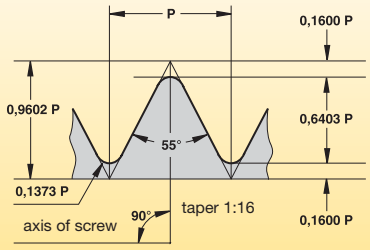
Use: Fittings and pipe couplings.

NPT (American National Pipe Thread)



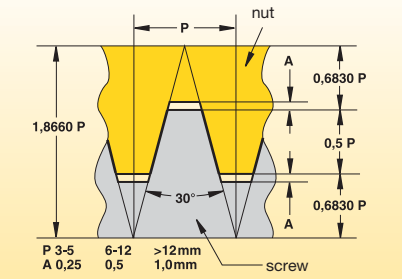
Use: Fittings and pipe couplings.

BSPT (British Standard Pipe Thread)



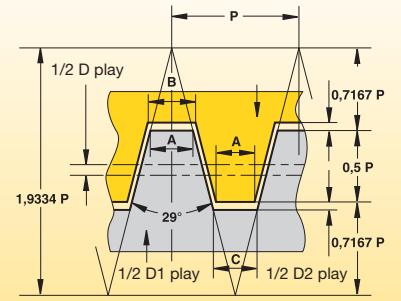
Use: Pipe thread for steam, gas, and water lines.

TR DIN 103



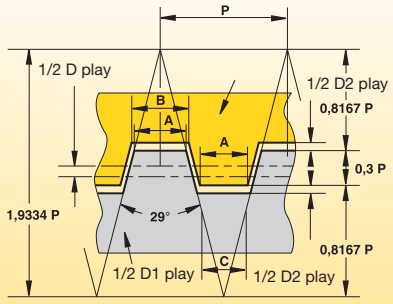
Use: Mechanical industry for motion transmission screws.

Acme



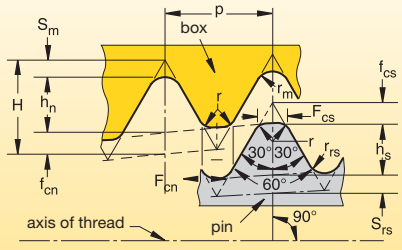
A = 0,0307 P
B = 0,3707 P—x D play
C = 0,3707 P—(D1 play—D2 play)
Use: Acme-General is used in mechanical industry for motion transmission screws.

Acme, truncated (Stub)



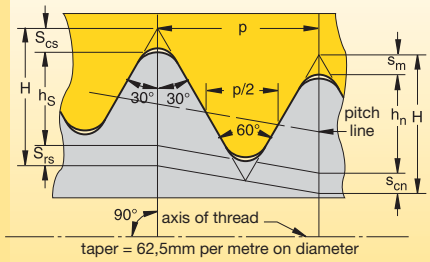
A = 0,4224 P
B = 0,4224 P—x D play
C = 0,4224 P—(D1 play—D2 play)
Use: Where normal Acme is too deep.

API Rotary Shoulder Connection



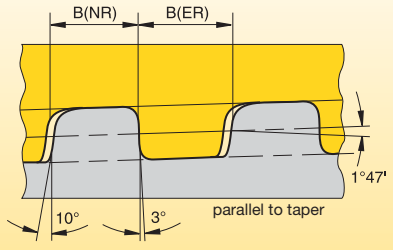
NOTE: Taper shown exaggerated.

API Casing and Tubing Round Thread Form



NOTE: Taper shown exaggerated.

API Buttress

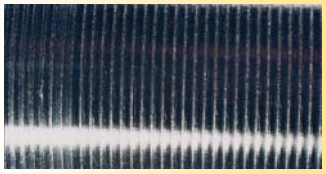


Suggested Grades and Speeds for Threading Various Workpiece Materials

workpiece group	workpiece material	recommended surface speed — m/mm				
		uncoated	PVD coated			
		K68	KC5010	KC5025	KC5410	KU25T
free-machining carbon steel	10L18, 10L45, 1213, 12L13, 12L14, 1140, 1141, 11L44, 1151, 10L50	—	91–198	45–198	—	91–137
plain carbon steel	10063, 1008, 1010, 1015, 1018, 1020, 1025, 1026, 1108, 1117	—	76–198	45–175	—	76–122
alloy steels/tool steels 150–325 HB (up to 35 HRC)	1042, 1045, 1070, 1080, 1085, 1090, 1095, 1541, 1561, 1572, 5140, 8620, W1, O1, S1, P20, H13, D2, A6, H13, L6	—	76–198	38–167	—	73–122
alloy steels/tool steels 330–450 HB (36–47 HRC)		—	61–160	—	—	61–106
martensitic/ferritic stainless/precipitation hardening	416, 420F, 440F, 405, 409, 429, 430, 434, 436, 442, PH	—	45–160	30–122	—	24–61
austenitic stainless steel	201, 202, 301, 302, 303, 304, 304, 305, 321, 347, 348, 310, 314, 316, 316L, 330	61–106	61–198	46–137	—	24–106
grey cast iron 135–270 HB	class 20, 30, 35, 45	61–91	61–237	46–122	—	30–110
grey cast iron 275–450 HB	class 50, 55, 60	45–76	45–175	15–76	—	30–110
alloy/ductile iron	A536, J434C, 60-40-18, 80-55-06, 100-70-03	45–76	45–198	30–160	—	30–110
free-machining aluminium alloys	2024-T4, 2014-T6, 6061-T6 2011-T3, 3003-H18, A2, Alcan, Alcoa 510, Duralumin	122–244	122–365	—	152–457	30–305
high-silicon aluminium alloys	A380, A390, A380-1, A390-1, A380-2	—	—	—	—	—
copper/zinc/brass		76–183	76–304	46–236	—	30–244
non-metallics	Graphite, Nylon, Plastics, Rubbers, Phenolics, Carbon	122–457	122–396	46–305	—	30–244
high-temperature alloys 125–269 HB (up to 27 HRC)	Nickel 200, Monel, R405, Monel K500, INCONEL 600, INCONEL® 625/901x750/718, Waspaloy, Hastelloy C	24–37	24–122	13–76	—	11–85
high-temperature alloys 260–450 HB (26–47 HRC)	Rene 95, Waspaloy A286, Incoloy 800, Haynes 188, Stellite F, Haynes 25	24–30	30–76	6–61	—	11–61
titanium alloys	Ti-6Al-4V, TI-5Al-2.5Sn	34–55	34–99	—	—	11–76

NOTE: When workpiece hardness levels are at the top of a range, starting m/mm should be at the lower end. Regularly inspect insert clamps for worn flats.

Edge preparation:
Uncoated — sharp
PVD coated — light hone except positive top rake, top rake-sharp

problem	cause	possible solution
thread with torn finish 	• Burs. • Torn finish. • Steps. • Improper shim. • Improper infeed.	• Use modified flank infeed. • Use full profile insert. • Increase coolant concentration. • Increases m/min. • Check machine “Z” travel axis. • Check insert form. • Check for correct shim in LT system. • Calculate flank clearance.
chatter 	• Poor rigidity. • Insert movement. • Improper infeed. • Off centreline.	• Use modified flank infeed. • Minimise tool overhang. • Check for workpiece deflection. • Check insert and clamp. • Verify that tool cutting position is at workpiece centreline. • Adjust number of passes. Fewer passes reduce chatter.
built-up edge 	• Speed too low. • Insufficient coolant. • Chip load.	• Increase m/min. • Increase coolant concentration and/or flow. • Adjust infeed angle. • Increase depth of cut per pass.
deformation 	• Wrong grade. • Speed too high. • Improper infeed angle. • Insufficient coolant.	• Use modified flank infeed. • Use a more wear-resistant grade (e.g., KC5010™). • Reduce m/mm. • Increase coolant flow.
chipping  	• Improper infeed. • Chip load. • Wrong grade. • Incorrect speed. • Poor rigidity.	• Use modified flank infeed. • Increase or decrease number of passes. • Eliminate spring passes. • Use tougher grade (e.g., KC5025™). • Increase m/mm if chipping on trailing edge. • Decrease m/mm if chipping on leading edge. • Minimise tool overhang. • Check for insert movement/check clamp. Torque screw or clamp to correct value. • Check for possible part deflection. • Calculate flank clearance. • Ensure correct shim.
broken nose 	• Heavy chip load. • Small nose radius. • Wrong grade. • Improper infeed.	• Use modified flank infeed. • Decrease chip load. • Use large nose radius if possible. • Use tougher grade (e.g., KC5025).
flank wear 	• Improper shim. • Wrong grade. • Insufficient coolant. • Off centreline. • Insufficient flank clearance. • Improper infeed angle.	• Ensure correct shim. • Use a more wear-resistant grade (e.g., KC5025). • Increase coolant flow. • Check the centreline height of the tool. (The smaller the diameter, the more critical the need for centreline accuracy.) • Calculate flank clearance and change shim to increase clearance on worn flank. • If wear is on trailing flank, increase infeed angle clearance.

(continued)

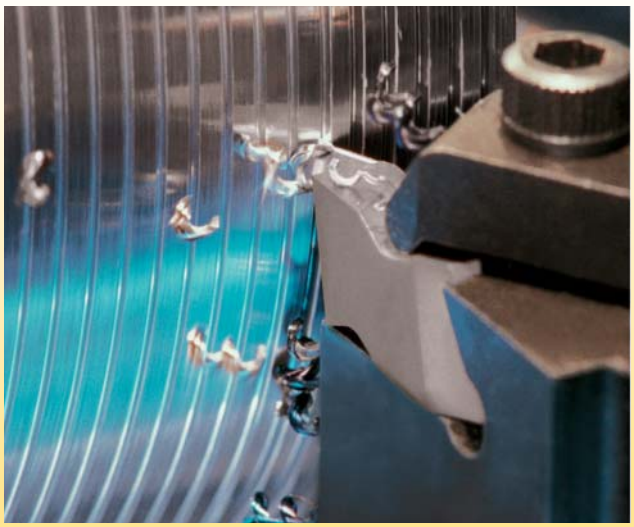
(Technical Information • Failure and Solution Guide — continued)

problem	possible solution																	
	increase m/min	reduce m/min	increase chip load	decrease chip load where failure occurs	use tougher carbide grade	use harder carbide grade	apply coolant	use coated carbide	use topping insert	change infeed angle	check for insert movement and reseat	reduce tool overhang	reselect shim	apply chipbreaker style	reduce DOC	adjust centre height	begin cutting threads 12mm before workpiece	change infeed method
chatter	•			•							•	•				•		•
bur on crest	•								•									•
short tool life		•	•	•		•		•										•
chipped leading edge			•	•	•													
chipped trailing edge					•					•								
broken nose (first pass)	•														•	•		
broken nose (after first pass)				•	•					•			•					•
built-up on cutting edge	•		•				•	•										•
premature topping													•					
splitting threads																	•	
poor chip evacuation														•				•

Kennametal insert technology brings chip control to your threading operations with the Top Notch™ platform. The proprietary Kennametal recessed chip groove, when used according to our recommendations, controls the chip in most applications. Our positive rake design lowers cutting pressures, which in turn lowers damaging heat generation thus providing better tool life. Long, stringy chips no longer mar the workpiece surface finish. The danger to operators when removing long chips from the workpiece and chuck is eliminated. All of these benefits combine to improve the productivity of your threading operations.

The Last Pass

Some CNC controls require the last pass to be at a 0° infeed angle because the chip will not break on the last pass. On most carbon and alloy steels, the last pass can remain at 0,127mm depth of cut and produce an acceptable finish. For some materials, a 0,025mm to 0,076mm (spring) pass may be used to improve surface finish, however, chip breaking action may be compromised.

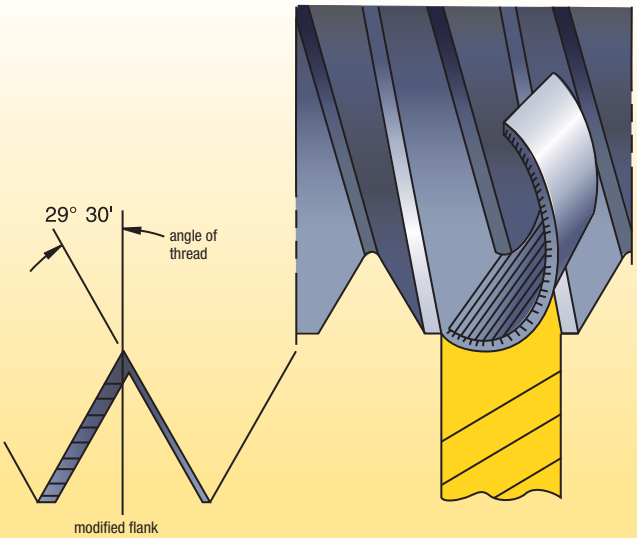


Machine Programming

Modern CNC controls allow the programmer to easily adjust infeed angle, the number of passes, and depth of cut for each pass. The chip control threading insert performs best at an infeed angle of 29° 30', although 15° to 30° is acceptable. Also, it is important to maintain a minimum of 0,127mm depth of cut on every pass. In most applications, use of CNC canned cycles produce only marginally successful results. Custom written programmes are better and are recommended.

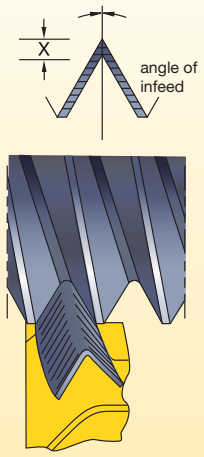
Infeed Angle

In order to effectively and consistently break the chip, it is important to use an infeed angle between 28° and 29° 30'. Do not apply chip control inserts at infeed angles less than 15°.



Radial

modified flank



Advantage —

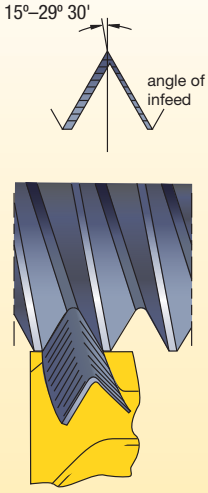
- Cutting on both sides of the thread form places all of the cutting edge in the cut and protects edge from chipping.
- Even wear on the insert.

Disadvantage —

- Tool develops a channel chip that may be difficult to handle.
- Tip chipping occurs when cutting high-tensile materials.
- Bur condition is increased.
- Entire cutting edge is engaged at finish of thread, causing increased tendency to chatter.

Modified flank

modified flank



Advantage —

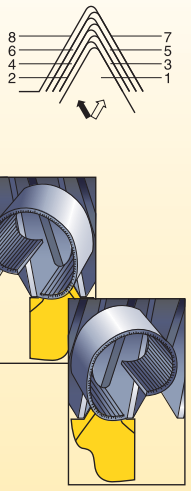
- Tool cuts both sides of thread form, so it is protected from chipping similar to 0° infeed. Channel-type chip develops, but uneven chip thickness helps remove the chip similar to flank infeed.
- This is the preferred method, especially when used with a chip control insert.
- Combined radial and/or alternating flank infeed.
- Results in good tool life, with wear evenly distributed over both flanks.

Disadvantage —

- Similar disadvantages as with 0° infeed, although reduced somewhat in magnitude as cutting forces are better equalised and chip flow is much less of a problem.

Alternating flank

alternating flank



Advantage —

- Increased tool life because both edges are used equally.

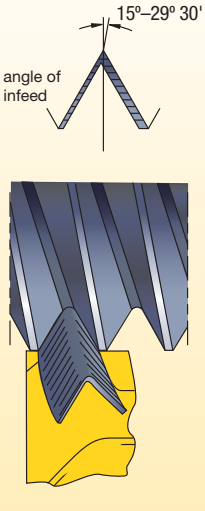
NOTE: Some machine tools may require special programming techniques to achieve this method of infeed.

Disadvantage —

- Difficult to cut on conventional machinery.

Reversed modified flank

modified flank



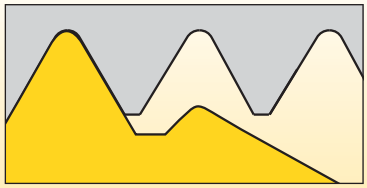
Advantage —

- Tool cuts both sides of thread form, so it is protected from chipping similar to 0° infeed. Channel-type chip develops, but uneven chip thickness helps remove the chip similar to flank infeed.
- This is the preferred method, especially when used with a chip control insert.
- Combined radial and/or alternating flank infeed.
- Results in good tool life, with wear evenly distributed over both flanks.
- As chip flow is the reversed feed direction, it is an excellent choice for internal threading.

Disadvantage —

- Programming needs to be done line by line.

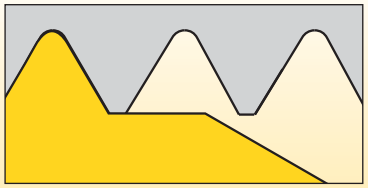
Partial Profile



Tooth profile with universal profile shape:

- Reduced inventory.
- For various pitches in a limited range.
- Major/minor diameters must be accurately pre-turned.

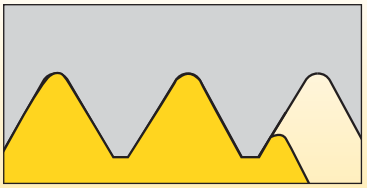
Full Profile



Tooth profile with full profile shape including tooth height:

- For bur-free, precise threads in the specified pitch.
- General application.
- Machining allowance for outside/core diameter around .004–.006".

Multi-Tooth Profile



Multi-tooth full profile generally with 2–3 teeth:

- Highly productive threading with fewer passes and longer tool life.
- Requires a rigid setup and long thread pass through.

Formulas

Metric Formula		
to find	**given**	**formula**
m/min	D (mm) RPM	$m/min = \frac{\pi \times D}{1000} \times RPM$
RPM	D (mm) m/min	$RPM = \frac{m/min \times 1000}{D \times \pi}$

Legend

m/min	=	metres per minute
RPM	=	revolutions per minute
D	=	part diameter
π	=	3.1416

Maximum Cutting Speeds

On older machines cutting speed is often limited by the maximum travel speed (IPM or mm/min) of the tool allowed by the machine. Check your maximum speed with the following formulas:

metric formula: maximum cutting speed (m/min) =
part diameter (mm) x 3.14 x (1/pitch) x $\frac{\text{max mm/min}}{1000\text{mm}}$

Flank clearance

γ = arctan (sin (β/2) * tan(α))
γ = side (flank) clearance
β = included angle of thread form
α = radial inclination angle

Thread	Angle	External	Internal
UN & ISO	60	5.3	8
BSW	55	4.8	7.3
TR	30	2.6	4
ACME	29	2.6	3.9
AMBUT	7	.6	.9
AMBUT	45	4	6

Recommendation for Threading Infeed Passes

TPI	48–32	28–24	20–16	14–12	11.5–9	8–6	5–4	3–2
metric pitch (mm)	0,50–0,75	0,80–1	1,25–1,5	1,75–2	2,5–3	3,5–4	4,5–6	8,0
Thread Type	**recommended number of passes**							
Common V-thread forms ISO, UN, UNJ, NPT, Whitworth, BSPT, API Rotary Shoulder	4–5	5–6	6–8	8–10	9–12	12–15	14–16	15–25
Acme, Trapez, Round, API Round	—	—	5–6	7–8	10–11	12–13	13–15	18–20
Stub Acme, API Buttress	—	—	5	5–6	7–8	8–10	10–12	14–16
American Buttress	—	—	7–8	9–10	11–12	13–15	17–19	22–24

NOTE: Maintain minimum .0,05mm infeed on last passes to avoid work hardening and excessive abrasion of the threading tool.

Constant Volume Infeed Values for Threading Operations

In most applications, use of CNC canned cycles produces only marginally successful results. For example, an 8-pitch external thread has a depth of 2mm (.0789").

$$\Delta ap_x = \frac{ap}{\sqrt{nap-1}} * \sqrt{\phi}$$

Formula for constant chip load infeed

Δap = radial infeed
x = actual pass (from 1 to the nap)
nap = number of passes
ϕ = 1st pass, 0.3
2nd pass, 1
3rd pass and up, x-1

Using Radial Infeed

Bending stress on the cutting edge caused by V-shaped chips from long-chipping steel workpiece materials.

High cutting forces with small cutting thicknesses require sharp edges with high strength.

Using Flank Infeed

Lower bending stress and stabilised cutting edges produce more favourable chip shapes and larger cutting thicknesses.

Carbides with high hardness, good wear resistance, and temperature stability are advantageous.

Guidelines for Infeeds — How to Determine the Number and the Size of Passes

The number of passes “s” per thread is decisive for successful threading and crest turning. The following tables give standard values for the application condition when machining steel. The proper number of passes must be determined empirically.

If insert breakage occurs, the number of passes must be increased. With increased wear, we recommend decreasing the number of passes. The chip thickness should not be less than 0,05mm. The allowance at the diameter should not exceed 0,2mm.

Metric ISO, External Thread Cutting

thread pitch P (mm)	0,50	0,75	1,00	1,25	1,50	1,75	2,00	2,50	3,00	3,50	4,00	4,50	5,00
T Ap (mm)	0,305	0,457	0,610	0,762	0,914	1,067	1,219	1,524	1,829	2,159	2,464	2,769	3,073
N Ap	4	4	5	6	6	8	8	10	12	14	15	15	16
	values for flank infeed (X/Z)												
order of passes	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z
1	0,096	0,145	0,167	0,187	0,224	0,221	0,252	0,278	0,302	0,328	0,361	0,405	0,435
2	0,080	0,119	0,138	0,154	0,185	0,182	0,208	0,230	0,249	0,271	0,298	0,335	0,359
3	0,073	0,109	0,126	0,141	0,169	0,167	0,191	0,210	0,228	0,248	0,273	0,306	0,329
4	0,056	0,084	0,097	0,108	0,130	0,128	0,146	0,161	0,175	0,190	0,209	0,235	0,252
5			0,082	0,091	0,110	0,108	0,123	0,136	0,148	0,160	0,176	0,198	0,213
6				0,080	0,097	0,095	0,109	0,120	0,130	0,141	0,155	0,175	0,187
7						0,086	0,098	0,108	0,118	0,128	0,141	0,158	0,169
8						0,079	0,090	0,100	0,108	0,118	0,129	0,145	0,156
9								0,093	0,101	0,109	0,120	0,135	0,145
10								0,087	0,095	0,103	0,113	0,127	0,136
11									0,089	0,097	0,107	0,120	0,129
12									0,085	0,092	0,102	0,114	0,122
13										0,088	0,097	0,109	0,117
14										0,085	0,093	0,105	0,112
15											0,090	0,101	0,108
16													0,104
T Ap (mm)	0,305	0,457	0,610	0,762	0,914	1,067	1,219	1,524	1,829	2,159	2,464	2,769	3,073

NOTE: Always allow 0,08–0,13mm extra stock for full profile inserts.

Metric ISO, Internal Thread Cutting

thread pitch P (mm)	0,50	0,75	1,00	1,25	1,50	1,75	2,00	2,50	3,00	3,50	4,00	4,50	5,00
T Ap (mm)	0,279	0,406	0,533	0,686	0,813	0,940	1,092	1,346	1,626	1,905	2,159	2,438	2,718
N Ap	4	4	5	6	6	8	8	10	11	12	14	15	16
	values for flank infeed (X/Z)												
order of passes	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z
1	0,088	0,129	0,146	0,168	0,199	0,195	0,226	0,246	0,282	0,315	0,328	0,357	0,384
2	0,073	0,106	0,121	0,139	0,164	0,161	0,187	0,203	0,232	0,260	0,271	0,295	0,317
3	0,067	0,097	0,110	0,127	0,151	0,147	0,171	0,186	0,213	0,238	0,248	0,270	0,291
4	0,051	0,075	0,085	0,097	0,116	0,113	0,131	0,143	0,163	0,183	0,190	0,207	0,223
5			0,071	0,082	0,097	0,095	0,111	0,120	0,138	0,154	0,160	0,175	0,188
6				0,072	0,086	0,084	0,097	0,106	0,121	0,136	0,141	0,154	0,166
7						0,076	0,088	0,096	0,110	0,123	0,128	0,139	0,150
8						0,070	0,081	0,088	0,101	0,113	0,118	0,128	0,138
9								0,082	0,094	0,105	0,109	0,119	0,128
10								0,077	0,088	0,099	0,103	0,112	0,120
11									0,083	0,093	0,097	0,106	0,114
12									0,000	0,089	0,092	0,101	0,108
13										0,000	0,088	0,096	0,103
14										0,000	0,085	0,092	0,099
15											0,000	0,089	0,096
16													0,092
T Ap (mm)	0,279	0,406	0,533	0,686	0,813	0,940	1,092	1,346	1,626	1,905	2,159	2,438	2,718

NOTE: Always allow 0,08–0,13mm extra stock for full profile inserts.

UN Thread, External Thread Cutting

TPI	24	20	18	16	14	12	11	10	9	8	7	6	5
T Ap (mm)	0,660	0,787	0,864	0,965	0,914	1,067	1,219	1,524	1,829	2,159	2,464	2,769	3,073
N Ap	5	6	6	7	9	9	10	11	12	13	14	15	16
	values for flank infeed (X/Z)												
order of passes	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z
1	0,181	0,193	0,212	0,216	0,177	0,207	0,223	0,264	0,302	0,341	0,374	0,405	0,435
2	0,149	0,159	0,175	0,178	0,146	0,171	0,184	0,218	0,249	0,282	0,309	0,335	0,359
3	0,137	0,146	0,160	0,163	0,134	0,156	0,168	0,200	0,228	0,258	0,283	0,306	0,329
4	0,105	0,112	0,123	0,125	0,103	0,120	0,129	0,153	0,175	0,198	0,217	0,235	0,252
5	0,088	0,094	0,103	0,106	0,087	0,101	0,109	0,129	0,148	0,167	0,183	0,198	0,213
6		0,083	0,091	0,093	0,076	0,089	0,096	0,114	0,130	0,147	0,161	0,175	0,187
7				0,084	0,069	0,080	0,087	0,103	0,118	0,133	0,146	0,158	0,169
8					0,063	0,074	0,080	0,095	0,108	0,122	0,134	0,145	0,156
9					0,059	0,069	0,074	0,088	0,101	0,114	0,125	0,135	0,145
10							0,070	0,083	0,095	0,107	0,117	0,127	0,136
11								0,078	0,089	0,101	0,111	0,120	0,129
12									0,085	0,096	0,105	0,114	0,122
13										0,092	0,101	0,109	0,117
14											0,097	0,105	0,112
15												0,101	0,108
16													0,104
T Ap (mm)	0,660	0,787	0,864	0,965	0,914	1,067	1,219	1,524	1,829	2,159	2,464	2,769	3,073

NOTE: Always allow 0,08–0,13mm extra stock for full profile inserts.

UN Thread, Internal Thread Cutting

TPI	24	20	18	16	14	12	11	10	9	8	7	6	5
T Ap (mm)	0,584	0,686	0,762	0,864	0,991	1,143	1,245	1,372	1,524	1,727	1,956	2,286	2,743
N Ap	5	6	6	7	8	9	9	10	11	12	13	14	15
	values for flank infeed (X/Z)												
order of passes	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z
1	0,160	0,168	0,187	0,193	0,205	0,221	0,241	0,250	0,264	0,285	0,309	0,347	0,402
2	0,132	0,139	0,154	0,159	0,169	0,183	0,199	0,207	0,218	0,236	0,255	0,287	0,332
3	0,121	0,127	0,141	0,146	0,155	0,167	0,182	0,189	0,200	0,216	0,234	0,263	0,304
4	0,093	0,097	0,108	0,112	0,119	0,128	0,140	0,145	0,153	0,166	0,179	0,202	0,233
5	0,078	0,082	0,091	0,094	0,100	0,108	0,118	0,123	0,129	0,140	0,151	0,170	0,196
6		0,072	0,080	0,083	0,088	0,095	0,104	0,108	0,114	0,123	0,133	0,150	0,173
7				0,075	0,080	0,086	0,094	0,098	0,103	0,111	0,120	0,135	0,156
8					0,073	0,079	0,086	0,090	0,095	0,102	0,111	0,124	0,144
9						0,074	0,080	0,084	0,088	0,095	0,103	0,116	0,134
10								0,078	0,083	0,089	0,097	0,109	0,126
11									0,078	0,085	0,092	0,103	0,119
12										0,080	0,087	0,098	0,113
13											0,083	0,094	0,108
14											0,080	0,090	0,104
15													0,100
16													
T Ap (mm)	0,584	0,686	0,762	0,864	0,991	1,143	1,245	1,372	1,524	1,727	2,036	2,286	2,743

NOTE: Always allow 0,08–0,13mm extra stock for full profile inserts.

NPT Thread, External, and Internal Machining

TPI	27	18	14	11.5	8
T Ap (mm)	0,762	1,118	1,422	1,727	2,489
N Ap	6	8	10	12	14
	values for flank infeed (X/Z)				
order of passes	X/Z	X/Z	X/Z	X/Z	X/Z
1	0,187	0,231	0,260	0,285	0,378
2	0,154	0,191	0,214	0,236	0,312
3	0,141	0,175	0,196	0,216	0,286
4	0,108	0,134	0,151	0,166	0,219
5	0,091	0,113	0,127	0,140	0,185
6	0,080	0,100	0,112	0,123	0,163
7		0,090	0,101	0,111	0,147
8		0,083	0,093	0,102	0,135
9			0,087	0,095	0,126
10			0,081	0,089	0,118
11				0,085	0,112
12				0,080	0,107
13					0,102
14					0,098
15					
16					
T Ap (mm)	0,762	1,118	1,422	1,727	2,489

NOTE: Always allow 0,08–0,13mm extra stock for full profile inserts.

BSPT Thread, External, and Internal Machining

TPI	28	19	14	11
T Ap (mm)	0,584	0,864	1,168	1,448
N Ap	5	8	10	12
	values for flank infeed (X/Z)			
order of passes	X/Z	X/Z	X/Z	X/Z
1	0,160	0,179	0,213	0,239
2	0,132	0,148	0,176	0,197
3	0,121	0,135	0,161	0,181
4	0,093	0,104	0,124	0,139
5	0,078	0,087	0,104	0,117
6		0,077	0,092	0,103
7		0,070	0,083	0,093
8		0,064	0,076	0,086
9			0,071	0,080
10			0,067	0,075
11				0,071
12				0,067
13				
14				
15				
16				
T Ap (mm)	0,584	0,864	1,168	1,448

Trapezoid Thread to DIN 103, External, and Internal Machining

pitch	1,5	2	3	4	5
T Ap (mm)	1,016	1,245	1,753	2,261	2,743
N Ap	6	8	10	12	14
	values for flank infeed (X/Z)				
order of passes	X/Z	X/Z	X/Z	X/Z	X/Z
1	0,249	0,258	0,320	0,373	0,417
2	0,206	0,213	0,264	0,308	0,344
3	0,188	0,195	0,242	0,282	0,315
4	0,144	0,150	0,186	0,217	0,242
5	0,122	0,126	0,157	0,183	0,204
6	0,107	0,111	0,138	0,161	0,180
7		0,100	0,125	0,145	0,162
8		0,092	0,115	0,134	0,149
9			0,107	0,125	0,139
10			0,100	0,117	0,131
11				0,111	0,123
12				0,105	0,117
13					0,112
14					0,108
15					
16					
T Ap (mm)	1,016	1,245	1,753	2,261	2,743

NOTE: Always allow 0,08–0,13mm extra stock for full profile inserts.

Round Thread to DIN 405, External, and Internal Machining

pitch	10	8	6
T Ap (mm)	1,321	1,626	2,159
N Ap	8	10	12
	values for flank infeed (X/Z)		
order of passes	X/Z	X/Z	X/Z
1	0,273	0,297	0,357
2	0,226	0,245	0,294
3	0,207	0,224	0,270
4	0,159	0,172	0,207
5	0,134	0,145	0,174
6	0,118	0,128	0,154
7	0,107	0,116	0,139
8	0,098	0,106	0,128
9		0,099	0,119
10		0,093	0,112
11			0,106
12			0,100
13			
14			
15			
16			
T Ap (mm)	1,321	1,626	2,159

Whitworth, External, and Internal Thread Cutting

TPI	28	20	19	16	14	12	11	10	9	8	7	6	5
T Ap (mm)	0,584	0,813	0,813	0,864	1,016	1,346	1,473	1,626	1,803	2,032	2,311	2,718	3,251
N Ap	5	6	6	8	8	9	9	10	11	12	14	15	16
	values for flank infeed (X/Z)												
order of passes	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z
1	0,160	0,199	0,199	0,179	0,210	0,261	0,285	0,297	0,312	0,336	0,351	0,398	0,460
2	0,132	0,164	0,164	0,148	0,174	0,215	0,236	0,245	0,258	0,277	0,290	0,329	0,380
3	0,121	0,151	0,151	0,135	0,159	0,197	0,216	0,224	0,236	0,254	0,266	0,301	0,348
4	0,093	0,116	0,116	0,104	0,122	0,151	0,166	0,172	0,181	0,195	0,204	0,231	0,267
5	0,078	0,097	0,097	0,087	0,103	0,128	0,140	0,145	0,153	0,164	0,172	0,195	0,225
6		0,086	0,086	0,077	0,091	0,112	0,123	0,128	0,135	0,145	0,151	0,171	0,198
7				0,070	0,082	0,102	0,111	0,116	0,122	0,131	0,137	0,155	0,179
8				0,064	0,075	0,093	0,102	0,106	0,112	0,120	0,126	0,143	0,165
9						0,087	0,095	0,099	0,104	0,112	0,117	0,133	0,153
10								0,093	0,098	0,105	0,110	0,125	0,144
11									0,093	0,099	0,104	0,118	0,136
12										0,095	0,099	0,112	0,130
13											0,095	0,107	0,124
14											0,091	0,103	0,119
15												0,099	0,114
16													0,110
T Ap (mm)	0,584	0,813	0,813	0,864	1,016	1,346	1,473	1,626	1,803	2,032	2,311	2,718	3,251

NOTE: Always allow 0,08–0,13mm extra stock for full profile inserts.

Multi-Tooth Threads, Internal

	ISO metric						ISO UN					Whitworth	NPT		
type	3M	2M	3M	2M	3M	2M	2M	3M	2M	3M	2M	2M	2M	3M	2M
pitch (mm)	1,0	1,5	1,5	2,0	2,0	3,0	—	—	—	—	—	—	—	—	—
TPI	—	—	—	—	—	—	16	16	12	12	8	11	11,5	11,5	8
total depth	0,609	0,838	0,838	1,168	1,168	1,778	0,939	0,939	1,245	1,245	1,880	1,575	1,753	1,753	2,540
1	0,330	0,381	0,508	0,508	0,711	0,558	0,431	0,558	0,558	0,762	0,584	0,736	0,584	0,812	0,889
2	0,279	0,254	0,330	0,381	0,457	0,482	0,304	0,381	0,406	0,482	0,508	0,482	0,508	0,558	0,635
3	—	0,203	—	0,279	—	0,431	0,203	—	0,279	—	0,431	0,355	0,355	0,3815	0,558
4	—	—	—	—	—	0,304	—	—	—	—	0,355	—	0,304	—	0,457

Recommendations for Steel Workpieces (<300 BHN)

			total depth — on radius		
catalogue number	insert size	TPI profile	1st pass	2nd pass	3rd pass
NTC-8R/L8EM	8	8 UN	1,21	1,63	2,00
NTC-8R/L8IM	8	8 UN	1,19	1,55	1,88
NTC-8R/L10EM	8	10 UN	0,92	1,27	1,60
NTC-8R/L10IM	8	10 UN	0,90	1,22	1,52
NTC-8R/L12EM	8	12 UN	0,76	1,04	1,32
NTC-8R/L12IM	8	12 UN	0,76	0,93	1,20
NTC-8R/L14EM	8	14 UN	0,68	0,95	1,12
NTC-8R/L14IM	8	14 UN	0,60	0,78	1,04
NTC-8R/L16EM 8	8	16 UN	0,58	0,81	0,96
NTC-8R/L16IM	8	16 UN	0,50	0,68	0,93
NTC-8R/L18EM	8	18 UN	0,48	0,66	0,86
NTC-8R/L18IM	8	18 UN	0,48	0,60	0,83
NDC-68RDR/L-75M	8	8 round	1,47	1,65	1,85
NDC-61RDR/L-75M	8	10 round	1,11	1,29	1,45
NDC-88RDRD/L-75M	8	8 round	1,29	1,75	1,85
NDC-88VR/L-75M	8	8 NPT	1,01	1,72	2,45
NDC-8115VR/L-75M	8	11.5 NPT	0,96	1,37	1,70
NDN-814VR/L-75M	8	14 NPT	0,96	1,22	1,36

NOTE: Always allow 0,08–0,13mm extra stock for full profile inserts.

ACME, External

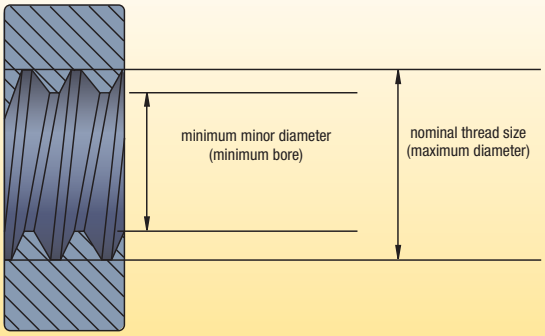
pitch, TPI	28	20	19	16	14	12	11	10	9	8	7	6	5
depth	.028	.032	.032	.034	.040	.053	.058	.064	.071	.080	.091	.107	0.128
number of passes	5	6	6	8	8	9	9	10	11	12	14	15	16
	values for flank infeed (X/Z)												
order of passes	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z
1	.039	.041	.050	.063	.074	.095	.112	.138	.180	.256	.008/-	.008/-	.008/-
2	.009	.008	.009	.010	.010	.011	.012	.013	.019	.028	.013/.007	.014/.007	.017/.009
3	.009	.008	.009	.009	.010	.011	.011	.012	.018	.026	.01/.005	.011/.006	.013/.007
4	.007	.007	.007	.009	.009	.010	.010	.011	.016	.023	.008/.004	.009/.005	.011/.006
5	.006	.006	.007	.007	.007	.009	.010	.011	.015	.022	.007/.004	.008/.004	.009/.005
6	.005	.005	.005	.006	.006	.008	.009	.010	.013	.019	.007/.003	.007/.004	.009/.004
7	.003	.004	.005	.005	.005	.007	.008	.010	.011	.017	.006/.003	.007/.004	.008/.004
8		.003	.004	.005	.005	.006	.007	.009	.011	.015	.006/.003	.006/.003	.007/.004
9			.004	.004	.005	.006	.007	.008	.009	.013	.005/.003	.006/.003	.007/.004
10				.004	.005	.006	.007	.008	.009	.013	.005/.003	.005/.003	.006/.003
11				.004	.004	.006	.006	.007	.009	.011	.005/.002	.005/.003	.006/.003
12					.004	.006	.006	.007	.008	.011	.004/.002	.005/.003	.006/.003
13					.004	.005	.006	.006	.007	.010	.004/.002	.005/.003	.006/.003
14						.004	.005	.006	.007	.009	.004/.002	.005/.002	.005/.003
15							.004	.006	.007	.009		.005/.002	.005/.003
16							.004	.006	.006	.008			.005/.003
17								.004	.005	.007	.004/.002	.005/.003	.006/.003
18								.004	.005	.007	.004/.002	.005/.002	.005/.003
19									.005	.006		.005/.002	.005/.003
20										.006			.005/.003

NOTE: Always allow 0,08–0,13mm extra stock for full profile inserts.

ACME, Internal

pitch, TPI	28	20	19	16	14	12	11	10	9	8	7	6	5
depth	.028	.032	.032	.034	.040	.053	.058	.064	.071	.080	.091	.107	0.128
number of passes	5	6	6	8	8	9	9	10	11	12	14	15	16
	values for flank infeed (X/Z)												
order of passes	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z	X/Z
1	.039	.041	.050	.063	.074	.095	.112	.138	.180	.256	.008/-	.008/-	.008/-
2	.009	.008	.009	.010	.010	.011	.012	.013	.019	.028	.013/.007	.014/.007	.017/.009
3	.009	.008	.009	.009	.010	.011	.011	.012	.018	.026	.01/.005	.011/.006	.013/.007
4	.007	.007	.007	.009	.009	.010	.010	.011	.016	.023	.008/.004	.009/.005	.011/.006
5	.006	.006	.007	.007	.007	.009	.010	.011	.015	.022	.007/.004	.008/.004	.009/.005
6	.005	.005	.005	.006	.006	.008	.009	.010	.013	.019	.007/.003	.007/.004	.009/.004
7	.003	.004	.005	.005	.005	.007	.008	.010	.011	.017	.006/.003	.007/.004	.008/.004
8		.003	.004	.005	.005	.006	.007	.009	.011	.015	.006/.003	.006/.003	.007/.004
9			.004	.004	.005	.006	.007	.008	.009	.013	.005/.003	.006/.003	.007/.004
10				.004	.005	.006	.007	.008	.009	.013	.005/.003	.005/.003	.006/.003
11				.004	.004	.006	.006	.007	.009	.011	.005/.002	.005/.003	.006/.003
12					.004	.006	.006	.007	.008	.011	.004/.002	.005/.003	.006/.003
13					.004	.005	.006	.006	.007	.010	.004/.002	.005/.003	.006/.003
14						.004	.005	.006	.007	.009	.004/.002	.005/.002	.005/.003
15							.004	.006	.007	.009		.005/.002	.005/.003
16							.004	.006	.006	.008			.005/.003
17								.004	.005	.007	.004/.002	.005/.003	.006/.003
18								.004	.005	.007	.004/.002	.005/.002	.005/.003
19									.005	.006		.005/.002	.005/.003
20										.006			.005/.003

The following charts list the largest thread pitch that can be applied on internal applications using Top Notch threading inserts for 60° V-threading and Acme threading.



Metric-sized 60° V-Threading Limits

internal threading limitations NT-1, NT-2 60° V-threading inserts

TPI	nominal thread size		minimum thread diameter (mm)	
	NT-1	NT-2	NT-1	NT-2
4,00	M48 x 4.00	–	43,67	–
3,00	M42 x 3.00	–	38,75	–
2,50	M39 x 2.50	M24 x 2,50	36,29	21,29
2,00	M33 x 2.00	M15 x 2,00	30,84	12,84
1,75	M32 x 1.75	M15 x 1,75	30,11	13,11
1,50	M32 x 1.50	M15 x 1,50	30,38	13,38
1,25	M29 x 1.29	M14 x 1,25	27,65	12,65
1,00*	M27 x 1.00	M14 x 1,00	25,92	12,92
0,75	M22 x 0.75	M12 x 0,75	21,19	11,19

*Thread pitch of 1mm and less can be cut with an NT-2 insert provided the core thread diameter is 25mm or larger (11mm or larger with NT-1).

internal threading limitations NT-3 and NT-4 60° V-threading inserts

TPI	nominal thread size	minimum thread diameter (mm)
6,00**	M76 x 6.00	69,50
5,50**	M73 x 5.50	67,05
5,00	M70 x 5.00	64,59
4,00	M64 x 4.00	59,67
3,00	M52 x 3.00	48,75
2,50	M48 x 2.50	45,29
2,00	M42 x 2.00	39,84
1,75	M40 x 1.75	38,11
1,50*	M38 x 1.50	36,38

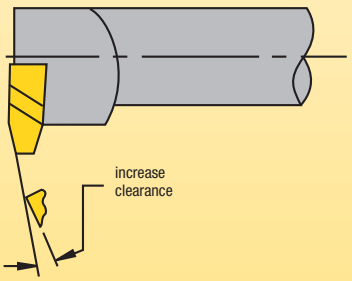
*Thread pitch of 1,5mm and less can be cut provided core thread diameter is 35mm or larger.
**NT-4-insert only.

Acme Threading Limits

internal threading limitations NA and NAS-2, -3, -4, and -6 Acme threading inserts

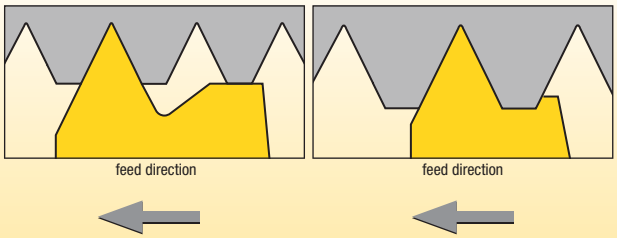
TPI	nominal thread size	minimum thread diameter (mm)	
	NT-1	NT-1	NT-2
2**	5	4.500	114.3
2-1/2**	4-1/2	4.100	104.1
3**	4	3.665	93.1
4	3-1/2	3.250	82.6
5	3	2.800	71.1
6	2-1/2	2.333	59.3
8	2-1/4	2.125	54.0
10	2	1.900	48.3
12	1-3/4	1.667	42.4
14	1-5/8	1.554	39.5
16*	1-1/2	1.438	36.5

*Sixteen threads per inch and finer can be cut provided minor diameter is 36,5mm (1.438") or larger.
**NA-6 insert only.



Additional secondary clearance can be ground on leading edge of insert to provide sufficient helical clearance for machining coarser threads and multiple start threads. Modified standard inserts may be furnished for machining threads outside of the limits shown.

60° V-Thread Crest Turning Application Data



NTC crest turning insert for (P ≤ 2mm) and finer.

NTC crest turning insert for (P ≥ 3mm) and coarser.

NOTE: NTC inserts automatically control root to crest dimensions. Therefore, in setting up threading operations with NTC inserts, check the O.D. or I.D. at the thread crest for correct dimensions.

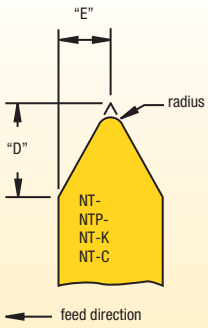
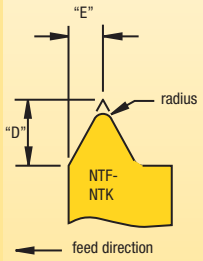
60° V-Thread Crest Turning Application Data

insert catalogue number	nose radius on insert (mm)	thread radius per MIL-S-8879A (mm)
NJ-3014R/L12	0,317/0,342	0,317/0,381
NJK-3008R/L20	0,190/0,215	0,190/0,0228

"J" thread note for catalogue

The controlled root radius thread form (SAE8879C) is defined for the external thread only. To machine the corresponding internal thread, choose any insert that will cut a unified class 2B thread, then bore the minor diameter to size. Refer to SAE8879C and MIL-S-8879C and SAEAS8879D for the correct "J" thread minor diameter values.

60° V-Thread Application Data

insert description	insert	D (mm)	E (mm)	recommended TPI*		recommended TP*	
				external	internal	external	internal
	NT-1	1,90	1,11	–	24–12	–	1,00–2,00
	NT-2	28,70	1,90	36–8	20–7	0,70–3,00	1,25–3,50
	NT-2-K	28,70	1,90	36–8	20–7	0,70–3,00	1,25–3,50
	NTF-2	15,75	1,01	44–14	24–12	0,60–1,75	1,00–2,00
	NTK-2	15,75	1,01	44–14	24–12	0,60–1,75	1,00–2,00
	NTP-2	28,70	1,90	36–8	20–7	0,70–3,0	1,25–3,50
	NT-3	37,59	2,46	20–6	12–5	1,25–4,00	2,00–5,00
	NT-3-K	37,59	2,46	20–6	12–5	1,25–4,00	2,00–5,00
	NT-3-C	37,59	2,46	11–6	6 (only)	2,50–4,00	4,00 (only)
	NT-3-CK	37,59	2,46	11–6	6 (only)	2,50–4,00	4,00 (only)
	NTF-3	21,08	1,37	44–10	24–9	0,60–2,50	1,00–2,50
	NTK-3	21,08	1,37	44–10	24–9	0,60–2,50	1,00–2,50
	NTP-3	37,59	2,46	20–6	12–5	1,25–4,00	2,00–5,00
	NT-4	49,78	3,22	20–4	12–4	1,25–6,25	2,00–6,25
	NT-4-K	49,78	3,22	20–4	12–4	1,25–6,25	2,00–6,25
	NT-4-C	49,78	3,22	11–4 1/2	6–4 1/2	2,50–5,50	4,00–5,50
	NT-4-CK	49,78	3,22	11–4 1/2	6–4 1/2	2,50–5,50	4,00–5,50
	NTF-4	21,08	1,37	44–10	24–9	0,60–2,50	1,00–2,50
	NTK-4	21,08	1,37	44–10	24–9	0,60–2,50	1,00–2,50
	NTP-4	49,78	3,22	20–4	12–4	1,25–6,25	2,00–6,25

*Based on maximum insert radius size and class 2A and 2B thread specifications.

API Thread Forms • Insert Applications Chart for API Rotary Shouldered Connections

thread form	Kennametal insert		tool joint application	minimum box size*
	cresting	non-cresting		
V-.038R 2" TPF 4 TPI	NDC-4038R/L2 4-E/IR4API382	ND-3038R/L	2-3/8 API internal flush 2-7/8 API internal flush 3-1/2 API internal flush 4 API internal flush 4-1/2 API internal flush 5-1/2 API internal flush 6-5/8 API internal flush 4 API full hole API #23, API #26, API #31, API #35, API #38, API #40, API #44, API #46, API #50	API #31 2-7/8 IF
V-.038R 3" TPF 4 TPI	NDC-4038R/L3 4-E/IR4API383	ND-3038R/L	API #56 API #61 API #70 API #77	API #56
V-.050 2" TPF 4 TPI	NDC-4050R/L2 4-E/IRAPI502	ND-4050R/L	5-1/2 API full hole 6-5/8 API regular 6-5/8 API full hole	5-1/2 API full hole
V-.050 3" TPF 4 TPI	NDC-4050R/L3 4-E/IR4API503	ND-4050R/L	5-1/2 API regular 7-5/8 API regular 8-5/8 API regular	5-1/2 API regular
V-.040 3" TPF 5 TPI	NDC-3040R/L3 NDC-4040R/L3 4-E/IR5API403	ND-3040R/L ND-4040R/L	2-3/8 API regular 2-7/8 API regular 3-1/2 API regular 4-1/2 API regular	3-1/2 API regular

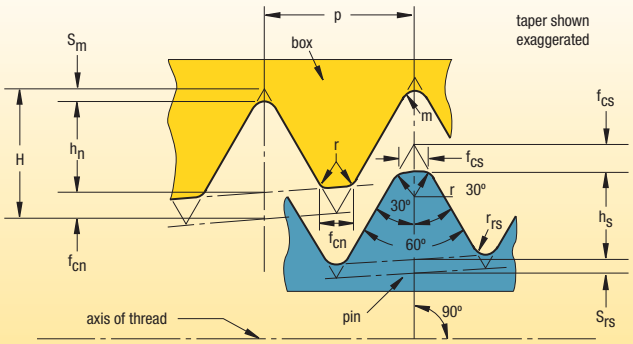
*Minimum box size that can be threaded with a standard Top Notch insert due to minimum bore equipment.

API Thread Forms
Product Thread Dimensions • Rotary Shouldered Connections (Inch)

thread form	taper inch per ft.	thread height, not truncated H	thread height, truncated $h_n=h_s$	root truncation $S_m=S_{rs}$ $f_m=f_{rs}$	crest truncation $f_{cn}=f_{cs}$	width of flat		root radius $r_m=r_{rs}$	radius at thread corners r	pitch p
						crest $f_{cn}=f_{cs}$	crest $f_m=f_{rs}$			
V-.038R	2	.216005	.121844	.038000	.056161	.065	—	.038	.015	.250
V-.038R	3	.215379	.121381	.038000	.055998	.065	—	.038	.015	
V-.040	3	.172303	.117842	.020000	.034461	.040	—	.020	.015	.250
V-.050	3	.215379	.147303	.025000	.043076	.050	—	.025	.015	
V-.050	2	.216005	.147804	.025000	.043201	.050	—	.025	.015	.250

NOTE: All dimensions in inches.

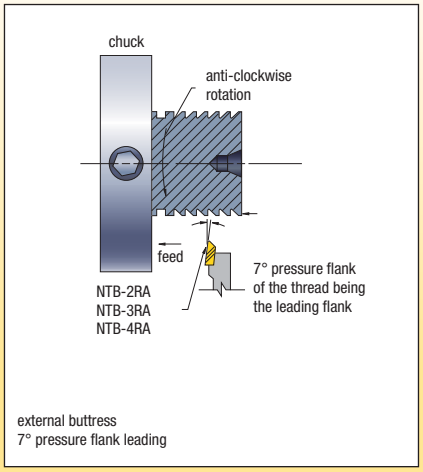
V-.040 and V-.050 Product Thread Form

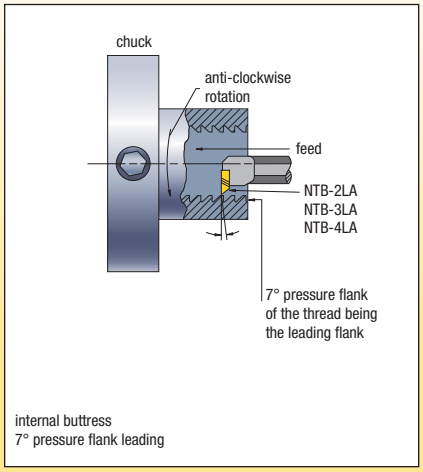


Casing and Tubing Round Thread (Height Dimensions)

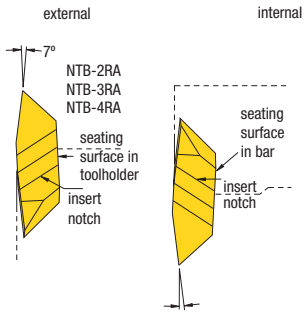
thread element		10 TPI p = .1000	8 TPI p = .1250
H	= .866p	.08660	.10825
$H_s = h_n$	= .626p - .007	.05560	.07125
$S_{rs} = S_m$	= .120p + .002	.01400	.01700
$S_{cs} = S_{cn}$	= .120p + .005	.01700	.02000

American Buttress (7° Pressure Flank Leading) NTB-A Inserts • Push Type

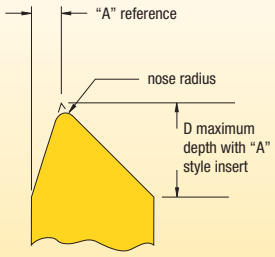




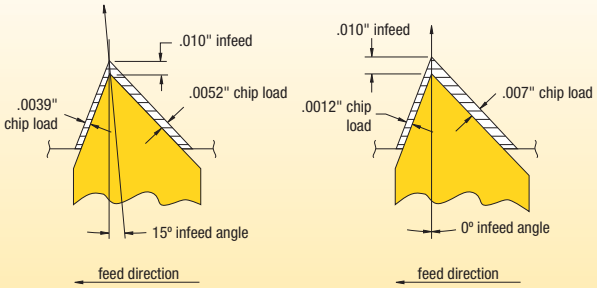
Insert vs. Toolholder Orientation



Reference Dimensions



Infeed Angle vs. Chip Load: 7° Pressure Flank Leading



NTB-A insert

insert	D (inch)	"A" ref. (inch)	nose radius (inch)	pitch based on maximum radius
NTB-2A	.133	.024	.002–.004	16–20 TPI
NTB-3A	.171	.031	.005–.008	8–16 TPI
NTB-4A	.218	.049	.008–.012	4–6 TPI

NOTE: For balanced chip load, 15° infeed angle is suggested.

Internal Threading Limitations

internal threading limitations
NTB-2A Buttress threading inserts

TPI	nominal thread size	minimum minor diameter (inch)
8	1-3/4	1.600
10	1-5/8	1.505
12	1-1/2	1.400
16	1-1/4	1.175
20	1-1/16	1.002

internal threading limitations
NTB-3 and NTB-4A Buttress threading inserts

TPI	nominal thread size	minimum minor diameter (inch)
4*	2-1/2	2.200
5	2-1/4	2.010
6	2	1.800
8	1-3/4	1.600
10	1-5/8	1.505
12**	1-1/2	1.400

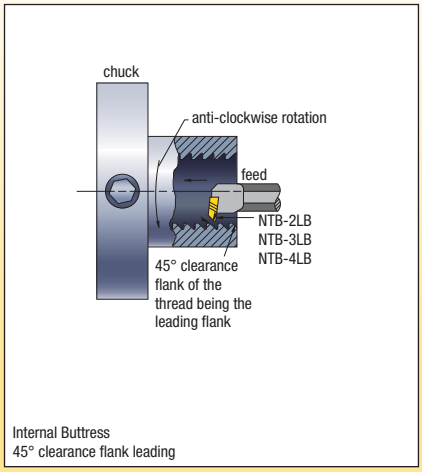
*NTB-4A insert only.
**Can cut 16 or 20 threads per inch provided minor diameter is 1.375" or larger.

Threads per Inch vs. Maximum Root Radius Chart (Inch)

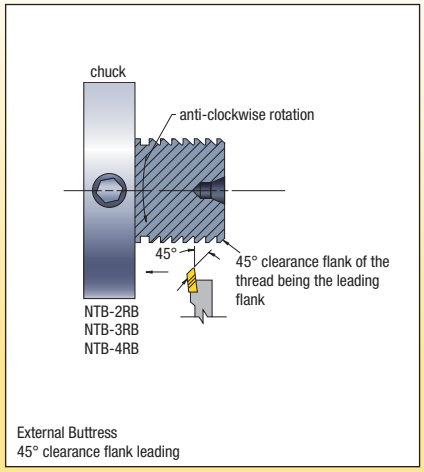
TPI	20	16	12	10	8	6	5	4	3	2-1/2	2	1-1/2	1-1/4	1
maximum root radius	.0036	.0045	.0059	.0071	.0089	.0119	.0143	.0179	.0238	.0268	.0375	.0476	.0572	.0714

NOTE: Special Buttress forms are available upon request.

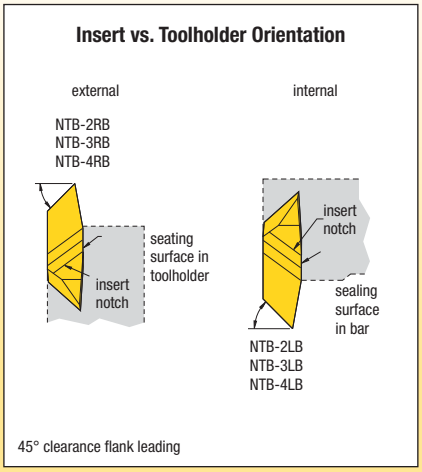
American Buttress (45° Clearance Flank Leading): NTB-B Inserts • PULL-type



Internal Buttress
45° clearance flank leading

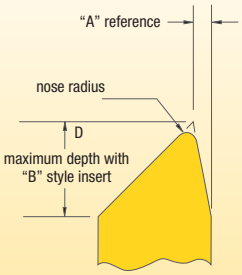


External Buttress
45° clearance flank leading

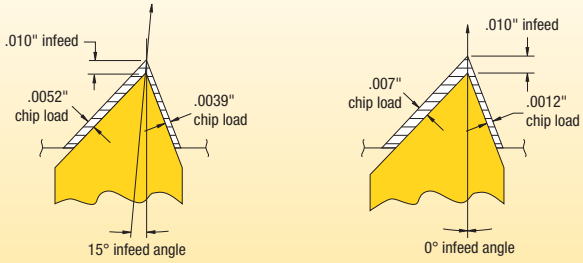


45° clearance flank leading

Reference Dimensions



Infeed Angle vs. Chip Load: 45° Clearance Flank Leading



NTB-B insert

insert	D (inch)	"A" reference (inch)	nose radius (inch)	pitch based on maximum radius
NTB-3B	.171	.031	.005–.004	8–16 TPI

NOTE: For balanced chip load, a reverse 15° infeed angle is suggested.

Internal Threading Limitations

internal threading limitations
NTB-2B Buttress threading inserts

TPI	nominal thread size	minimum minor diameter (inch)
8	1-3/4	1.600
10	1-5/8	1.505
12	1-1/2	1.400
16	1-1/4	1.175
20	1-1/16	1.002

internal threading limitations
NTB-3 and NTB-4B Buttress threading inserts

TPI	nominal thread size	minimum minor diameter (inch)
4*	2-7/8	2.575
5	2-3/4	2.510
6	2-3/8	2.175
8	2-1/8	1.975
10	1-7/8	1.755
12	1-5/8	1.525
16	1-1/2	1.407
20	1-7/16	1.378

*NTB-4B insert only.

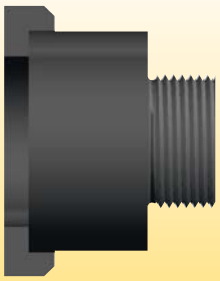
Required Information

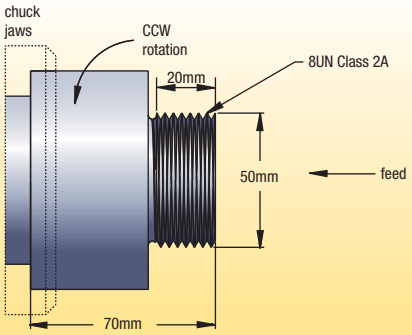
From Part Drawing:

material: 316SS, 200 HB
thread form: 8UN
tolerance: class 2A
operation: external threading
pitch diameter: 50mm x 25mm deep

From Machine Setup Data:

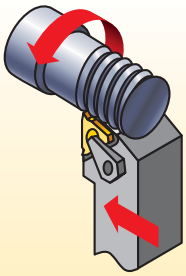
tooling: 20mm x 20mm
spindle rotation: anti-clockwise
feed: toward chuck





Steps for a Successful Threading Operation

Step 1 • Determine Threading Method



Need to Know:

- Operation (external).
- Spindle rotation (CCW).
  Anti-clockwise rotation.
- Feed direction (toward chuck).
- Right-hand toolholder.
- Right-hand insert (ER).
- Standard helix method.

Step 2 • Select Insert



Need to Know:

- Thread form (ISO R262 1mm pitch).
- Hand of insert (right hand — ER).

Choose the High-Performance Solution

catalogue number	insert size	KCU25/ KC5025
3ER10ISO	3	•

High-Performance Selection

NOTE: Use insert with largest insert size available.
insert: 3ER10ISO
grade: KCU25/KC5025
speed: 150 m/min

Step 3 • Select the Grade and Speed

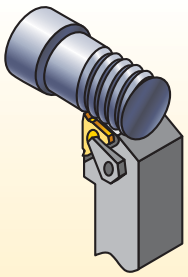
Need to Know:

- Workpiece material (316SS-200HB).
- Operation (external).

Options: Grade and Speed Selection Guidelines

threading operation	stainless steel
external	general purpose and high performance
	KC5025
	50–360 m/min

Step 4 • Select Toolholder



Need to Know:

- External or internal operation (external).
- Pitch diameter to determine minimum bore diameter (N/A).
- Type of tooling — toolholder, boring bar (toolholder).
- Hand of tool (right hand).
- Insert size (16).

Options:

catalogue number	insert size	shim
AL203R	3	SM-YE3

First choice: LSASR-123 holder

Step 5 • Select Shim

Need to Know:

- Thread form — TPI or pitch (8 TPI).
- Pitch diameter (50mm).
- Helix method (standard).
  See Laydown Threading (LT) shim selection chart.

Select SM-YE3 shim

NOTE: The SM-YE3 shim is supplied with the selected toolholder.

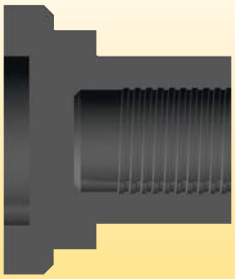
Required Information

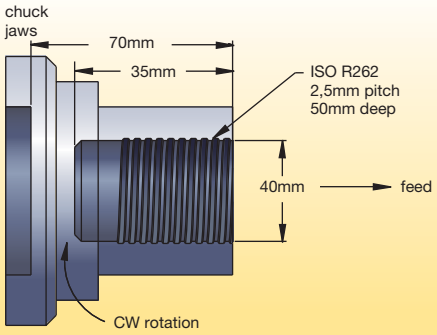
From Part Drawing:

material: 4140 steel
thread form: ISO R262 2,5mm pitch
tolerance: ISO Metric Class 6G/6H
operation: internal threading
pitch diameter: 40mm x 35mm deep

From Machine Setup Data:

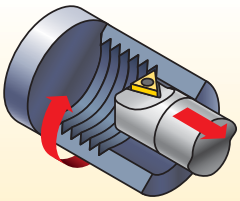
tooling: 20mm boring bar
spindle rotation: clockwise
feed: away from chuck





Steps for a Successful Threading Operation

Step 1 • Determine Threading Method



Need to Know:

- Operation (internal).
- Spindle rotation (CW).
  Clockwise rotation.
- Feed direction (away from chuck).
- Left-hand toolholder.
- Left-hand insert (NL).
- Reverse helix method.

Step 2 • Select Insert



Need to Know:

- Thread form (ISO Metric Class 6G/6H).
- Hand of insert (left hand — NL).

Choose the High-Performance Solution

catalogue number	insert size	KCU25/ KC5025
3IL25ISO	3	•

High-Performance Selection

NOTE: Use insert with largest possible insert size to go into the bore.
insert: 3IL25ISO
grade: KCU25/KC5025
speed: 130 m/min

Step 3 • Select the Grade and Speed

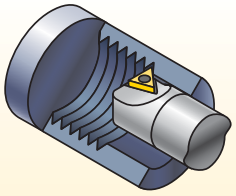
Need to Know:

- Workpiece material (4010 steel).
- Operation (internal).

Options: Grade and Speed Selection Guidelines

threading operation	steel
internal	general purpose and high performance
	KC5025
	40–200 m/min

Step 4 • Select Toolholder



Need to Know:

- External or internal operation (internal).
- Pitch diameter to determine minimum bore diameter for internal operations (40mm).
- Type of tooling — toolholder, boring bar (boring bar).
- Hand of tool (left hand).
- Insert size (16).

Options:

catalogue number	insert size	shim
AVR32D3R	3	SM-YE3

First choice: LSASR-123 holder

Step 5 • Select Shim

Need to Know:

- Thread form — TPI or pitch (2,5mm pitch).
- Pitch diameter (50mm).
- Helix method (standard). See Laydown Threading (LT) shim selection chart.

Select SM-YE3 shim

NOTE: For this application, the standard shim supplied should be replaced with the recommended shim, SM-YE3.

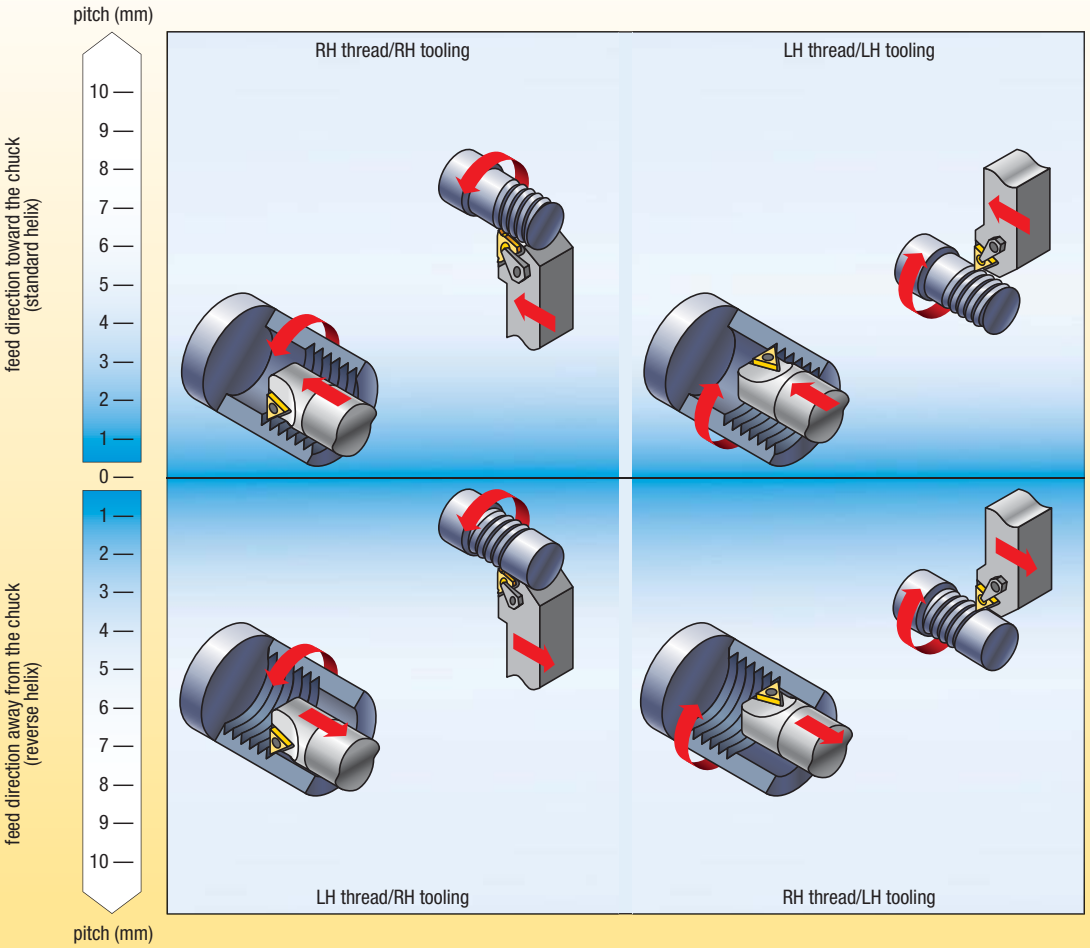
Laydown Threading Shim Selection Guidelines

It is essential to select the correct shim to ensure thread quality and maximum tool life. These parameters are needed:

- Pitch
- Pitch diameter
- Number of starts
- Feed direction

NOTE: When considering method of thread cutting, the part's shape and stability and the flow of chips are determining factors in your decision.

Laydown Selection Chart



NOTE: For multi-start threads, use the lead value instead of the pitch.

Diagram of Thread Lead Angles

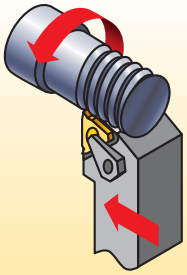
To calculate the lead angle of a given thread, use this formula:

$$ß = \text{Arctan} \frac{P \bullet S}{\pi D_e}$$

ß = thread lead angle
D_e = effective pitch diameter of thread wear
P = 1/TPI
TPI = threads per inch
S = number of starts
single-start, lead = pitch
multiple-start, lead = pitch (x) number of starts

All toolholders are designed with an inclination angle = 1.5°. When turning standard threads with a lead angle of 1–2°, this guarantees adequate clearance at the flanks of the insert's thread tooth. The thread lead angle and the required inclination angle of the insert are given by ß.

Cutting edge height is constant at every shim and insert combination. All toolholders are supplied with 1-1/2° lead angle.

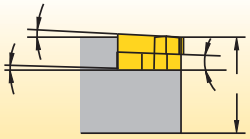


Laydown Threading Shim Selection Table • Metric

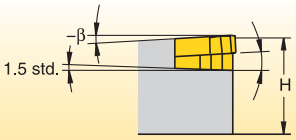
insert size	toolholder external	toolholder internal	shim ordering code (mm)							
						standard				
3 (9,52)	RH	LH	SM–YE3–3P	SM–YE3–2P	SM–YE3–1P	SM–YE3	SM–YE3–1N	SM–YE3–1.5N	SM–YE3–2N	SM–YE3–3N
3 (9,52)	LH	RH	SM–YI3–3P	SM–YI3–2P	SM–YI3–1P	SM–YI3	SM–YI3–1N	SM–YI3–1.5N	SM–YI3–2N	SM–YI3–3N
4 (12,7)	RH	LH	SM–YE4–3P	SM–YE4–2P	SM–YE4–1P	SM–YE4	SM–YE4–1N	SM–YE4–1.5N	SM–YE4–2N	SM–YE4–3N
4 (12,7)	LH	RH	SM–YI4–3P	SM–YI4–2P	SM–YI4–1P	SM–YI4	SM–YI4–1N	SM–YI4–1.5N	SM–YI4–2N	SM–YI4–3N
TPI		**pitch (mm)**	**pitch diameter (mm)**							
72		—	—	—	—	3,1–8	8–21,4	>21,4	21,4–8	8–3,1
—		0,35	—	—	—	3,0–8	8–21,3	>21,3	21,3–8	3–8
64		—	—	—	—	3,4–9	9–24,1	>24,1	24,1–9	9–3,4
—		0,40	—	—	—	3,5–9,1	9,1–24,3	>24,3	24,3–9,1	9,1–3,5
56		0,45	—	—	—	3,9–10,3	10,3–27,6	>27,6	27,6–10,3	10,3–3,9
—		0,50	—	—	2,8–4,3	4,3–11,4	11,4–30,4	>30,4	30,4–11,4	11,4–4,3
48		—	—	—	3–4,6	4,6–12,1	12,1–32,2	>32,2	32,2–12,1	12,1–4,6
44		—	—	—	3,3–5	5–13,2	13,2–35,1	>35,1	35,1–13,2	13,2–5
—		0,60	—	2,6–3,4	3,4–5,2	5,2–13,7	13,7–36,5	>36,5	36,5–13,7	13,7–5,2
40		—	—	2,8–3,6	3,6–5,5	5,5–14,5	14,5–38,6	>38,6	38,6–14,5	14,5–5,5
—		0,70	—	3,0–4	4–6,1	6,1–16	16–42,6	>42,6	42,6–16	16–6,1
36		—	—	3,1–4	4–6,1	6,1–16,1	16,1–42,9	>42,9	42,9–16,1	16,1–6,1
—		0,75	2,8–3,2	3,3–4,3	4,3–6,5	6,5–17,1	17,1–45,6	>45,6	45,6–17,1	17,1–6,5
32		—	3–3,4	3,4–4,5	4,5–6,9	6,9–18,1	18,1–48,3	>48,3	48,3–18,1	18,1–6,9
—		0,80	3–3,5	3,5–4,6	4,6–6,9	6,9–18,2	18,2–48,6	>48,6	48,6–18,2	18,2–6,9
28		—	3,4–3,9	3,9–5,2	5,2–7,9	7,9–20,7	20,7–55,1	>55,1	55,1–20,7	20,7–7,9
27		—	3,6–4,1	4,1–5,4	5,4–8,2	8,2–21,4	21,4–57,2	>57,2	57,2–21,4	21,4–8,2
—		1,00	3,8–4,3	4,3–5,7	5,7–8,7	8,7–22,8	22,8–60,8	>60,8	60,8–22,8	22,8–8,7
24		—	4–4,6	4,6–6	6–9,2	9,2–24,1	24,1–64,3	>64,3	64,3–24,1	24,1–9,2
—		1,25	4,7–5,4	5,4–7,1	7,1–10,8	10,9–28,5	28,5–76	>76,0	76–28,5	28,5–10,8
20		—	4,8–5,5	5,5–7,2	7,2–11	11–28,9	29–77,2	>77,2	77,2–28,9	29–11
18		—	5,3–6,1	6,1–8	8–12,2	12,2–32,2	32,2–85,8	>85,8	85,8–32,2	32,2–12,2
—		1,50	5,7–6,5	6,5–8,5	8,5–13	13–34,2	34,2–91,2	>91,2	91,2–34,2	34,2–13
16		—	6–6,9	6,9–9	9–13,8	13,8–36,2	36,2–96,5	>96,5	96,5–36,2	36,2–13,8
—		1,75	6,6–7,96	7,6–10	10–15,2	15,2–39,9	39,9–106,4	>106,4	106,4–39,9	39,9–15,2
14		—	6,9–7,9	7,9–10,3	10,3–15,7	15,7–41,4	41,4–110,3	>110,3	110,3–41,4	41,4–15,7
13		—	7,4–8,5	8,5–11,1	11,1–17	17–44,5	44,5–118,8	>118,8	118,8–44,5	44,5–17
—		2,00	7,6–8,7	8,7–11,4	11,4–17,4	17,4–45,6	45,6–121,6	>121,6	121,6–45,6	45,6–17,4
12		—	8–9,2	9,2–12	12,1–18,4	18,4–48,2	48,3–128,7	>128,7	128,7–48,2	48,2–18,4
11.5		—	8,4–9,6	9,6–12,6	12,6–19,2	19,2–50,3	50,3–134,3	>134,3	134,3–50,3	50,3–19,2
11		—	8,8–10	10–13,1	13,1–20	20–52,6	52,6–140,4	>140,4	140,4–52,6	52,6–20
—		2,50	9,5–10,8	10,8–14,2	14,2–21,7	21,7–57	57–152	>152,0	152–57	57–21,7
10		—	9,6–11	11–14,5	14,5–22	22–57,9	57,9–154,4	>154,4	154,4–57,9	57,9–22
9		—	10,7–12,2	12,2–16,1	16,1–24,5	24,5–64,3	64,3–171,6	>171,6	171,6–64,3	64,3–24,5
—		3,00	11,4–13	13–17,1	17,1–26	26–68,4	68,4–182,4	>182,4	182,4–68,4	68,4–26
8		—	12–13,8	13,8–18,1	18,1–27,6	27,6–72,4	72,4–193	>193,0	193–72,4	72,4–27,6
—		3,50	13,3–15,2	15,2–19,9	19,9–30,4	30,4–79,8	79,8–212,8	>212,8	212,8–79,8	79,8–30,4
7		—	13,8–15,7	15,7–20,7	20,7–31,5	31,5–82,7	82,7–220,6	>220,6	220,6–82,7	82,7–31,5
—		4,00	15,2–17,3	17,3–22,8	22,8–34,7	34,7–91,2	91,2–243,2	>243,2	243,2–91,2	91,2–34,7
6		—	16–18,3	18,3–24,1	24,1–36,7	36,7–96,5	96,5–257,4	>257,4	257,4–96,5	96,5–36,7
—		5,00	19–21,7	21,7–28,5	28,5–43,4	43,4–114	114–304	>304,0	304–114	114–43,4
5		—	19,3–22	22–28,9	28,9–44,1	44,1–115,8	115,8–308,8	>308,8	308,8–115,8	115,8–44,1
4,5		—	21,4–24,5	24,5–32,1	32,1–49	49–128,7	128,7–343,1	>343,1	343,1–128,7	128,7–49
—		6,00	22,7–26	26–34,2	34,2–52,1	52,1–136,8	136,8–364,8	>364,8	364,8–136,8	136,8–52,1
4		—	24,1–27,5	27,5–36,2	36,2–55,1	55,1–144,8	144,8–386	>386	386–144,8	144,8–55,1
inclination angle			4.5	3.5	2.5	1.5	0.0	0.0	-0.5	-1.5
			standard helix (feed toward the chuck)						**reverse helix (feed away from the chuck)**	

1. Select TPI or pitch from the left-hand columns.
2. Follow row to specified pitch diameter and the correct feed direction.
3. Follow the column to the top for the required shim based on the toolholder and insert size.

standard helix method:
Used when RH thread is cut with RH tool or LH thread with LH tool.



reverse helix method:
Used when RH thread is cut with LH tool or when LH thread is cut with RH tool.



NOVO KNOWS SEARCH

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

ADVISE

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

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

SELECT

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

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

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



Application Specific

Fix-Perfect E2–E18

Top Notch Profiling E20–E43

Railroad Machining E44–E61

K-Lock Inserts E62–E65

Fix-Perfect™

Precision Ground Insert Programme Goes Above and Beyond!

The breakthrough performance characteristics of these precision ground inserts enable outstanding indexing accuracy and excellent chip flow when machining steel, cast iron, and stainless steel workpiece materials.

Fix-Perfect Beyond™ inserts are the ideal solution to machining operations in a multitude of industries, including fluid power, energy, automotive, heavy equipment, and general engineering applications.

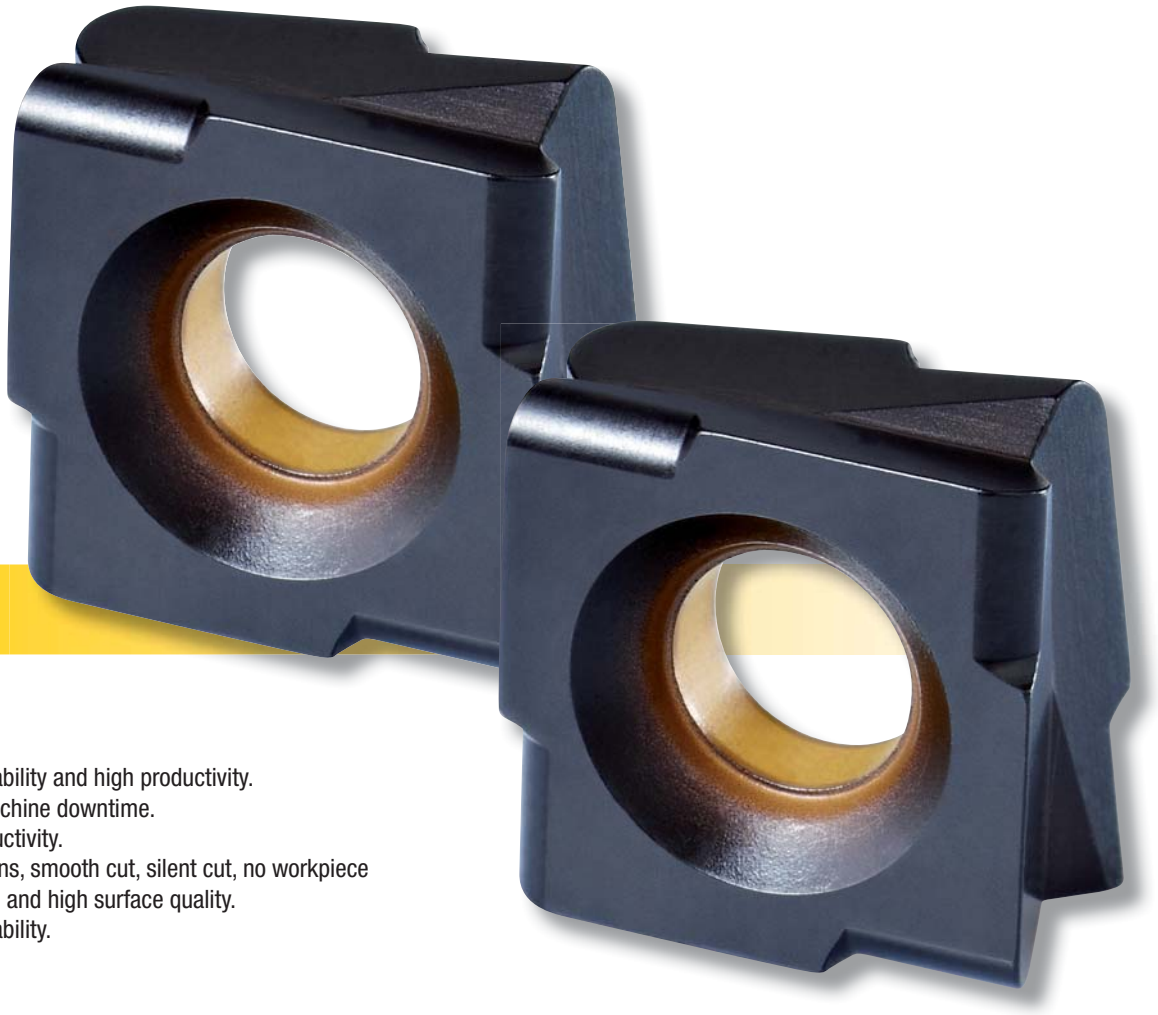
Features, Functions, and Benefits

Features

- Tangential design.
- Rigid clamping system.
- Up to eight cutting edges (protected by pocket seat).
- Positive geometry.
- Precision ground insert.

Functions

- Stable system.
- Very stable clamping system and quick and easy cutting edge switch.
- Use up to eight edges per insert.
- Very low cutting forces and excellent chip control.
- Better indexing accuracy.

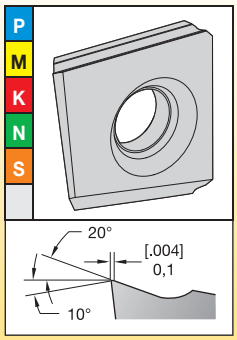


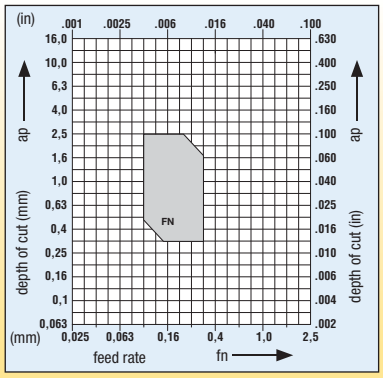
Benefits

- Process reliability and high productivity.
- Reduced machine downtime.
- Higher productivity.
- Low vibrations, smooth cut, silent cut, no workpiece deformation, and high surface quality.
- Process reliability.

Finishing

D2FIX-FN

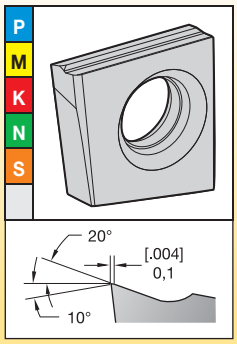


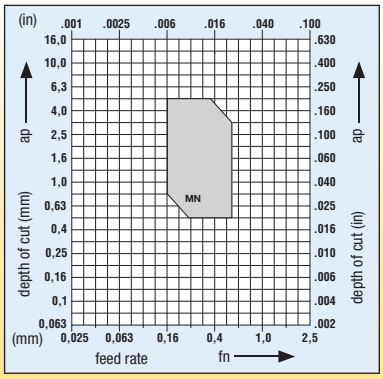


P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous Materials
S	High-Temp Alloys
H	Hardened Materials

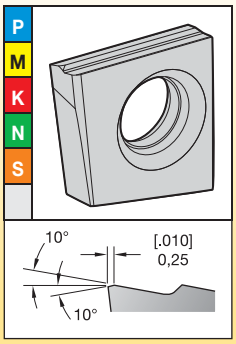
Medium Machining

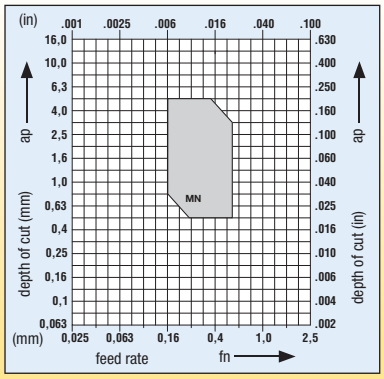
C2FIX-MN



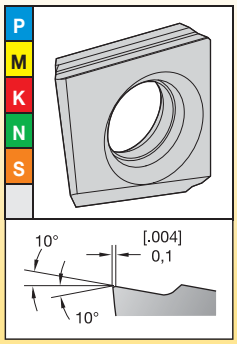


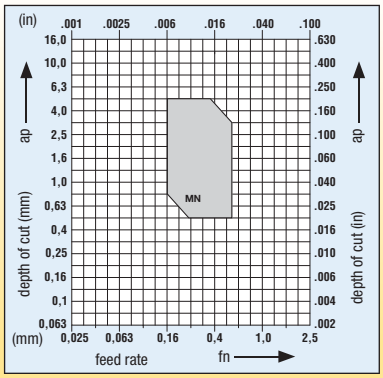
C2FIX18-MN



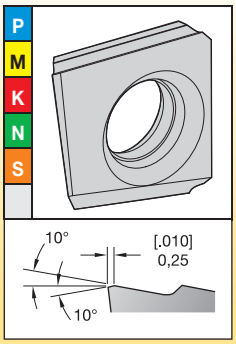


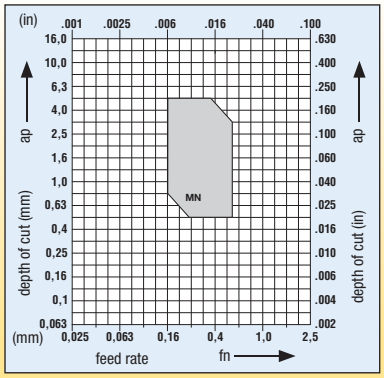
D2FIX15-MN



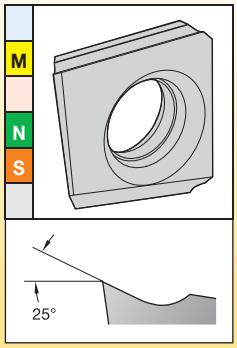


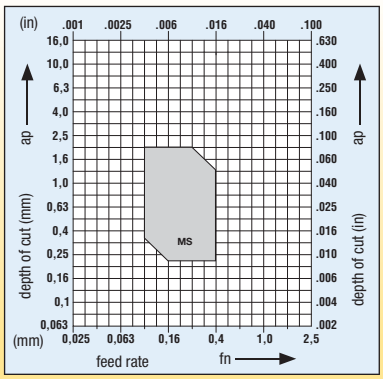
K2FIX-MN



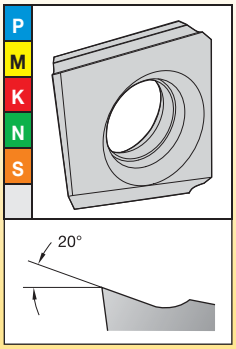


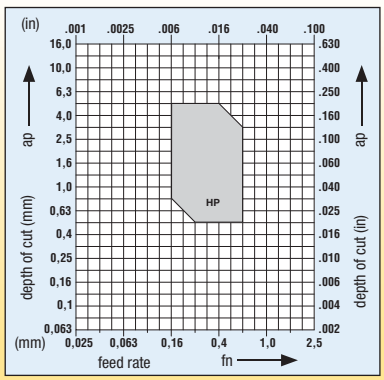
D2FIX-MS





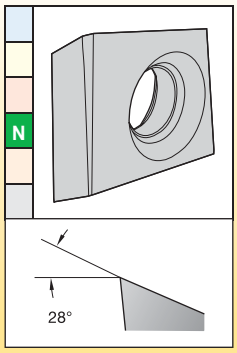
D2FIX-HP

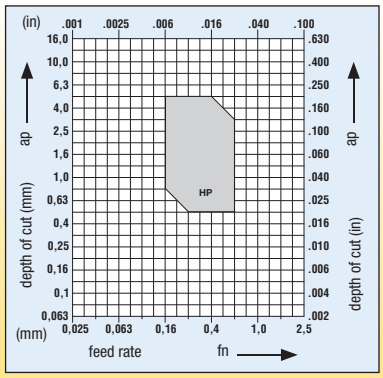




Medium Machining

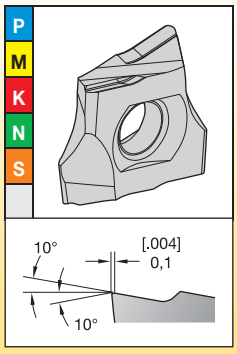
E2FIX-HP

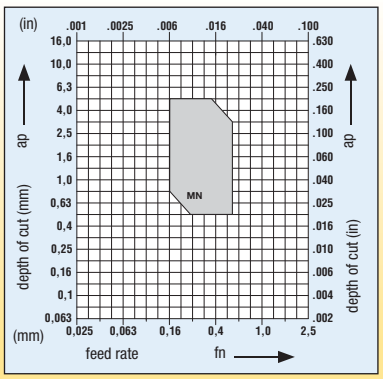




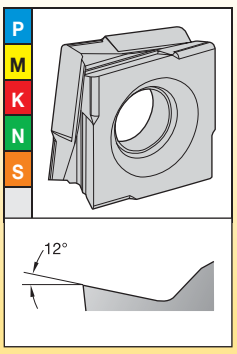
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non-Ferrous Materials
S	High-Temp Alloys
H	Hardened Materials

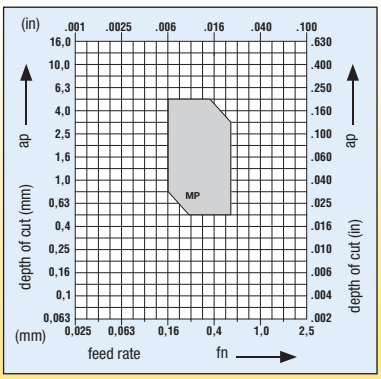
D4FIX-MN





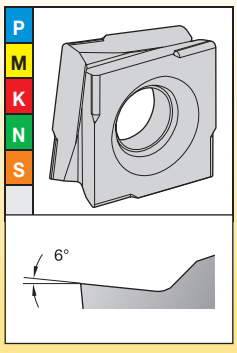
C8FIX-MP

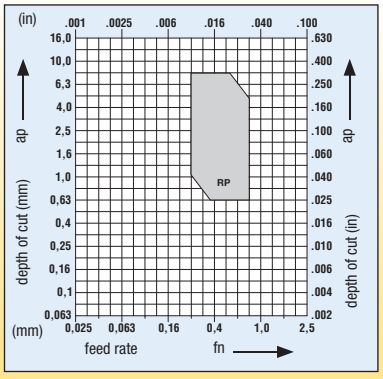




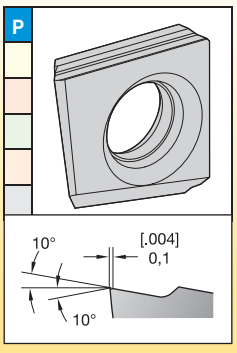
Roughing

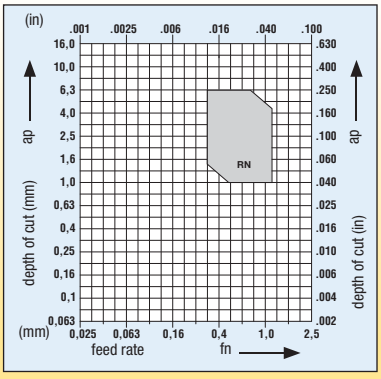
C8FIX-RP



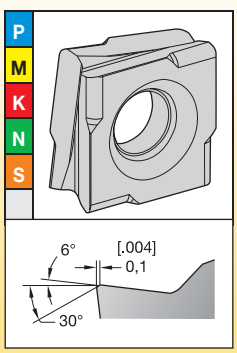


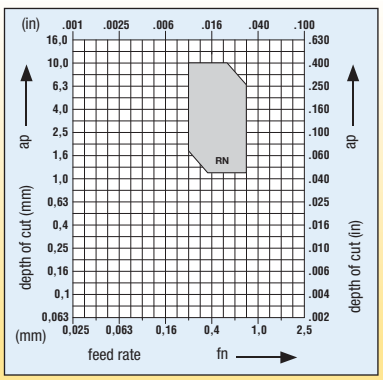
D2FIX-RN



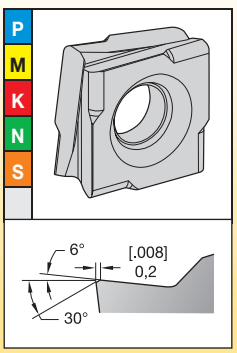


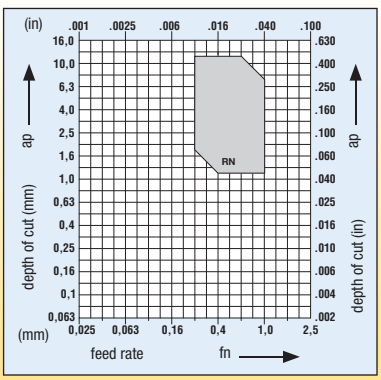
C8FIX15-RN





C8FIX18-RN





Select the Insert Geometry

8-Edged Inserts

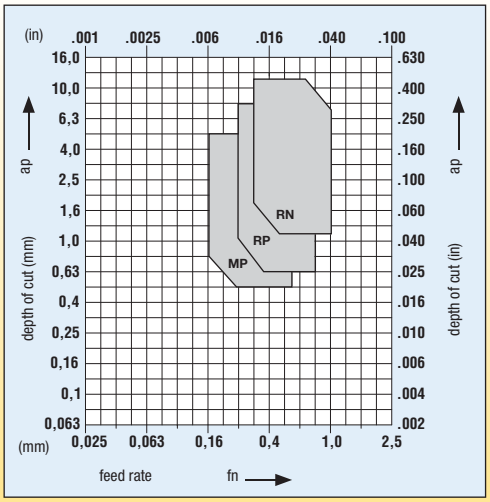
Roughing
Interrupted cut and/or heavy scale
USE: -RP OR -RN


-RP


-RN

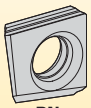
Medium Turning
Slightly interrupted cut and/or slight scale
USE: -MP


-MP

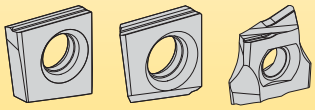


2- and 4-Edged Inserts

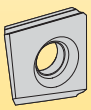
Roughing
Interrupted cut and/or heavy scale
USE: -RN

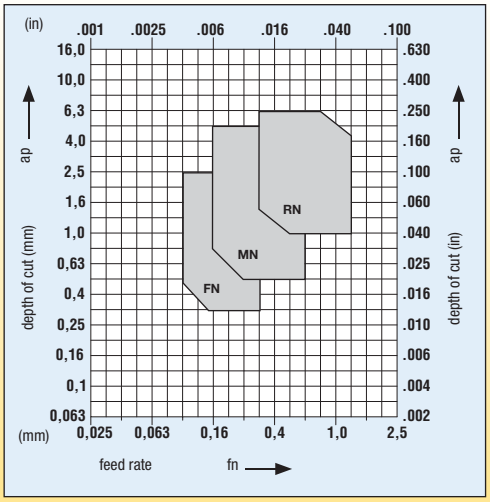

-RN

Medium Turning
Slightly interrupted cut and/or slight scale
USE: -MN


-MN

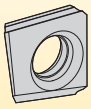
Finishing
Non-interrupted cut, not scale
USE: FN

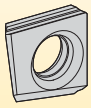

-FN

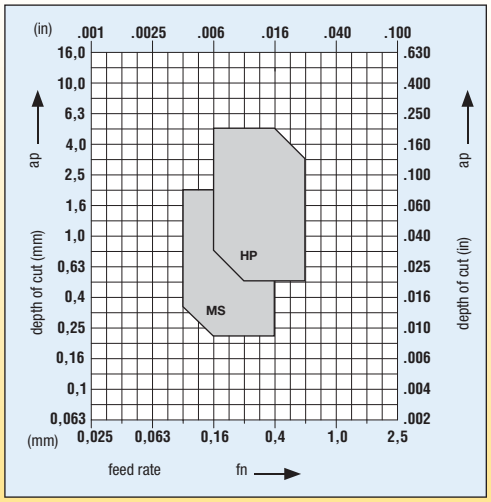


2-Edged Inserts, High Positive

Medium Turning
Slightly interrupted cut and/or slight scale
USE: -HP OR -MS


-HP


-MS



Select the grade

	P	M	K	N	S	H
heavily interrupted	KCP40/KCU25	KCU25/KCP40	KCP25/KCU25	KCU25	KCU25	–
lightly interrupted	KCP25/KCU25	KCU25/KCP40	KCP25/KCU25	KCU25	KCU25	–
varying depths of cut	KCP10/KCU10	KCU10/KCM15	KCP10/KCU10	KCU10	KCU10	KCU10
smooth	KCP10/KCU10	KCU10/KCM15	KCP10/KCU10	KCU10	KCU10	KCU10

Select the cutting speed

Steel — speed — m/min (SFM) — starting conditions ◁▷

material group	grade	60 (200)	90 (300)	120 (400)	105 (500)	185 (617)	215 (717)	245 (800)	275 (900)	300 (1000)	m/min	SFM
P	KCP40				◁▷						150	500
	KCU10						◁▷				200	650
	KCP25						◁▷				200	650
	KCP10							◁▷			250	180

Stainless Steel — speed — m/min (SFM) — starting conditions ◁▷

material group	grade	45 (150)	70 (233)	90 (300)	115 (383)	140 (467)	165 (550)	185 (617)	210 (700)	230 (767)	m/min	SFM
M	KCP40					◁▷					140	450
	KCM15						◁▷				165	550
	KCU25						◁▷				165	550
	KCU10							◁▷			185	600

Cast Iron — speed — m/min (SFM) — starting conditions ◁▷

material group	grade	90 (300)	135 (450)	180 (600)	225 (750)	275 (900)	320 (1050)	360 (1200)	410 (1350)	460 (1500)	m/min	SFM
K	KCU25			◁▷							140	450
	KCU10				◁▷						165	550
	KCP25					◁▷					165	550
	KCP10						◁▷				185	600

Non-Ferrous — speed — m/min (SFM) — starting conditions ◁▷

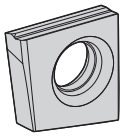
material group	grade	150 (500)	225 (750)	300 (1000)	380 (1267)	460 (1533)	535 (1783)	610 (2033)	685 (2283)	760 (2533)	m/min	SFM
N	KCU10					◁▷					460	1500

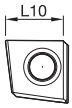
High-Temperature Alloys — speed — m/min (SFM) — starting conditions ◁▷

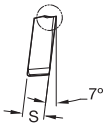
material group	grade	35 (117)	45 (150)	55 (183)	65 (217)	75 (250)	85 (283)	95 (317)	120 (400)	140 (467)	m/min	SFM
S	KCU25		◁▷								45	150
	KCU10				◁▷						60	200

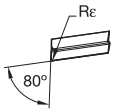
Hardened Steel — speed — m/min (SFM) — starting conditions ◁▷

material group	grade	5 (17)	15 (50)	25 (83)	35 (117)	45 (150)	55 (183)	65 (217)	75 (250)	85 (283)	m/min	SFM
H	KCU10				◁▷						30	100









● first choice
○ alternate choice

		KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
P		●	●	●	●	●	●
M		○	○	●	●	●	●
K		●	●	●	●	●	●
N						●	●
S				○	○	●	●
H							

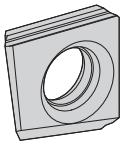
C2FIX-MN

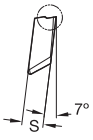
catalogue number	L10	S	Rε	KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
right hand									
C2FIX110404RMN	10,70	4,00	0,40	–	–	–	–	●	–
C2FIX110405RMN	10,70	4,00	0,50	–	●	●	–	–	–
C2FIX150510RMN	14,50	5,00	1,00	–	●	–	–	–	–
C2FIX150512RMN	14,50	5,00	1,20	–	–	–	–	–	●
C2FIX150505RMN	14,70	5,00	0,50	–	●	–	–	–	–
left hand									
C2FIX110404LMN	10,70	4,00	0,40	–	–	–	–	–	●
C2FIX110405LMN	10,70	4,00	0,50	–	●	●	–	●	–
C2FIX110408LMN	10,70	4,00	0,80	–	●	–	–	–	–
C2FIX150510LMN	14,50	5,00	1,00	–	●	●	–	–	–
C2FIX150508LMN	14,60	5,00	0,80	–	●	–	–	●	●
C2FIX150504LMN	14,70	5,00	0,40	–	–	●	–	–	●
C2FIX150505LMN	14,70	5,00	0,50	–	●	●	–	●	–
C2FIX180610LMN	17,50	6,00	1,00	–	●	●	–	●	–

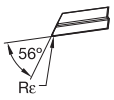
beyond

		KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
P		●	●	●	●	●	●
M		○	○	●	●	●	●
K		●	●	●	●	●	●
N						●	●
S				○	○	●	●
H							

● first choice
○ alternate choice

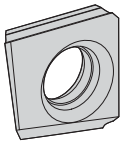


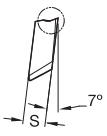



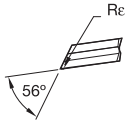


D2FIX-MN

catalogue number	L10	S	Rε	KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
right hand									
D2FIX110405RMN	10,50	4,00	0,50	–	●	●	–	–	–
D2FIX150508RMN	14,20	5,00	0,80	–	●	–	–	–	–
D2FIX150505RMN	14,50	5,00	0,50	●	●	●	–	–	–
D2FIX150504RMN	14,60	5,00	0,40	–	●	–	–	–	–
D2FIX150503RMN	14,70	5,00	0,30	–	●	–	–	–	–
left hand									
D2FIX110405LMN	10,50	4,00	0,50	–	●	●	–	–	–
D2FIX150508LMN	14,20	5,00	0,80	–	●	–	–	–	–
D2FIX150505LMN	14,50	5,00	0,50	–	●	–	–	–	–





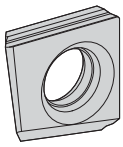
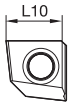
D2FIX-HP

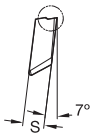
catalogue number	L10	S	Rε	KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
right hand									
D2FIX110404RHP	10,00	4,00	0,40	–	–	–	–	–	●
D2FIX110403RHP	10,10	4,00	0,30	–	●	–	–	●	–
D2FIX150508RHP	13,60	5,00	0,80	–	–	–	–	●	●
D2FIX150504RHP	14,00	5,00	0,40	–	–	–	–	●	●
D2FIX150503RHP	14,10	5,00	0,30	–	●	–	–	●	–
left hand									
D2FIX110403LHP	10,10	4,00	0,30	–	–	–	–	●	–
D2FIX150508LHP	13,60	5,00	0,80	–	–	–	–	●	–
D2FIX150503LHP	14,10	5,00	0,30	–	–	–	–	●	–

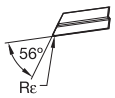
beyond

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

● first choice
○ alternate choice

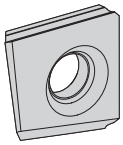
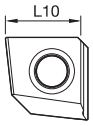



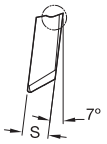


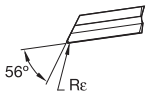


D2FIX-MS

catalogue number	L10	S	Rε	KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
right hand									
D2FIX150505RMS	13,90	5,00	0,50	–	–	–	–	●	–
D2FIX150503RMS	14,10	5,00	0,30	–	–	–	–	●	–
left hand									
D2FIX150505LMS	13,90	5,00	0,50	–	–	–	–	●	–
D2FIX150503LMS	14,10	5,00	0,30	–	–	–	–	●	–

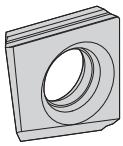



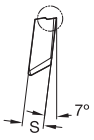


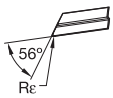


D2FIX-FN

catalogue number	L10	S	Rε	KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
right hand									
D2FIX150505RFN	13,90	5,00	0,50	–	●	–	–	●	–

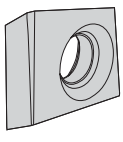
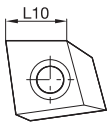


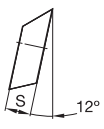



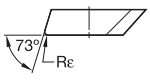


D2FIX-RN

catalogue number	L10	S	Rε	KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
right hand									
D2FIX150505RRN	14,50	5,00	0,50	●	–	●	–	–	–
left hand									
D2FIX150505LRN	14,50	5,00	0,50	–	●	–	–	–	–

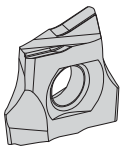


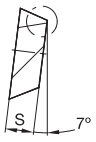


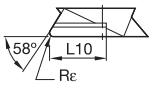
E2FIX-HP

catalogue number	L10	S	Rε	KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
right hand									
E2FIX100505RHP	10,50	5,00	0,50	–	–	–	–	●	–
left hand									
E2FIX100505LHP	10,50	5,00	0,50	–	–	–	–	●	–

beyond





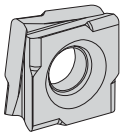
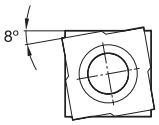


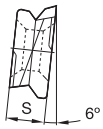
● first choice
○ alternate choice

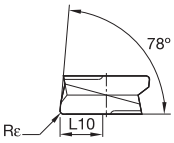
P		●	●	●	●	●	●
M		○	○	●	●	●	●
K		●	●	●	●	●	●
N						●	●
S				○	○	●	●
H							

D4FIX-MN

catalogue number	L10	S	Rε	KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
right hand									
D4FIX140608RMN	6,70	5,90	0,80	●	●	–	–	●	●
D4FIX140605RMN	7,00	5,90	0,50	●	●	–	–	–	–
D4FIX140604RMN	7,10	5,90	0,40	–	–	●	–	–	●
D4FIX140603RMN	7,20	5,90	0,30	●	●	–	–	–	–
left hand									
D4FIX140608LMN	6,70	5,90	0,80	–	●	–	–	–	–

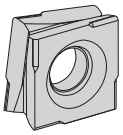



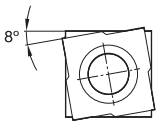


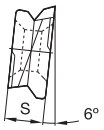


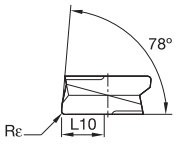
C8FIX-RN

catalogue number	L10	S	Rε	KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
right hand									
C8FIX150612RRN	8,60	6,60	1,20	–	●	–	–	–	–
C8FIX150608RRN	8,90	6,60	0,80	●	●	●	–	–	●
C8FIX150605RRN	9,10	6,60	0,50	●	●	●	–	●	●
C8FIX180812RRN	10,60	7,90	1,20	–	●	●	–	–	●
C8FIX180808RRN	10,90	7,90	0,80	–	●	●	–	–	–
left hand									
C8FIX150612LRN	8,60	6,60	1,20	–	●	–	–	–	–
C8FIX150608LRN	8,90	6,60	0,80	–	●	–	–	–	●
C8FIX150605LRN	9,10	6,60	0,50	–	●	●	–	–	●
C8FIX180812LRN	10,60	7,90	1,20	–	●	–	–	–	–







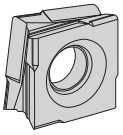


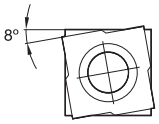
● first choice
○ alternate choice

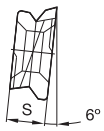
P		●	●	●	●	●	●
M		○	○	●	●	●	●
K		●	●	●	●	●	●
N						●	●
S				○	○	●	●
H							

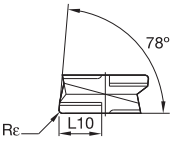
C8FIX-RP

catalogue number	L10	S	Rε	KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
right hand									
C8FIX120508RRP	6,90	5,50	0,80	●	●	–	–	–	–
C8FIX120505RRP	7,10	5,50	0,50	–	●	–	–	–	●
C8FIX120504RRP	7,20	5,50	0,40	●	●	–	–	–	–
C8FIX120503RRP	7,30	5,50	0,30	–	●	●	–	–	–
left hand									
C8FIX120508LRP	6,90	5,50	0,80	–	●	●	–	–	–
C8FIX150612LRP	7,80	6,60	1,20	–	●	–	–	–	–
C8FIX150608LRP	8,80	6,60	0,80	–	–	–	–	–	●







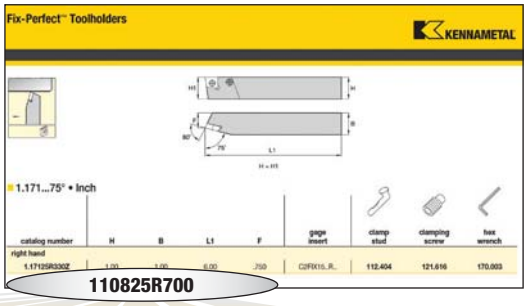


C8FIX-MP

catalogue number	L10	S	Rε	KCP10	KCP25	KCP40	KCM15	KCU10	KCU25
right hand									
C8FIX120503RMP	7,30	5,50	0,30	–	●	–	–	●	●
C8FIX150603RMP	9,30	6,60	0,30	●	●	●	–	●	●
C8FIX180805RMP	11,10	7,90	0,50	–	●	–	–	–	–
left hand									
C8FIX120503LMP	7,30	5,50	0,30	●	●	–	–	●	–
C8FIX150603LMP	9,30	6,60	0,30	–	●	–	–	–	–

How Do Catalogue Numbers Work?

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding image to easily identify which attributes apply.



1	1	08	25	R	7	0	0
Turning Programme	Number of Cutters	Version	Shaft Dimensions	Direction of Working	Insert Size and Type	Insert Shape	Clamping Screw Support

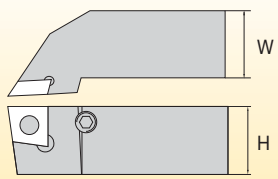
1 = Fix-Perfect

1 = Inserts with 2 cutting edges

3 = Inserts with 4 cutting edges

7 = Inserts with 8 cutting edges

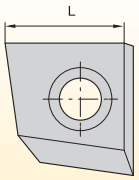
08 = 90° or 93° setting, for machining aluminium
16 = 92° setting angle
20 = 92° setting angle
22 = 92° setting angle
30 = 75° setting angle
71 = 75° setting angle
72 = 45° setting angle
77 = 90° setting angle
80 = 90° or 93° setting angle



Toolholder

10 = 10 x 10mm
11 = 40 x 40mm
16 = 16 x 16mm
20 = 20 x 20mm
21 = 50 x 50mm
25 = 25 x 25mm
32 = 32 x 25mm
32 x 32mm
40 = 40 x 32mm

R = Right
L = Left



	L	cutting edges
0	8mm 20mm 25mm	4 4 4
1	10,5mm 12mm	2 8
3	14,5mm 15mm	2 8
4	17,5mm 18mm	2 8
5	23,5mm 21mm	2 8
7	10,5mm	2 Alu

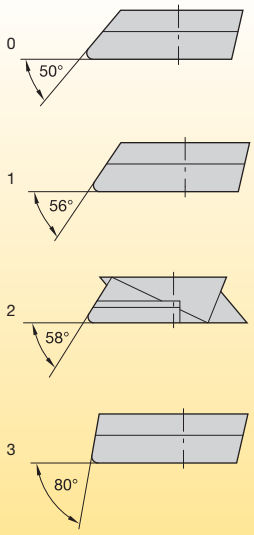
0 = Activated from main cutting edge

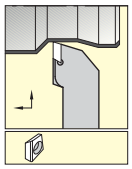
1 = Minor cutting edge

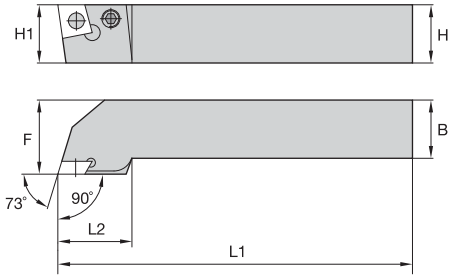
2 = Above

5 = Main cutting edge with sharp-edged full cartridge

6 = Minor cutting edge with sharp-edged full cartridge



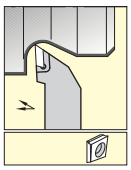


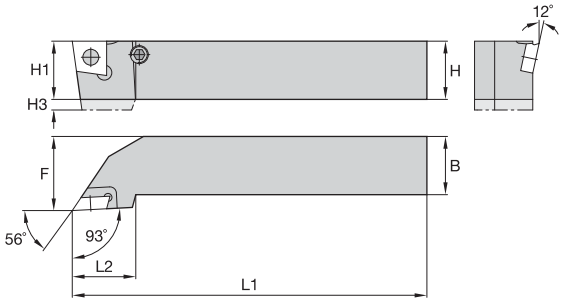


H = H1

1.108...90° • Metric

catalogue number	H	B	L1	F	gage insert	clamp stud	clamping screw	hex wrench
right hand								
1.10825R700	25	25	150,0	32,0	E2FIX10..R..	**410.081**	**121.616**	**170.003**

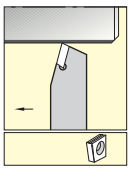


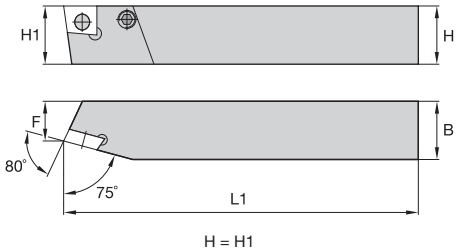


H = H1

1.108...93° • Metric

catalogue number	H	H3	B	L1	F	gage insert	clamp stud	clamping screw	hex wrench
right hand									
1.10820R310	20	5	20	125,0	25,0	D2FIX15..RHP/FN/MS	**112.403**	**121.612**	**170.003**
1.10825R310	25	–	25	150,0	32,0	D2FIX15..RHP/FN/MS	**112.404**	**121.616**	**170.003**
left hand									
1.10825L310	25	5	25	150,0	32,0	D2FIX15..LHP/FN/MS	**112.404**	**121.616**	**170.003**



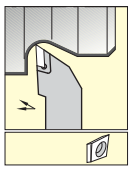


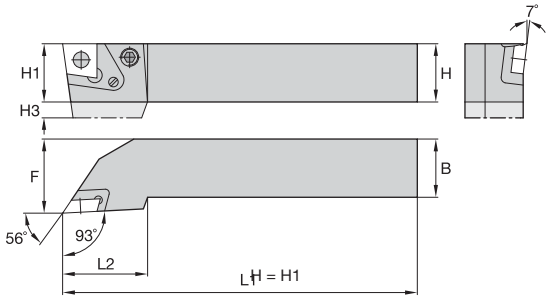
1.171...75° • Metric





catalogue number	H	B	L1	F	gage insert	clamp stud	clamping screw	hex wrench
left hand								
1.17125L330	25	25	150,0	17,0	C2FIX15..L..	**112.404**	**121.616**	**170.003**



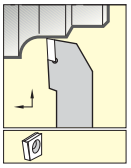


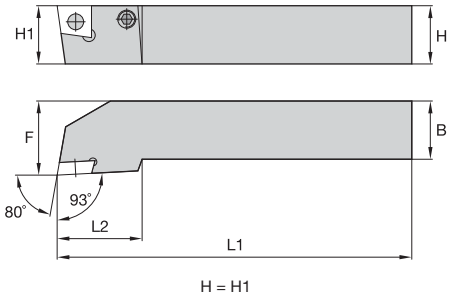
1.18 • Metric





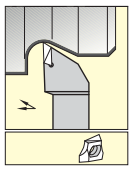

catalogue number	H	H3	B	L1	F	gage insert	clamp stud	clamping screw	hex wrench	steel nest assembly
right hand										
1.18016R110	16	4	16	100,0	24,0	D2FIX11..R..	**112.244**	**121.612**	**170.003**	–
1.18020R110	20	–	20	125,0	25,0	D2FIX11..R..	**112.244**	**121.612**	**170.003**	–
1.18020R310	20	5	20	125,0	26,0	D2FIX15..R..	**112.403**	**121.612**	**170.003**	–
1.18025R110	25	–	25	150,0	32,0	D2FIX11..R..	**112.244**	**121.612**	**170.003**	–
1.18025R310	25	–	25	150,0	32,0	D2FIX15..R..	**112.404**	**121.616**	**170.003**	–
1.18025R315	25	7	25	150,0	32,0	D2FIX15..R..	**112.505**	**121.616**	**170.003**	**132.151**
1.18032R315	32	–	25	170,0	32,0	D2FIX15..R..	**112.505**	**121.616**	**170.003**	**132.151**
left hand										
1.18016L110	16	4	16	100,0	24,0	D2FIX11..L..	**112.244**	**121.612**	**170.003**	–
1.18020L110	20	–	20	125,0	25,0	D2FIX11..L..	**112.244**	**121.612**	**170.003**	–
1.18025L310	25	–	25	150,0	32,0	D2FIX15..L..	**112.404**	**121.616**	**170.003**	–
1.18025L315	25	7	25	150,0	32,0	D2FIX15..L..	**112.505**	**121.616**	**170.003**	**132.156**
1.18032L315	32	–	25	170,0	32,0	D2FIX15..L..	**112.505**	**121.616**	**170.003**	**132.156**

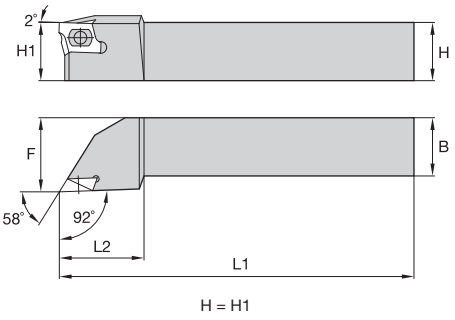




1.180...93° • Metric

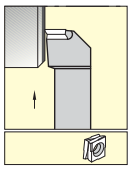
catalogue number	H	B	L1	F	gage insert	clamp stud	clamping screw	hex wrench
left hand								
1.18025L330	25	25	150,0	32,0	C2FIX15..L..	**112.404**	**121.616**	**170.003**

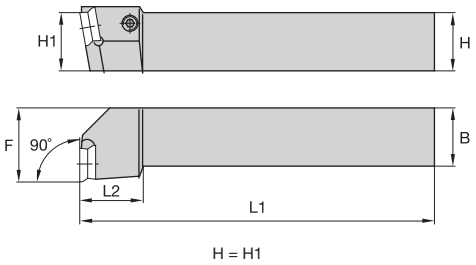




1.380...92° • Metric

catalogue number	H	B	L1	F	gage insert	clamp stud	clamping screw	hex wrench
right hand								
1.38020R021	20	20	125,0	25,0	D4FIX..R..	**114.111**	**121.812**	**170.004**
1.38025R021	25	25	150,0	32,0	D4FIX..R..	**114.114**	**121.816**	**170.004**
left hand								
1.38025L021	25	25	150,0	32,0	D4FIX..L..	**114.114**	**121.816**	**170.004**

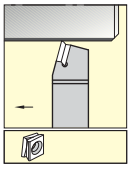


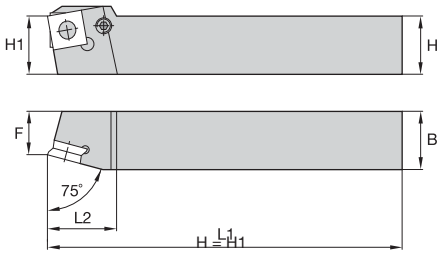


1.777...90° • Metric

catalogue number	H	B	L1	F	gage insert	clamp stud	clamping screw	hex wrench
right hand								
1.77725R301	25	25	150,0	32,0	C8FIX15..L..	**118.314**	**121.816**	**170.004**

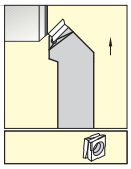
NOTE: Right-hand tool requires left-hand insert.

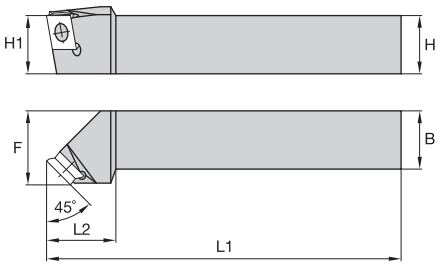




1.771...75° • Metric

catalogue number	H	B	L1	F	gage insert	clamp stud	clamping screw	hex wrench
right hand								
1.77120R100	20	20	125,0	17,0	C8FIX12..R..	**118.204**	**121.612**	**170.003**
1.77125R300	25	25	150,0	21,0	C8FIX115..R..	**410.084**	**121.816**	**170.004**
1.77132R400	32	32	170,0	27,0	C8FIX18..R..	**410.091**	**–**	**–**
left hand								
1.77120L100	20	20	125,0	17,0	C8FIX12..L..	**118.204**	**121.612**	**170.003**



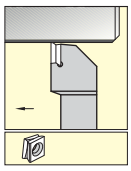


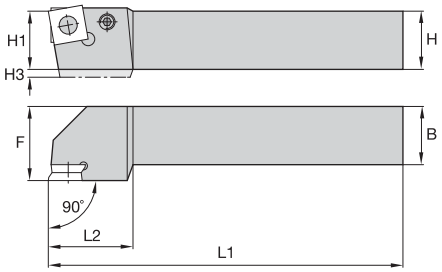
H = H1

1.772...45° • Metric

catalogue number	H	B	L1	F	gage insert	clamp stud	clamping screw	hex wrench
right hand								
1.77225R301	25	25	150,0	32,0	C8FIX15..L..	**118.314**	**121.816**	**170.004**

NOTE: C8FIX15..L.. is usable for plunging only.
For both plunging and turning, C4FIX15..L.. has to be used.





H = H1

1.780...90° • Metric

catalogue number	H	H3	B	L1	F	gage insert	clamp stud	clamping screw	hex wrench
right hand									
1.78012R103	12	–	12	80,0	14,0	C8FIX12..R..	–	–	**170.003**
1.78016R100	16	4	16	100,0	25,0	C8FIX12..R..	**118.204**	**121.616**	**170.003**
1.78020R100	20	–	20	125,0	25,0	C8FIX12..R..	**118.204**	**121.616**	**170.003**
1.78025R100	25	–	25	150,0	32,0	1.81201R...	**118.204**	**121.616**	**170.003**
1.78025R300	25	–	25	150,0	32,0	C8FIX15..R..	**410.084**	**121.816**	**170.004**
1.78032R400	32	–	32	170,0	40,0	C8FIX18..R..	**410.091**	**121.825**	**170.004**
left hand									
1.78025L100	25	–	25	150,0	32,0	1.81202L...	**118.204**	**121.616**	**170.003**
1.78025L300	25	–	25	150,0	32,0	C8FIX15..L..	**410.084**	**121.816**	**170.004**

Grooving Tools and **Beyond**™ Inserts for Your Shallow Groove and Turn Operations

Top Notch™



Top Notch Grooving Tools and Beyond Inserts are the proven solution for high productivity. The Top Notch system provides consistent tool performance, accurate indexing, and superior clamping to provide excellent surface finishing and superior tool life.

FEATURES AND BENEFITS

- The Beyond PVD coated grades are designed to cut a variety of workpiece materials.
- Rigid clamping securely locks insert in place through the toughest cuts.
- Versatile design enables one system to handle O.D. and I.D. grooving, face grooving, back turning, undercutting, and even threading operations.
- Chip control inserts provide excellent chip evacuation in grooving, and offer better chip control in multidirectional turning.

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

KENNAMETAL®

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Beyond™ Top Notch™ Profiling

The Top Notch system is the proven solution for high productivity. The Top Notch system provides consistent tool performance, accurate indexing, and superior clamping to provide excellent surface finishing and superior tool life.



Features and Benefits

Beyond™ Grades

Higher Productivity and Profitability

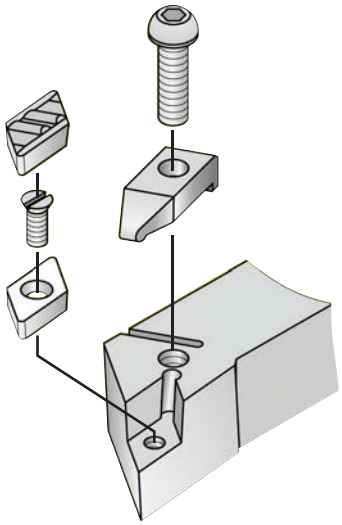
- Lower cutting forces increase speeds and reduce cycle time.
- Extended tool life.

Reliability

- Predictable tool life/uniform wear.
- Resists chip flow damage.
- Consistent surface finish.

Versatility

- Products can be applied across a wide range of applications.
- Use in low- to high-speed applications.
- Complete portfolio of products.
- For finish to rough turning of steel, cast iron, stainless steel, and high-temp alloys.



FP Geometry

- Higher metal removal rate.
- Versatility.
- Long tool life.
- Optimum chip control over wide range of cutting conditions and workpiece materials.
- Improved surface finish.
- Better indexability.
- Less adjustment during insert change.



UF Geometry

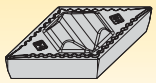
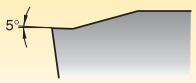
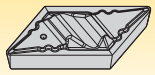
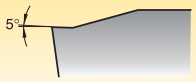
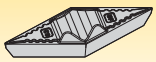
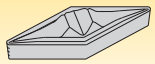
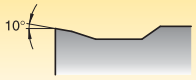
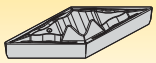
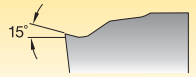
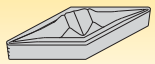
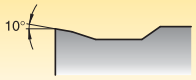
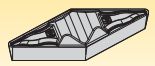
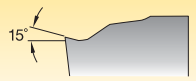
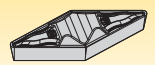
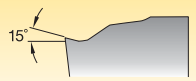
- Reduces cutting forces.
- Long tool life.
- Optimum chip control over wide range of cutting conditions.
- Chip control in finishing applications.

HP Geometry

- Reduces cutting forces.
- Long tool life.
- Interference is avoided to improve surface finish of the workpiece.
- Better indexability.
- Good control over job dimensions.
- Reduces workpiece material sticking.

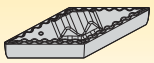
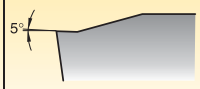
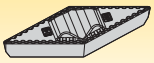
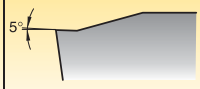
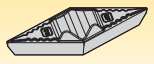
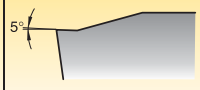
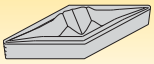
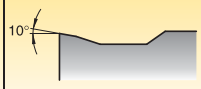
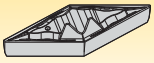
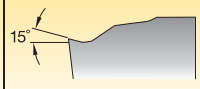
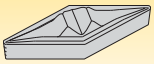
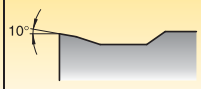
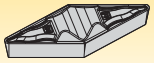
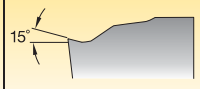
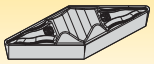
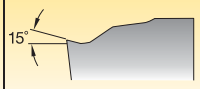
Select the geometry — based on feed rate and depth of cut

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

operation	insert style application	insert geometry	profile	feed rate — mm: 0,04 / 0,063 / 0,01 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 5,0 — depth of cut — mm: 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 4,0 / 6,3 / 10,0
fine finishing	DCGR-UF			0,1–0,3 0,1–1,3
	KCGR-UF			0,1–0,3 0,1–1,3
finishing	DCGR			0,1–0,3 0,1–1,3
	KCGR			0,1–0,4 0,3–2,0
	DCGR-FP			0,063–0,25 0,16–1,6
	DCGR-HP			0,1–0,4 0,3–2,0
	KCGR-FP			0,063–0,25 0,16–1,6
	KCGR-HP			0,063–0,25 0,16–1,6

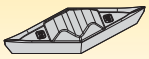
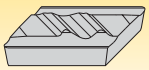
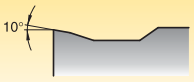
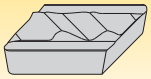
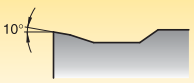
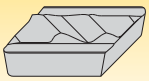
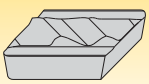
Select the geometry — based on feed rate and depth of cut

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

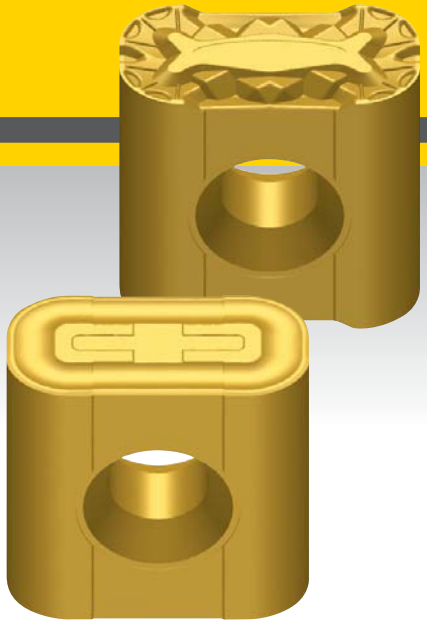
operation	insert style application	insert geometry	profile	feed rate — mm: 0,04 / 0,063 / 0,01 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 5,0 depth of cut — mm: 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 4,0 / 6,3 / 10,0
fine finishing	VBMR-UF			0,1–0,3 0,1–1,3
	VCMR-UF			0,1–0,3 0,1–1,3
	VPGR-UF			0,1–0,3 0,1–1,3
finishing	VBMR			0,1–0,4 0,3–2,0
	VBMR-FP			0,063–0,25 0,16–1,6
	VCGR			0,1–0,4 0,3–2,0
	VCMR-FP			0,063–0,25 0,16–1,6
	VPGR-FP			0,063–0,25 0,16–1,6

Select the geometry — based on feed rate and depth of cut

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

operation	insert style application	insert geometry	profile	feed rate — mm: 0,04 / 0,063 / 0,01 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 5,0 depth of cut — mm: 0,1 / 0,16 / 0,25 / 0,4 / 0,63 / 1,0 / 1,6 / 2,5 / 4,0 / 6,3 / 10,0
finishing	**VPGR-HP**			0,2–0,4 0,6–2,3
finishing	**KNGX-15**			0,2–0,4 0,8–2,8
finishing	**KNGX-20**			0,2–0,5 1,0–3,0
	KNGX-25			0,3–0,6 1,1–3,6
finishing	**KNGX-32**			0,3–0,7 1,5–5,1

Kennametal Tools for **Railways** and **Wheel Machining**



Kennametal offers a complete line of tooling for wheel and axle maintenance in railroad shops. All tools incorporate the latest technology for maximum metal removal and higher productivity. They are proven performers in actual use over extended periods of time, under a wide range of operating conditions. Standard off-the-shelf inserts and fewer pieces of hardware reduce inventory and operating costs. Included in this range are tools for reconditioning mounted wheel sets, wheel boring, wheel truing, axle turning, and journal burnishing.

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KENNAMETAL®

kennametal.com

Step 1 • Select the insert geometry

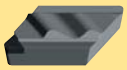
Negative Inserts



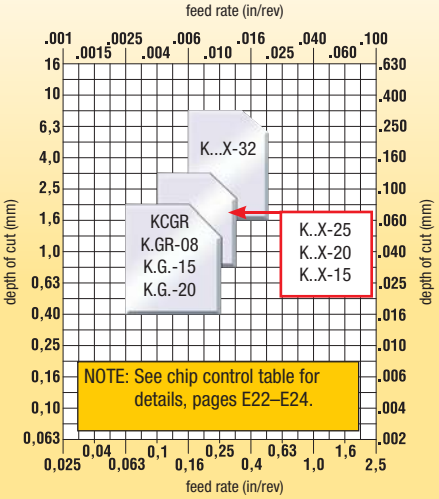
-K...X-32
Roughing



-K...X-25–K...X-15,
Medium Machining



-K. GR-08, K.G.-15,
K.G.-20
Finishing



Positive Inserts



-VCMR
Medium Machining



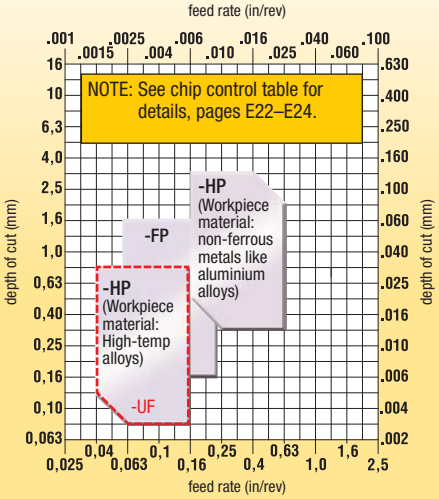
-.CGR, VBMR
Finishing



-VCGN
Finishing



-KCGR
Finishing



Chip Control Range
-UF: feed 0,08–0,3 mm/rev; DOC 0,1–1,3mm
-FP: feed 0,1–0,3 mm/rev; DOC 0,1–1,3mm
-HP: feed 028–0,4 mm/rev; DOC 0,6–2,3mm

Step 2 • Select the grade

		Steel			Stainless Steel		
cutting condition		**Finishing**	**Medium Machining**	**Roughing**	**Finishing**	**Medium Machining**	**Roughing**
heavily interrupted cut		**KCP25**	**KCM25**	**KCM25**	**KCM25**	**KCM25**	**KCM25**
lightly interrupted cut		**KCP10**	**KCP25**	**KCP25**	**KC5010/KCU10**	**KC5025/KCU25**	**KC5025/KCU25**
varying depth of cut, casting, or forging skin		**KT315**	**KCP25**	**KCP25**	**KT315**	**KCM25**	**KCM25**
smooth cut, pre-turned surface		**KT315**	**KCP05/KCP10**	**KCP10**	**KT315**	**KC5010/KCU10**	**KCM25**

		Cast Iron			Non-Ferrous		
cutting condition		**Finishing**	**Medium Machining**	**Roughing**	**Finishing**	**Medium Machining**	**Roughing**
heavily interrupted cut		**KCP10**	**KCP10**	**KCP10**	**KC5010/KCU10**	**KC5010/KCU10**	**KC5010/313/ KCU10**
lightly interrupted cut		**KCP05**	**KCP05**	**KCP05**	**KC5410/KD1425**	**KC5010/KCU10**	**KC5010**
varying depth of cut, casting, or forging skin		**KCK05**	**KCK05**	**KCK05**	**KD1425**	**KC5410**	**KC5410**
smooth cut, pre-turned surface		**KC5010/KCU10**	**KC5010/KCU10**	**KC5010/KCU10**	**KD1425**	**KC5410**	**KC5410**

		High-Temperature Alloys		
cutting condition		**Finishing**	**Medium Machining**	**Roughing**
heavily interrupted cut		**KC5025/KUC25**	**K68**	**K68**
lightly interrupted cut		**KC5010**	**KC5010**	**KCM25**
varying depth of cut, casting, or forging skin		**KC5010**	**KC5010**	**KC5010**
smooth cut, pre-turned surface		**KC5010/KCU10/ K313**	**KC5010/KCU10**	**KC5010**

Select the cutting speed

Steel — speed — m/min (SFM) — starting conditions ◁▷

material group	grade	50 (170)	100 (330)	150 (490)	200 (655)	250 (820)	300 (980)	350 (1150)	400 (1300)	m/min	SFM
P	KT315					◁▷				260	850
	KCP05/KCP10					◁▷				340	800
	KCP25				◁▷					180	600
	KCM25			◁▷						165	550

Stainless Steel — speed — m/min (SFM) — starting conditions ◁▷

material group	grade	50 (170)	100 (330)	150 (490)	200 (655)	250 (820)	300 (980)	350 (1150)	400 (1300)	m/min	SFM
M	KT315			◁▷						230	750
	KC5010/KCU10				◁▷					180	600
	KC5025/KCU25		◁▷							120	400
	KCM25			◁▷						150	500

Cast Iron — speed — m/min (SFM) — starting conditions ◁▷

material group	grade	150 (490)	200 (655)	250 (820)	300 (980)	350 (1150)	400 (1300)	500 (1600)	750 (2400)	m/min	SFM
K	KB1345								◁▷	760	2520
	KT315				◁▷					275	900
	KC5010/KCU10			◁▷						245	800
	KCK20			◁▷						245	800
	KCP25			◁▷						230	750

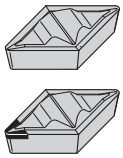
Non-Ferrous — speed — m/min (SFM) — starting conditions ◁▷

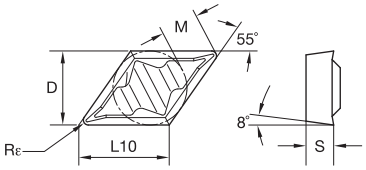
material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	1250 (4000)	1500 (4800)	1750 (5600)	2000 (6400)	m/min	SFM
N	K01425			◁▷						765	2500
	KC5410		◁▷							550	1800
	KC5010/KCU10		◁▷							460	1500
	K68/K313	◁▷								150	500

High-Temperature Alloys — speed — m/min (SFM) — starting conditions ◁▷

material group	grade	15 (50)	40 (120)	55 (180)	80 (250)	100 (330)	170 (550)	200 (655)	120 (400)	m/min	SFM
S	KC5010/KCU10				◁▷					60	200
	KC5025/KCU25			◁▷						50	170
	KCM25				◁▷					70	230
	K68/K313		◁▷							30	100

◁▷ Represents the recommended starting conditions. Optimise for your specific application.



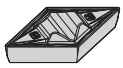


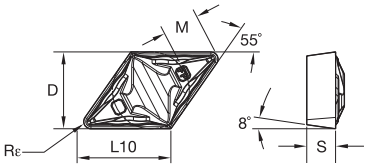
● first choice
○ alternate choice

		K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
P		●	●	●	●	●	●	○	○	○	○	●	●	●	●		●	
M		●	●	●					●	●	●	●	●	●	●		●	
K		●	●	●	○	○	○	●				●	●	●	●		●	
N		●	●	●								●	●	●	●	●		●
S		●	●	●					●	●	●	●	●	●	●			
H																		

DCGR • DPGR

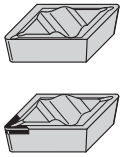
ISO catalogue number	D	L10	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
DCGR150404	12,70	15,50	4,76	6,94	0,4	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–
DCGR150408	12,70	15,50	4,76	6,48	0,8	●	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	●
DCGR150412	12,70	15,50	4,76	6,01	1,2	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–

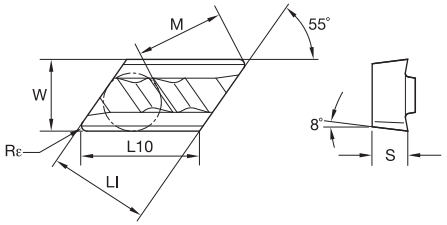




DCGR-FP • DPGR-FP

ISO catalogue number	D	L10	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
DCGR150404FP	12,70	15,50	4,76	6,94	0,4	–	–	–	–	–	●	–	–	–	–	●	–	–	–	–	–	–
DCGR150408FP	12,70	15,50	4,76	6,48	0,8	–	–	–	●	–	–	–	–	–	●	–	–	–	–	–	–	–



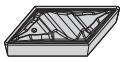


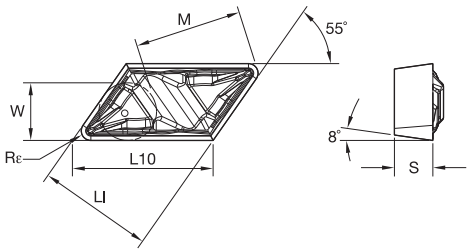
● first choice
○ alternate choice

		K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
P		●	●	●	●	●	●	○	○	○	○	●	●	●	●		●	
M		●	●	●					●	●	●	●	●	●	●		●	
K		●	●	●	○	○	○	●				●	●	●	●		●	
N		●	●	●								●	●	●	●	●		●
S		●	●	●					●	●	●	●	●	●	●			
H																		

KCGR • NPGR

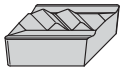
ISO catalogue number	LI	L10	W	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
right hand																							
KCGR110304R08	9,53	11,60	6,35	3,18	9,10	0,4	●	–	–	–	–	–	–	–	–	–	●	●	●	●	–	●	●
KCGR110308R08	9,53	11,60	6,35	3,18	8,66	0,8	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	●	–
left hand																							
KCGR110308L08	9,53	11,60	6,35	3,18	8,66	0,8	–	–	–	–	–	–	–	●	–	–	●	●	–	●	–	–	●
KCGR110304L08	9,53	11,60	6,35	3,18	9,10	0,4	●	–	–	–	–	–	–	–	–	–	●	●	●	●	–	●	–

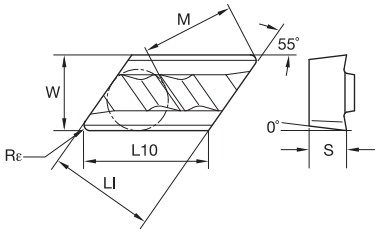




KCGR-FP • NPGR-FP

ISO catalogue number	LI	L10	W	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
right hand																							
KCGR110304R08FP	9,52	11,60	6,35	3,18	9,13	0,4	–	–	–	●	–	●	–	–	–	●	–	–	–	–	–	–	–
KCGR110308R08FP	9,52	11,63	6,35	3,18	8,73	0,8	–	–	–	●	–	–	–	–	–	–	●	–	–	–	–	–	–
left hand																							
KCGR110308L08FP	9,52	11,63	6,35	3,18	8,73	0,8	–	–	–	●	–	●	–	–	–	–	–	–	–	–	–	–	–
KCGR110304L08FP	9,52	11,60	6,35	3,18	9,13	0,4	–	–	–	●	–	●	–	–	–	●	–	●	–	–	–	–	–





● first choice
○ alternate choice

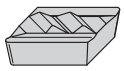
		K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
P		●	●	●	●	●	●	○	○	○	○	●	●	●	●		●	
M		●	●	●					●	●	●	●	●	●	●		●	
K		●	●	●	○	○	○	●				●	●	●	●		●	
N		●	●	●								●	●	●	●	●		●
S		●	●	●					●	●	●	●	●	●	●			
H																		

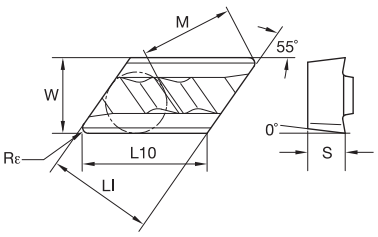
KNGX • NPR/L

ISO catalogue number	LI	L10	W	S	M	Rε
right hand						
KNGX150404R20	12,68	15,44	9,47	4,76	13,46	0,4
KNGX150408R20	12,68	15,44	9,47	4,76	12,99	0,8
KNGX150401R15	12,70	15,44	9,53	4,76	13,76	0,1
KNGX150402R15	12,70	15,44	9,53	4,76	13,67	0,2
KNGX220404R25	18,62	22,73	9,53	4,76	19,91	0,4
KNGX220408R32	18,62	22,73	9,53	4,76	19,47	0,8
left hand						
KNGX150408L20	12,68	15,44	9,47	4,76	12,99	0,8
KNGX150404L20	12,68	15,44	9,47	4,76	13,46	0,4
KNGX220408L20	18,62	22,73	9,53	4,76	19,47	0,8

–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–		
–	–	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	–	
●	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	
–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	
–	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	
–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	
●	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	
–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–	
–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	

Application Specific



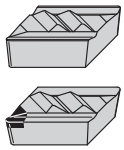


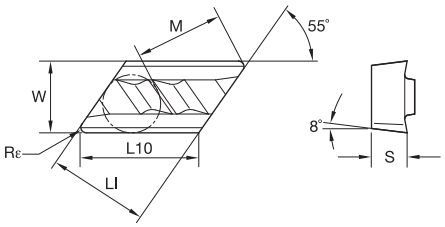
● first choice
○ alternate choice

		K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
P		●	●	●	●	●	●	○	○	○	○	●	●	●	●		●	
M		●	●	●					●	●	●	●	●	●	●		●	
K		●	●	●	○	○	○	●				●	●	●	●		●	
N		●	●	●								●	●	●	●	●		●
S		●	●	●					●	●	●	●	●	●	●			
H																		

KNUX • NPR/L

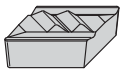
ISO catalogue number	LI	L10	W	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
right hand																							
KNUX150405R20	12,70	15,44	9,53	4,76	13,32	0,5	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–
KNUX150405R25	12,70	15,44	9,53	4,76	13,32	0,5	●	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
KNUX150410R25	12,70	15,44	9,53	4,76	12,74	1,0	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
KNUX160405R1	16,15	17,51	9,52	4,76	–	0,5	–	–	–	–	–	–	–	●	●	–	–	●	–	–	–	–	–
KNUX160405R2	16,15	17,51	9,52	4,76	–	0,5	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
KNUX160410R1	16,15	17,51	9,52	4,76	–	1,0	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
KNUX160410R2	16,15	17,51	9,52	4,76	–	1,0	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–	–	–
left hand																							
KNUX150410L25	12,70	15,44	9,53	4,76	12,74	1,0	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
KNUX150405L25	12,70	15,44	9,53	4,76	13,32	0,5	●	–	–	–	–	–	–	–	–	–	●	–	–	–	–	–	–
KNUX160405L1	16,15	17,51	9,52	4,76	–	0,5	–	–	–	–	–	–	–	●	●	–	–	–	–	–	–	–	–
KNUX160405L2	16,15	17,51	9,52	4,76	–	0,5	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–

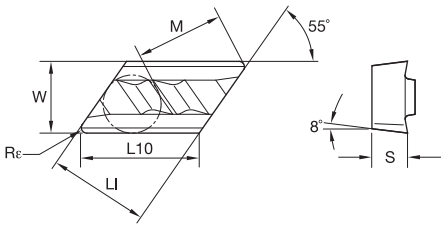




KCGX • NPR/L

ISO catalogue number	LI	L10	W	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
right hand																							
KCGX110301R15	9,53	11,60	6,35	3,18	9,43	0,1	●	●	–	–	–	–	–	–	–	–	●	–	●	●	–	–	●
KCGX110302R15	9,53	11,60	6,35	3,18	9,34	0,2	–	●	–	–	–	–	–	–	–	–	●	●	●	–	–	●	●
KCGX110304R15	9,53	11,60	6,35	3,18	9,11	0,4	●	●	–	–	–	–	–	–	–	–	●	●	●	●	●	●	●
KCGX110308R15	9,57	–	6,33	3,18	8,69	0,8	●	–	–	–	–	–	–	–	–	–	●	–	●	●	–	●	–
left hand																							
KCGX110304L15	9,53	11,60	6,35	3,18	9,11	0,4	●	●	–	–	–	–	–	–	–	–	●	●	●	●	–	–	●
KCGX110302L15	9,53	11,60	6,35	3,18	9,34	0,2	–	●	–	–	–	–	–	–	–	–	●	●	–	–	–	–	●
KCGX110301L15	9,53	11,60	6,35	3,18	9,43	0,1	●	●	–	–	–	–	–	–	–	–	–	●	●	–	–	–	●
KCGX110308L15	9,57	–	6,33	3,18	8,69	0,8	●	●	–	–	–	–	–	–	–	–	–	●	●	–	–	–	–



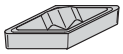


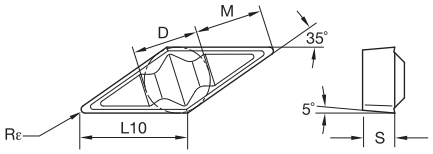
● first choice
○ alternate choice

		K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
P		●	●	●	●	●	●	○	○	○	○	●	●	●	●		●	
M		●	●	●					●	●	●	●	●	●	●		●	
K		●	●	●	○	○	○	●				●	●	●	●		●	
N		●	●	●								●	●	●	●	●		●
S		●	●	●					●	●	●	●	●	●	●			
H																		

KCUX • NPR/L

ISO catalogue number	LI	L10	W	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
right hand																							
KCUX110302R15	9,50	11,60	6,33	3,18	9,40	0,2	●	–	–	–	–	–	–	–	–	–	–	–	●	–	–	–	–
KCUX110305R15	9,53	11,60	6,35	3,18	9,06	0,5	●	–	–	–	●	–	–	–	–	–	●	–	●	–	–	–	–
KNUX150405R20	12,70	15,44	9,53	4,76	13,32	0,5	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–
left hand																							
KCUX110302L15	9,46	11,60	6,33	3,18	9,40	0,2	●	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–
KCUX110305L15	9,53	11,60	6,35	3,18	9,06	0,5	●	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–

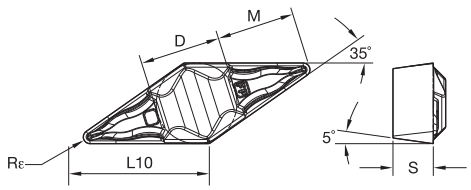




VBMR

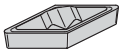
ISO catalogue number	D	L10	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
VBMR110304	6,35	11,07	3,18	6,46	0,4	–	–	–	–	–	–	–	–	–	–	–	–	●	●	–	●	–

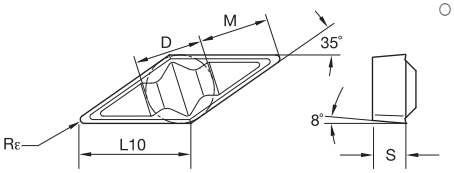




VBMR-FP

ISO catalogue number	D	L10	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
VBMR110302FP	6,35	11,04	3,18	6,91	0,2	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–
VBMR110304FP	6,35	11,07	3,18	6,46	0,4	–	–	–	●	–	●	–	–	–	–	–	●	–	–	–	–	–
VBMR110308FP	6,35	11,07	3,18	5,54	0,8	–	–	–	●	–	–	–	–	–	–	●	–	–	–	–	–	–



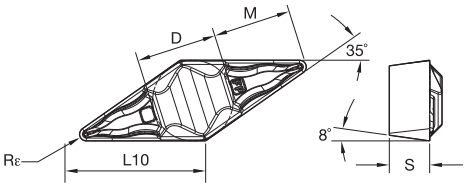


● first choice
○ alternate choice

VCMR

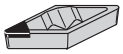
ISO catalogue number	D	L10	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
P						●	●	●	●	●	●	○	○	○	○	●	●	●	●		●	
M						●	●	●					●	●	●	●	●	●	●		●	
K						●	●	●	○	○	○	●				●	●	●	●		●	
N						●	●	●								●	●	●	●	●		●
S						●	●	●					●	●	●	●	●	●	●			
H																						
VCMR160404	9,53	16,61	4,76	10,15	0,4	–	–	–	–	–	–	–	●	–	–	–	●	●	●	–	●	–
VCMR160408	9,53	16,61	4,76	9,23	0,8	–	–	–	–	–	–	–	●	–	–	●	●	●	●	–	●	–

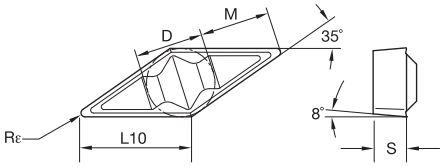




VCMR-FP

ISO catalogue number	D	L10	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
VCMR160404FP	9,52	16,61	4,76	10,15	0,4	–	–	–	●	–	●	–	–	–	●	●	●	–	–	–	–	–
VCMR160408FP	9,52	16,61	4,76	9,23	0,8	–	–	–	●	–	●	●	–	–	●	–	–	–	–	–	–	–



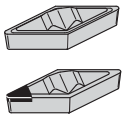


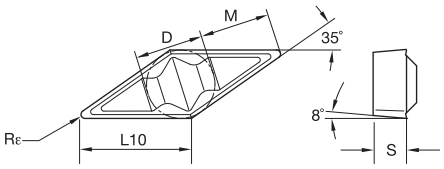
● first choice
○ alternate choice

		K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
P		●	●	●	●	●	●	○	○	○	○	●	●	●	●		●	
M		●	●	●					●	●	●	●	●	●	●		●	
K		●	●	●	○	○	○	●				●	●	●	●		●	
N		●	●	●								●	●	●	●	●		●
S		●	●	●					●	●	●	●	●	●	●			
H																		

VPGN

ISO catalogue number	D	L10	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
VCGN160404	9,53	16,61	4,76	10,15	0,4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●
VCGN160408	9,53	16,61	4,76	9,23	0,8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	●

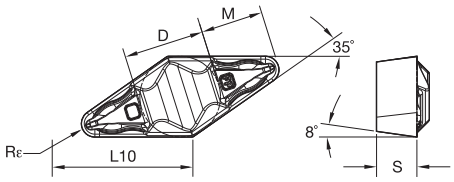




VCGR • VPGR

ISO catalogue number	D	L10	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
VCGR160402	9,53	16,61	4,76	10,60	0,2	●	–	–	–	–	–	–	–	–	–	●	●	●	●	●	–	–
VCGR160404	9,53	16,61	4,76	10,15	0,4	●	●	–	–	–	●	–	–	–	–	●	●	●	●	●	●	●
VCGR160408	9,52	16,61	4,76	9,23	0,8	●	●	–	–	●	–	–	–	–	–	●	●	●	●	●	●	●
VCGR160412	9,53	16,61	4,76	8,31	1,2	●	–	–	–	–	–	–	–	–	–	●	●	●	–	–	–	●
VCGR160416	9,53	16,61	4,76	7,38	1,6	–	–	–	–	–	–	–	–	–	–	●	–	●	–	–	–	–





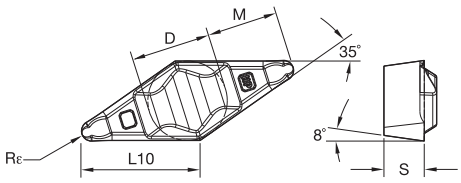
● first choice
○ alternate choice

		K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
P		●	●	●	●	●	●	○	○	○	○	●	●	●	●		●	
M		●	●	●					●	●	●	●	●	●	●		●	
K		●	●	●	○	○	○	●				●	●	●	●		●	
N		●	●	●								●	●	●	●	●		●
S		●	●	●					●	●	●	●	●	●	●			
H																		

VCGR-FP • VPGR-FP

ISO catalogue number	D	L10	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
VCGR160402FP	9,52	16,61	4,76	10,60	0,2	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGR160404FP	9,52	16,61	4,76	10,15	0,4	–	–	–	●	–	●	–	–	–	●	●	–	–	–	–	–	–
VCGR160408FP	9,52	16,61	4,76	9,23	0,8	–	–	–	●	–	●	●	–	–	●	–	–	–	–	–	–	–
VCGR160412FP	9,52	16,61	4,76	8,31	1,2	–	–	–	●	–	●	●	–	–	–	–	–	–	–	–	–	–
VCGR160416FP	9,52	16,61	4,76	7,38	1,6	–	–	–	–	–	●	–	–	–	–	–	–	–	–	–	–	–

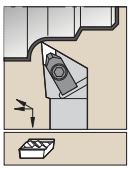


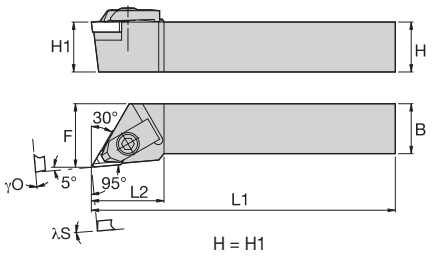


VCGR-HP • VPGR-HP

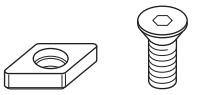
ISO catalogue number	D	L10	S	M	Rε	K68	K313	KU10	KCP10	KCP25B	KCP25	KCK05	KCM15B	KCM25B	KCM25	KCU10	KCU25	KC5010	KC5025	KC5410	KT315	KD1425
VCGR160404HP	9,52	16,61	4,76	–	0,4	–	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Application Specific

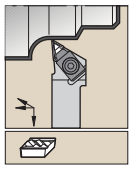


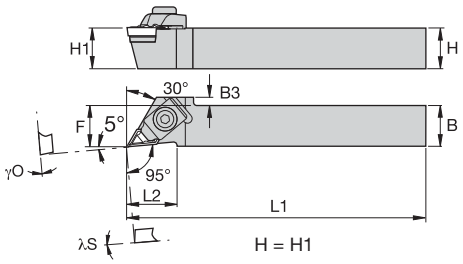


NKLC 95°



catalogue number	H	B	F	L1	λS°	γO°	gage insert	shim	shim screw	hex (mm)	clamp	clamp screw	hex (mm)
right hand													
NKLCR1616H11	16	16	20,0	100	0.0	0.0	KC..110305R	**SM885**	**MS959**	3 mm	**CM68**	**MS524**	3 mm
NKLCR2020K11	20	20	25,0	125	0.0	0.0	KC..110305R	**SM885**	**MS959**	3 mm	**CM68**	**MS524**	3 mm
NKLCR2525M11	25	25	32,0	150	0.0	0.0	KC..110305R	**SM885**	**MS959**	3 mm	**CM68**	**MS524**	3 mm
left hand													
NKLCL2020K11	20	20	25,0	125	0.0	0.0	KC..110305L	**SM886**	**MS959**	3 mm	**CM68**	**MS524**	3 mm
NKLCL2525M11	25	25	32,0	150	0.0	0.0	KC..110305L	**SM886**	**MS959**	3 mm	**CM68**	**MS524**	3 mm

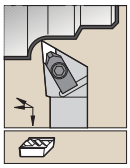


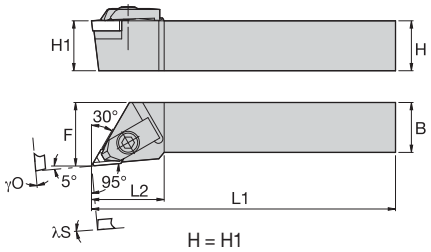


NKLC-F 95°

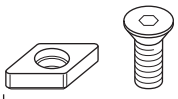
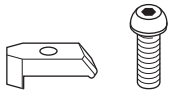


catalogue number	H	B	F	L1	λS°	γO°	gage insert	shim	shim screw	hex (mm)	clamp	clamp screw	hex (mm)
right hand													
NKLCRF1212M11Q	12	12	12,0	150	0.0	0.0	KC..110305R	**SM885**	**MS959**	3 mm	**CM180**	**MS524**	3 mm

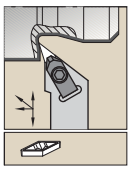


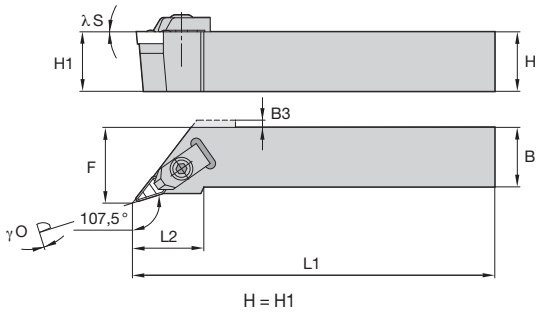


NKLN 95°

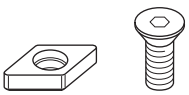
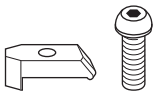



catalogue number	H	B	F	L1	λS°	γO°	gage insert	shim	shim screw	hex (mm)	clamp	clamp screw	hex (mm)
right hand													
NKLNR2020K15	20	20	25,0	125	-2.0	-5.0	KN..150410R	**SM872**	**MS111**	2 mm	**CM66**	**MS625**	4 mm
NKLNR2525M15	25	25	32,0	150	-2.0	-5.0	KN..150410R	**SM872**	**MS111**	2 mm	**CM66**	**MS625**	4 mm
left hand													
NKLNL2020K15	20	20	25,0	125	-2.0	-5.0	KN..150410L	**SM871**	**MS111**	2 mm	**CM66**	**MS625**	4 mm
NKLNL2525M15	25	25	32,0	150	-2.0	-5.0	KN..150410L	**SM871**	**MS111**	2 mm	**CM66**	**MS625**	4 mm

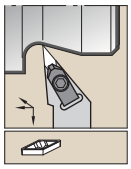


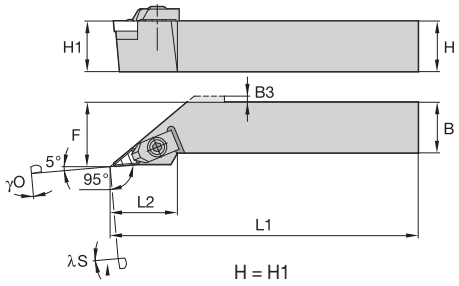


NVHB 107,5°

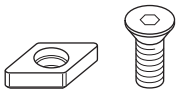
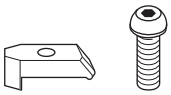



catalogue number	H	B	F	L1	LH	λS°	γO°	gage insert	shim	shim screw	hex (mm)	clamp	clamp screw	hex (mm)
right hand														
NVHBR2020K11	20	20	25,0	125	30,0	0.0	0.0	VB..110304	**SM813**	**MS959**	2.5 mm	**CM158**	**MS518**	2.5 mm
NVHBR2525M11	25	25	32,0	150	30,0	0.0	0.0	VB..110304	**SM813**	**MS959**	2.5 mm	**CM158**	**MS518**	2.5 mm
left hand														
NVHBL2020K11	20	20	25,0	125	30,0	0.0	0.0	VB..110304	**SM813**	**MS959**	2.5 mm	**CM159**	**MS518**	2.5 mm
NVHBL2525M11	25	25	32,0	150	30,0	0.0	0.0	VB..110304	**SM813**	**MS959**	2.5 mm	**CM159**	**MS518**	2.5 mm

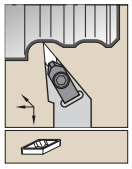


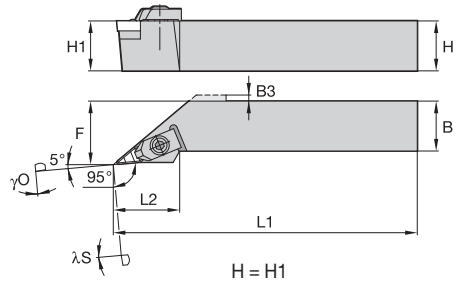


NVLB 95°

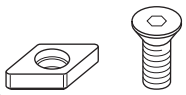
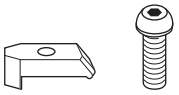



catalogue number	H	B	F	L1	LH	λS°	γO°	gage insert	shim	shim screw	hex (mm)	clamp	clamp screw	hex (mm)
right hand														
NVLBR2020K11	20	20	25,0	125	30,0	0.0	0.0	VB..110304	**SM813**	**MS959**	2.5 mm	**CM158**	**MS518**	2.5 mm
NVLBR2525M11	25	25	32,0	150	32,0	0.0	0.0	VB..110304	**SM813**	**MS959**	2.5 mm	**CM158**	**MS518**	2.5 mm
left hand														
NVLBL2020K11	20	20	25,0	125	30,0	0.0	0.0	VB..110304	**SM813**	**MS959**	2.5 mm	**CM159**	**MS518**	2.5 mm
NVLBL2525M11	25	25	32,0	150	32,0	0.0	0.0	VB..110304	**SM813**	**MS959**	2.5 mm	**CM159**	**MS518**	2.5 mm

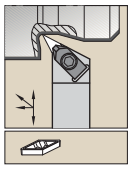


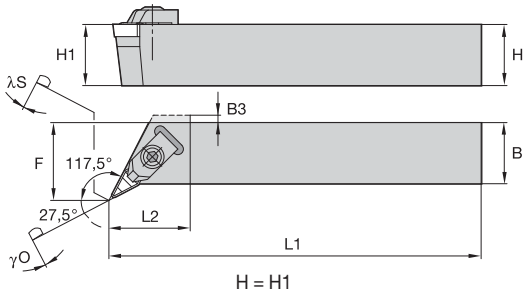


NVLC 95°

catalogue number	H	B	F	L1	LH	B3	λS°	γO°	gage insert	shim	shim screw	hex (mm)	clamp	clamp screw	hex (mm)
right hand															
NVLCR1616H16	16	16	20,0	100	37,0	5,0	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM113**	**MS412**	4 mm
NVLCR2020K16	20	20	25,0	125	37,0	—	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM113**	**MS412**	4 mm
NVLCR2525M16	25	25	32,0	150	37,0	—	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM113**	**MS412**	4 mm
NVLCR3225P16	32	25	32,0	170	37,0	—	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM113**	**MS412**	4 mm
left hand															
NVLCL2020K16	20	20	25,0	125	37,0	—	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM114**	**MS412**	4 mm
NVLCL2525M16	25	25	32,0	150	37,0	—	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM114**	**MS412**	4 mm
NVLCL3225P16	32	25	32,0	170	37,0	—	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM114**	**MS412**	4 mm

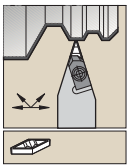


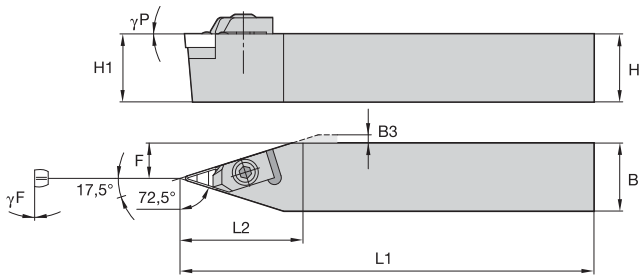


NVOC 117,5°

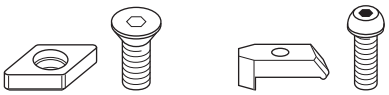


catalogue number	H	B	F	L1	LH	B3	λS°	γO°	gage insert	shim	shim screw	hex (mm)	clamp	clamp screw	hex (mm)
right hand															
NVOCR2020K16	20	20	32,0	125	29,0	3,0	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM113**	**MS412**	4 mm
NVOCR2525M16	25	25	32,0	150	29,0	3,0	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM113**	**MS412**	4 mm
left hand															
NVOCL2020K16	20	20	32,0	125	29,0	3,0	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM114**	**MS412**	4 mm
NVOCL2525M16	25	25	32,0	150	29,0	3,0	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM114**	**MS412**	4 mm

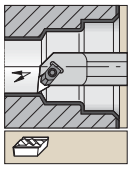




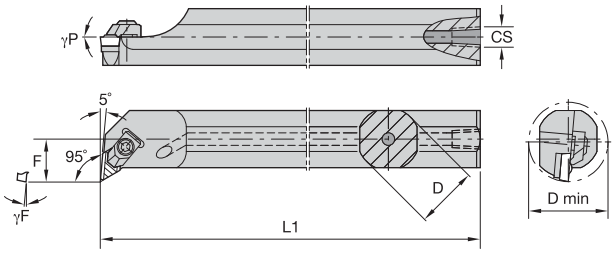
NVVC 72,5°



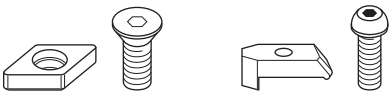
catalogue number	H	B	F	L1	LH	B3	γF°	γP°	gage insert	shim	shim screw	hex (mm)	clamp	clamp screw	hex (mm)
NVVCN2020K16	20	20	10,0	125	42,0	2,0	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM113**	**MS412**	4 mm
NVVCN2525M16	25	25	12,5	150	42,0	—	0.0	0.0	VC..160408	**SM812**	**MS959**	4 mm	**CM113**	**MS412**	4 mm



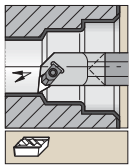
Steel shank with through coolant.



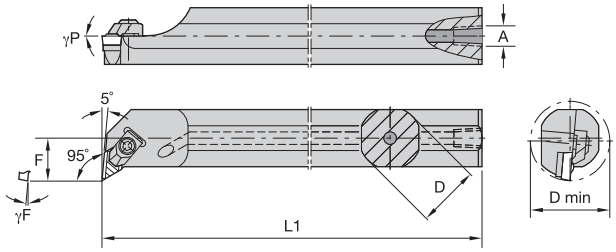
A-NKLC 95°



catalogue number	D	D min	F	L1	CS	γF°	γP°	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand														
A12MNKLCR11	12	16,0	9,0	150	1/16-27 NPT	-5.0°	0.0°	KC..110305R	—	—	2.5 mm	**CM106**	**MS518**	2.5 mm
A16MNKLCR11	16	20,0	11,0	150	1/8-27 NPT	-7.0°	0.0°	KC..110305L	**SM886**	**MS959**	2.5 mm	**CM106**	**MS518**	2.5 mm
A20QNKLCR11	20	25,0	13,0	180	1/8-27 NPT	-5.0°	0.0°	KC..110305L	**SM886**	**MS959**	3 mm	**CM68**	**MS524**	3 mm
A25RNKLCR11	25	32,0	16,0	200	1/4-18 NPT	-5.0°	0.0°	KC..110305L	**SM886**	**MS959**	3 mm	**CM68**	**MS524**	3 mm
A32SNKLCR11	32	40,0	22,0	250	1/4-18 NPT	-5.0°	0.0°	KC..110305L	**SM886**	**MS959**	3 mm	**CM68**	**MS524**	3 mm
left hand														
A12MNKLCL11	16	20,0	11,0	150	1/8-27 NPT	-7.0°	0.0°	KC..110305L	—	—	2.5 mm	**CM106**	**MS518**	2.5 mm
A16MNKLCL11	16	20,0	11,0	150	1/8-27 NPT	-7.0°	0.0°	KC..110305R	**SM885**	**MS959**	2.5 mm	**CM105**	**MS518**	2.5 mm
A20QNKLCL11	20	25,0	13,0	180	1/8-27 NPT	-5.0°	0.0°	KC..110305R	**SM885**	**MS959**	3 mm	**CM68**	**MS524**	3 mm
A25RNKLCL11	25	32,0	16,0	200	1/4-18 NPT	-5.0°	0.0°	KC..110305R	**SM885**	**MS959**	3 mm	**CM68**	**MS524**	3 mm



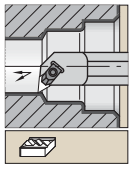
Carbide shank with through coolant.



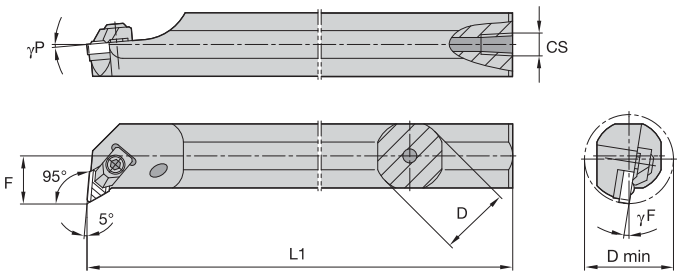
E-NKLC 95°



catalogue number	D	D min	F	L1	A	γF°	γP°	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand														
E12QNKLCR11	12	16,0	9,0	180	4,8	-5.0°	0.0°	KC..110308L	–	–	2.5 mm	**CM106**	**MS518**	2.5 mm
E16RNKLCR11	16	20,0	11,0	200	5,5	-5.0°	0.0°	KC..110308L	**SM886**	**MS959**	2.5 mm	**CM106**	**MS518**	2.5 mm
left hand														
E12QNKLCL11	12	16,0	9,0	180	4,8	-5.0°	0.0°	KC..110308R	–	–	2.5 mm	**CM105**	**MS518**	2.5 mm



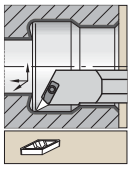
Steel shank with through coolant.



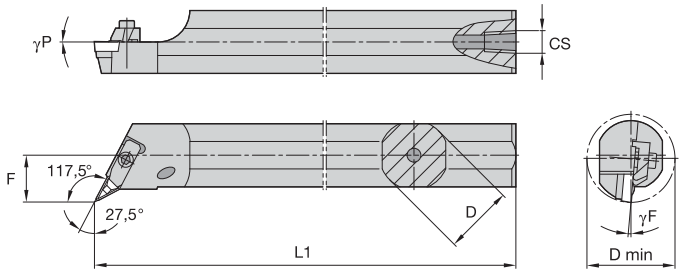
A-NKLN 95°



catalogue number	D	D min	F	L1	CS	γF°	γP°	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand														
A40TNKLNR15	40	50,0	27,0	300	1/4-18 NPT	-5.0°	-5.0°	KN..150410L	**SM871**	**MS111**	4 mm	**CM66**	**MS624**	4 mm



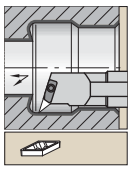
Steel shank with through coolant.



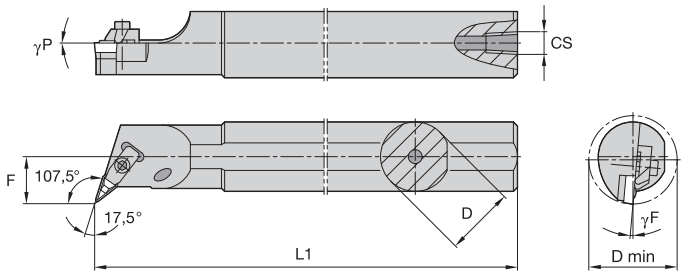
A-NVOC 117,5°



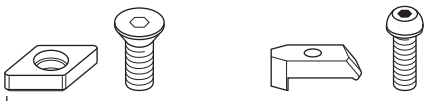
catalogue number	D	D min	F	L1	CS	γF°	γP°	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand														
A32SNVOCR16	32	40,0	22,0	250	1/4-18 NPT	-2.0°	0.0°	VC..160408	**SM812**	**MS959**	4 mm	**CM113**	**MS412**	4 mm
A50UNVOCR16	50	63,0	35,0	350	1/4-18 NPT	-2.0°	0.0°	VC..160408	**SM812**	**MS959**	4 mm	**CM113**	**MS412**	4 mm
left hand														
A32SNVOCL16	32	40,0	22,0	250	1/4-18 NPT	-2.0°	0.0°	VC..160408	**SM812**	**MS959**	4 mm	**CM114**	**MS412**	4 mm
A40TNVOCL16	40	50,0	27,0	300	1/4-18 NPT	-2.0°	0.0°	VC..160408	**SM812**	**MS959**	4 mm	**CM114**	**MS412**	4 mm



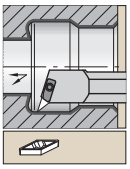
Steel shank with through coolant.



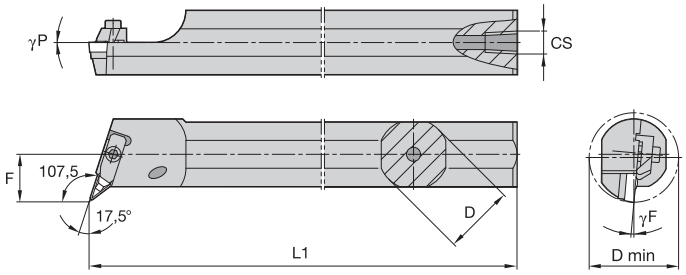
A-NVQB 107,5°



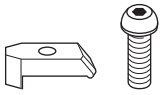
catalogue number	D	D min	F	L1	CS	γF°	γP°	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand														
A25TNVQBR11	25	32,0	17,0	300	1/4-18 NPT	-5.0°	0.0°	VB..110304	**SM813**	**MS959**	2.5 mm	**CM159**	**MS518**	2.5 mm



Steel shank with through coolant.



A-NVQC 107,5°

catalogue number	D	D min	F	L1	CS	γF°	γP°	gage insert	shim	shim screw	hex	clamp	clamp screw	hex
right hand														
A32SNVQCR16	32	40,0	22,0	250	1/4-18 NPT	-2.0°	0.0°	VC..160408	**SM812**	**MS959**	4 mm	**CM113**	**MS412**	4 mm

Railroad

The intimate understanding Kennametal provides of the economics of the railroad value chain enables us to offer unparalleled custom solutions tailored to your needs. We deliver superior value because we listen closely to you, our customer, and innovate based on your feedback. Our goal is to help you be more competitive — both locally and on a global scale.



Best Practices in Productivity

As your trusted partner for optimised production, Kennametal offers customers a unique commitment to research and development excellence, leading to continued delivery of highly innovative ways to enhance your productivity. Certification to ISO 9001. QS 9000 TES, and VDA 6.4 guarantees the highest possible quality standards.

Best Performance, Less Environmental Impact

With technology, we can do both. Kennametal helps customers focus on the root causes of unsustainable behaviour in highly complex manufacturing systems, while at the same time improving cost structure, quality, and performance. In addition to offering the latest in metalcutting tools and technology, our Advanced Engineering Team will analyse your existing production processes and help you identify new methods to improve your overall performance.

Wheel Lathe Tooling

Kennametal railroad tooling incorporates a unique locking unit design developed through years of testing on all types of wheel lathes and machining wheels with all types of tread surfaces.

This heavy-duty, rugged design has proven to be effective in reducing machining costs on tread turning applications, the most severe machining operation encountered in wheel and axle shops.

Strong inserts, with raised chipbreaker land and honed cutting edges, offer more effective chip control and a stronger cutting edge. Combining this tool geometry with the Kennametal grade selection delivers higher wheel turning productivity.



Wheelset

Advantages of Kennametal Wheel Lathe Tools:

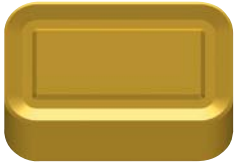
- No top clamp to wear out or interfere with chip flow.
- Insert locks against two walls in the toolholder to prevent insert movement under heavy cutting loads.
- Hardened steel locking unit provides positive insert seating and holder protection.
- Fast, trouble-free insert indexing — just unlock one screw to release the insert.
- Quick removal of the steel locking unit and insert for cleaning or replacement.
- Heavy-duty steel locking unit design ensures longer life and helps reduce operating costs.
- Fewer parts to inventory.
- Toolholders and steel locking units, made from heat-treated alloy steel, provide support to withstand severe roughing cuts on work-hardened wheels.

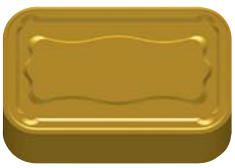

LNUX-RRF Full Radius


LNUX-RRP Full Radius


LNUX-RRH


LNUX-RRP

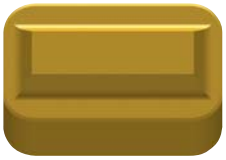

KRR6586-71


KRR6586-75


LNUX-RRSM


KRR6586-65


KRR6586-52

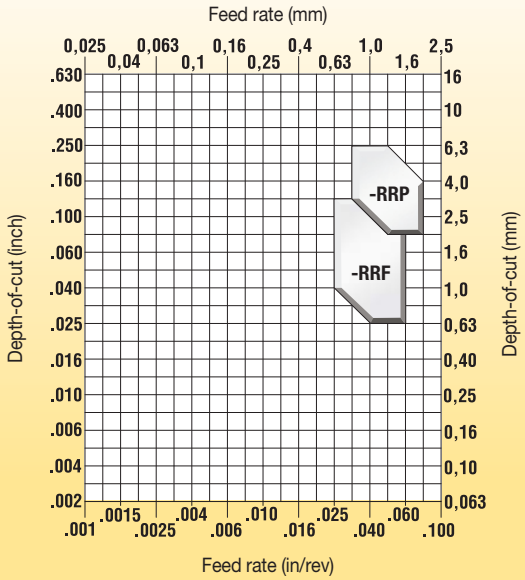

KRR6586-50

LNUX

Full-Radius Design

Our well-performed chipbreaking geometry RRF and RRP

- One insert can be applied in profiling and facing.
- Chip control even at smaller DOC will be improved!




-RRP

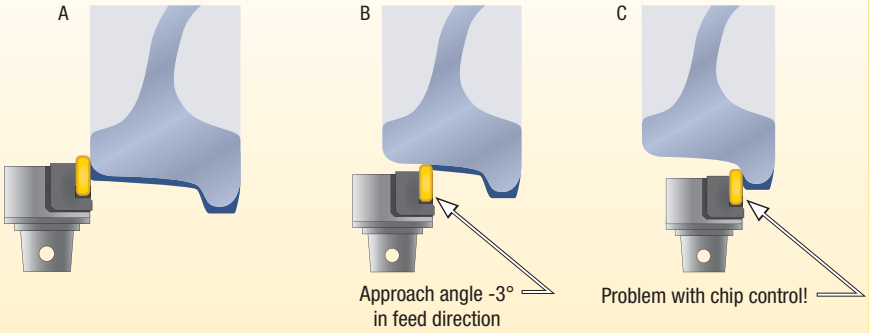

-RRF

Application Recommendation

A: At the beginning of the process, the DOC is higher because most of the bigger bur needs to be removed.

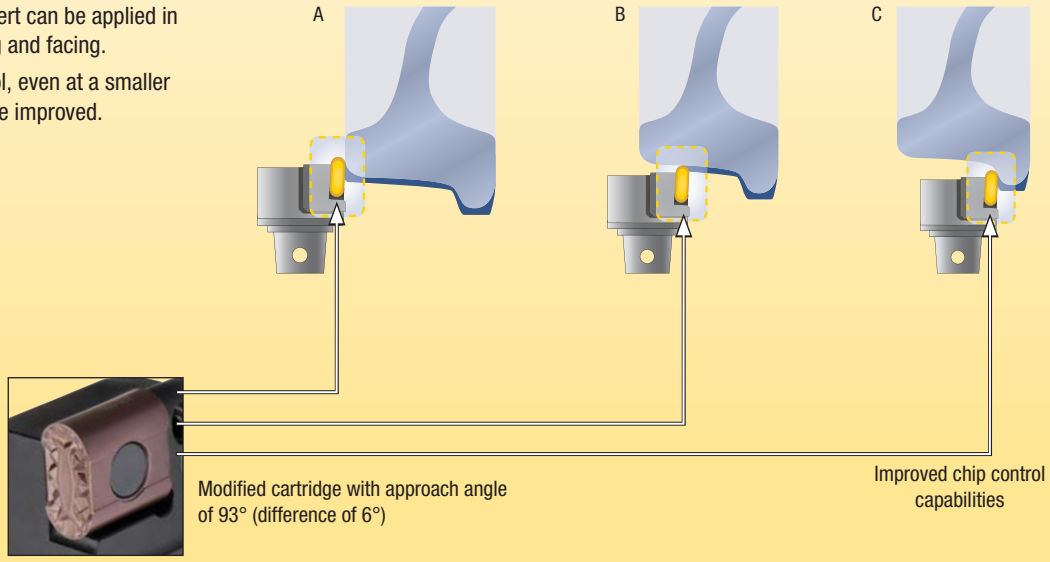
B: The DOC is smaller, but sometimes it has “hot spots” or brake spots.

C: Most critical area in regards to chip control because the thickness of the chip is quite thin and very diffficult to manage.

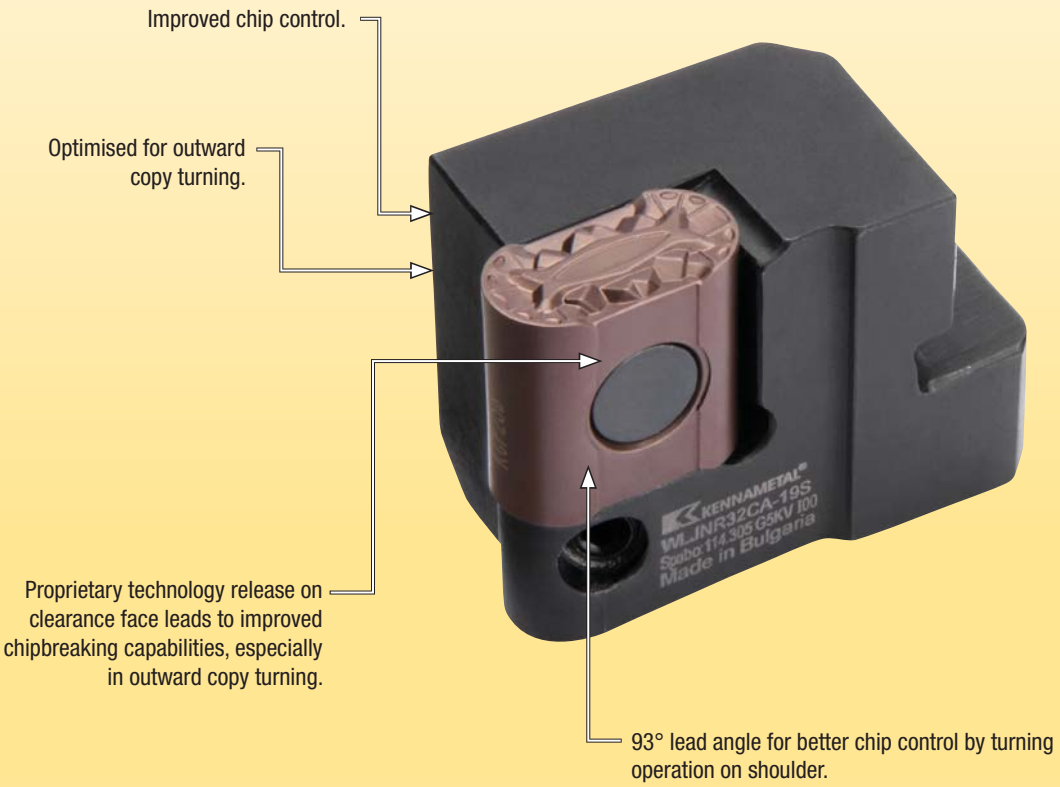


A, B, & C: One insert can be applied in profiling and facing.

A & C: Chip control, even at a smaller DOC, will be improved.



Features and Benefits

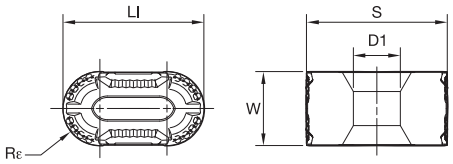


- The well performed RRF and RRP chipbreaker geometry with a full-radius design offers better chip control even at smaller DOC.

● first choice
○ alternate choice

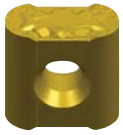
P		●	●
M			
K			
N			
S			
H			

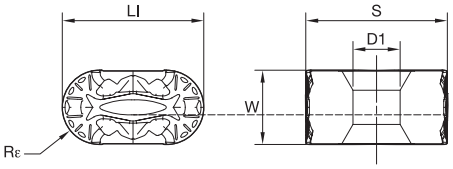




LNUX-RRF Full-Radius

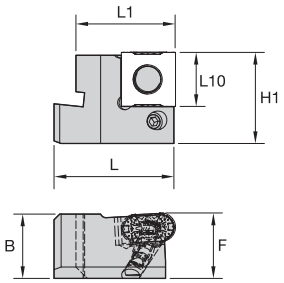
ISO catalogue number	W	LI	S	Rε	D1	KCP10B	KCP25B
LNUX191950RRF	10,00	19,05	19,05	5,00	6,35	●	●

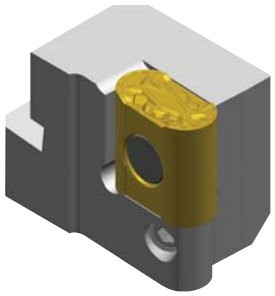




LNUX-RRP Full-Radius

ISO catalogue number	W	LI	S	Rε	D1	KCP10B	KCP25B
LNUX191950RRP	10,00	19,05	19,05	5,00	6,35	●	●
LNUX301960RRP	12,00	30,00	19,05	6,00	6,35	●	●



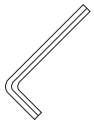


Cartridge WLJN

order number	catalogue number	H1	B	F	L10	L1	L	gage insert
6049016	WLJNL32CA19S	1.260	.890	.906	.750	1.38	1.681	LNUX191950RRP
6049018	WLJNL32CA30S	1.260	.890	.925	1.181	1.38	1.772	LNUX301960RRP
6049015	WLJNR32CA19S	1.260	.890	.906	.750	1.38	1.681	LNUX191950RRP
6049017	WLJNR32CA30S	1.260	.890	.925	1.181	1.38	1.772	LNUX301960RRP

Spare Parts

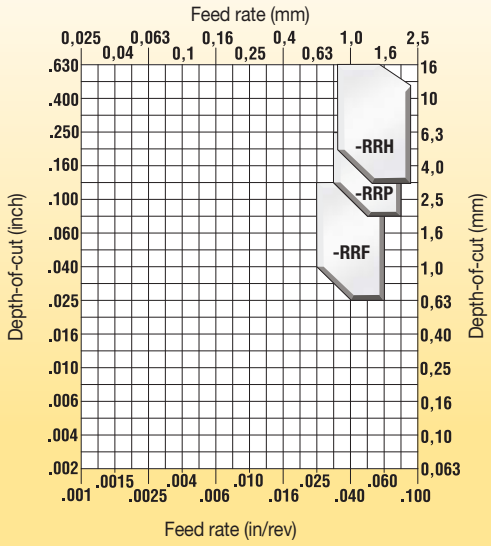




catalogue number	clamp stud	clamp screw	hex wrench
WLJNL32CA19S	114.305	121.616	170.003
WLJNL32CA30S	114.305	121.616	170.003
WLJNR32CA19S	114.305	121.616	170.003
WLJNR32CA30S	114.305	121.616	170.003

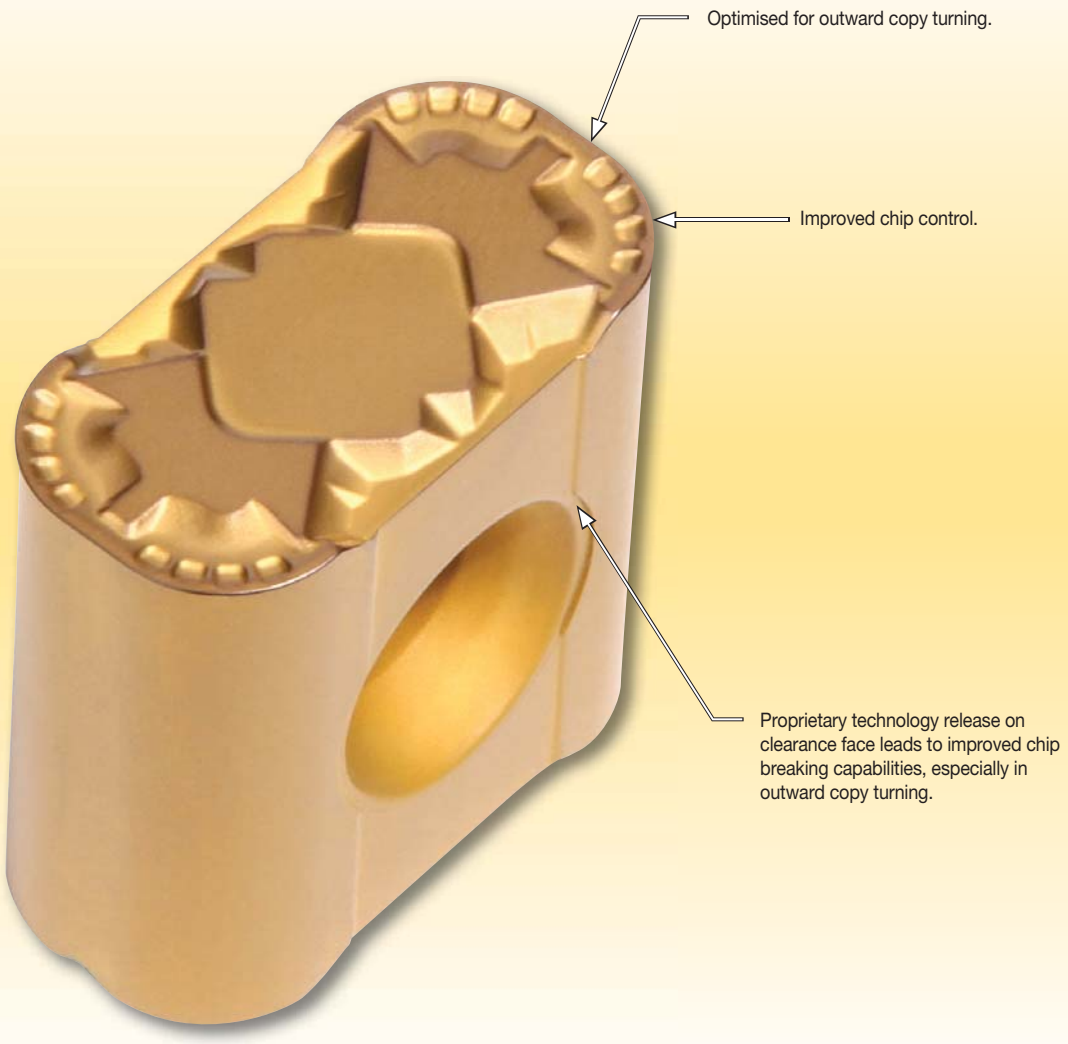
New Chipbreaking Geometry

For Rail Wheel Machining — RRF





Small DOC Re-Profiling

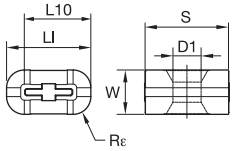


Kennametal stocks a complete line of standard inserts for wheel and axle machining. Inserts are available in various styles, sizes, and grades.

- **Wheel boring** — moulded chipbreaker inserts in round, square, octagon, and regrindable inserts.
- **Axle turning** — triangle- and diamond-shaped inserts with chipbreakers.
- **Wheel turning** — rectangular and square styles, with or without moulded chipbreakers.
- **Wheel truing** — round buttons with centre hole for locking.

● first choice
○ alternate choice





LNUX-RRF

ISO catalogue number	W	LI	L10	S	Rε	D1	KCP10B	KCP10	KCP25B	KCP25
LNUX191940RRF	10,00	19,00	19,00	19,05	4,00	6,35	–	●	–	●
LNUX301940RRF	12,00	30,00	30,00	19,05	4,00	6,35	–	●	–	–

NOTE: Also available in KC9105™.

LNUX-RRH

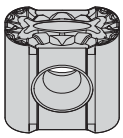
ISO catalogue number	W	LI	L10	S	Rε	D1	KCP10B	KCP10	KCP25B	KCP25
LNUX191940RRH	10,00	19,00	19,00	19,05	4,00	6,35	–	●	–	●
LNUX301940RRH	12,00	30,00	30,00	19,05	4,00	6,35	●	–	–	●

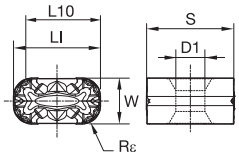
NOTE: Also available in KC9105.

Kennametal stocks a complete line of standard inserts for wheel and axle machining. Inserts are available in various styles, sizes, and grades.

- **Wheel boring** — moulded chipbreaker inserts in round, square, octagon, and regrindable inserts.
- **Axle turning** — triangle- and diamond-shaped inserts with chipbreakers.
- **Wheel turning** — rectangular and square styles, with or without moulded chipbreakers.
- **Wheel truing** — round buttons with centre hole for locking.

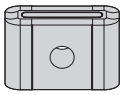
● first choice
○ alternate choice

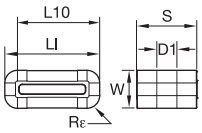




LNUX-RRP

ISO catalogue number	W	LI	L10	S	Rε	D1	P	M	K	N	S	H
							KCP10B	KCP10	KCP25B	KCP25		
LNUX191940RRP	10,00	19,00	19,00	19,05	4,00	6,35	–	●	–	●		
LNUX301940RRP	12,00	30,00	30,00	19,05	4,00	6,35	–	–	–	●		





LNUX-RRSM

ISO catalogue number	W	LI	L10	S	Rε	D1	P	M	K	N	S	H
							KCP10B	KCP10	KCP25B	KCP25		
LNUX191940RRSM	10,00	19,00	19,00	19,05	4,00	6,35	–	–	●	–		
LNUX301940RRSM	12,00	30,00	30,00	19,05	4,00	6,35	●	–	–	–		

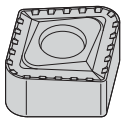
NOTE: Also available in KC9105™.

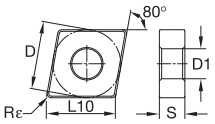
Kennametal stocks a complete line of standard inserts for wheel and axle machining. Inserts are available in various styles, sizes, and grades.

- **Wheel boring** — moulded chipbreaker inserts in round, square, octagon, and regrindable inserts.
- **Axle turning** — triangle- and diamond-shaped inserts with chipbreakers.
- **Wheel turning** — rectangular and square styles, with or without moulded chipbreakers.
- **Wheel truing** — round buttons with centre hole for locking.

● first choice
○ alternate choice

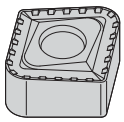
P		●	●	●	●
M					
K			●	●	●
N					
S					
H					

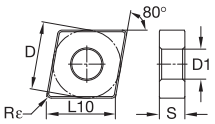




CNMM-RRP

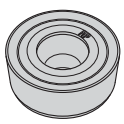
ISO catalogue number	L10	S	Rε	D1	KCP10B	KCP10	KCP25B	KCP25
CNMM190740RRP	19,34	7,94	4,00	7,93	●	–	–	–

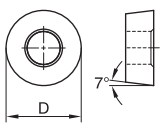




LNUX-WT5

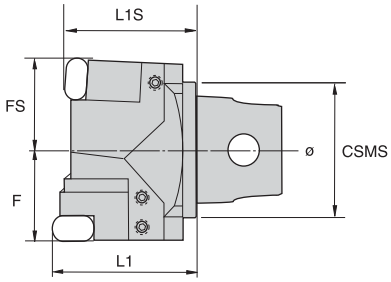
ISO catalogue number	L10	S	Rε	D1	KCP10B	KCP10	KCP25B	KCP25
LNUX191940S-WT5	19,05	19,05	4,00	6,35	–	–	●	–
SNMX190640S-WT5	19,05	6,35	4,00	6,35	–	–	●	–





RCMX

ISO catalogue number	L10	S	Rε	D1	KCP10B	KCP10	KCP25B	KCP25
RCMX2507M076	–	7,94	–	7,40	–	–	●	–



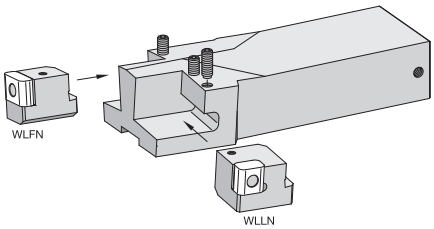


TK

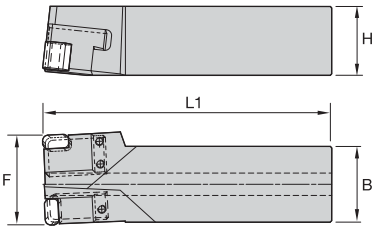
order number	catalogue number	CSMS system size	F	FS	L1	L1S
1781755	**TK01338D**	KM63	42,50	42,50	66,00	60,00
1781756	**TK01339D**	KM63	42,50	42,50	66,00	60,00

Assembly Instructions

basic/KM shank	cartridge WLLN..	cartridge WLFN..
right	right	left
left	left	right

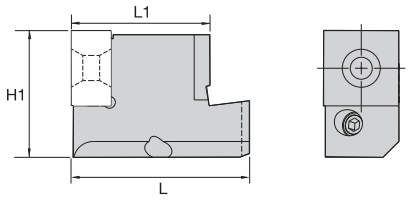


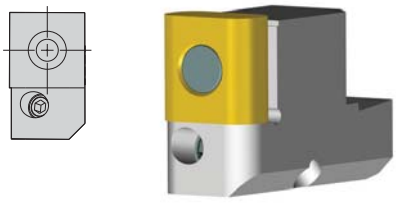
Assembly of complete tool

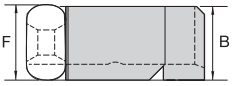


Basic Shank WXXN

order number	catalogue number	H mm	H in	B mm	B in	F assembly mm	F assembly in	L1 assy mm	L1 assy in	clamp screw
1251261	**WXXNL4455X-FL**	50,00	1.969	55,00	2.165	65,00	2.559	210,00	8.268	**PT00163**
1251262	**WXXNR4455X-FL**	50,00	1.969	55,00	2.165	65,00	2.559	210,00	8.268	**PT00163**







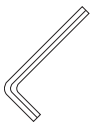
Cartridge WLFN

order number	catalogue number	H1	B	F	L1	L	insert 1
2435188	WLFNL32CA19S	32,00	18,60	19,00	35,00	42,70	LNUX191940...
2435187	WLFNR32CA19S	32,00	18,60	19,00	35,00	42,70	LNUX191940...

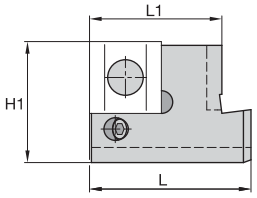
Spare Parts

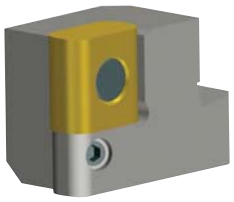


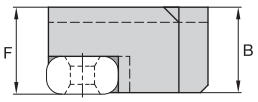




catalogue number	clamp stud	clamp screw	hex wrench
WLFNL32CA19S	114.305	121.616	170.003
WLFNR32CA19S	114.305	121.616	170.003







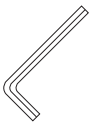
Cartridge WLLN

order number	catalogue number	H1	B	F	L1	L	insert 1
2435184	WLLNL32CA19S	32,00	22,60	23,00	35,00	42,70	LNUX191940...
2435186	WLLNL32CA30S	32,00	22,60	23,00	35,00	42,70	LNUX301940...
2435183	WLLNR32CA19S	32,00	22,60	23,00	35,00	42,70	LNUX191940...
2435185	WLLNR32CA30S	32,00	22,60	23,00	35,00	42,70	LNUX301940...

Spare Parts







catalogue number	clamp stud	clamp screw	hex wrench
WLLNL32CA19S	114.305	121.616	170.003
WLLNL32CA30S	114.305	121.616	170.003
WLLNR32CA19S	114.305	121.616	170.003
WLLNR32CA30S	114.305	121.616	170.003

Wheel and Wheelset Truing with Beyond™ RU and UP Geometries

Kennametal tooling incorporates the latest technology for maximum metal removal and higher productivity. Standard off-the-shelf inserts and fewer pieces of hardware reduce inventory and operating costs. These tools are for reconditioning mounted wheel sets, wheel boring, wheel truing, axle turning, and journal burnishing.



Features and Benefits

Advantages of Kennametal Wheel Lathe Tools

- Heavy-duty steel locking unit.
- No top clamp to wear out or interfere with chip flow.
- Hardened-steel locking unit prevents insert movement.
- Quick removal of the steel locking unit.
- Fast trouble-free insert indexing.
- Withstand severe roughing cuts on work-hardened wheels.

Achieve superior results while lowering production time and maintenance costs in these tough conditions:

- Skid flat areas.
- Accidental torch burns.
- Overheating of spinning wheels.
- Excessive mushroom and rollovers that are hardened by unusual hump retarder pressure.
- Mismatched wheels that cause excessive wear on the flange side.





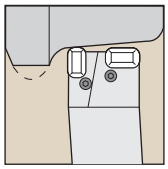
RU–Roughing Universal

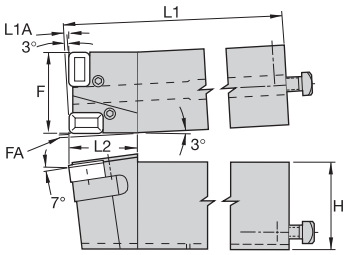




UP–Universal Positive

- Fully automatic, heavy-duty wheel lathe with integrated measuring device to determine wheel set profile wear.
- Portal-type machine bed enables roll-through operation.
- Suitable for machining wheel sets for locomotives, transit, passenger, and freight cars.



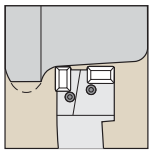


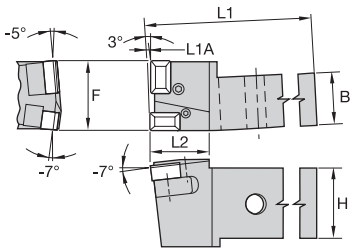
Tread Profile Truing

order number	catalogue number	H	F	L1	L2	FA	L1A	insert 1
1015754	**HUWTCL**	80,00	76,20	275,00	63,50	3,00	3,00	KRR6586__
1015723	**HUWTCR**	80,00	76,20	275,00	63,50	3,00	3,00	KRR6586__

NOTE: Requires two inserts.

- Maximum productivity at minimum operating costs.
- Fast insert indexing while tool is mounted in the tool block.
- Individual steel locking units make it easy to index and lock each insert.
- Gage location on tool, over insert, is held to +/- 0,08mm.
- No top clamp to wear out or interfere with chip flow.
- Replaceable steel locking unit protects toolholder from damage.
- Improved inserts with chip control.



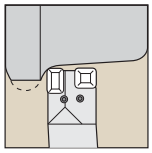


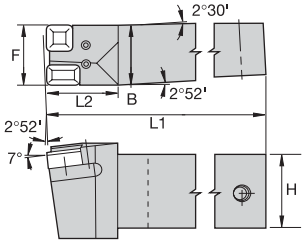
Wheel Tread Contouring

order number	catalogue number	H	B	F	L1	L2	L1A	insert 1
1015688	**FUWTCL**	76,20	57,15	76,20	254,00	66,55	3,05	KRR6586__
1015687	**FUWTCR**	76,20	57,15	76,20	254,00	66,55	3,05	KRR6586__

NOTE: Requires two inserts.

- Maximum productivity at minimum operating costs.
- Fast insert indexing tool mounted in tool block.
- Individual steel locking units make it easy to index and lock each insert.
- Minimum parts for lower inventory.
- No top clamp to wear out or interfere with chip flow.
- Replaceable steel locking unit protects toolholder from damage.
- Indexable inserts with pre-formed chipbreakers deliver chip control at optimum feeds and speeds.

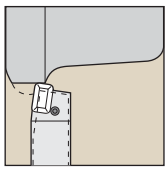


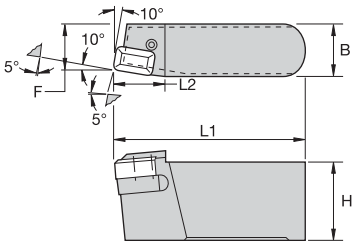


Wheel Tread Contouring

order number	catalogue number	H	B	F	L1	L2	insert 1
1015659	**SUWTCL**	76,20	57,15	57,15	254,00	66,55	KRR6586__
1015658	**SUWTCR**	76,20	57,15	57,15	254,00	66,55	KRR6586__

NOTE: Requires two inserts.

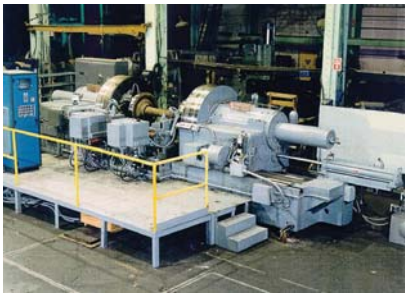




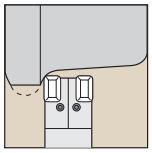
Wheel Flange Topping

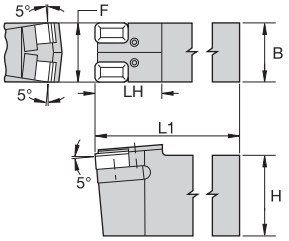
order number	catalogue number	H	B	F	L1	L2	insert 1
1015690	**NUFRL**	63,50	41,28	36,53	152,40	39,62	KRR6586__
1015689	**NUFRR**	63,50	41,28	36,53	152,40	39,62	KRR6586__

- Maximum productivity at minimum operating costs.
- Fast insert indexing tool mounted in tool block.
- Individual steel locking units make it easy to index and lock each insert.
- Gage location on tool, over insert, is held to +/- 0,08mm.
- No top clamp to wear out or interfere with chip flow.
- Replaceable steel locking unit protects toolholder from damage.
- Indexable inserts with pre-formed chipbreakers deliver chip control at optimum feeds and speeds.



Simmons-Niles Wheel Turning Lathe



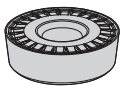


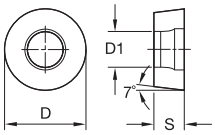
Wheel Tread Contouring

order number	catalogue number	H	B	F	L1	LH	insert 1	steel locking unit	lock screw
1015684	**NUWTC**	76,20	57,15	57,15	412,75	95,25	KRR6586__	**SU3**	**S1006PKG**

NOTE: Requires two inserts.

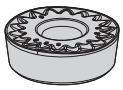
● first choice
○ alternate choice

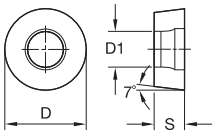




RCMH-UPG

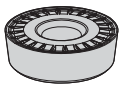
ISO catalogue number	D	D1	S	KCK15B	KCK20	KCP10	KCP10B	KCP25	KCP25B	KCPK05	KCU10
				P		○	●	●	●	●	○
				M							●
				K	●	●	○	○	○		○
				N							○
				S							●
				H							○
RCMH2507M0TUPG	25	7,55	7,94	–	–	–	●	–	●	–	–
RCMH3209M0TUPG	32	10,35	9,52	–	–	–	●	–	●	–	–

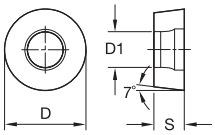




RCMH-RU

ISO catalogue number	D	D1	S	KCK15B	KCK20	KCP10	KCP10B	KCP25	KCP25B	KCPK05	KCU10
RCMH2507M0RU	25	7,55	7,94	–	–	–	–	●	–	–	–
RCMH3209M0RU	32	10,35	9,53	–	–	–	–	●	–	–	–





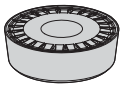
RCMT-UPG

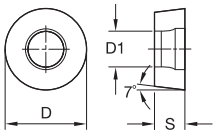
ISO catalogue number	D	D1	S	KCK15B	KCK20	KCP10	KCP10B	KCP25	KCP25B	KCPK05	KCU10
RCMT1606M0UPG	16	5,50	6,35	●	–	–	●	–	●	●	–
RCMT2006M0UPG	20	6,50	6,35	●	–	–	●	–	●	●	–

Application Specific

● first choice
○ alternate choice

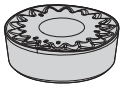
		KCK15B	KCK20	KCP10	KCP10B	KCP25	KCP25B	KCPK05	KCU10
P		○	●	●	●	●	●	○
M								●
K		●	●	○	○	○	○		○
N									○
S									●
H									○

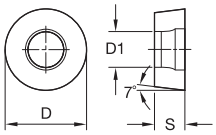




RCMX-UPG

ISO catalogue number	D	D1	S	KCK15B	KCK20	KCP10	KCP10B	KCP25	KCP25B	KCPK05	KCU10
RCMX2507M0TUPG	25	7,19	7,94	–	–	–	●	–	●	–	–
RCMX3209M0TUPG	32	9,78	9,52	–	–	–	●	–	●	–	–





RCMX-RU

ISO catalogue number	D	D1	S	KCK15B	KCK20	KCP10	KCP10B	KCP25	KCP25B	KCPK05	KCU10
RCMX2507M0RU	25	7,19	7,94	–	●	–	–	–	–	–	–
RCMX3209M0RU	32	9,78	9,53	–	●	●	–	–	–	–	–

K-Lock™ Inserts

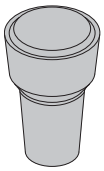


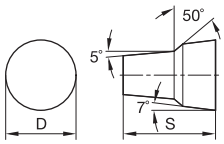
Features and Benefits

- K-Lock inserts are ideal for deep grooving and profiling.
- A unique insert clamping system enables unimpeded chip flow.
- Available in moulded and ground peripheries.

● first choice
○ alternate choice

		K68	KCU10	KCU25	KC5010	KC5025	KC5410
P			○	○	○	○	
M			●	●	●	●	
K		○					
N		●	○				●
S		●	●	●	●	●	
H							

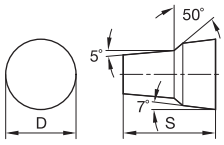




RCGK-FS

ISO catalogue number	D	S	K68	KCU10	KCU25	KC5010	KC5025	KC5410
RCGK040300FS	4,76	6,38	–	●	–	–	–	–
RCGK060400FS	6,35	9,09	–	●	–	●	–	–
RCGK090700FS	9,53	13,23	–	●	–	●	●	–
RCGK120800FS	12,70	16,61	–	●	–	–	–	–

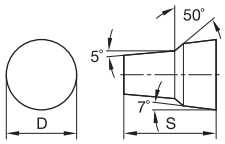




RCGK-HP

ISO catalogue number	D	S	K68	KCU10	KCU25	KC5010	KC5025	KC5410
RCGK040300HP	4,76	6,38	–	●	–	●	–	–
RCGK060400HP	6,35	9,09	–	●	–	●	–	●
RCGK090700HP	9,53	13,23	–	●	–	–	–	●
RCGK120800HP	12,70	16,61	–	●	–	–	–	●





RCMK

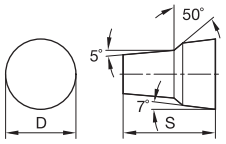
ISO catalogue number	D	S	K68	KCU10	KCU25	KC5010	KC5025	KC5410
RCMK040300	4,76	6,38	–	–	–	●	–	–
RCMK060400	6,35	9,09	–	●	–	●	–	–
RCMK090700	9,53	13,23	–	–	–	●	–	–
RCMK120800	12,70	16,61	–	–	–	●	–	–

- Medium geometry with positive rake face for chip control in difficult materials.

● first choice
○ alternate choice

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

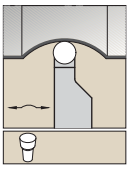


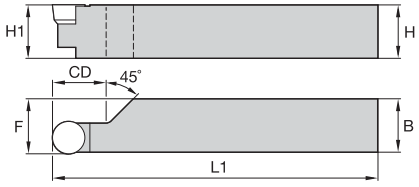


RCMK-MP

ISO catalogue number	D	L10	Rε	K68	KCU10	KCU25	KC5010	KC5025	KC5410	KCS10
RCMK060400MP	6,35	–	–	–	–	–	–	–	–	●
RCMK090700MP	9,53	–	–	–	–	–	–	–	–	●
RCMK120800MP	12,70	–	–	–	–	–	–	–	–	●

Application Specific

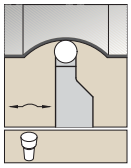


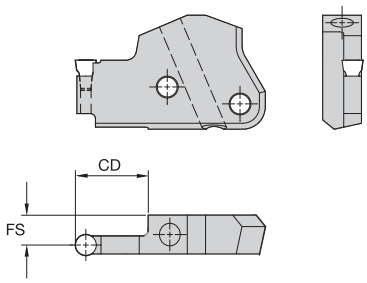


H = H1

TRAO

catalogue number	H1	B	F	L1	CD	gage insert
right hand						
TRAOR2525M04	25	25	25,4	150	20	RC..040300
TRAOR2525M06	25	25	25,5	150	20	RC..060400
TRAOR3225P06	32	25	25,5	170	20	RC..060400
left hand						
TRAOL2525M06	25	25	25,5	150	20	RC..060400





TRM

catalogue number	CD	FS	cartridge size	gage insert
right hand				
TRM50R0432M	32	9,62	50	RCMK152
TRM50R0620M	19	8,98	50	RCMK23
TRM50R0632M	32	8,98	50	RCMK-23
TRM50R0640M	38	8,98	50	RCGK23
TRM50R0720M	19	8,42	50	RCMK-2.55
TRM50R0920M	19	7,64	50	RC_K35
TRM50R0932M	32	7,65	50	RCMK-35
TRM50R0940M	38	7,64	50	RC_K35
TRM50R0950M	50	7,65	50	RCMK-35
left hand				
TRM50L0432M	32	9,62	50	RCMK152
TRM50L0620M	19	8,98	50	RCMK23
TRM50L0632M	32	8,98	50	RCMK-23
TRM50L0640M	38	8,98	50	RCGK23
TRM50L0920M	19	7,64	50	RC_K35
TRM50L0932M	32	7,65	50	RCMK-35
TRM50L0950M	50	7,65	50	RCMK-35

Order No.	Catalogue No.	Page(s)
1015658	SUWTCR	E58
1015659	SUWTCL	E58
1015684	NUWTC	E59
1015687	FUWTCR	E57
1015688	FUWTCL	E57
1015689	NUFRR	E58
1015690	NUFRL	E58
1015723	HUWTCR	E57
1015754	HUWTCL	E57
1016536	SM812 K9	E38–40, E42–43
1016544	SM837 K9	B172, B354, B378
1016546	SM840 K9	B170, B353–354
1016548	SM841 K9	B172–174, B354–355, B371
1016552	SM871 K9	E37, E41
1016574	SM872 K9	E37
1016576	SM885 K9	E36, E40
1016578	SM886 K9	E36, E40–41
1016582	SM449 K9	T102
1016602	SKTP343 K9	B247–248, B257
1016624	SKCP343 K9	B179–181
1016626	SKDP343 K9	B209–211
1016628	SKCP453 K9	B180, B182
1016644	IWSN433 K9	B161–164
1016648	ITSN323 K9	B132, B137
1016674	ISSN433 K9	B105, B107–108, B110
1016678	ICSN433 K9	B58–60, B66
1016680	IDSN433 K9	B85, B89–90
1016694	IDSN533 K9	B91
1017174	SMYE3 K9	D78–79, D81, D83–86
1017176	SMYI3 K9	D78–79, D81–86
1017178	SMYE4 K9	D78–79, D81, D83–84, D86
1017180	SMYI4 K9	D78–79, D81–86
1017220	ITSN322 K9	B133–134, B137, B139–141
1017222	ISSN332 K9	B109
1017226	IVSN322 K9	B149–153
1017228	SKVN343 K9	B266–268
1017230	IDSN432 K9	B86, B90–93
1017246	IRSN43 K9	B95
1017252	ICSN432 K9	B61–63, B67–68, B70–72
1017276	ITSN433 K9	B133–134, B139–141
1017278	ISSN432 K9	B109–110, B114–117, B119
1017282	IVSN432 K9	B151–152
1017296	ISSN533 K9	B108–109
1017298	ICSN533 K9	B61–63, B66–67, B72
1017300	ISSN633 K9	B108–110, B114–115, B119
1017334	ICSN633 K9	B61–63, B67–68, B72
1018407	CM105	E40–41
1018409	CM106	E40–41
1018413	CM109	C170, D37
1018525	CM66	E37, E41
1018527	CM68	E36, E40
1018531	CM-72	D31–33, D39
1018533	CM73	D31–33, D39
1018569	CM80	D32
1018571	CM81	D32
1018647	MW25	U27–35, V146–147
1018649	MW3	U40–49
1019821	MS1241	T109
1020545	MS1861	H76
1020575	CKM6	B62, B67, B151, B162, B164
1020577	CKM7	B86, B90, B162, B172, B354
1020581	CKM9	B133–134, B170, B173, B353–355
1020583	CKM10	B170, B173–174, B353–355, B371
1020595	CKM12	B61–63, B67–68, B91, B108–110, B114
1020597	CKM13	B172, B354
1020601	CKM19	B109, B172–174, B355, B371
1020603	CKM20	B68, B134, B164
1020605	CKM21	B61–63, B67–68, B95, B108–110, B114, B133–134, B137
1020607	CKM22	B86, B90–91, B153
1020645	CKM26	B151–152
1020653	CKM31	B151–153
1020657	CKM41	B72, B92
1020787	KUAM20	B199–205, B229, B260–262
1020789	KUAM22	B70–72, B92, B115–119, B139–141, B375, B378
1020791	KUAM23	B73, B183, B229, B235–237, B260–263, C171, D41–42
1020805	KUAM26	B72, C171, D41–42
1020807	KUAM27	B72, B115, B119, T81
1020809	KUAM28	B70, B73, B115–121, B142, B199, B202, B220–221, B240–242, B260–263, B376–378
1020811	KUAM30	B70, B115–119, B199, B202, B220–221, B240–242, B260–263, B376–378
1020813	KUAM31	B70–73, B92, B115–121, B139–142, B183, B229, B235–237, B260–263, B375, B378, C171, D41–42
1020835	KUAM32	B70–73, B92–93, B115–117, B119, B139–141, B183, B235, B378
1020839	KUAM34	B199–205, B229, B260–262
1020841	KUAM35	B199, B202, B204–205
1020843	KUAM25	B70–72, B92–93, B115–117, B119, B139–141, B183, B235, B378
1020917	SRS3	B179–181, B209–211, B227–228, B233–234, B247–248, B257, B266–268, B271, S41, T102
1020919	SRS4	B180, B182, B209–211, B213, B233–234
1020923	SSY3T	D78–79, D81–86
1020935	SSY4T	D78–79, D81–86
1020939	MS1374	T79–81
1020941	SSN2T	D81, D86
1020943	SSA3T	D78–79, D81–86
1020965	SSA4T	D78–79, D81–86
1020969	MS110	B174, B371
1020971	MS111	B170, B172–173, B353–355, E37, E41
1020973	MS412	B386, C171, D41–42, E38–40, E42–43
1020975	MS125	B172, B354, B378
1020977	MS1273	C46–47, T109
1021007	MS1321	B168, B370
1021011	MS524	E36, E40
1021013	MS625	E37
1021051	MS1025	C171, D41–42
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Turning Icons

 Shank: KM-TS™ (ISO 26622)	 Shank: KM4X™	 Shank: VDI Shank	 DIN Number 69880	 Through Coolant
 Through Coolant: 100 bar	 Through Coolant: 1500 psi	 Through Coolant: 80 bar	 Through Coolant: 1200 psi	 ISO: 26622
 ISO: 10889	 Turning	 Profiling	 Facing	 Face Grooving
 Chamfering	 Back Boring	 Threading	 Grooving	 Cut-Off
 I.D. Turning	 I.D. Chamfering	 I.D. Facing	 I.D. Grooving	 I.D. Face Grooving
 Deep Grooving	 I.D. Internal Threading			

Holemaking Icons

 Countersinking/ Stroke Chamfering	 Taper Drilling	 Counterboring	 Drilling	 Drilling: Inclined Entry
 Drilling: Inclined Exit	 Drilling: Exit Offset	 Drilling: Flat Bottom	 Drilling: Stacked Plates	 Drilling: Convex
 Drilling: Blind Hole	 Drilling: Concave	 Drilling: Chain	Drilling: Cross Hole	Drilling: Half Cylinder
Drilling: Corner Drilling 45°	Reaming: Through Hole	Reaming: Blind Hole	Reaming: Through Cross	Reaming: Blind and Cross Holes
Reaming: Interrupted Cut	Drilling Depth: 1 x D	Drilling Depth: 3 x D	Drilling Depth: 5 x D	Drilling Depth: 8 x D
Drilling Depth: 10 x D	Drilling Depth: 12 x D	Drilling Depth: 7 x D	Drilling Depth: 4 x D	Drilling Depth: 1.5 x D

(continued)

(Holemaking Icons — continued)

Corner Style: Corner Chamfer	Corner Style: Square End	Shank: Cylindrical Plain	Shank: Cylindrical Plain ≤h6	Shank: Cylindrical Weldon®
Shank: Cylindrical Whistle Notch	Shank: Cylindrical Whistle Notch ≤h6	Shank: Cylindrical Whistle Notch 2°	Shank: Cylindrical with Flat	Flat Shank
SK Shank: Rübig	Shank: SK BT JIS B 6339	Shank: SK CAT(CV) ANSI B5.50	Shank: SK DV DIN 69871	Shank: Cylindrical Whistle Notch with Drive and Flange
Shank: Cylindrical with Flat and Flange	KM™ Shank	Shank: HSK DIN 69893	Shank: HSK DIN 69893 Form A	Shank: KM-TS™ (ISO 26622)
Shank: KM-XMZ	Shank: ER	Helix Angle: 0°	Helix Angle: 15°	Helix Angle: 30°
Tip Angle: 118°	Tip Angle: 130°	Balance (G 6.3/25,000)	Balance (G 6.3/10,000)	Balance (G 6.3/6,000)
Balance (G 16/20,000)	DIN Number 6537	DIN Number 6535	DIN Number 69893	DIN Number 69090-3
Drilling: No Coolant	Through Coolant: Radial: Drilling	Through Coolant: Radial: Reaming	Through Coolant: Radial: Indexable Drilling	Flood Coolant: Drilling
Through Coolant: MQL (Minimum Quantity Lubricant): Drilling	Through Coolant: Axial: Drilling	Through Coolant: Axial: Reaming	Through Coolant: Coolant Entry AD	Through Coolant: Coolant Entry AD/B
Tool Dimensions: 2 Flute/2 Margin/ Coolant	Tool Dimensions: 2 Flute/2 Margin/ No Coolant	Tool Dimensions: 2 Flute/3 Margin/ Coolant	Tool Dimensions: 2 Flute/4 Margin/ Coolant	Tool Dimensions: 2 Flute/4 Margin/ No Coolant
Tool Dimensions: 2 Flute/4 Margin/ X/Coolant	Tool Dimensions: 3 Flute/3 Margin/ Coolant	Tool Dimensions: 3 Flute/3 Margin/ No Coolant	Tool Dimensions: Flute Configuration: 2	Tool Dimensions: Flute Configuration: 3
Tool Dimensions: Flute Configuration: 4				

Tapping Icons

Countersinking/ Stroke Chamfering	Drilling: Flat Bottom	Drilling: Blind	Tapping: Through Hole	Tapping: Blind Hole
Threading: Through Hole	HSS-E: High-Speed Steel with Cobalt Alloy for Materials with Higher Hardnes	HSS-E-PM: High-Speed Steel with Cobalt Alloy for Materials with Higher Hardness (PM = Powder Metal Steel)	HM: (Carbide)	Drilling Depth: 2xD
Chamfer Form B (3.5–5.5)	Chamfer Form C (2–3)	Chamfer Form D (3.5–5)	Chamfer Form E (1.5–2)	Plug Chamfer Form B (3–5)
Tapping Helix Angle: 0º	Tapping Helix Angle: 10º	Tapping Helix Angle: L8º	Tapping Helix Angle: 15º	Tapping Helix Angle: L15º
Tapping Helix Angle: 25º	Tapping Helix Angle: 30º	Tapping Helix Angle: 42º	Tapping Helix Angle: 45º	Multipurpose Taps: Spiral Point
Tension/ Compression	DIN Number 371	DIN Number 374	DIN Number 376	DIN Number 5156
DIN Number 2174	Through Coolant: Radial: Tapping	Flood Coolant: Tapping	Through Coolant: Axial: Tapping	Manufacturer's Specs: ISO 2
Manufacturer's Specs: ISO 3	Manufacturer's Specs: JIS	Class of Fit: 2B	Class of Fit: 3B	Class of Fit: 6H
Class of Fit: 6HX	Class of Fit: 6G	Class of Fit: 2BX	Class of Fit: 3BX	Unified Fine Thread
Unified Course Thread	American Tapered Pipe Thread for Threads with Dryseal Material	American Tapered Pipe Thread for Threads without Dryseal Material	Whitworth Pipe Thread	Unified Course Thread: J Profile
Unified Fine Thread: J Profile	ISO Metric Coarse Thread	ISO Metric Fine Thread		

Solid End Milling Icons

Face Milling	Helical Milling	Plunge Milling	Plunge Milling: Ball Nose	Ramping: Blank
Ramping: Up to 3°	Slotting: Ball Nose	Slotting: Ball Nose with AP Dimension	Slotting: Square End	Slotting: Square End with AP Dimension
Trochoidal Milling	Trochoidal Milling: Ball Nose	Side Milling/Shoulder Milling: Ball Nose	Side Milling/ Shoulder Milling: Ball Nose with AE/AP Dimensions	Side Milling/ Shoulder Milling: Square End
Side Milling/ Shoulder Milling: Square End with AE/AP Dimensions	Side Milling/ Shoulder Milling: Eased Chamfer	Side Milling/ Shoulder Milling: Eased Chamfer with AE/AP Dimensions	Side Milling/ Shoulder Milling: Fine Finishing	Side Milling/ Shoulder Milling: Fine Finishing with AE/AP Dimensions
Side Milling/ Shoulder Milling: Finishing	Side Milling/ Shoulder Milling: Finishing with AE/AP Dimensions	Side Milling/ Shoulder Milling: Thin Wall Solid End Milling	Side Milling/ Shoulder Milling: Radius	Side Milling/ Shoulder Milling: Radius with AE/AP Dimensions
3D Profiling	3D Profiling with AE/AP Dimensions	3D Profiling with Square End Mill	Corner Style: Ball Nose	Corner Style: Corner Chamfer
Corner Style: Corner Radius	Corner Style: Square End	Corner Style: Torus	Shank: Cylindrical Plain	Shank: Cylindrical Weldon®
Shank: SK BT JIS B 6339	Shank: SK CAT(CV) ANSI B5.50	Shank: HSK: CAT: Drawbar Thread: 5/8–11 UNC	Shank: HSK A/ DIN69893	Shank: Safe-Lock™ ≤h6
Shank: Safe-Lock™	Shank: PSC Shank	Duo-Lock™ Connection	Helix Angle: 0°	Helix Angle: 15°
Helix Angle: 20°	Helix Angle: 25°	Helix Angle: 30°	Helix Angle: 35°	Helix Angle: 38°
Helix Angle: 40°	Helix Angle: 45°	Helix Angle: 50°	Helix Angle: 60°	Helix Angle: 43°
Helix Angle: 36°	Helix Angle: 35°/38°	Helix Angle: 37°/39°	Balance (G 2.5/25,000)	DIN Number 6527
DIN Number 6528	Drilling: Through Coolant	Through Coolant	Through Coolant: Axial: Solid End Mill	Tool Dimensions: Flute Configuration: X (Variable)

(continued)

(Solid End Milling Icons — continued)

Tool Dimensions: Flute Configuration: 2	Tool Dimensions: Flute Configuration: 3	Tool Dimensions: Flute Configuration: 4	Tool Dimensions: Flute Configuration: 5	Tool Dimensions: Flute Configuration: 6
Tool Dimensions: Flute Configuration: 1	Tool Dimensions: Flute Configuration: 12	ISO 26622		

Indexable Milling Icons

Counterboring	Spiral Circular	Face Milling	Helical Milling	Plunge Milling
Plunge Milling: Ball Nose	Ramping: Blank	Slotting: Ball Nose	Slotting: Side	Slotting: Side with AE/AP Dimensions
Slotting: Side Milling: Ball Nose	Slotting: Square End	Slotting: T	Slotting: T with AP Dimension	Side Milling/ Shoulder Milling: Ball Nose
Side Milling/ Shoulder Milling: Bottom Shouldering	Side Milling/ Shoulder Milling: Square End	Side Milling/ Shoulder Milling: Eased Chamfer	Slotting: Shoulder Profiling	Slotting: Shoulder
3D Profiling	3D Profiling with Square End Mill	PCD Tool	Pocketing	Shank: Cylindrical Plain
Shank: Cylindrical Weldon®	Shank: Cylindrical Weldon 2 Flat	Shank: Screw-On	Shank: HSK DIN 69893	Shell Mill Shank
Milling: Through Coolant	Through Coolant: Pressurised Air Coolant: Radial: Indexable Milling			

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

material group	description	content	tensile strength RM (MPa)*	hardness (HB)	hardness (HRC)	material number
P0	Low-Carbon Steels, Long Chipping	C <0,25%	<530	<125	–	–
P1	Low-Carbon Steels, Short Chipping, Free Machining	C <0,25%	<530	<125	–	C15, Ck22, ST37-2, S235JR, 9SMnPb28, GS38
P2	Medium- and High-Carbon Steels	C >0,25%	>530	<220	<25	ST52, S355JR, C35, GS60, Cf53
P3	Alloy Steels and Tool Steels	C >0,25%	600–850	<330	<35	16MnCr5, Ck45, 21CrMoV5-7, 38SMn28
P4	Alloy Steels and Tool Steels	C >0,25%	850–1400	340–450	35–48	100Cr6, 30CrNiMo8, 42CrMo4, C70W2, S6525, X120Mn12
P5	Ferritic, Martensitic, and PH Stainless Steels	–	600–900	<330	<35	100Cr6, 30CrNiMo8, 42CrMo4, C70W2, S6525, X120Mn12
P6	High-Strength Ferritic, Martensitic, and PH Stainless Steels	–	900–1350	350–450	35–48	X102CrMo17, G-X120Cr29
M1	Austenitic Stainless Steel	–	<600	130–200	–	X5CrNi 18 10, X2CrNiMo 17 13 2, G-X25CrNiSi18 9, X15CrNiSi 20 12
M2	High-Strength Austenitic Stainless and Cast Stainless Steels	–	600–800	150–230	<25	X2CrNiMo 13 4, X5NiCr 32 21, X5CrNiNb 18 10, G-X15CrNi 25-20
M3	Duplex Stainless Steel	–	<800	135–275	<30	X8CrNiMo27 5, X2CrNiMoN22 5 3, X20CrNiSi25 4, G-X40CrNiSi27 4
K1	Grey Cast Iron	–	125–500	120–290	<32	GG15, GG25, GG30, GG40, GTW40
K2	Low- and Medium-Strength Ductile Irons (Nodular Irons) and Compacted Graphite Irons (CGI)	–	<600	130–260	<28	GGG40, GTS35
K3	High-Strength Ductile Irons and Austempered Ductile Iron (ADI)	–	>600	180–350	<43	GGG60, GTW55, GTS65
N1	Wrought Aluminium	–	–	–	–	AlMg1, Al99.5, AlCuMg1, AlCuBiPb, AlMgSi1, ALMgSiPb
N2	Low-Silicon Aluminium Alloys and Magnesium Alloys	Si <12,2%	–	–	–	GAlSiCu4, GDAlSi10Mg
N3	High-Silicon Aluminium Alloys and Magnesium Alloys	Si >12,2%	–	–	–	G-ALSi12, G-AlSi17Cu4, G-AlSi21CuNiMg
N4	Copper-, Brass-, Zinc-Based on Machinability Index Range of 70–100	–	–	–	–	CuZn40, Ms60, G-CuSn5ZnPb, CuZn37, CuSi3Mn
N5	Nylon, Plastics, Rubbers, Phenolics, Resins, Fibreglass	–	–	–	–	Lexan®, Hostalen™, Polystyrol, Makrolon®
N6	Carbon, Graphite Composites, CFRP	–	–	–	–	CFK, GFK
N7	Metal Matrix Composites (MMC)	–	–	–	–	–
S1	Iron-Based, Heat-Resistant Alloys	–	500–1200	160–260	25–48	X1NiCrMoCu32 28 7, X12NiCrSi36 16, X5NiCrAlTi31 20, X40CoCrNi20 20
S2	Cobalt-Based, Heat-Resistant Alloys	–	1000–1450	250–450	25–48	Haynes® 188, Stellite 6,21,31
S3	Nickel-Based, Heat-Resistant Alloys	–	600–1700	160–450	<48	INCONEL® 690, INCONEL 625, Hastelloy®, NIMONIC® 75
S4	Titanium and Titanium Alloys	–	900–1600	300–400	33–48	Ti1, TiAl5Sn2, TiAl6V4, TiAl4Mo4Sn2
H1	Hardened Materials	–	–	–	44–48	GX260NiCr42, GX330NiCr42, GX300CrNiSi952, GX300CrMo153, Hardox® 400
H2	Hardened Materials	–	–	–	48–55	–
H3	Hardened Materials	–	–	–	56–60	–
H4	Hardened Materials	–	–	–	>60	–
C1	CFRP, CFRP/CFRP	–	–	–	–	–
C2	CFRP/Non-Ferrous	–	–	–	–	–
C3	CFRP/High Temp	–	–	–	–	–
C4	CFRP/Stainless Steel	–	–	–	–	–
C5	CFRP/Non-Ferrous/High-Temp	–	–	–	–	–

P0 Workpiece Materials Listing • Steel • P0

P0 Low-Carbon Steels, Long Chipping *Content: C <.25%* *Tensile Strength RM (MPa)*: <530* *Hardness (HB): <125*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
1013	USt 34-1	–	–	G10130	–	–	–	1233	–	–	1.0055	–
1010	C 10	045 M 10	S 10 C	G10100	C 10	XC 10	C 10	–	–	–	1.0301	–
1008	DD 11 (StW 22)	HR 3	SPHD	–	DD 11	1 C	–	–	–	–	1.0332	–
1020	C 22	050 A 20	S 22 C	G10200	1 C 22	C 20	C 20	1450	–	–	1.0402	–
1025	C 25	070 M 26	S 22 C	G10250	1 C 25	C 25	C 25	–	–	–	1.0406	–
1012	B 500 H	–	S 12 C	G10120	B 500 B	XC 12	B 500 B	1332	–	–	1.0439	–
1018	C16.8	080 A 17	–	G10180	–	–	–	–	–	–	1.0453	–
1108	10 S 20	210 M 15	–	G 11080	10 S 20	10 F 1	CF 10 S 20	–	–	–	1.0721	–
1010	Ck 10	040 A 10	S 10 C	G10100	2 C 10	XC 10	C 10	1265	–	–	1.1121	–
1022	20 Mn 5	120 M 19	SMn 420	G 10220	20 Mn 5	20 M 5	G 22 Mn 3	–	–	–	1.1133	–
1015	Ck 15	080 M 15	S 15 C	G 10150	2 C 15	XC 15	C 15	1370	–	–	1.1141	–
1021	22 B 2	–	SWRCHB 220	G10210	C 22 BE 69	21 B 3	–	–	–	–	1.5508	–
–	PS 275 TM	S 275 M	–	–	S 275 M	S 275 M	S 275 M	–	–	–	1.8818	–
–	DI-MC 355 B	–	–	–	S 355 M	E 355	S 355 M	–	–	–	1.8823	–
–	DI-MC 420 B	S 420 M	–	–	S 420 M	E 420	S 420 M	–	–	–	1.8825	–
–	S 460 M	S 460 M	–	–	S 460 M	E460; S460M	S460M	–	–	–	1.8827	–
–	BTStE 355 TM	S 355 ML	–	–	S 355 ML	E 355	S 355 ML	–	–	–	1.8834	–
–	BTStE 420 TM	S 420 MI	–	–	S 420 ML	E 420	S 420 ML	–	–	–	1.8836	–
–	St E 320-3Z	–	–	–	S 320 GD + ZA	–	–	–	–	–	1.0250	–

P1 Workpiece Materials Listing • Steel • P1

P1 Low-Carbon Steels, Short Chipping, Free Machining *Content: C <.25%* *Tensile Strength RM (MPa)*: <530* *Hardness (HB): <125*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	R St 34-2/ S 205 G2T	34/20CR	–	K02502	–	–	–	–	–	–	1.0034	–
–	St 33	HR 15	SS 330	K01400	–	A 33	Fe 320	–	–	–	1.0035	–
A 570 Gr. 33	USt 37-2	4360-40 B	SS 34	K 02502	S 235 JR G1	E 24-2	Fe 360 BFU	1311	–	–	1.0036	–
–	St 37-2	HS 37/23	STKR 400	K02702	S 235 JR	E 28-2	Fe 430 C	1412	–	–	1.0037	–
A 570 Gr. 36	R St 37-2/S235 JRG2	4260-40 C	SS 34	K 02502	S235 JR G 2	E 24-2 NE	Fe 360 BFN	1312	–	–	1.0038	–
–	S 235 JRH	S 235 JRH	–	–	S235JRH	E 24-2	S 235 JRH	–	–	–	1.0039	–
–	R St 42-1	–	–	K02507	–	–	–	–	–	–	1.0077	–
–	S235J2G3/Fe 360 D1	S 235 J 2 G 3	–	K01501	S 235 J2 G3	E 24-4	S 235 J2G3	1313	–	–	1.0161	–
–	C 10 Pb	–	–	–	C 10 GPb	–	–	–	–	–	1.0302	–
–	QSt 32-3	–	SWRCH6R	–	CB 4 FF KD	–	CB 4 F U	–	–	–	1.0303	–
–	St 35.8	–	STPT 38	K01201	–	–	–	–	–	–	1.0305	–
–	St 37-2	360	STKM 12 A	K02504	S 235 JR	E 24-2	Fe 360	1412	–	–	1.0308	–
–	C10D	–	SWRM 10	–	C 10 D	FM 10	C 10 D	–	–	–	1.0310	–
–	C12D	–	SWRM 12	–	C 12 D	–	C 12 D	–	–	–	1.0311	–
–	R St 15	FeP05	–	–	Fe P05	FeP05	FeP05	–	–	–	1.0312	–
–	D 6-2	0 1 5 A 03	SWRM 6	G10050	C 4 D	–	3 CD 5	–	–	–	1.0314	–
–	St 37.8	–	STB 35	–	–	–	Fe 37	–	–	–	1.0315	–
–	St 13	CR 3	SPCD	–	–	–	–	–	–	–	1.0333	–
–	D D 13 (StW 24)	H S 3	SPHE	–	D D 13	3C	–	–	–	–	1.0335	–
–	USt 4/DC 04 G	–	–	–	D C 04 G 1	–	–	–	–	–	1.0336	–
–	Ro St 4/DC 04 GT	–	–	–	DC 04 GT	–	–	–	–	–	1.0337	–
–	St 4	DC 04/FeP04	SPCE	–	Fe P04	Fe 14	DC04/FeP04	–	–	–	1.0338	–
–	DC01Cu	–	–	–	DC 01 Cu	–	–	–	–	–	1.0344	–
–	RR St 3	CR 3	SPCD	–	Fe P03	F 13	DC 03/FeP 03	–	–	–	1.0347	–
–	U H I/P 195GH	–	SGV 480	–	P 195 Gh	–	–	–	–	–	1.0348	–
–	St 14 Cu 3	–	–	–	DC 04 Cu	–	–	–	–	–	1.0354	–
–	–	3 CR	–	–	D D 12	D D 12	–	–	–	–	1.0398	–
1015	C 15	080 M 15	S 15 C	G10170	C 15	C 12	C 15	1350	–	–	1.0401	–
–	LSt 45.8	–	–	–	C 16	–	C 16	–	–	–	1.0407	–
–	C15D	–	SWRM 15	–	C 15 D	FM 15	C 15 D	–	–	–	1.0413	–
–	C20D	–	SWRM 20	–	C 20 D	FM 20	C 20 D	–	–	–	1.0414	–
–	C26D	–	SWRH 27	–	C 26 D	FM 26	C 26 D	–	–	–	1.0415	–
–	C18D	–	SWRM 17	–	C 18 D	FM 18	C 18 D	–	–	–	1.0416	–
–	RSt 44-2	440	–	G10160	–	–	–	–	–	–	1.0419	–
–	P265 NB	–	SG 295	–	P 265 NB	BS 2	–	–	–	–	1.0423	–
–	P 265 GH	151-400	SG 30	K02801	P 265 GH	A42CP	P 265 GH	1430	–	–	1.0425	–
–	C 22.3	–	–	–	C 22 G 1	–	–	–	–	–	1.0427	–
–	BSt 420 S	–	–	–	Fe B 400	–	–	–	–	–	1.0428	–
–	C 21	–	SFVC 1	K03504	P 305 GH	–	–	–	–	–	1.0432	–
–	GS-45	A1	SC 450	J03001	GE 230	E23-45M	–	1305	–	–	1.0446	–
–	TStE 275 (S 275 NL)	40EE	–	–	S 275 NL	S 275 NL	S 275 NL	–	–	–	1.0491	–
–	St 42.8	–	STPT 42	–	–	–	Fe 42	–	–	–	1.0498	–
–	S 335 N (StE 355)	50 E	–	–	S 355 N	E 355	S 355 N	2134	–	–	1.0545	–
–	S 355 NL (TStE 355)	50 E E	–	–	S 355 NL	E 355	S 355 N L	2135	–	–	1.0546	–
–	R 7 S 6/C 7 RG 2	–	–	–	C 7 RG 2	–	–	–	–	–	1.0709	–
B1112	9 S 20	220 M 07	SUM 21	G 11120	–	–	CF 9 S 22	–	–	–	1.0711	–
1213	9 SMn 28/11 SMn 30	230 M 07	SUM 22	G 12130	11 SMn 28	S 250	CF 9 SMn 28	1912	–	–	1.0715	–
12L13	9 SMnPb 28	–	SUM 22 L	G 12134	11 SMnPb 28	S 250 Pb	CF 9 SMnPb 28	1914	–	–	1.0718	–
–	15 S 22/15 S 20	En32M	SUM 32	–	15 S 22	–	–	1922	–	–	1.0723	–
–	15 SMn 13	15 SMn 13	–	–	15 SMn 13	15 SMn 13	–	–	–	–	1.0725	–
1215	9 SMn 36/11 S Mn 37	240 M 07	SUM 25	G 12150	11 SMn 37	S 300	CF 9 SMn 36	–	–	–	1.0736	–
12L14	9 SMnPb 36/11 SMnPb 37	–	–	G 12144	11 SMnPb 37	S 300 Pb	CF 9 SMnPb 36	1926	–	–	1.0737	–
–	11 SMnPbTe 37	11 SMn 37	–	–	11 SMn 37	–	–	–	–	–	1.0738	–
–	15 SPb 20/15 SPb 22	–	–	–	15 SPb 22	–	–	–	–	–	1.0753	–
–	36 SMn 14	36SMn14	–	–	36SMn14	36SMn14	–	–	–	–	1.0764	–
–	C10D2	–	–	–	C 10 D 2	FM 10	C 10 D 2	–	–	–	1.1114	–
–	Cq 10 (C 10 C)	–	SWRCH 10 K	–	C 10 KD	–	–	–	–	–	1.1122	–
–	C15D2	–	–	–	C 15 D 2	FM 15	C 15 D 2	–	–	–	1.1126	–
–	C 18D2	–	–	–	C 18 D 2	FM 18	C 18 D 2	–	–	–	1.1129	–

(continued)

P1 Workpiece Materials Listing • Steel • P1 *(continued)*

P1 Low-Carbon Steels, Short Chipping, Free Machining *Content: C <.25%* *Tensile Strength RM (MPa)*: <530* *Hardness (HB): <125*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	GS-16 Mn 5	–	–	–	G 17 Mn 5	G 17 Mn 5	G17Mn5	–	–	–	1.1131	–
–	C20D2	–	–	–	C 20 D 2	FM 20	C20D 2	–	–	–	1.1137	–
–	C26D2	–	–	–	C 26 D 2	FM 26	C26D 2	–	–	–	1.1139	–
–	GC 16 E/GS-Ck 16	–	–	–	GC 16 E	–	–	–	–	–	1.1142	–
–	C 16 E	C 16 E	–	–	C 16 E	XC 18	–	–	–	–	1.1148	–
–	Cm 22	070 M 20	C 22 R (3 C 22)	–	3 C 22	XC 18 u	C 22 R	–	–	–	1.1149	–
–	Ck 22	050 A 20	S 22 C	G10230	2 C 22	XC 25	C 20	–	–	–	1.1151	–
–	Cq 22	–	SWRCH20K	–	C 21 KD	–	CB 20 FF	–	–	–	1.1152	–
–	Ck 25	070 M 26	S 25 C	G10250	2 C 25	XC 25	C 25	–	–	–	1.1158	–
–	C2D1	–	–	–	C 2 D 1	–	C 2 D 1	–	–	–	1.1185	–
–	19 MnVS 6	–	–	–	19 MnVS 6	–	–	–	–	–	1.1301	–
–	PS 275 TM	S 275 M	–	–	S 275 M	S 275 M	S 275 M	–	–	–	1.8818	–
–	DI-MC 355 B	–	–	–	S 355 M	E 355	S 355 M	–	–	–	1.8823	–
–	DI-MC 420 B	S 420 M	–	–	S 420 M	E 420	S 420 M	–	–	–	1.8825	–
–	S 460 M	S 460 M	–	–	S 460 M	E460;S460M	S460M	–	–	–	1.8827	–
–	BTStE 355 TM	S 355 ML	–	–	S 355 ML	E 355	S 355 ML	–	–	–	1.8834	–
–	BTStE 420 TM	S 420 MI	–	–	S 420 ML	E 420	S 420 ML	–	–	–	1.8836	–
–	S 235 J 0 W (Allwesta 360)	S 235 J 0 W	SMA 400 BW	–	S 235 JO W	S 235 J 0 W	–	–	–	–	1.8958	–
–	S 355 J 0 W (Allwesta 510)	WR 50 B	SMA 490 BW	–	S 235 JO W	E24W-3	S 235 JO W	–	–	–	1.8959	–
–	WTSt 37-2/S235JRW	WR 50 B	SMA 41 A	K11538	S 235 JR W	E 24 W-2	–	–	–	–	1.8960	–
–	WTSt 37-3	WR 50 C	SMA 50 A	–	S 235 J2 W	S 235 J 2 W	Fe 360 D FF	–	–	–	1.8961	–
–	USt 42-2	–	SS 41	–	–	HS 18-0-2-10	–	–	–	–	1.0040	–
–	St 37-2	–	–	–	S 235 JRC	E 24-2	S 235 JRC	–	–	–	1.0120	–
–	S 235 JR G1F	–	–	–	S 235 JRG 1 F	–	–	–	–	–	1.0160	–
–	St 12	DC 01/Fe P01	SPCC	–	Fe P01	DC 01/fe P01	DC 01/FeP0 1	–	–	–	1.0330	–
–	GS-38	A1	–	–	GE 200	230-400M	–	1306	–	–	1.0420	–
–	GS-20 Mn 5	–	SMnC 420	H15220	–	–	–	–	–	–	1.1120	–
–	G 20 Mn 5	–	–	–	G 20 Mn 5	–	G 20 Mn 5	–	–	–	1.6220	–

P2 Workpiece Materials Listing • Steel • P2

P2 Medium- and High-Carbon Steels *Content: C >.25%* *Tensile Strength RM (MPa)*: >530* *Hardness (HB): <220 (HRC): <25*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	S 355 JR	En 50 B	SM 490 YA	–	S 1207	E36-2	Fe 510 BFN	–	–	–	1.0045	–
1035	C 35	060 A 35	S 35 C	G 10350	1 C 35	CC 35	C 35	1550	–	–	1.0501	–
1045	GS-C 45	080 M 46	S 45 C	G10450	1 C 45	CC 45	C 45	1650	–	–	1.0503	–
1040	C 40	080 M 40	S 40 C	G 10 400	1 C 40	C 40	C 40	–	–	–	1.0511	–
1046	S 355 K 2 G 4 Cu	–	–	G10460	S 355 K2 G4 Cu	–	–	–	–	–	1.0519	–
1030	C30	080 M 30	SUP 7	G 10 300	1 C 30	C C 32	C 30	–	–	–	1.0528	–
1055	C 55	070 M 55	S 55 C	J05000	1 C 55	C 55	C 55	1655	–	–	1.0535	–
1551	C 50 Pb	–	–	G15510	C 50 G Pb	–	–	–	–	–	1.0542	–
–	GS-60	A3	–	–	GE 300	320-560M	C 45	1606	–	–	1.0558	–
1037	36 Mn4	170 H 36	–	G10370	–	–	–	–	–	–	1.0561	–
–	PSt 52-3 (S 355 J2 G3 F)	–	–	–	S 355 J2 G3 F	–	FE 510 C	–	–	–	1.0572	–
–	S 355 J2H (RoSt 52-3)	50D	–	–	S355J2H	–	S355J2H	–	–	–	1.0576	–
1060	C 60	080 A 62	S 60 C-CSP	G 10600	1 C 60	AF 70 C 55	C 60	–	–	–	1.0601	–
1070	C 67	CS 70	S 70 C -CSP	G10700	1 CS 67	C 68	C 67	–	–	–	1.0603	–
1074	C 75	CS 80	–	G10740	1 CS 75	C 75	C 75	–	–	–	1.0605	–
1059	C58D	–	S 58 C	G10590	C 58 D	FM 58	C 58 D	–	–	–	1.0609	–
1075	C76D	–	–	G10750	C 76 D	FM 76	C 76 D	–	–	–	1.0614	–
1080	C86D	CS 80	–	G10860	C 86 D	FM 86	C 86 D	–	–	–	1.0616	–
1095	C92D	95 CS	–	G10950	C 92 D	–	C 92 D	–	–	–	1.0618	–
1110	U 10 S 10	–	SUM 12	G11100	–	–	–	–	–	–	1.0702	–
11L08	10 SPb 20	–	–	G 11084	10 SPb 20	10 Pb F 2	CF 10 SPb 20	–	–	–	1.0722	–
1140	35 S 20	212 M 36	–	G 11400	35 S 20	35 MF 4	–	1957	–	–	1.0726	–
1146	45 S 20	212 M 44	–	G 11460	45 S 20	45 MF 4	–	1973	–	–	1.0727	–
1151	60 S 20	–	–	G11510	60 S 20	60 MF 4	–	–	–	–	1.0728	–
1141	36 Mn 6	212 M 36	S Mn 443	G 11410	–	–	–	–	–	–	1.1127	–
1039	40 Mn 4	150 M 36	–	G10390	–	35 M 5	–	–	–	–	1.1157	–
1536	34 Mn 5	En15B	SS 55	G15360	–	–	–	–	–	–	1.1166	–
1030	Cq 35	–	F.1133 (C 35 DF)	G 10300	C 35 KD	–	CB 35	–	–	–	1.1172	–
1034	Ck 34	080 M 34	S 34 C	G 10340	2 C 34	–	C 34	–	–	–	1.1173	–
1038 H	Ck 38	–	–	G 10380	–	XF 38	–	–	–	–	1.1176	–
1030	Ck 30	080 M 30	S 30 C	G 10300	2 C 30	XC 32	C 30	–	–	–	1.1178	–
1034	Ck 35	080 M 36	S 35 C	G 10340	2 C 35	XC 38 H1	C 35	1572	–	–	1.1181	–
1035	Cf 35	060 A 35	S 35 C	G 10350	C 35 G	XC 38 TS	C 35	1572	–	–	1.1183	–
1040	Ck 40	080 A 40	S 40 C	G 10400	2 C 40	XC 42 H1	C 40	–	–	–	1.1186	–
1045	Cf 45	060 A 47	S 45 C	G10450	C 45 G	XC 42 TS	C 43	1672	–	–	1.1193	–
1055	Ck 55	070 M 55	S 55 C	G10550	2 C 55	XC 55 H1	C 55	1655	–	–	1.1203	–
1050	Ck 50	080 M 50	S 50 C	G10500	2 C 50	XC 48 H1	C 50	1674	–	–	1.1206	–
1055	Cm 55	070 M 55	–	G 10550	3 C 55	XC 55 H1	C 55 R	–	–	–	1.1209	–
1053	Ck 53	En43C	S 53 C	G 10530	–	–	–	–	–	–	1.1210	–
1050	Cf 53	060 A 57	S 50 C	G 10500	C 53 G	XC 48 TS	C 48	1674	–	–	1.1213	–
1060	Ck 60	060 A 62	S 58 C	G 10640	2 C 60	XC 60	C 60	1678	–	–	1.1221	–
1552	52 Mn 5	–	–	G15520	–	–	–	–	–	–	1.1226	–
1065	FD (Federstahldraht)	095 A 65	–	G10650	C 68 D	–	–	–	–	–	1.1230	–
1070	Ck 67	060 A 67	S 70 C-CSP	G 10700	C 67 S	XC 68	C 70	1770	–	–	1.1231	–
1069	Ck 68	–	–	G10690	C 70 D	–	–	–	–	–	1.1234	–
1080	Ck 75	060 A 78	C 75	G 10800	C 75 S	XC 75	C 75	1774	–	–	1.1248	–
–	Cf 70	–	–	–	C 70 G	XC 70	–	–	–	–	1.1249	–
1090	Ck 85	–	SK 5 -CSP	G 10900	C 85 S	XC 90	C 90	–	–	–	1.1269	–
1085	90 Mn 4	080 A 83	SUP4	G 10850	–	–	–	–	–	–	1.1273	–
1095	Ck 101	060 A 96	SUP_4	G 10950	C 100 S	XC 100	C 100	1870	–	–	1.1274	–
1050	C 50	080 M 50	S 50 C	G 10 500	1 C 50	C 50	C 50	1674	–	–	1.0540	–
–	St 52-3 G	4360-50 B	SM 50 YB	–	S 355 J 2 G 3	E 36-3	Fe 510 B	2132	–	–	1.0570	–
1078	C78D	–	SWRH 77 B	G10780	C 78 D	FM 78	C 78 D	–	–	–	1.0620	–
1035	Cm 35	080 M 36	–	G 10350	3 C 35	38 H1 k	C 35 R	1572-03	–	–	1.1180	–
1566	66 Mn 4	–	–	G15660	–	–	–	–	–	–	1.1260	–
1084	C 85 W	–	SK 5	G10840	C 90 U	Y3 90	–	–	–	–	1.1830	–

NOTE: For legend, see page Y217.

P3 Workpiece Materials Listing • Steel • P3

P3 Alloy Steels and Tool Steels *Content: C >.25%* *Tensile Strength RM (MPa)*: 600–850* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
1330	GS-30 Mn 5	120 M 36	SMn 433 H; SCMn 2	K13300	–	35 M 5	–	1330	–	–	1.1165	–
1330	28 Mn 6	150 M 28	SCMn 1	G 13300	28 Mn 6	35 M 5	C 28 Mn	–	–	–	1.1170	–
1335	36 Mn 5	150 M 36	SMn 438(H)	G13350	–	40 M 5	–	2120	–	–	1.1167	–
1345	StSch 90 C/GP 280 GH	–	–	G13450	GP 280 GH	GP 280 GH	GP 280 GH	–	–	–	1.0625	–
1513	P265	HR 40/30	–	G15130	–	12 M 5	–	–	–	–	1.0424	–
4142	43 CrMo 4	–	–	G41420	–	43 Cr Mo 4	–	–	–	–	1.3563	–
4147	48 CrMo 4	817 M 40	SNC 836	H41470	–	48 CrMo 4	–	–	–	–	1.3565	–
4419	GS-22 Mo 4	243-430	SCPH 11	G44190	G 20 Mo 5	G20Mo5	G 22 Mo 5	–	–	–	1.5419	–
4520	16 Mo 5	1503-245-420	SBC 690	K11522	–	–	16 Mo 5	–	–	–	1.5423	–
5015	15 Cr 3	523 M15	SCr 415 H	G50150	15 Cr 2	12 C 3	–	–	–	–	1.7015	–
5046	44 Cr 2	–	–	H50460	46 Cr 1 KD	44 Cr 2	–	–	–	–	1.3561	–
5115	16 MnCr 5	527 M 17	SCR 415	G 51150	16 MnCr 5 KD	16 MC 5	16 MnCr 5	2173	–	–	1.7131	–
5117	17 Cr 3	17 Cr 3	–	G51170	(15 Cr 2 KD)	18 C 3	–	–	–	–	1.7016	–
5130	28 Cr 4	530 A 30	–	G51300	28 Cr 4	30 CD 4	–	–	–	–	1.7030	–
5140	41 Cr 4	530 M 40	SCr 440 H	G51400	41 Cr 4	42 C 4	41 Cr 4	–	–	–	1.7035	–
5140	42 Cr 4	530 A 40	SCr 440	–	40 NiCrMo 3	42 C 4 TS	40 NiCrMo 3	2245	–	–	1.7045	–
9255	51 Si 7	250 A 53	–	G92550	–	51 S 7	48 Si 7	2090	–	–	1.0903	–
9255	55 Si 7	250 A 53	SKH 1; SKT 4	G92550	55 NiCrMoV 7	55 S 7	55 Si 8	2085	–	–	1.0904	–
9260	60 Si 7	251 A 60	–	G92600	60 Si 7	60 S 7	60 Si 7	–	–	–	1.5027	–
9262	60 SiCr 7	250 A 61	SUP 7	G92620	60 SiCr 8	60 SC 7	60 SiCr 8	–	–	–	1.0961	–
9262	60 SC 7	–	–	G92620	60 SiCr 8	61 SC 7	60 SiCr 8	–	–	–	1.5092	–
9262	60 SiCr 7	–	–	–	60 SiCr 8	–	–	–	–	–	1.7108	–
15B21 H	19 MnB 4	170 H 20	SWRCHB 420	H15211	19 MnB 4	20 MB 5	–	–	–	–	1.5523	–
15B21 H	20 MnB 5	–	SWRCHB 620	–	20 MnB 5	20 MnB 5	20 MnB 5	–	–	–	1.5530	–
50B40	37 CrB 1	120 M 36	SMnC 3 H	H50401	38 Cr 2	–	35 CB 1	–	–	–	1.7007	–
5130 H	34 Cr 4	530 A 32	SCr 430 H	G51300	34 Cr 4 KD	32 C 4	34 Cr 4 KB	–	–	–	1.7033	–
5132 H	37 Cr 4	530 A 36	SCr 435 H	G51320	37 Cr 4	38 C 4	36 CrMn 4	–	–	–	1.7034	–
A 204 Gr. A	15 Mo 3	1501-240	STFA 12	K11820	16 Mo 3	15 D3	16 Mo 3 KW	2912	–	–	1.5415	–
A 350-LF 5	10 Ni 14	503	SL 3 N 26	K31718	12 Ni 14	12Ni14	18 Ni 14 KT	–	–	–	1.5637	–
A 387 Gr. 12 Cl. 2	16 CrMo 4 4	–	–	K11564	–	–	A 18 CrMo 4 5 KW	–	–	–	1.7337	–
A 570 Gr. 36	St 37-3	4360-40 C	–	K01501	S 235 J2 G3	Fe 360 D1(2); E 24-3	Fe 360 D1(2)	1312	–	–	1.0116	–
A 570 Gr. 40	St 44-2	4360-43 B	SM 41 B	K 02502	S 275 JR	E 28-2	Fe 430 BFN	1412	–	–	1.0044	–
A 570 Gr. 50	St 50-2	4360-50 B	SS 50	–	E 295	A 50-2	Fe 490	2172	–	–	1.0050	–
A 573 Gr. 70	St 44-3	4360-43 C	SM 41 B	–	Fe 430 D1(2); S 275 J2 G3 (4)	Fe 430 D1(2); E 28-4	Fe 430 D FF	1414	–	–	1.0144	–
A 633 Gr. C	St E 355	P 355 N	SM 50 YB	K12000	P 355 N	E 355 R/FP	Fe E 355 KG	2132	–	–	1.0562	–
A 633 Gr. E	St E 420	S 420 N	SM 50 C	K02002	FeE 420 KGN	E 420-I	Fe E 420 KG	2143	–	–	1.8902	–
A 633 Gr. E	St E 460	P 460 N	SM 53 B	K02900	P 460 N	E 460-I	Fe E 460 KG	2143	–	–	1.8905	–
A-6	C 67 W	–	–	T30106	–	Y1 70	–	–	–	–	1.1744	–
E 52100	100 Cr 6	535 A 99	SUJ 2	G52986	100 Cr 6	100 C 6	100 Cr 6	2258	–	–	1.3505	–
O 2	90 MnCrV 8	BO 2	–	T31502	90 Mn V 8	90 MV 8	90 MnVCr 8 KU	–	–	–	1.2842	–
P21	90 Cr 3	–	–	T51621	–	–	–	–	–	–	1.2056	–
P3	10 NC 6	–	–	T51603	15 NiCr 6	10 NC 6	–	–	–	–	1.5713	–
P6	15 NiCr 14	–	SNC 22	T51606	–	10 NC 12	–	–	–	–	1.2735	–
T 8	C 80 W2	BW 1B	SKC 3	T12008	–	Y1 80	C 80 KU	–	–	–	1.1625	–
W 108	C 80 W1	–	–	T72301	C 80 U	Y1 90	C 80 KU	1880	–	–	1.1525	–
W 110	C 105 W1	B W 1 A	–	T72301	C 105 U	Y 105	C 100 KU	1880	–	–	1.1545	–
W 112	C 125 W	–	–	–	C 125 U	–	–	–	–	–	1.1563	–
W 112	C 125 W	–	SK 2	T72301	C 120 U	Y2 120	C 120 KU	–	–	–	1.1663	–
W 210	100 V 1	BW 2	SKS 43	T72302	100 V 2	Y1 105 V	102 V 2 KU	–	–	–	1.2833	–
–	St 50-1	–	–	–	–	–	–	–	–	–	1.0052	–
–	S 235 JO/ Fe 360 C	En 40C	–	–	S 235 JO	E24-3	Fe 360 CFN	–	–	–	1.0114	–
–	QSt 37-3	–	SWRCH 12R	–	–	–	–	–	–	–	1.0123	–
–	S 275 J0	En43C; S275J0	–	–	S 275 J0/ Fe 430 C	S 275 J0; E 28-3	S275J0; Fe430CFN	–	–	–	1.0143	–
–	S 275 J2 G4/ Fe 430 D 2	S 275 J2 G4	–	–	S 275 J2 G4	E28-4; S 275 J2 G4	S 275 J2 G4	1414	–	–	1.0145	–
–	Ro St 44-2	43C	–	–	S 275 J0 H	–	S 275 J0 H	–	–	–	1.0149	–
–	St 37.0	–	STPG 38	–	P 235 T1	–	–	–	–	–	1.0254	–
–	C9D	–	SWRM 8	–	C 9 D	FM 9	C 9 D	–	–	–	1.0304	–
–	C7D	C 7 D	SWRM 8	G10060	C 7 D	FM 8	C 7 D	–	–	–	1.0313	–
–	P235 GH	P 235 GH	SPV 50	K02503	P 235 GH	A 37 CP	Fe E 235	1330	–	–	1.0345	–
–	C 25 Pb	–	–	–	C 25 GPb	–	–	–	–	–	1.0411	–
–	L 245 MB	430	–	K03006	L 245 MB	L 245 MB	–	–	–	–	1.0418	–
–	P310 NB	224-410	SG 325	K02100	P280GH	BS 2	P 275 N	2103	–	–	1.0426	–
–	L 290 MB	–	–	–	L290MB	L 290 MB	–	–	–	–	1.0429	–
–	H III/P285NH	–	Sm 38	–	P 285 NH	–	–	–	–	–	1.0435	–
–	P310 NB	224-430	SG 325	K02100	P305GH	P 275 N	P 275 N	2103	–	–	1.0436	–
–	A St 41	P 275 N	STK 400	K02100	S 275 N	BS 3	P 275 N	2103	–	–	1.0437	–
–	B 500 A	–	SD 490	–	B 500 A	–	B 500 A	–	–	–	1.0438	–
–	H IV/P295NH	–	SG 37	K03102	–	–	Fe 460-2 KW	–	–	–	1.0445	–
–	StE 240.7	–	–	–	L 245 NB	L 245 NB	–	–	–	–	1.0457	–
–	TStE 255	–	–	K11535	–	–	–	–	–	–	1.0463	–
–	15 Mn 3 Al	–	–	–	C 14 GAl	–	–	–	–	–	1.0468	–
–	19 Mn 6/P 355 GH	P 355 GH	SGV 46	K03300	P355GH	A 52 CP	Fe E355-2	2101	–	–	1.0473	–
–	17 Mn 4/P 295 GH	224-460B	SG 37	K03501	P 295 GH	A 48 CP	Fe E 295	2102	–	–	1.0481	–
–	19 Mn 5	224-460	SG 37	K 03102	–	A 52 CP; AP; FP	Fe 460- 2 KW	–	–	–	1.0482	–
–	L 290 AG	–	–	–	L290GA	TS E 290	–	–	–	–	1.0483	–
–	L 290 NB	–	–	–	L290NB	L 290 NB	–	–	–	–	1.0484	–
–	21 Mn 6	–	–	K12320	–	–	–	–	–	–	1.0485	–
–	St E 285	P 275 N	SM 41 A	K 01802	P 275 N	P 275 N	Fe E 285 KG	–	–	–	1.0486	–
–	W St E 285	P 275 N	–	K 01802	P 275 NH	P 275 N	Fe E 285 KW	–	–	–	1.0487	–
–	T St E 285	P 275 NL 1	SLA 235 A	K 01803	P 275 NL 1	P 275 NL 1	Fe E 285 KT	–	–	–	1.0488	–
–	H 300/ZSt E 300	H280LA	–	–	H 280 LA	E 280 C	–	–	–	–	1.0489	–
–	S 275 NH	S 275 NH	–	–	S 275 NH	–	S 275 NH	–	–	–	1.0493	–
–	S 275 NLH	S275NLH	–	–	S 275 NLH	–	S275NLH	–	–	–	1.0497	–
–	C 35 Pb/C 35 GPb	–	–	–	C 35 Pb	–	–	–	–	–	1.0502	–
–	St E 315/P 315N	–	SM 50 A	K11506	P 315 N	–	Fe E 315 KG	–	–	–	1.0505	–
–	W St E 315	–	SNC 1	K02404	P 315 NH	–	Fe E 315 KW	2107	–	–	1.0506	–
–	St 55	–	STKM 16A	–	–	–	Fe 540	–	–	–	1.0507	–
–	T St E315	–	SLA 325 A	K02404	P 315 NL	–	–	2106	–	–	1.0508	–
–	C 40 Pb	–	–	–	C 40 G Pb	–	–	–	–	–	1.0512	–
–	C38D	–	SWRH 37	–	C 38 D	FM 38	C 38 D	–	–	–	1.0516	–
–	C48D	–	SWRH 48	–	C 48 D	FM 48	C 48 D	–	–	–	1.0517	–
–	C56D	–	–	–	C 56 D	FM 56	C 56 D	–	–	–	1.0518	–
–	S 355 NH	S 355 NH	–	–	S 355 NH	–	S 355 NH	–	–	–	1.0539	–
–	C42D	–	SWRH 42 B	–	C 42 D	FM 42	C 42 D	–	–	–	1.0541	–
–	S 355 JO H	50 C	–	–	S 355 JO H	–	S 355 JO H	–	–	–	1.0547	–
–	ZStE 340/ H 340	H 320 L A	–	–	H 320 LA	E 315 C	–	–	–	–	1.0548	–
–	S 335 NLH	50 EE	–	–	S 355 N LH	–	S 355 N L H	–	–	–	1.0549	–
–	S 355 JO	En 50 C; S 355 JO	SM 520 M	–	S 355 JO	S 355 JO; E 36-3	S 355 JO; Fe 510 C FN	–	–	–	1.0553	–
–	GS-70	50 C	–	–	S 355 JO C	E 36-3	Fe 510 C	–	–	–	1.0554	–

(continued)

P3 Workpiece Materials Listing • Steel • P3 *(continued)*

P3 Alloy Steels and Tool Steels *Content: C >.25%* *Tensile Strength RM (MPa)*: 600–850* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	ZStE 420/H 420	46/40HR, HS, CS	–	–	H 400 LA	H 400 LA	–	–	–	–	1.0556	–
–	P355 NB	–	SG 365	–	P 355 NB	BS 4	–	–	–	–	1.0557	–
–	W St E 355	P 355 NH	–	K01600	P 355 NH	P 355 NH	Fe E 355 KW	–	–	–	1.0565	–
–	T St E355	P 355 NL1	SLA 37	–	P 355 NL1	P 355 NL1	Fe E 355 KT	–	–	–	1.0566	–
–	P355 QH1	P 355 QH	–	–	P 355 QH	P 355 QH	–	–	–	–	1.0571	–
–	S 355 J 2 G 4	S 355 J 2 G 4	–	–	S 355 J 2 G 4	S 355 J 2 G 4	S 355 J 2 G 4	–	–	–	1.0577	–
–	L 360 MB	–	–	–	L 360 MB	L 360 MB	–	–	–	–	1.0578	–
–	St 52.4	–	STS 49	–	–	–	–	–	–	–	1.0581	–
–	L 360 NB/StE 360.7	–	–	–	L360NB	L 360 NB	–	–	–	–	1.0582	–
–	S 355 J 2 G 3 Cu/St 52-3 Cu3	–	–	–	S 355 J2 G3 Cu + CR	–	–	–	–	–	1.0585	–
–	C50D	–	–	–	C 50 D	FM 50	C 50 D	–	–	–	1.0586	–
–	QSt 52-3 Cu 3	–	–	–	S 355 J2 G3 Cu C	–	–	–	–	–	1.0587	–
–	D 53-2	–	SWRH 52 B	–	C 52 D	FM 52	C 52 D	–	–	–	1.0588	–
–	S 355 J 2 G 4 Cu	–	–	–	S 355 J2 G4 Cu	–	–	–	–	–	1.0592	–
–	S355k2G3/Fe 510 DD1 (MULTIST)	S 355 K 2 G 3	SM 520 C	K02505	S 355 K 2 G 3	E36-4	S 355 K 2 G 3	–	–	–	1.0595	–
–	S355K2G4/Fe 510 DD 2 (MULTIST)	S 355 K 2 G 4	–	–	S 355 K 2 G 4	S 355 K 2 G 4	S 355 K 2 G 4	–	–	–	1.0596	–
–	C62D	–	SWRH 62 B	–	C 62 D	FM 62	C 62 D	–	–	–	1.0611	–
–	C66D	–	–	–	C 66 D	FM 66	C 66 D	–	–	–	1.0612	–
–	C68D	–	SWRH 67 B	–	C 68 D	FM 68	C 68 D	–	–	–	1.0613	–
–	C70D	–	–	–	C 70 D	FM 70	C 70 D	–	–	–	1.0615	–
–	C72D	–	SWRH 72 B	–	C 72 D	FM 72	C 72 D	–	–	–	1.0617	–
–	GS-C 25	–	SCPH 1	–	GP 240 GH	GP 240 GH	GP 240 Gh	–	–	–	1.0619	–
–	C80D	–	–	–	C 80 D	FM 80	C 80 D	–	–	–	1.0622	–
–	C82D	–	SWRH 82 B	–	C 82 D	FM 82	C 82 D	–	–	–	1.0626	–
–	35 SPb 20	35 SPb 20	–	–	35 SPb 20	35 SPb 20	–	–	–	–	1.0756	–
–	45 SPb 20	–	–	–	46 SPb 20	–	–	–	–	–	1.0757	–
–	38 SMnPb 28	38 SMnPb 28	–	–	38 SMnPb 28	38 SMnPb 28	–	–	–	–	1.0761	–
–	44 SMn 28	44 SMn 28	–	–	44 SMn 28	44 SMn 28	–	–	–	–	1.0762	–
–	44 SMnPb 28	44 SMnPb 28	–	–	44 SMnPb 28	44 SMnPb 28	–	–	–	–	1.0763	–
–	36 SMnPb 14	36 SMnPb 14	–	–	36 SMnPb 14	36 SMnPb 14	–	–	–	–	1.0765	–
–	QSt E 690 TM (S 700 MC)	–	–	–	S 700 MC	S 690 MC	S 700 MC	–	–	–	1.0966	–
–	QSt E 260 N 7 S 260 NC	–	AE 275 NC	–	S 260 NC	–	S 260 NCX	–	–	–	1.0971	–
–	QSt E 300 TM/S 315 MC	43 F35 HR, HS, CS	–	–	S 315 MC	E 315 D	S 315 MC	–	–	–	1.0972	–
–	QSt E 300 N 7/ S 315 NC	–	AE 340 NC	–	S 315 NC	–	S 315 NC	–	–	–	1.0973	–
–	QSt E340 TM	HR 40/30	–	–	S 340 MC	E 335 D	–	–	–	–	1.0974	–
–	QSt E340 N	–	–	–	S 340 NC	–	Fe E 355 TD	–	–	–	1.0975	–
–	QSt E 360TM	–	–	–	S 355 MC	E 355 D	Fe E 355 TM	–	–	–	1.0976	–
–	QSt E360 N	–	–	–	S 355 NC	–	Fe E 355 TD	–	–	–	1.0977	–
–	QSt E380 TM	–	–	–	S 380 MC	E 390 D	–	–	–	–	1.0978	–
–	QSt E380 N	–	–	–	S 380 NC	–	Fe E 380 TD	–	–	–	1.0979	–
–	QSt E420 TM	HR 50 F 45	–	–	S 420 MC	E 430 D	Fe E 420 TM	–	–	–	1.0980	–
–	QSt E 420 N	–	–	–	S 420 NC	–	Fe E 420 TD	–	–	–	1.0981	–
–	QSt E 460 TM	50/45 HR	–	–	S 460 MC	E 445 D	–	–	–	–	1.0982	–
–	QSt E 460 N	–	–	–	S 460 NC	–	Fe E 460 TD	–	–	–	1.0983	–
–	QSt E500 TM	–	–	–	S 500 MC	E 490 D	Fe E 490 TM	2662	–	–	1.0984	–
–	QSt E500 N	–	–	–	S 500 NC	–	–	–	–	–	1.0985	–
–	QSt E550 TM	60/55 HS	–	–	S 550 MC	E 560 D	Fe E 560 TM	–	–	–	1.0986	–
–	QSt E550 N	–	–	–	S 550 NC	–	–	–	–	–	1.0987	–
–	EStE 285	P 275 NL 2	STK 400	–	P 275 NL 2	P 275 NL 2	P 275 NL 2	–	–	–	1.1104	–
–	EStE 315	–	–	–	S 315 NL 1	–	–	–	–	–	1.1105	–
–	EStE 355	P 355 NL 2	STK 500	–	P 355 NL 2	P 355 NL 2	P 355 NL 2	–	–	–	1.1106	–
–	C5D2	–	–	–	C 5 D 2	FM 6	C 5 D 2	–	–	–	1.1111	–
–	C8D2	–	–	–	C 8 D 2	FM 8	C 8 D 2	–	–	–	1.1113	–
–	C 10 E W/RSD 11	–	–	–	C 10 EW	–	–	–	–	–	1.1115	–
–	C32D2	–	–	–	C 32 D 2	FM 32	C 32 D 2	–	–	–	1.1143	–
–	C36D2	–	–	–	C 36 D 2	FM 36	C 36 D 2	–	–	–	1.1145	–
–	C40D2	–	–	–	C 40 D 2	FM 40	C 40 D 2	–	–	–	1.1153	–
–	C42D2	–	–	–	C 42 D 2	FM 42	C 42 D 2	–	–	–	1.1154	–
–	C46D2	–	–	–	C 46 D 2	FM 46	C46D 2	–	–	–	1.1162	–
–	C 25 R	C 25 R	–	–	C 25 R	C 25 R	C 25 R	–	–	–	1.1163	–
–	C48D2	–	–	–	C 48 D 2	FM 48	C48 D 2	–	–	–	1.1164	–
–	20 Mn 6	150 M 19	–	–	–	20 M 5	20 Mn 6	–	–	–	1.1169	–
–	C50D2	–	–	–	C 50 D 2	FM 50	C50D 2	–	–	–	1.1171	–
–	C 30 R	C 30 R	C 30 R (3 C 30)	–	C 30 R	C 30 R	C 30 R	–	–	–	1.1179	–
–	C3D1	–	–	–	C 3 D 1	–	C 3 D 1	–	–	–	1.1187	–
–	C40R/Cm 40	C 40 R	–	–	C 40 R	C 40 R	C 40	–	–	–	1.1189	–
–	Ck 45	080 M 46	S 45 C	–	2 C 45	XC 42	C 40	1672	–	–	1.1191	–
–	Cq 45	–	SWRCH45K	–	C 45 KD	–	–	–	–	–	1.1192	–
–	C 45 R	080 M 46	S 50 C	–	C 45 R	XC 48 H1u	C 45 R	1672	–	–	1.1201	–
–	C52D2	–	–	–	C 52 D 2	FM 52	C 52 D 2	–	–	–	1.1202	–
–	C 53 R/Cm 53	–	–	–	C 53 R	–	–	–	–	–	1.1205	–
–	C 10 R	C 10 R	–	–	C 10 R	C 10 R	–	–	–	–	1.1207	–
–	C 16 R	C 16 R	–	–	C 16 R	C 16 R	–	–	–	–	1.1208	–
–	C58D2	–	–	–	C 58 D 2	FM 58	C 58 D 2	–	–	–	1.1212	–
–	C62D2	–	–	–	C 62 D 2	FM 62	C 62 D 2	–	–	–	1.1222	–
–	Cm 60	C 60 R	–	–	3 C 60	C 60 R	C 60 R	–	–	–	1.1223	–
–	C60D2	–	–	–	C 60 D 2	FM 60	C 60 D 2	–	–	–	1.1228	–
–	C68D2	–	–	–	C 68 D 2	FM 68	C 68 D 2	–	–	–	1.1232	–
–	C66D2	–	–	–	C 66 D 2	FM 66	C 66 D 2	–	–	–	1.1236	–
–	C50R	C 50 R	–	–	C 50 R	FM 50	C 50 R	–	–	–	1.1241	–
–	C72D2	–	–	–	C 72 D 2	FM 72	C 72 D 2	–	–	–	1.1242	–
–	C70D2	–	–	–	C 70 D 2	FM 70	C 70 D 2	–	–	–	1.1251	–
–	C78D2	–	–	–	C 78 D 2	FM 78	C 78 D 2	–	–	–	1.1252	–
–	C76D2	–	–	–	C 76 D 2	FM 76	C 76 D 2	–	–	–	1.1253	–
–	C80D2	–	–	–	C 80 D 2	FM 80	C 80 D 2	–	–	–	1.1255	–

NOTE: For legend, see page Y217.

(continued)

P3 Workpiece Materials Listing • Steel • P3 *(continued)*

P3 Alloy Steels and Tool Steels *Content: C >.25%* *Tensile Strength RM (MPa)*: 600–850* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	C82D2	–	–	–	C 82 D 2	FM 82	C 82 D 2	–	–	–	1.1262	–
–	C86D2	–	–	–	C 86 D 2	FM 86	C 86 D 2	–	–	–	1.1265	–
–	C88D2	–	–	–	C 88 D 2	–	C 88 D 2	–	–	–	1.1272	–
–	C92D2	–	–	–	C 92 D 2	–	C 92 D 2	–	–	–	1.1282	–
–	C98D2	–	–	–	C 98 D 2	–	C 98 D 2	–	–	–	1.1283	–
–	46 MnVS 6	–	–	–	46 MnVS 6	–	–	–	–	–	1.1304	–
–	C 90 U	–	–	–	C90U	–	–	–	–	–	1.1535	–
–	85 Cr 1	–	–	–	–	Y1 100 C 2	–	–	–	–	1.2004	–
–	140 Cr 3	–	SKS 8	–	140 Cr 2	Y2 140 C	–	–	–	–	1.2008	–
–	21 MnCr 5	–	SCR 420 H	–	21 MnCr 5	20 NC 5	–	–	–	–	1.2162	–
–	40 CrMnNiMo 8 6 4	–	–	–	40 CrMnNiMo 8-6-4	–	–	–	–	–	1.2738	–
–	16 CrNiMo 6	820A16	–	–	–	16 NCD 6	16NiCrMo6	–	–	–	1.3531	–
–	100 CrMn 7 3	–	–	–	100 CrMnMo 7	100 CD 7	–	–	–	–	1.3536	–
–	100 CrMo 7	–	SUS 4	K19965	100 CrMo 7	100 CD 7	100CrMo7	–	–	–	1.3537	–
–	100 CrMnMo 8	–	–	–	–	100 CrMnMo 8	–	–	–	–	1.3539	–
–	46 Si 7	–	–	–	45 Si	46 S 7	–	–	–	–	1.5024	–
–	55 Si 7	250 A 53	–	G92550	56 Si 7	55 S 7	55 Si 8	2085	–	–	1.5026	–
–	37 MnSi 5	–	–	–	–	38 MS 5	–	F.130.A	–	–	1.5122	–
–	15 MnMoV 4 5	–	–	–	15 MnMoV 4-5	15 MDV 4.05	–	–	–	–	1.5402	–
–	11 MnMo 4 5	–	–	K11123	11 MnMo 45 KE	–	–	–	–	–	1.5425	–
–	13 MnMo 6 5	–	–	K11424	11 MnMo 65 KE	–	–	–	–	–	1.5426	–
–	35 B 2	–	SWRCHB 237	–	C 35 B	35 B 3	–	–	–	–	1.5511	–
–	24 Ni 8	–	SCPL 21	J22501	G 9 Ni 10	22 N 8	G9Ni10	–	–	–	1.5633	–
–	10 NiCr 5 4	10NiCr5-4	–	–	10 NiCr 5-4	10 NiCr 5-4	–	–	–	–	1.5805	–
–	18 MnMoNi 5 5	–	–	–	18 MnMoNi 5-5	–	–	–	–	–	1.6308	–
–	20 MnMoNi 4 5	–	SQV 2 B	K12539	20 MnMoNi 4-5	–	–	–	–	–	1.6311	–
–	15 MnCrMoNiV 5 3	–	–	–	15 MnCrMoNiV 5-3	–	–	–	–	–	1.6920	–
–	17 CrS 3	17 CrS3	–	–	17 CrS 3	17 CrS 3	–	–	–	–	1.7014	–
–	28 CrS 4	–	–	–	28CrS4	28CrS4	–	–	–	–	1.7036	–
–	34 CrS 4	34 CrS 4	–	–	34 CrS 4	34 CrS 4	34 CrS 4	–	–	–	1.7037	–
–	41 CrS 4	41 CrS 4	–	–	41 CrS 4	41 CrS 4	41 CrS 4	2245	–	–	1.7039	–
–	38 Cr 4	–	–	–	38 Cr 4	–	38 Cr 4	–	–	–	1.7043	–
–	16 CrMo 4	18 CrMo4	SCM 418 H	–	18 CrMo 4	15 CD 3.5	18 CrMo 4	–	–	–	1.7242	–
–	12 CrMo 11 10	–	–	–	–	–	–	–	–	–	1.7305	–
–	22 CrMoS 3 5	–	–	–	22 CrMoS 3-5	22 CrMoS 3-5	–	–	–	–	1.7333	–
–	12 CrMo 19 5	3606-625	SCMV 6	K41545	X 12 CrMo 5	Z 10 CD 5.05	16 CrMo 20 5	–	–	–	1.7362	–
–	X 7 CrMo 6 1	B 5	–	S50281	CM 5-IG	–	–	–	–	–	1.7373	–
–	51 CrMoV 4	–	–	–	51 CrMoV 4	51 CDV 4	51 CrMoV 4	–	–	–	1.7701	–
–	21 CrMoV 5 7	–	–	K14073	21 CrmoV 5-7	20 CDV 5.07	–	–	–	–	1.7709	–
–	20 CrMoVTiB 4 10	–	–	–	20 CrMoVTiB 4-10	20 CrMoVTiB 4-10	–	–	–	–	1.7729	–
–	PS 275 TMK	S 275 ML	–	–	S 275 ML	S 275 ML	S 275 ML	–	–	–	1.8819	–
–	S 500 M	–	–	–	S 500 m	–	–	–	–	–	1.8829	–
–	BTStE 460 TM	S 460 ML	–	–	S 460 ML	E 460	S 460 ML	–	–	–	1.8838	–
–	S 500 ML	–	–	–	S 500 ML	–	–	–	–	–	1.8839	–
–	S 275 MH	–	–	–	S 275 MH	–	S 275 MH	–	–	–	1.8843	–
–	S 275 MLH	–	–	–	S 275 MLH	–	S 275 MLH	–	–	–	1.8844	–
–	S 355 MH	–	–	–	S 355 MH	–	S 355 MH	–	–	–	1.8845	–
–	S 355 MLH	–	–	–	S 355 MLH	–	S 355 MLH	–	–	–	1.8846	–
–	S 420 MH	–	–	–	S 420 MH	–	S 420 MH	–	–	–	1.8847	–
–	S 420 MLH	–	–	–	S 420 MLH	–	S 420 MLH	–	–	–	1.8848	–
–	S 460 MH	–	–	–	S 460 MH	–	S 460 MH	–	–	–	1.8849	–
–	StE 460	S 460 N	–	–	S 460 N	E 460	S 460N	–	–	–	1.8901	–
–	TStE 460	S 460 L	–	–	S 460 NL	E460	S 460 NL	–	–	–	1.8903	–
–	S 550 Q	–	–	–	S 550 Q	E 550	S 550 Q	–	–	–	1.8904	–
–	S 460 Q	55 F	–	–	S 460 Q	E 460	S 460 Q	–	–	–	1.8908	–
–	S 420 NL/TStE 420	S 420 NL	STK 540	K02002	S 420 NL	E 420 T-I	Fe E 420 KT	–	–	–	1.8912	–
–	S 620 Q	–	–	–	S 620 Q	E 620	S 620 Q	–	–	–	1.8914	–
–	T St E 460/P460NL1	P 460 NL 1	–	K02900	P 460 NL1	E 460 T-I	Fe E 460 KT	–	–	–	1.8915	–
–	S 460 QL1	55 F	–	–	S 460 QL 1	–	–	–	–	–	1.8916	–
–	T St E 500	–	–	K02001	–	E 500 T-I	–	–	–	–	1.8917	–
–	EStE 460/P460NI2	P 460 NL 2	–	–	P 460 NL 2	P 460 NL 2	P 460 NL 2	–	–	–	1.8918	–
–	EStE 500/S500NL1	–	–	–	S 500 NL 1	–	–	–	–	–	1.8919	–
–	TStE 690 VA/S690G1QL	–	–	–	S 690 G 1 QL	–	–	–	–	–	1.8920	–
–	TStE 690 VB/S690G2QL	–	–	K11646	S 690 G 2 QL	–	–	–	–	–	1.8921	–
–	S 690 G 4 QL/TStE 690 VC	–	–	–	S 690 G 4 QL	–	–	–	–	–	1.8922	–
–	S 590 QL/TStE 590 V	–	–	–	S 590 QL	–	–	–	–	–	1.8923	–
–	S 500 Q (StE 500 V)	–	–	–	S 500 Q	E 500	S 500 Q	2614	–	–	1.8924	–
–	S 890 QL 1 (EStE 90 V)	–	–	–	S 890 QL 1	–	–	–	–	–	1.8925	–
–	S 690 QL (TStE 690 V)	–	SHY 685 NS	–	S 690 QL	–	–	–	–	–	1.8928	–
–	S 690 Q/StE 690 V	–	SHY 685 N	–	S 690 Q	E 690	S 690 Q	–	–	–	1.8931	–
–	WSt E 420/P420NH	S 420 NL	STK 540	K02002	S 420 NL	S 420 NL	Fe E 420 KW	–	–	–	1.8932	–
–	S 960 QL/TStE 960 V	–	–	–	S 960 QL	–	–	–	–	–	1.8933	–
–	WSt E 460/P460NH	P 460 NH	–	K02900	P 460 NH	P 460 NH	Fe E 460 KW	–	–	–	1.8935	–
–	S 960 Q	–	–	–	S 960 Q	E 960 T-II	S 960 Q	–	–	–	1.8941	–
–	S 355 J 0 WP	WR 50 A	–	–	S 355 J0 WP	E 36 W-A3	S 355 J0 WP	–	–	–	1.8945	–
–	S 355 J 2 WP	S 355 J 2 WP	–	–	S 355 J2 WP	E36W-A4	S 355 J2 WP	–	–	–	1.8946	–
–	L 415 QB	–	–	–	L 415 QB	L 415 QB	–	–	–	–	1.8947	–
–	L 360 QB	–	–	–	L 360 QB	L 360 QB	–	–	–	–	1.8948	–
–	L 450 QB	–	–	–	L 450 QB	L 450 QB	–	–	–	–	1.8952	–
–	S 460 NH (FGS 47)	–	–	–	S 460 NH	–	S 460 NH	–	–	–	1.8953	–
–	L 485 QB	–	–	–	L 485 QB	L 485 QB	–	–	–	–	1.8955	–
–	S 460 NLH/FG S 47	–	–	–	S 460 NLH	–	S460NLH	–	–	–	1.8956	–
–	L 555 QB	–	–	–	L 555 QB	L 555 QB	–	–	–	–	1.8957	–
–	9 CrNiCuP 3 2 4	WR 50 A	SPA-H	K11430	–	–	–	–	–	–	1.8962	–
–	WTSt 52-3	WR 50 C	SMA 58 W	K11430	S 355 J 2 G 1 W	E 36 W-A2	–	–	–	–	1.8963	–
–	S 355 J 2 G 2 W	S 355 J 2 G 2 W	–	–	S 355 J 2 G 2 W	S 355 J 2 G 2 W	S 355 J 2 G 2 W	–	–	–	1.8965	–

(continued)

P3 Workpiece Materials Listing • Steel • P3 *(continued)*

P3 Alloy Steels and Tool Steels *Content: C >.25%* *Tensile Strength RM (MPa)*: 600–850* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	S 355 K 2 G 1 W	S 355 K 2 G 1 W	SMA 490 CW	–	S 355 K2 G1 W	S 355 K2 G1 W	S 355 K 2 G 1 W	–	–	–	1.8966	–
–	S 355 K 2 G 2 W	S 355 K 2 G 2 W	–	–	S 355 K2G2W	S 355 K 2 G 2 W	S 355 K 2 G 2 W	–	–	–	1.8967	–
–	QStE 600 TM/S 600 MC	–	–	–	S 600 MC	E 620 D	S 600 MC	–	–	–	1.8969	–
–	StE 415..7/L 415 NB	–	–	–	L 415 NB	L 415 NB	–	–	–	–	1.8972	–
–	StE 415.7 TM/L 415 MB	–	–	–	L 415 MB	L 415 MB	–	–	–	–	1.8973	–
–	S 700 MC (QStE 690 TM)	–	–	–	S 700 MC	E 690 D	S 700 MC	–	–	–	1.8974	–
–	L 450 MB/StE 445.7 TM	–	–	–	L 450 MB	L 450 MB	–	–	–	–	1.8975	–
–	S 650 MC (QStE 650 TM)	–	–	–	S 650 MC	E 620 D	S 650 MC	–	–	–	1.8976	–
–	L 485 MB/StE 480.7 TM	–	–	–	L 485 MB	L 485 MB	–	–	–	–	1.8977	–
–	StE 550.7 TM/L 555 MB	–	–	–	L 555 MB	L 555 MB	–	–	–	–	1.8978	–
–	St 60-2	4360-55 E	SM 58	–	E 335	A 60-2	Fe 60-2	1650	–	–	1.0060	–
–	St 70-2	E 360	–	–	E 360	A 70-2	Fe 70-2	1655	–	–	1.0070	–
–	C4D	–	–	–	C 4 D	FM 5	C 4 D	–	–	–	1.0300	–
–	C 22 8	–	–	–	P 250 GH	–	–	–	–	–	1.0460	–
–	H 260/ZSt E 260	H 240 LA	–	–	H 240 LA	E 240 C	–	–	–	–	1.0480	–
–	C32D	–	SWRH 32	K02701	C 32 D	FM 32	C 32 D	–	–	–	1.0530	–
–	ZStE 380/H 380	H 360 L A	–	–	H 360 LA	E 355 C	–	–	–	–	1.0550	–
–	C60D	–	–	–	C 60 D	FM 60	C 60 D	–	–	–	1.0610	–
–	38 SMn 28	38 SMn 28	–	–	38 SMn 28	38 SMn 28	–	–	–	–	1.0760	–
–	QSt E 260 TM/5260 MC	–	–	–	S 260 MC	41 S 7	Fe E 275 TM	–	–	–	1.0970	–
–	C3D2	–	–	–	C 3 D 2	FM 5	C 3 D 2	–	–	–	1.1110	–
–	C38D2	–	–	–	C 38 D 2	FM 38	C 38 D 2	–	–	–	1.1150	–
–	C 42 E Al/Ck 42 Al	–	–	–	S 355 G15	–	–	–	–	–	1.1190	–
–	C56D2/D 55-2	–	–	–	C 56 D 2	FM 56	C 56 D 2	–	–	–	1.1220	–
–	C 70 W1	–	–	–	CT 70	C 70 E 2 U	C 70 K U	–	–	–	1.1520	–
–	C 45 W	–	–	–	C 45 U	Y3 42	–	–	–	–	1.1730	–
–	C 60 W	–	SK 7	–	–	Y3 55	–	–	–	–	1.1740	–
–	100 CrMn 6	–	–	K19195	100 CrMn 6	100 CM 6	–	–	–	–	1.3520	–
–	28 B 2	–	SWRCHB 26	–	C 30 B	20 B 3	–	–	–	–	1.5510	–
–	St E 380	–	SM 50 B	–	S 380 N	–	Fe E 390 KG	–	–	–	1.8900	–
–	TStE 380/S380NL	–	–	–	S 380 NL	–	Fe E 390 KT	2117	–	–	1.8910	–
–	S 890 Q	–	–	–	S 890 Q	S 890 Q	S 890 Q	–	–	–	1.8940	–
–	46 Si 7	–	–	–	45 Si	46 S 7	–	–	–	–	1.5024	–
–	55 Si 7	250 A 53	–	G92550	56 Si 7	55 S 7	55 Si 8	2085	–	–	1.5026	–
–	37 MnSi 5	–	–	–	–	38 MS 5	–	F.130.A	–	–	1.5122	–
–	15 MnMoV 4 5	–	–	–	15 MnMoV 4-5	15 MDV 4.05	–	–	–	–	1.5402	–
–	11 MnMo 4 5	–	–	K11123	11 MnMo 45 KE	–	–	–	–	–	1.5425	–
–	13 MnMo 6 5	–	–	K11424	11 MnMo 65 KE	–	–	–	–	–	1.5426	–
–	35 B 2	–	SWRCHB 237	–	C 35 B	35 B 3	–	–	–	–	1.5511	–
–	24 Ni 8	–	SCPL 21	J22501	G 9 Ni 10	22 N 8	G9Ni10	–	–	–	1.5633	–
–	10 NiCr 5 4	10NiCr5-4	–	–	10 NiCr 5-4	10 NiCr 5-4	–	–	–	–	1.5805	–
–	18 MnMoNi 5 5	–	–	–	18 MnMoNi 5-5	–	–	–	–	–	1.6308	–
–	20 MnMoNi 4 5	–	SQV 2 B	K12539	20 MnMoNi 4-5	–	–	–	–	–	1.6311	–
–	15 MnCrMoNiV 5 3	–	–	–	15 MnCrMoNiV 5-3	–	–	–	–	–	1.6920	–
–	17 CrS 3	17 CrS3	–	–	17 CrS 3	17 CrS 3	–	–	–	–	1.7014	–
–	28 CrS 4	–	–	–	28CrS4	28CrS4	–	–	–	–	1.7036	–
–	34 CrS 4	34 CrS 4	–	–	34 CrS 4	34 CrS 4	34 CrS 4	–	–	–	1.7037	–
–	41 CrS 4	41 CrS 4	–	–	41 CrS 4	41 CrS 4	41 CrS 4	2245	–	–	1.7039	–
–	38 Cr 4	–	–	–	38 Cr 4	–	38 Cr 4	–	–	–	1.7043	–
–	16 CrMo 4	18 CrMo4	SCM 418 H	–	18 CrMo 4	15 CD 3.5	18 CrMo 4	–	–	–	1.7242	–
–	12 CrMo 11 10	–	–	–	–	–	–	–	–	–	1.7305	–
–	22 CrMoS 3 5	–	–	–	22 CrMoS 3-5	22 CrMoS 3-5	–	–	–	–	1.7333	–
–	12 CrMo 19 5	3606-625	SCMV 6	K41545	X 12 CrMo 5	Z 10 CD 5.05	16 CrMo 20 5	–	–	–	1.7362	–
–	X 7 CrMo 6 1	B 5	–	S50281	CM 5-IG	–	–	–	–	–	1.7373	–
–	51 CrMoV 4	–	–	–	51 CrMoV 4	51 CDV 4	51 CrMoV 4	–	–	–	1.7701	–
–	21 CrMoV 5 7	–	–	K14073	21 CrmoV 5-7	20 CDV 5.07	–	–	–	–	1.7709	–
–	20 CrMoVTiB 4 10	–	–	–	20 CrMoVTiB 4-10	20 CrMoVTiB 4-10	–	–	–	–	1.7729	–
–	PS 275 TMK	S 275 ML	–	–	S 275 ML	S 275 ML	S 275 ML	–	–	–	1.8819	–
–	S 500 M	–	–	–	S 500 m	–	–	–	–	–	1.8829	–
–	BTStE 460 TM	S 460 ML	–	–	S 460 ML	E 460	S 460 ML	–	–	–	1.8838	–
–	S 500 ML	–	–	–	S 500 ML	–	–	–	–	–	1.8839	–
–	S 275 MH	–	–	–	S 275 MH	–	S 275 MH	–	–	–	1.8843	–
–	S 275 MLH	–	–	–	S 275 MLH	–	S 275 MLH	–	–	–	1.8844	–
–	S 355 MH	–	–	–	S 355 MH	–	S 355 MH	–	–	–	1.8845	–
–	S 355 MLH	–	–	–	S 355 MLH	–	S 355 MLH	–	–	–	1.8846	–
–	S 420 MH	–	–	–	S 420 MH	–	S 420 MH	–	–	–	1.8847	–
–	S 420 MLH	–	–	–	S 420 MLH	–	S 420 MLH	–	–	–	1.8848	–
–	S 460 MH	–	–	–	S 460 MH	–	S 460 MH	–	–	–	1.8849	–
–	StE 460	S 460 N	–	–	S 460 N	E 460	S 460N	–	–	–	1.8901	–
–	TStE 460	S 460 L	–	–	S 460 NL	E460	S 460 NL	–	–	–	1.8903	–
–	S 550 Q	–	–	–	S 550 Q	E 550	S 550 Q	–	–	–	1.8904	–
–	S 460 Q	55 F	–	–	S 460 Q	E 460	S 460 Q	–	–	–	1.8908	–
–	S 420 NL/TStE 420	S 420 NL	STK 540	K02002	S 420 NL	E 420 T-I	Fe E 420 KT	–	–	–	1.8912	–
–	S 620 Q	–	–	–	S 620 Q	E 620	S 620 Q	–	–	–	1.8914	–
–	T St E 460/P460NL1	P 460 NL 1	–	K02900	P 460 NL1	E 460 T-I	Fe E 460 KT	–	–	–	1.8915	–
–	S 460 QL1	55 F	–	–	S 460 QL 1	–	–	–	–	–	1.8916	–
–	T St E 500	–	–	K02001	–	E 500 T-I	–	–	–	–	1.8917	–
–	EStE 460/P460NI2	P 460 NL 2	–	–	P 460 NL 2	P 460 NL 2	P 460 NL 2	–	–	–	1.8918	–
–	EStE 500/S500NL1	–	–	–	S 500 NL 1	–	–	–	–	–	1.8919	–
–	TStE 690 VA/S690G1QL	–	–	–	S 690 G 1 QL	–	–	–	–	–	1.8920	–
–	TStE 690 VB/S690G2QL	–	–	K11646	S 690 G 2 QL	–	–	–	–	–	1.8921	–
–	S 690 G 4 QL/TStE 690 VC	–	–	–	S 690 G 4 QL	–	–	–	–	–	1.8922	–
–	S 590 QL/TStE 590 V	–	–	–	S 590 QL	–	–	–	–	–	1.8923	–
–	S 500 Q (StE 500 V)	–	–	–	S 500 Q	E 500	S 500 Q	2614	–	–	1.8924	–
–	S 890 QL 1 (EStE 90 V)	–	–	–	S 890 QL 1	–	–	–	–	–	1.8925	–
–	S 690 QL (TStE 690 V)	–	SHY 685 NS	–	S 690 QL	–	–	–	–	–	1.8928	–
–	S 690 Q/StE 690 V	–	SHY 685 N	–	S 690 Q	E 690	S 690 Q	–	–	–	1.8931	–

NOTE: For legend, see page Y217.

(continued)

P3 Workpiece Materials Listing • Steel • P3 *(continued)*

P3 Alloy Steels and Tool Steels *Content: C >.25%* *Tensile Strength RM (MPa)*: 600–850* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	WSt E 420/P420NH	S 420 NL	STK 540	K02002	S 420 NL	S 420 NL	Fe E 420 KW	–	–	–	1.8932	–
–	S 960 QL/TStE 960 V	–	–	–	S 960 QL	–	–	–	–	–	1.8933	–
–	WSt E 460/P460NH	P 460 NH	–	K02900	P 460 NH	P 460 NH	Fe E 460 KW	–	–	–	1.8935	–
–	S 960 Q	–	–	–	S 960 Q	E 960 T-II	S 960 Q	–	–	–	1.8941	–
–	S 355 J 0 WP	WR 50 A	–	–	S 355 J0 WP	E 36 W-A3	S 355 J0 WP	–	–	–	1.8945	–
–	S 355 J 2 WP	S 355 J 2 WP	–	–	S 355 J2 WP	E36W-A4	S 355 J2 WP	–	–	–	1.8946	–
–	L 415 QB	–	–	–	L 415 QB	L 415 QB	–	–	–	–	1.8947	–
–	L 360 QB	–	–	–	L 360 QB	L 360 QB	–	–	–	–	1.8948	–
–	L 450 QB	–	–	–	L 450 QB	L 450 QB	–	–	–	–	1.8952	–
–	S 460 NH (FGS 47)	–	–	–	S 460 NH	–	S 460 NH	–	–	–	1.8953	–
–	L 485 QB	–	–	–	L 485 QB	L 485 QB	–	–	–	–	1.8955	–
–	S 460 NLH/FG S 47	–	–	–	S 460 NLH	–	S460NLH	–	–	–	1.8956	–
–	L 555 QB	–	–	–	L 555 QB	L 555 QB	–	–	–	–	1.8957	–
–	9 CrNiCuP 3 2 4	WR 50 A	SPA-H	K11430	–	–	–	–	–	–	1.8962	–
–	WTSt 52-3	WR 50 C	SMA 58 W	K11430	S 355 J 2 G 1 W	E 36 W-A2	–	–	–	–	1.8963	–
–	S 355 J 2 G 2 W	S 355 J 2 G 2 W	–	–	S 355 J 2 G 2 W	S 355 J 2 G 2 W	S 355 J 2 G 2 W	–	–	–	1.8965	–
–	S 355 K 2 G 1 W	S 355 K 2 G 1 W	SMA 490 CW	–	S 355 K2 G1 W	S 355 K2 G1 W	S 355 K 2 G 1 W	–	–	–	1.8966	–
–	S 355 K 2 G 2 W	S 355 K 2 G 2 W	–	–	S 355 K2G2W	S 355 K 2 G 2 W	S 355 K 2 G 2 W	–	–	–	1.8967	–
–	QStE 600 TM/S 600 MC	–	–	–	S 600 MC	E 620 D	S 600 MC	–	–	–	1.8969	–
–	StE 415..7/L 415 NB	–	–	–	L 415 NB	L 415 NB	–	–	–	–	1.8972	–
–	StE 415.7 TM/L 415 MB	–	–	–	L 415 MB	L 415 MB	–	–	–	–	1.8973	–
–	S 700 MC (QStE 690 TM)	–	–	–	S 700 MC	E 690 D	S 700 MC	–	–	–	1.8974	–
–	L 450 MB/StE 445.7 TM	–	–	–	L 450 MB	L 450 MB	–	–	–	–	1.8975	–
–	S 650 MC (QStE 650 TM)	–	–	–	S 650 MC	E 620 D	S 650 MC	–	–	–	1.8976	–
–	L 485 MB/StE 480.7 TM	–	–	–	L 485 MB	L 485 MB	–	–	–	–	1.8977	–
–	StE 550.7 TM/L 555 MB	–	–	–	L 555 MB	L 555 MB	–	–	–	–	1.8978	–
–	St 60-2	4360-55 E	SM 58	–	E 335	A 60-2	Fe 60-2	1650	–	–	1.0060	–
–	St 70-2	E 360	–	–	E 360	A 70-2	Fe 70-2	1655	–	–	1.0070	–
–	C4D	–	–	–	C 4 D	FM 5	C 4 D	–	–	–	1.0300	–
–	C 22 8	–	–	–	P 250 GH	–	–	–	–	–	1.0460	–
–	H 260/ZSt E 260	H 240 LA	–	–	H 240 LA	E 240 C	–	–	–	–	1.0480	–
–	C32D	–	SWRH 32	K02701	C 32 D	FM 32	C 32 D	–	–	–	1.0530	–
–	ZStE 380/H 380	H 360 L A	–	–	H 360 LA	E 355 C	–	–	–	–	1.0550	–
–	C60D	–	–	–	C 60 D	FM 60	C 60 D	–	–	–	1.0610	–
–	38 SMn 28	38 SMn 28	–	–	38 SMn 28	38 SMn 28	–	–	–	–	1.0760	–
–	QSt E 260 TM/5260 MC	–	–	–	S 260 MC	41 S 7	Fe E 275 TM	–	–	–	1.0970	–
–	C3D2	–	–	–	C 3 D 2	FM 5	C 3 D 2	–	–	–	1.1110	–
–	C38D2	–	–	–	C 38 D 2	FM 38	C 38 D 2	–	–	–	1.1150	–
–	C 42 E Al/Ck 42 Al	–	–	–	S 355 G15	–	–	–	–	–	1.1190	–
–	C56D2/D 55-2	–	–	–	C 56 D 2	FM 56	C 56 D 2	–	–	–	1.1220	–
–	C 70 W1	–	–	–	CT 70	C 70 E 2 U	C 70 K U	–	–	–	1.1520	–
–	C 45 W	–	–	–	C 45 U	Y3 42	–	–	–	–	1.1730	–
–	C 60 W	–	SK 7	–	–	Y3 55	–	–	–	–	1.1740	–
–	100 CrMn 6	–	–	K19195	100 CrMn 6	100 CM 6	–	–	–	–	1.3520	–
–	28 B 2	–	SWRCHB 26	–	C 30 B	20 B 3	–	–	–	–	1.5510	–
–	St E 380	–	SM 50 B	–	S 380 N	–	Fe E 390 KG	–	–	–	1.8900	–
–	TStE 380/S380NL	–	–	–	S 380 NL	–	Fe E 390 KT	2117	–	–	1.8910	–
–	S 890 Q	–	–	–	S 890 Q	S 890 Q	S 890 Q	–	–	–	1.8940	–

P4 Workpiece Materials Listing • Steel • P4

P4 Alloy Steels and Tool Steels *Content: C>.25%* *Tensile Strength RM (MPa)*: 850–1400* *Hardness (HB): 350–450 (HRC): 35–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
A 570 Gr. 40	St 44-2	4360-43 B	SM 41 B	K 02502	S 275 JR	E 28-2	Fe 430 BFN	1412	–	–	1.0044	–
–	S 235 J0/Fe 360 C	En 40C	–	–	S 235 J0	E24-3	Fe 360 CFN	–	–	–	1.0114	–
A 570 Gr. 36	St 37-3	4360-40 C	–	K01501	S 235 J2 G3	Fe 360 D1(2); E 24-3	Fe 360 D1(2)	1312	–	–	1.0116	–
–	QSt 37-3	–	SWRCH 12R	–	–	–	–	–	–	–	1.0123	–
–	S 275 J0	En43C; S275J0	–	–	S 275 J0/Fe 430 C	S 275 J0; E 28-3	S275J0; Fe430CFN	–	–	–	1.0143	–
A 573 Gr. 70	St 44-3	4360-43 C	SM 41 B	–	Fe 430 D1(2); S 275 J2 G3 (4)	Fe 430 D1(2); E 28-4	Fe 430 D FF	1414	–	–	1.0144	–
–	S 275 J2 G4/Fe 430 D 2	S 275 J2 G4	–	–	S 275 J2 G4	E28-4; S 275 J2 G4	S 275 J2 G4	1414	–	–	1.0145	–
–	Ro St 44-2	43C	–	–	S 275 J0 H	–	S 275 J0 H	–	–	–	1.0149	–
–	St 37.0	–	STPG 38	–	P 235 T1	–	–	–	–	–	1.0254	–
–	C9D	–	SWRM 8	–	C 9 D	FM 9	C 9 D	–	–	–	1.0304	–
–	C7D	C 7 D	SWRM 8	G10060	C 7 D	FM 8	C 7 D	–	–	–	1.0313	–
–	L 210 GA	–	–	–	L 210 GA	TS E 220 class 2	–	–	–	–	1.0319	–
–	USD 7/C 8 G1 W	–	–	–	C 8 G 1 W	–	–	–	–	–	1.0323	–
–	RSD 7/C8G2W	–	–	–	C 8 G 2 W	–	–	–	–	–	1.0324	–
–	RSD 10 Si/C10WSi	–	–	–	C 10 W Si	–	–	–	–	–	1.0339	–
–	P235 GH	P 235 GH	SPV 50	K02503	P 235 GH	A 37 CP	Fe E 235	1330	–	–	1.0345	–
–	RRSD 10/C10 W	–	–	–	C 10 W	–	–	–	–	–	1.0351	–
–	St 45.8	–	STB 410	K02727	–	–	–	–	–	–	1.0405	–
–	C 25 Pb	–	–	–	C 25 GPb	–	–	–	–	–	1.0411	–
–	L 245 MB	430	–	K03006	L 245 MB	L 245 MB	–	–	–	–	1.0418	–
1513	P265	HR 40/30	–	G15130	–	12 M 5	–	–	–	–	1.0424	–
–	P310 NB	224-410	SG 325	K02100	P280GH	BS 2	P 275 N	2103	–	–	1.0426	–
–	L 290 MB	–	–	–	L290MB	L 290 MB	–	–	–	–	1.0429	–
–	H II/P285NH	–	Sm 38	–	P 285 NH	–	–	–	–	–	1.0435	–
–	P310 NB	224-430	SG 325	K02100	P305GH	P 275 N	P 275 N	2103	–	–	1.0436	–
–	A St 41	P 275 N	STK 400	K02100	S 275 N	BS 3	P 275 N	2103	–	–	1.0437	–
–	B 500 A	–	SD 490	–	B 500 A	–	B 500 A	–	–	–	1.0438	–
–	GS-45	–	SC 450	–	–	–	–	–	–	–	1.0443	–
–	H IV/P295NH	–	SG 37	K03102	–	–	Fe 460-2 KW	–	–	–	1.0445	–

(continued)

P4

Workpiece Materials Listing • Steel • P4 *(continued)*

P4 Alloy Steels and Tool Steels *Content: C>.25%* *Tensile Strength RM (MPa)*: 850–1400* *Hardness (HB): 350–450 (HRC): 35–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	StE 240.7	–	–	–	L 245 NB	L 245 NB	–	–	–	–	1.0457	–
–	HIII/L 235 GA	–	–	–	L 235 GA	–	–	–	–	–	1.0458	–
–	L 245 GA/RRStE 240.7	–	–	–	L 245 GA	TS E 250	–	–	–	–	1.0459	–
–	St E255	–	–	K01800	–	–	–	–	–	–	1.0461	–
–	TStE 255	–	–	K11535	–	–	–	–	–	–	1.0463	–
–	15 Mn 3 Al	–	–	–	C 14 GAl	–	–	–	–	–	1.0468	–
–	21 Mn 4	–	–	–	–	–	20 Mn 4	–	–	–	1.0469	–
–	19 Mn 6/P 355 GH	P 355 GH	SGV 46	K03300	P355GH	A 52 CP	Fe E355-2	2101	–	–	1.0473	–
–	17 Mn 4/P 295 GH	224-460B	SG 37	K03501	P 295 GH	A 48 CP	Fe E 295	2102	–	–	1.0481	–
–	19 Mn 5	224-460	SG 37	K 03102	–	A 52 CP; AP; FP	Fe 460- 2 KW	–	–	–	1.0482	–
–	L 290 AG	–	–	–	L290GA	TS E 290	–	–	–	–	1.0483	–
–	L 290 NB	–	–	–	L290NB	L 290 NB	–	–	–	–	1.0484	–
–	21 Mn 6	–	–	K12320	–	–	–	–	–	–	1.0485	–
–	St E 285	P 275 N	SM 41 A	K 01802	P 275 N	P 275 N	Fe E 285 KG	–	–	–	1.0486	–
–	W St E 285	P 275 N	–	K 01802	P 275 NH	P 275 N	Fe E 285 KW	–	–	–	1.0487	–
–	T St E 285	P 275 NL 1	SLA 235 A	K 01803	P 275 NL 1	P 275 NL 1	Fe E 285 KT	–	–	–	1.0488	–
–	H 300/ZSt E 300	H280LA	–	–	H 280 LA	E 280 C	–	–	–	–	1.0489	–
–	S 275 NH	S 275 NH	–	–	S 275 NH	–	S 275 NH	–	–	–	1.0493	–
–	S 275 NLH	S275NLH	–	–	S 275 NLH	–	S275NLH	–	–	–	1.0497	–
–	L 360 GA	–	–	–	L 360 GA	–	–	–	–	–	1.0499	–
–	C 35 Pb/C 35 GPb	–	–	–	C 35 Pb	–	–	–	–	–	1.0502	–
–	St E 315/P 315N	–	SM 50 A	K11506	P 315 N	–	Fe E 315 KG	–	–	–	1.0505	–
–	W St E 315	–	SNC 1	K02404	P 315 NH	–	Fe E 315 KW	2107	–	–	1.0506	–
–	St 55	–	STKM 16A	–	–	–	Fe 540	–	–	–	1.0507	–
–	T St E315	–	SLA 325 A	K02404	P 315 NL	–	–	2106	–	–	1.0508	–
–	C 40 Pb	–	–	–	C 40 G Pb	–	–	–	–	–	1.0512	–
–	C38D	–	SWRH 37	–	C 38 D	FM 38	C 38 D	–	–	–	1.0516	–
–	C48D	–	SWRH 48	–	C 48 D	FM 48	C 48 D	–	–	–	1.0517	–
–	C56D	–	–	–	C 56 D	FM 56	C 56 D	–	–	–	1.0518	–
–	StSch 700 (R 0 700)	–	–	–	R 0700	–	–	–	–	–	1.0521	–
–	StSch800 (R 0 800)	–	–	–	R 0800	–	–	–	–	–	1.0524	–
–	Cf 45 Pb	–	–	–	–	–	C 46	–	–	–	1.0526	–
–	C32D	–	SWRH 32	K02701	C 32 D	FM 32	C 32 D	–	–	–	1.0530	–
–	GL-A 40 (S 390 G 1 S)	–	–	–	S 390 G 1 S	–	–	–	–	–	1.0532	–
–	S 355 NH	S 355 NH	–	–	S 355 NH	–	S 355 NH	–	–	–	1.0539	–
–	C42D	–	SWRH 42 B	–	C 42 D	FM 42	C 42 D	–	–	–	1.0541	–
–	Schienen 60 F(R 0600/ St Sch 60)	–	–	–	R 0600	–	–	–	–	–	1.0544	–
–	S 355 J0 H	50 C	–	–	S 355 J0 H	–	S 355 J0 H	–	–	–	1.0547	–
–	ZStE 340/H 340	H 320 L A	–	–	H 320 LA	E 315 C	–	–	–	–	1.0548	–
–	S 335 NLH	50 EE	–	–	S 355 N LH	–	S 355 N L H	–	–	–	1.0549	–
–	GS-52	A2	–	–	GE 260	–	–	–	–	–	1.0552	–
–	S 355 J0	En 50 C;S 355 J0	SM 520 M	–	S 355 J0	S 355 J0; E 36-3	S 355 J0; Fe 510 C FN	–	–	–	1.0553	–
–	GS-70	50 C	–	–	S 355 J0 C	E 36-3	Fe 510 C	–	–	–	1.0554	–
–	GS-62	–	–	–	S 355 GO 1	–	–	–	–	–	1.0555	–
–	ZStE 420/H 420	46/40HR,HS,CS	–	–	H 400 LA	H 400 LA	–	–	–	–	1.0556	–
–	P355 NB	–	SG 365	–	P 355 NB	BS 4	–	–	–	–	1.0557	–
–	GS-62.3	–	–	–	S 355 GO 2	–	–	–	–	–	1.0559	–
A 633 Gr. C	St E 355	P 355 N	SM 50 YB	K12000	P 355 N	E 355 R/FP	Fe E 355 KG	2132	–	–	1.0562	–
–	N 80	–	–	–	–	–	–	–	–	–	1.0564	–
–	W St E 355	P 355 NH	–	K01600	P 355 NH	P 355 NH	Fe E 355 KW	–	–	–	1.0565	–
–	T St E355	P 355 NL1	SLA 37	–	P 355 NL1	P 355 NL1	Fe E 355 KT	–	–	–	1.0566	–
–	32 Mn 3	–	–	–	–	–	–	–	–	–	1.0567	–
–	P355 QH1	P 355 QH	–	–	P 355 QH	P 355 QH	–	–	–	–	1.0571	–
–	ZStE 460/H 460	–	–	–	–	–	–	–	–	–	1.0574	–
–	S 355 J 2 G 4	S 355 J 2 G 4	–	–	S 355 J 2 G 4	S 355 J 2 G 4	S 355 J 2 G 4	–	–	–	1.0577	–
–	L 360 MB	–	–	–	L 360 MB	L 360 MB	–	–	–	–	1.0578	–
–	St 52.4	–	STS 49	–	–	–	–	–	–	–	1.0581	–
–	L 360 NB/StE 360.7	–	–	–	L360NB	L 360 NB	–	–	–	–	1.0582	–
–	S 355 J 2 G 3 Cu/St 52-3 Cu3	–	–	–	S 355 J2 G3 Cu + CR	–	–	–	–	–	1.0585	–
–	C50D	–	–	–	C 50 D	FM 50	C 50 D	–	–	–	1.0586	–
–	QSt 52-3 Cu 3	–	–	–	S 355 J2 G3 Cu C	–	–	–	–	–	1.0587	–
–	D 53-2	–	SWRH 52 B	–	C 52 D	FM 52	C 52 D	–	–	–	1.0588	–
–	FStE 355 OS 3/S355G03	–	–	K12000	S 355 G03	–	–	–	–	–	1.0591	–
–	S 355 J 2 G 4 Cu	–	–	–	S 355 J2 G4 Cu	–	–	–	–	–	1.0592	–
–	S355k2G3/Fe 510 DD1 (MULTIST)	S 355 K 2 G 3	SM 520 C	K02505	S 355 K 2 G 3	E36-4	S 355 K 2 G 3	–	–	–	1.0595	–
–	S355K2G4/Fe 510 DD 2 (MULTIST)	S 355 K 2 G 4	–	–	S 355 K 2 G 4	S 355 K 2 G 4	S 355 K 2 G 4	–	–	–	1.0596	–
–	C 30 Pb	–	–	–	C 3 0 GPb	–	–	–	–	–	1.0598	–
–	C 60 Pb	–	–	–	C 60 GPb	–	–	–	–	–	1.0602	–
–	C 67 GPb/C 67 Pb	–	–	–	C 67 GPb	–	–	–	–	–	1.0606	–
–	C 75 GPb/C 75 Pb	–	–	–	C 75 GPb	–	–	–	–	–	1.0607	–

NOTE: For legend, see page Y217.

(continued)

P4 Workpiece Materials Listing • Steel • P4 *(continued)*

P4 Alloy Steels and Tool Steels *Content: C>.25%* *Tensile Strength RM (MPa)*: 850–1400* *Hardness (HB): 350–450 (HRC): 35–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	C62D	–	SWRH 62 B	–	C 62 D	FM 62	C 62 D	–	–	–	1.0611	–
–	C66D	–	–	–	C 66 D	FM 66	C 66 D	–	–	–	1.0612	–
–	C68D	–	SWRH 67 B	–	C 68 D	FM 68	C 68 D	–	–	–	1.0613	–
–	C70D	–	–	–	C 70 D	FM 70	C 70 D	–	–	–	1.0615	–
–	C72D	–	SWRH 72 B	–	C 72 D	FM 72	C 72 D	–	–	–	1.0617	–
–	GS-C 25	–	SCPH 1	–	GP 240 GH	GP 240 GH	GP 240 Gh	–	–	–	1.0619	–
–	GP 240 GR	–	–	–	GP 240 GR	GP 240 GR	GP 240 GR	–	–	–	1.0621	–
–	C80D	–	–	–	C 80 D	FM 80	C 80 D	–	–	–	1.0622	–
–	StSch 900 A (R 0900)	–	–	–	R 0900	–	–	–	–	–	1.0623	–
–	StSch 900 B (R 0900 Mn)	–	–	–	R 0900 Mn	–	–	–	–	–	1.0624	–
1345	StSch 90 C/GP 280 GH	–	–	G13450	GP 280 GH	GP 280 GH	GP 280 GH	–	–	–	1.0625	–
–	C82D	–	SWRH 82 B	–	C 82 D	FM 82	C 82 D	–	–	–	1.0626	–
–	C88D	–	–	–	C 88 D	–	C 88 D	–	–	–	1.0628	–
–	StSch 1200 (R 1200)	–	–	–	R 1200	–	–	–	–	–	1.0631	–
–	C 61/60 Mn 3	–	–	–	C 61	–	C 61	–	–	–	1.0642	–
–	C 85/85 Mn 3	–	–	–	C 85	–	C 85	–	–	–	1.0647	–
–	35 SPb 20	35 SPb 20	–	–	35 SPb 20	35 SPb 20	–	–	–	–	1.0756	–
–	45 SPb 20	–	–	–	46 SPb 20	–	–	–	–	–	1.0757	–
–	38 SMnPb 28	38 SMnPb 28	–	–	38 SMnPb 28	38 SMnPb 28	–	–	–	–	1.0761	–
–	44 SMn 28	44 SMn 28	–	–	44 SMn 28	44 SMn 28	–	–	–	–	1.0762	–
–	44 SMnPb 28	44 SMnPb 28	–	–	44 SMnPb 28	44 SMnPb 28	–	–	–	–	1.0763	–
–	36 SMnPb 14	36 SMnPb 14	–	–	36 SMnPb 14	36 SMnPb 14	–	–	–	–	1.0765	–
9255	51 Si 7	250 A 53	–	G92550	–	51 S 7	48 Si 7	2090	–	–	1.0903	–
9255	55 Si 7	250 A 53	SKH 1; SKT 4	G92550	55 NiCrMoV 7	55 S 7	55 Si 8	2085	–	–	1.0904	–
–	StSch 1100 (R 1100 Cr)	–	–	–	R 1100 Cr	–	–	–	–	–	1.0915	–
9262	60 SiCr 7	250 A 61	SUP 7	G92620	60 SiCr 8	60 SC 7	60 SiCr 8	–	–	–	1.0961	–
–	QSt E 690 TM (S 700 MC)	–	–	–	S 700 MC	S 690 MC	S 700 MC	–	–	–	1.0966	–
–	QSt E 260 N 7 S 260 NC	–	AE 275 NC	–	S 260 NC	–	S 260 NCX	–	–	–	1.0971	–
–	QSt E 300 TM/S 315 MC	43 F35 HR,HS,CS	–	–	S 315 MC	E 315 D	S 315 MC	–	–	–	1.0972	–
–	QSt E 300 N 7/S 315 NC	–	AE 340 NC	–	S 315 NC	–	S 315 NC	–	–	–	1.0973	–
–	QSt E340 TM	HR 40/30	–	–	S 340 MC	E 335 D	–	–	–	–	1.0974	–
–	QSt E340 N	–	–	–	S 340 NC	–	Fe E 355 TD	–	–	–	1.0975	–
–	QSt E 360TM	–	–	–	S 355 MC	E 355 D	Fe E 355 TM	–	–	–	1.0976	–
–	QSt E360 N	–	–	–	S 355 NC	–	Fe E 355 TD	–	–	–	1.0977	–
–	QSt E380 TM	–	–	–	S 380 MC	E 390 D	–	–	–	–	1.0978	–
–	QSt E380 N	–	–	–	S 380 NC	–	Fe E 380 TD	–	–	–	1.0979	–
–	QSt E420 TM	HR 50 F 45	–	–	S 420 MC	E 430 D	Fe E 420 TM	–	–	–	1.0980	–
–	QSt E 420 N	–	–	–	S 420 NC	–	Fe E 420 TD	–	–	–	1.0981	–
–	QSt E 460 TM	50/45 HR	–	–	S 460 MC	E 445 D	–	–	–	–	1.0982	–
–	QSt E 460 N	–	–	–	S 460 NC	–	Fe E 460 TD	–	–	–	1.0983	–
–	QSt E500 TM	–	–	–	S 500 MC	E 490 D	Fe E 490 TM	2662	–	–	1.0984	–
–	QSt E500 N	–	–	–	S 500 NC	–	–	–	–	–	1.0985	–
–	QSt E550 TM	60/55 HS	–	–	S 550 MC	E 560 D	Fe E 560 TM	–	–	–	1.0986	–
–	QSt E550 N	–	–	–	S 550 NC	–	–	–	–	–	1.0987	–
–	FStE 355 OS 3/S355G04	–	–	–	S 355 G04	–	–	–	–	–	1.1102	–
–	EStE 285	P 275 NL 2	STK 400	–	P 275 NL 2	P 275 NL 2	P 275 NL 2	–	–	–	1.1104	–
–	EStE 315	–	–	–	S 315 NL 1	–	–	–	–	–	1.1105	–
–	EStE 355	P 355 NL 2	STK 500	–	P 355 NL 2	P 355 NL 2	P 355 NL 2	–	–	–	1.1106	–
–	C5D2	–	–	–	C 5 D 2	FM 6	C 5 D 2	–	–	–	1.1111	–
–	USD 5/C 8 E1 W	–	–	–	C 8 E 1 W	–	–	–	–	–	1.1112	–
–	C8D2	–	–	–	C 8 D 2	FM 8	C 8 D 2	–	–	–	1.1113	–
–	C 10 E W/RSD 11	–	–	–	C 10 EW	–	–	–	–	–	1.1115	–
–	USD 6/C 8 E2 W	–	–	–	C 8 E 2 W	–	–	–	–	–	1.1116	–
–	G 24 Mn 4/GS 24 Mn 4	–	–	–	G 24 Mn 4	–	–	–	–	–	1.1136	–
–	C32D2	–	–	–	C 32 D 2	FM 32	C 32 D 2	–	–	–	1.1143	–
–	C36D2	–	–	–	C 36 D 2	FM 36	C 36 D 2	–	–	–	1.1145	–
–	C38D2	–	–	–	C 38 D 2	FM 38	C 38 D 2	–	–	–	1.1150	–
–	C 25 R	C 25 R	–	–	C 25 R	C 25 R	C 25 R	–	–	–	1.1163	–
–	C48D2	–	–	–	C 48 D 2	FM 48	C48 D 2	–	–	–	1.1164	–
1330	GS-30 Mn 5	120 M 36	SMn 433 H; SCMn 2	K13300	–	35 M 5	–	1330	–	–	1.1165	–
1335	36 Mn 5	150 M 36	SMn 438(H)	G13350	–	40 M 5	–	2120	–	–	1.1167	–
–	G 40 Mn 5/GS 40 Mn 5	–	–	–	G 40 Mn 5	–	–	–	–	–	1.1168	–
–	20 Mn 6	150 M 19	–	–	–	20 M 5	20 Mn 6	–	–	–	1.1169	–
–	C50D2	–	–	–	C 50 D 2	FM 50	C50D 2	–	–	–	1.1171	–
–	Ck 38 Pb	–	–	–	25 Mn 4	–	–	–	–	–	1.1177	–
–	C 30 R	C 30 R	C 30 R (3 C 30)	–	C 30 R	C 30 R	C 30 R	–	–	–	1.1179	–
–	Ck 35 Pb	–	–	–	S 355 G 13	–	–	–	–	–	1.1182	–
–	Ck 36	–	–	–	S 355 G 14	–	–	–	–	–	1.1184	–
–	C3D1	–	–	–	C 3 D 1	–	C 3 D 1	–	–	–	1.1187	–
–	C40R/Cm 40	C 40 R	–	–	C 40 R	C 40 R	C 40	–	–	–	1.1189	–
–	C52D2	–	–	–	C 52 D 2	FM 52	C 52 D 2	–	–	–	1.1202	–
–	C 53 R/Cm 53	–	–	–	C 53 R	–	–	–	–	–	1.1205	–
–	C 10 R	C 10 R	–	–	C 10 R	C 10 R	–	–	–	–	1.1207	–
–	C 16 R	C 16 R	–	–	C 16 R	C 16 R	–	–	–	–	1.1208	–
–	C58D2	–	–	–	C 58 D 2	FM 58	C 58 D 2	–	–	–	1.1212	–
–	Ck 53 Pb	–	–	–	C 90 S	–	–	–	–	–	1.1217	–
–	C62D2	–	–	–	C 62 D 2	FM 62	C 62 D 2	–	–	–	1.1222	–
–	Cm 60	C 60 R	–	–	3 C 60	C 60 R	C 60 R	–	–	–	1.1223	–
–	C60D2	–	–	–	C 60 D 2	FM 60	C 60 D 2	–	–	–	1.1228	–
–	C68D2	–	–	–	C 68 D 2	FM 68	C 68 D 2	–	–	–	1.1232	–
–	C66D2	–	–	–	C 66 D 2	FM 66	C 66 D 2	–	–	–	1.1236	–
–	C50R	C 50 R	–	–	C 50 R	FM 50	C 50 R	–	–	–	1.1241	–
–	C72D2	–	–	–	C 72 D 2	FM 72	C 72 D 2	–	–	–	1.1242	–
–	C70D2	–	–	–	C 70 D 2	FM 70	C 70 D 2	–	–	–	1.1251	–
–	C78D2	–	–	–	C 78 D 2	FM 78	C 78 D 2	–	–	–	1.1252	–
–	C76D2	–	–	–	C 76 D 2	FM 76	C 76 D 2	–	–	–	1.1253	–
–	C80D2	–	–	–	C 80 D 2	FM 80	C 80 D 2	–	–	–	1.1255	–
–	C82D2	–	–	–	C 82 D 2	FM 82	C 82 D 2	–	–	–	1.1262	–
–	C86D2	–	–	–	C 86 D 2	FM 86	C 86 D 2	–	–	–	1.1265	–
–	C88D2	–	–	–	C 88 D 2	–	C 88 D 2	–	–	–	1.1272	–
–	C92D2	–	–	–	C 92 D 2	–	C 92 D 2	–	–	–	1.1282	–
–	C98D2	–	–	–	C 98 D 2	–	C 98 D 2	–	–	–	1.1283	–
–	46 MnVS 6	–	–	–	46 MnVS 6	–	–	–	–	–	1.1304	–
–	C 90 U	–	–	–	C90U	–	–	–	–	–	1.1535	–
–	C 110 W	–	–	–	C 110 U	–	–	–	–	–	1.1554	–
–	C 120 U	–	–	–	C120U	–	–	–	–	–	1.1555	–
T 8	C 80 W2	BW 1B	SKC 3	T12008	–	Y1 80	C 80 KU	–	–	–	1.1625	–
–	C 105 W2	–	SK 3	–	–	–	–	–	–	–	1.1645	–
–	C 135 W	–	SK 1	–	–	Y2 140	C 140 KU	–	–	–	1.1673	–
A-6	C 67 W	–	–	T30106	–	Y1 70	–	–	–	–	1.1744	–

(continued)

P4 Workpiece Materials Listing • Steel • P4 *(continued)*

P4 Alloy Steels and Tool Steels *Content: C>.25%* *Tensile Strength RM (MPa)*: 850–1400* *Hardness (HB): 350–450 (HRC): 35–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	125 Cr 1	–	–	–	125 Cr 2	Y2 120 C	–	–	–	–	1.2002	–
–	85 Cr 1	–	–	–	–	Y1 100 C 2	–	–	–	–	1.2004	–
–	140 Cr 3	–	SKS 8	–	140 Cr 2	Y2 140 C	–	–	–	–	1.2008	–
–	105 Cr 4	–	SKC 11	–	–	–	–	–	–	–	1.2057	–
–	21 MnCr 5	–	SCR 420 H	–	21 MnCr 5	20 NC 5	–	–	–	–	1.2162	–
–	35 CrMo 7	–	–	–	35 CrMo 7	–	–	–	–	–	1.2302	–
–	48 CrMoV 67	–	–	–	–	45 CDV 6	–	–	–	–	1.2323	–
P6	15 NiCr 14	–	SNC 22	T51606	–	10 NC 12	–	–	–	–	1.2735	–
–	40 CrMnNiMo 8 6 4	–	–	–	40 CrMnNiMo 8-6-4	–	–	–	–	–	1.2738	–
–	57 NiCrMoV 7 7	–	–	–	55 NiCrMoV 7	–	–	–	–	–	1.2744	–
–	70 MnMoCr 8	–	–	–	70 MnMoCr 8	–	–	–	–	–	1.2824	–
–	95 MnWCr 5	–	–	–	95 MnWCr 5	–	–	–	–	–	1.2825	–
–	60 MnSi 4	–	–	–	–	60 MSC 4	–	–	–	–	1.2826	–
–	101 Cr 6	–	–	–	–	–	102 Cr 6 KU	–	–	–	1.3514	–
–	16 CrNiMo 6	820A16	–	–	–	16 NCD 6	16NiCrMo6	–	–	–	1.3531	–
–	100 CrMn 7 3	–	–	–	100 CrMnMo 7	100 CD 7	–	–	–	–	1.3536	–
–	100 CrMo 7	–	SUS 4	K19965	100 CrMo 7	100 CD 7	100CrMo7	–	–	–	1.3537	–
–	100 CrMnMo 8	–	–	–	–	100 CrMnMo 8	–	–	–	–	1.3539	–
5046	44 Cr 2	–	–	H50460	46 Cr 1 KD	44 Cr 2	–	–	–	–	1.3561	–
4142	43 CrMo 4	–	–	G41420	–	43 Cr Mo 4	–	–	–	–	1.3563	–
4147	48 CrMo 4	817 M 40	SNC 836	H41470	–	48 CrMo 4	–	–	–	–	1.3565	–
–	46 Si 7	–	–	–	45 Si	46 S 7	–	–	–	–	1.5024	–
9259H	51 Si 7	–	–	–	50 Si 7	–	48 Si 7	2090	–	–	1.5025	–
–	55 Si 7	250 A 53	–	G92550	56 Si 7	55 S 7	55 Si 8	2085	–	–	1.5026	–
9260	60 Si 7	251 A 60	–	G92600	60 Si 7	60 S 7	60 Si 7	–	–	–	1.5027	–
–	65 Si 7	–	SUP 7	–	–	–	–	–	–	–	1.5028	–
–	12 Mn 8	–	–	–	11 Mn 8 KE	–	–	–	–	–	1.5086	–
9262	60 SC 7	–	–	G92620	60 SiCr 8	61 SC 7	60 SiCr 8	–	–	–	1.5092	–
–	37 MnSi 5	–	–	–	–	38 MS 5	–	F.130.A	–	–	1.5122	–
–	50 MnSi 4	–	–	K04800	–	–	–	–	–	–	1.5131	–
–	15 MnMoV 4 5	–	–	–	15 MnMoV 4-5	15 MDV 4.05	–	–	–	–	1.5402	–
A 204 Gr. A	15 Mo 3	1501-240	STFA 12	K11820	16 Mo 3	15 D3	16 Mo 3 KW	2912	–	–	1.5415	–
4419	GS-22 Mo 4	243-430	SCPH 11	G44190	G 20 Mo 5	G20Mo5	G 22 Mo 5	–	–	–	1.5419	–
–	20 MnMo 3 5	–	–	K12121	–	–	–	–	–	–	1.5421	–
–	G 18 Mo 5	–	–	–	G18Mo5	–	G 18 Mo5	–	–	–	1.5422	–
4520	16 Mo 5	1503-245-420	SBC 690	K11522	–	–	16 Mo 5	–	–	–	1.5423	–
–	11 MnMo 4 5	–	–	K11123	11 MnMo 45 KE	–	–	–	–	–	1.5425	–
–	13 MnMo 6 5	–	–	K11424	11 MnMo 65 KE	–	–	–	–	–	1.5426	–
–	13 MnMo 8 5	–	–	K11423	11 MnMo 85 KE	–	–	–	–	–	1.5427	–
–	35 B 2	–	SWRCHB 237	–	C 35 B	35 B 3	–	–	–	–	1.5511	–
15B21 H	19 MnB 4	170 H 20	SWRCHB 420	H15211	19 MnB 4	20 MB 5	–	–	–	–	1.5523	–
15B21 H	20 MnB 5	–	SWRCHB 620	–	20 MnB 5	20 MnB 5	20 MnB 5	–	–	–	1.5530	–
–	24 Ni 8	–	SCPL 21	J22501	G 9 Ni 10	22 N 8	G9Ni10	–	–	–	1.5633	–
A 350-LF 5	10 Ni 14	503	SL 3 N 26	K31718	12 Ni 14	12Ni14	18 Ni 14 KT	–	–	–	1.5637	–
P3	10 NC 6	–	–	T51603	15 NiCr 6	10 NC 6	–	–	–	–	1.5713	–
–	10 NiCr 5 4	10NiCr5-4	–	–	10 NiCr 5-4	10 NiCr 5-4	–	–	–	–	1.5805	–
–	18 MnMoNi 5 5	–	–	–	18 MnMoNi 5-5	–	–	–	–	–	1.6308	–
–	20 MnMoNi 4 5	–	SQV 2 B	K12539	20 MnMoNi 4-5	–	–	–	–	–	1.6311	–
–	10 NiMnMo 6 5	–	–	K11160	–	–	–	–	–	–	1.6312	–
–	16 NiCrMO 12 6	–	–	–	–	16 NCD 13	–	–	–	–	1.6782	–
–	15 MnCrMoNiV 5 3	–	–	–	15 MnCrMoNiV 5-3	–	–	–	–	–	1.6920	–
50B40	37 CrB 1	120 M 36	SMnC 3 H	H50401	38 Cr 2	–	35 CB 1	–	–	–	1.7007	–
–	13 Cr 2	–	–	–	–	–	–	–	–	–	1.7012	–
–	17 CrS 3	17 CrS3	–	–	17 CrS 3	17 CrS 3	–	–	–	–	1.7014	–
5015	15 Cr 3	523 M15	SCr 415 H	G50150	15 Cr 2	12 C 3	–	–	–	–	1.7015	–
5117	17 Cr 3	17 Cr 3	–	G51170	(15 Cr 2 KD)	18 C 3	–	–	–	–	1.7016	–
5130 H	34 Cr 4	530 A 32	SCr 430 H	G51300	34 Cr 4 KD	32 C 4	34 Cr 4 KB	–	–	–	1.7033	–
5132 H	37 Cr 4	530 A 36	SCr 435 H	G51320	37 Cr 4	38 C 4	36 CrMn 4	–	–	–	1.7034	–
5140	41 Cr 4	530 M 40	SCr 440 H	G51400	41 Cr 4	42 C 4	41 Cr 4	–	–	–	1.7035	–
–	28 CrS 4	–	–	–	28CrS4	28CrS4	–	–	–	–	1.7036	–
–	34 CrS 4	34 CrS 4	–	–	34 CrS 4	34 CrS 4	34 CrS 4	–	–	–	1.7037	–
–	41 CrS 4	41 CrS 4	–	–	41 CrS 4	41 CrS 4	41 CrS 4	2245	–	–	1.7039	–
–	38 Cr 4	–	–	–	38 Cr 4	–	38 Cr 4	–	–	–	1.7043	–
5140	42 Cr 4	530 A 40	SCr 440	–	40 NiCrMo 3	42 C 4 TS	40 NiCrMo 3	2245	–	–	1.7045	–
–	54 SiCr 6	–	–	–	–	54 SC 6	–	–	–	–	1.7102	–
–	67 SiCr 5	–	–	–	67 SiCr 5	–	67 SiCr 5	–	–	–	1.7103	–
9262	60 SiCr 7	–	–	–	60 SiCr 8	–	–	–	–	–	1.7108	–
–	52 SiCrNi 5	–	–	–	–	52 SCN 5	–	–	–	–	1.7117	–
5115	16 MnCr 5	527 M 17	SCR 415	G 51150	16 MnCr 5 KD	16 MC 5	16 MnCr 5	2173	–	–	1.7131	–
–	49 CrMo 4	–	SCM 445	–	–	–	–	–	–	–	1.7238	–
–	16 CrMo 4	18 CrMo4	SCM 418 H	–	18 CrMo 4	15 CD 3.5	18 CrMo 4	–	–	–	1.7242	–
–	10 CrMo 11	–	–	–	–	12 CD 10	–	–	–	–	1.7276	–
–	16 CrMo 9 3	–	–	–	–	20 CD 8	–	–	–	–	1.7281	–
–	22 CrMoS 3 5	–	–	–	22 CrMoS 3-5	22 CrMoS 3-5	–	–	–	–	1.7333	–
A 387 Gr. 12 Cl. 2	16 CrMo 4 4	–	–	K11564	–	–	A 18 CrMo 4 5 KW	–	–	–	1.7337	–
–	12 CrMo 8 5	–	–	K21509	–	–	–	–	–	–	1.7358	–
–	12 CrMo 19 5	3606-625	SCMV 6	K41545	X 12 CrMo 5	Z 10 CD 5.05	16 CrMo 20 5	–	–	–	1.7362	–
–	X 7 CrMo 6 1	B 5	–	S50281	CM 5-IG	–	–	–	–	–	1.7373	–
–	12 CrMo 9 10	–	–	–	–	12 CrMo 9-10	–	–	–	–	1.7375	–
–	SG-CrMo 9	–	–	S50480	–	–	–	–	–	–	1.7388	–
–	51 CrMoV 4	–	–	–	51 CrMoV 4	51 CDV 4	51 CrMoV 4	–	–	–	1.7701	–
–	21 CrMoV 5 7	–	–	K14073	21 CrmoV 5-7	20 CDV 5.07	–	–	–	–	1.7709	–
–	20 CrMoVTiB 4 10	–	–	–	20 CrMoVTiB 4-10	20 CrMoVTiB 4-10	–	–	–	–	1.7729	–
6150	50 CrV 4	735 A 50	SUP 10	G61500	51 CrV 4	50 CV 4	50 CrV 4	2230	–	–	1.8159	–
–	PS 275 TMK	S 275 ML	–	–	S 275 ML	S 275 ML	S 275 ML	–	–	–	1.8819	–
–	S 355 G1 M	–	–	–	S 355 G 1 M	–	–	–	–	–	1.8822	–
–	BTStE 460 TM	S 460 ML	–	–	S 460 ML	E 460	S 460 ML	–	–	–	1.8838	–
–	S 500 ML	–	–	–	S 500 ML	–	–	–	–	–	1.8839	–

NOTE: For legend, see page Y217.

(continued)

P4 Workpiece Materials Listing • Steel • P4 *(continued)*

P4 Alloy Steels and Tool Steels *Content: C>.25%* *Tensile Strength RM (MPa)*: 850–1400* *Hardness (HB): 350–450 (HRC): 35–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	S 275 MH	–	–	–	S 275 MH	–	S 275 MH	–	–	–	1.8843	–
–	S 275 MLH	–	–	–	S 275 MLH	–	S 275 MLH	–	–	–	1.8844	–
–	S 355 MH	–	–	–	S 355 MH	–	S 355 MH	–	–	–	1.8845	–
–	S 355 MLH	–	–	–	S 355 MLH	–	S 355 MLH	–	–	–	1.8846	–
–	S 420 MH	–	–	–	S 420 MH	–	S 420 MH	–	–	–	1.8847	–
–	S 420 MLH	–	–	–	S 420 MLH	–	S 420 MLH	–	–	–	1.8848	–
–	S 460 MH	–	–	–	S 460 MH	–	S 460 MH	–	–	–	1.8849	–
–	S 460 MLH	–	–	–	S 460 MLH	–	S 460 MLH	–	–	–	1.8850	–
–	FStE 355 OS 4/ S420G5Q	–	–	–	S 420 G 2	–	–	–	–	–	1.8853	–
–	P 550 QL	–	–	–	P 550 QL	–	–	–	–	–	1.8878	–
–	StE 460	S 460 N	–	–	S 460 N	E 460	S 460N	–	–	–	1.8901	–
A 633 Gr. E	St E 420	S 420 N	SM 50 C	K02002	FeE 420 KGN	E 420-I	Fe E 420 KG	2143	–	–	1.8902	–
–	TStE 460	S 460 L	–	–	S 460 NL	E460	S 460 NL	–	–	–	1.8903	–
–	S 550 Q	–	–	–	S 550 Q	E 550	S 550 Q	–	–	–	1.8904	–
A 633 Gr. E	St E 460	P 460 N	SM 53 B	K02900	P 460 N	E 460-I	Fe E 460 KG	2143	–	–	1.8905	–
–	BGH 8906	55 F	–	–	S 460 QL	S 460 QL	S 460 QL	–	–	–	1.8906	–
–	St E 500	–	SM 58	K02001	–	–	–	–	–	–	1.8907	–
–	S 460 Q	55 F	–	–	S 460 Q	E 460	S 460 Q	–	–	–	1.8908	–
–	S 420 NL/TStE 420	S 420 NL	STK 540	K02002	S 420 NL	E 420 T-I	Fe E 420 KT	–	–	–	1.8912	–
–	EStE 420/ S420NL1	–	STK 540	–	–	–	–	–	–	–	1.8913	–
–	S 620 Q	–	–	–	S 620 Q	E 620	S 620 Q	–	–	–	1.8914	–
–	T St E 460/ P460NL1	P 460 NL 1	–	K02900	P 460 NL1	E 460 T-I	Fe E 460 KT	–	–	–	1.8915	–
–	S 460 QL1	55 F	–	–	S 460 QL 1	–	–	–	–	–	1.8916	–
–	T St E 500	–	–	K02001	–	E 500 T-I	–	–	–	–	1.8917	–
–	EStE 460/ P460Nl2	P 460 NL 2	–	–	P 460 NL 2	P 460 NL 2	P 460 NL 2	–	–	–	1.8918	–
–	EStE 500/ S500NL1	–	–	–	S 500 NL 1	–	–	–	–	–	1.8919	–
–	TStE 690 VB/ S690G2QL	–	–	K11646	S 690 G 2 QL	–	–	–	–	–	1.8921	–
–	S 690 G 4 QL/ TStE 690 VC	–	–	–	S 690 G 4 QL	–	–	–	–	–	1.8922	–
–	S 590 QL/TStE 590 V	–	–	–	S 590 QL	–	–	–	–	–	1.8923	–
–	S 500 Q (StE 500 V)	–	–	–	S 500 Q	E 500	S 500 Q	2614	–	–	1.8924	–
–	S 890 QL 1 (EStE 90 V)	–	–	–	S 890 QL 1	–	–	–	–	–	1.8925	–
–	S 690 QL (TStE 690 V)	–	SHY 685 NS	–	S 690 QL	–	–	–	–	–	1.8928	–
–	TStE 690 VD/ S690G3QL	–	–	–	S 690 G 3 QL	–	–	–	–	–	1.8929	–
–	S 690 Q/StE 690 V	–	SHY 685 N	–	S 690 Q	E 690	S 690 Q	–	–	–	1.8931	–
–	WSt E 420/ P420NH	S 420 NL	STK 540	K02002	S 420 NL	S 420 NL	Fe E 420 KW	–	–	–	1.8932	–
–	S 960 QL/TStE 960 V	–	–	–	S 960 QL	–	–	–	–	–	1.8933	–
–	WSt E 460/ P460NH	P 460 NH	–	K02900	P 460 NH	P 460 NH	Fe E 460 KW	–	–	–	1.8935	–
–	P420 QH	–	–	–	P 420 QH	–	–	–	–	–	1.8936	–
–	TStE 770 V/ S770QL	–	–	–	S 770 QL	–	–	–	–	–	1.8938	–
–	EStE 790 V/ S790QL1	–	–	–	S 790 QL 1	–	–	–	–	–	1.8939	–
–	S 960 Q	–	–	–	S 960 Q	E 960 T-II	S 960 Q	–	–	–	1.8941	–
–	S 550 G 1 QL 1/ EStE 550 VA	–	–	–	S 550 G 1 QL 1	–	–	–	–	–	1.8944	–
–	S 355 J 0 WP	WR 50 A	–	–	S 355 J0 WP	E 36 W-A3	S 355 J0 WP	–	–	–	1.8945	–
–	S 355 J 2 WP	S 355 J 2 WP	–	–	S 355 J2 WP	E36W-A4	S 355 J2 WP	–	–	–	1.8946	–
–	L 415 QB	–	–	–	L 415 QB	L 415 QB	–	–	–	–	1.8947	–
–	L 360 QB	–	–	–	L 360 QB	L 360 QB	–	–	–	–	1.8948	–
–	L 450 QB	–	–	–	L 450 QB	L 450 QB	–	–	–	–	1.8952	–
–	S 460 NH (FGS 47)	–	–	–	S 460 NH	–	S 460 NH	–	–	–	1.8953	–
–	EStE620VA/S 620 G 1 QL 1	–	–	–	S 620 G 1 QL 1	–	–	–	–	–	1.8954	–
–	L 485 QB	–	–	–	L 485 QB	L 485 QB	–	–	–	–	1.8955	–
–	S 460 NLH/FG S 47	–	–	–	S 460 NLH	–	S460NLH	–	–	–	1.8956	–
–	L 555 QB	–	–	–	L 555 QB	L 555 QB	–	–	–	–	1.8957	–
–	9 CrNiCuP 3 2 4	WR 50 A	SPA-H	K11430	–	–	–	–	–	–	1.8962	–
–	WTSt 52-3	WR 50 C	SMA 58 W	K11430	S 355 J 2 G 1 W	E 36 W-A2	–	–	–	–	1.8963	–
–	EStE 690 VA	–	–	–	S 690 G1 QL1	–	–	–	–	–	1.8964	–
–	S 355 J 2 G 2 W	S 355 J 2 G 2 W	–	–	S 355 J 2 G 2 W	S 355 J 2 G 2 W	S 355 J 2 G 2 W	–	–	–	1.8965	–
–	S 355 K 2 G 1 W	S 355 K 2 G 1 W	SMA 490 CW	–	S 355 K2 G1 W	S 355 K2 G1 W	S 355 K 2 G 1 W	–	–	–	1.8966	–
–	S 355 K 2 G 2 W	S 355 K 2 G 2 W	–	–	S 355 K2G2W	S 355 K 2 G 2 W	S 355 K 2 G 2 W	–	–	–	1.8967	–
–	QStE 600 TM/S 600 MC	–	–	–	S 600 MC	E 620 D	S 600 MC	–	–	–	1.8969	–
–	StE 415..7/L 415 NB	–	–	–	L 415 NB	L 415 NB	–	–	–	–	1.8972	–
–	StE 415.7 TM/L 415 MB	–	–	–	L 415 MB	L 415 MB	–	–	–	–	1.8973	–
–	S 700 MC (QStE 690 TM)	–	–	–	S 700 MC	E 690 D	S 700 MC	–	–	–	1.8974	–
–	L 450 MB/StE 445.7 TM	–	–	–	L 450 MB	L 450 MB	–	–	–	–	1.8975	–
–	S 650 MC (QStE 650 TM)	–	–	–	S 650 MC	E 620 D	S 650 MC	–	–	–	1.8976	–
–	L 485 MB/StE 480.7 TM	–	–	–	L 485 MB	L 485 MB	–	–	–	–	1.8977	–
–	StE 550.7 TM/L 555 MB	–	–	–	L 555 MB	L 555 MB	–	–	–	–	1.8978	–

(continued)

P4 Workpiece Materials Listing • Steel • P4 *(continued)*

P4 Alloy Steels and Tool Steels *Content: C>.25%* *Tensile Strength RM (MPa)*: 850–1400* *Hardness (HB): 350–450 (HRC): 35–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
A 570 Gr. 50	St 50-2	4360-50 B	SS 50	–	E 295	A 50-2	Fe 490	2172	–	–	1.0050	–
–	St 60-2	4360-55 E	SM 58	–	E 335	A 60-2	Fe 60-2	1650	–	–	1.0060	–
–	St 70-2	E 360	–	–	E 360	A 70-2	Fe 70-2	1655	–	–	1.0070	–
–	C4D	–	–	–	C 4 D	FM 5	C 4 D	–	–	–	1.0300	–
–	C 22 8	–	–	–	P 250 GH	–	–	–	–	–	1.0460	–
–	H 260/ZSt E 260	H 240 LA	–	–	H 240 LA	E 240 C	–	–	–	–	1.0480	–
–	ZStE 380/H 380	H 360 L A	–	–	H 360 LA	E 355 C	–	–	–	–	1.0550	–
–	GL-E - 40 (S 390 G 3 S)	–	–	–	S 390 G 3 S	–	–	–	–	–	1.0560	–
–	C60D	–	–	–	C 60 D	FM 60	C 60 D	–	–	–	1.0610	–
–	C 64/64 Mn 3	–	–	–	C 64	–	–	–	–	–	1.0640	–
–	38 SMn 28	38 SMn 28	–	–	38 SMn 28	38 SMn 28	–	–	–	–	1.0760	–
–	QSt E 260 TM/5260 MC	–	–	–	S 260 MC	41 S 7	Fe E 275 TM	–	–	–	1.0970	–
–	C3D2	–	–	–	C 3 D 2	FM 5	C 3 D 2	–	–	–	1.1110	–
1330	28 Mn 6	150 M 28	SCMn 1	G 13300	28 Mn 6	35 M 5	C 28 Mn	–	–	–	1.1170	–
–	C 42 E Al/Ck 42 Al	–	–	–	S 355 G15	–	–	–	–	–	1.1190	–
–	C56D2/D 55-2	–	–	–	C 56 D 2	FM 56	C 56 D 2	–	–	–	1.1220	–
–	C 70 W1	–	–	–	CT 70	C 70 E 2 U	C 70 K U	–	–	–	1.1520	–
–	C 70 W2	–	–	–	C 70 U	–	–	–	–	–	1.1620	–
–	C 45 W	–	–	–	C 45 U	Y3 42	–	–	–	–	1.1730	–
–	C 60 W	–	SK 7	–	–	Y3 55	–	–	–	–	1.1740	–
–	100 CrMn 6	–	–	K19195	100 CrMn 6	100 CM 6	–	–	–	–	1.3520	–
–	28 B 2	–	SWRCHB 26	–	C 30 B	20 B 3	–	–	–	–	1.5510	–
5130	28 Cr 4	530 A 30	–	G51300	28 Cr 4	30 CD 4	–	–	–	–	1.7030	–
–	S 420 G1 M	–	–	–	P 550 M	–	–	–	–	–	1.8830	–
–	St E 380	–	SM 50 B	–	S 380 N	–	Fe E 390 KG	–	–	–	1.8900	–
–	TStE 380/ S380NL	–	–	–	S 380 NL	–	Fe E 390 KT	2117	–	–	1.8910	–
–	TStE 690 VA/ S690G1QL	–	–	–	S 690 G 1 QL	–	–	–	–	–	1.8920	–
–	WSt E 380/ P380Nh	–	–	–	P 380 NH	–	Fe E 390 KW	2116	–	–	1.8930	–
–	S 890 Q	–	–	–	S 890 Q	S 890 Q	S 890 Q	–	–	–	1.8940	–

P5 Workpiece Materials Listing • Steel • P5

P5 Ferritic, Martensitic, and PH Stainless Steels *Tensile Strength RM (MPa)*: 600–900* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
410 S	X 7 Cr 14	–	–	–	–	–	–	–	–	–	1.4001	–
405	X 6 CrAl 13	405 S 17	SUS 405	S40500	X 6 CrAl 13	Z 6 CA 13	X 6 CrAl 13	2302	–	–	1.4002	–
–	X 2 CrNi 1 2	–	–	–	Hyfab3/12	CLC4003	F12N(Mn<1,50)	–	–	–	1.4003	–
416	X 12CrS 13	416 S 21	SUS416	S41600	X 12 CrS 13	Z 12 CF 13	X12CrS13	2380	–	–	1.4005	ATI 416™
410	X 12Cr 13	410 S 21	SUS410	S 41000	(X 12 Cr 13 KD)	Z 12 C 13	X12Cr13	2302	–	–	1.4006	ATI 410™
414	GX 8 CrNi 1 3	410 C 21	SCS 1	S41400	GX 7 CrNiMo 12-1	Z 12 CN 13 M	GX 12 Cr 13	–	–	–	1.4008	–
–	X 8 Cr 14	–	SUS Y 410	S41080	X 8 Cr 13 KE	–	–	–	–	–	1.4009	B13Fe
–	GX 12 Cr 1 2	–	–	–	GX12Cr12	GX12Cr12	–	–	–	–	1.4011	–
–	N 3 2 0 (LW)	–	–	–	3S62	–	–	–	–	–	1.4014	–
–	X 8 Cr 18	–	SUS Y 430	S43080	–	–	–	–	–	–	1.4015	B17Fe
430	X 8 Cr 17	430 S 15	SUS430	S 43000	X 8 Cr 17	Z8C17	X8Cr17	2320	–	–	1.4016	ATI 430™
–	X 6 CrNi 17 1	–	–	–	X6CrNi17-1	F17N	X6CrNi17-1	–	–	–	1.4017	–
420	X20Cr13	420 S 37	SUS 420J1	S42000	X 20 Cr 13	Z20C13	X20Cr13	2303	–	–	1.4021	ATI 420™
403	X 15 Cr 13	420 S 29	SUS 410 J1	J91201	X 15 Cr 13	Z 12 C 13 M	X 12 Cr 13	2301	–	A403M	1.4024	ATI 403™
–	GX 20 Cr 1 4	420 C 29	SCS 2	–	–	Z 20 C 13 M	–	–	–	A743-4	1.4027	–
420	X 40 Cr 13	–	SUS 420 J2	S42080	X 40 Cr 13	Z 40 C 14	X 40 Cr 14	2304	–	–	1.4031	–
–	GX 120 Cr 29	425 C 11	–	–	–	–	–	–	–	F30C	1.4086	–
430 F	X 12 CrMoS 17	441 S 29	SUS 430 F	S 43020	X 14 CrMoS 17	Z 10 CF 17	X 10 CrS 17	2383	–	–	1.4104	–
430	X 4 CrMoS 18	–	SUS 430F	–	X 6 CrMoS 17	Z 6 CDF 18 - 02	–	–	–	–	1.4105	–
–	X 2 CrMoSiS 18 2 1	–	–	J91151	–	–	–	–	–	CA15	1.4106	–
–	GX 8 CrNi 1 2	–	–	–	GX 8 CrNi 12	GX8CrNi 12	G X 8 CrNi 12	–	–	–	1.4107	–
434	X 6CrMo 17	434 S 17	SUS434	S43400	434S17	Z8CD17-01	X8CrMo17	2325	–	–	1.4113	AL 434
–	X 15 CrMo 13	–	–	–	–	–	–	–	–	–	1.4119	–
–	GX 70 CrMo 29 2	–	–	–	–	Z 60 CD 29.2 M	–	–	–	–	1.4136	–
–	X 2 CrNi 24 12	309 S 93	–	–	X 2 CrNi 24 13 KE	Z 2 CN 24-14	–	–	–	–	1.4332	CN23/12-IG
–	X 5 NiCr 32 21	–	–	S33200	–	–	–	–	–	B536	1.4333	H521
–	GX 5 CrNiMo 16 5	–	–	–	GX 4 CrNiMo 16-5-1	GX4CrNiMo 16-5-1	G X 4 CrNiMo 16-5-1	–	–	–	1.4405	–
–	ERO 4411 A	–	–	–	GX 4 CrNiMo 16-5-2	GX 4 CrNiMo 16-5-2	–	–	–	–	1.4411	–
–	X 38 CrMo 14	–	–	–	–	–	–	–	–	–	1.4419	–
–	X 8 CrTi 18	–	–	–	X 6 Cr 18 KE	–	–	–	–	–	1.4502	–
430 Nb	X 6 CrNb 17	–	SUS 430 LX	–	X 3 CrNb 17	Z 8 CNb 17	X 6 CrNb 17	–	–	–	1.4511	AXC525
409	X 6 CrTi 12	409 S 19	SUH 409	S40900	X 5 CrTi 12	Z 6 CT 12	X 6 CrTi 12	–	–	–	1.4512	–
–	X 6 CrNiTi 12	–	–	–	X 6 CrNiTi 12	X 6 CrNiTi 12	X 6 CrNiTi 12	–	–	–	1.4516	–
–	X 2 CrTi 17	–	SUS 430 LX	–	X 2 CrTi 17	F 20T	X 2 CrTi 17	–	–	–	1.4520	–
–	X 8 CrMoTi 17	–	–	–	X 2 CrMoTiS 18 2	X2CrMoTiS18-2	–	–	–	–	1.4523	1802
–	GX 5 CrNiCu 16 4	–	–	–	GX 5 CrNiCu 16-4	GX 5 CrNiCu 16-4	–	–	–	–	1.4525	–
–	X 6 CrMoNb 17 1	–	–	–	X 6 CrMoNb 17-1	X6CrMoNb 17-1	F 17 MNb	–	–	–	1.4526	–
904 L	X 1 NiCrMoCuN 25 20 5	904 S 13	–	N08904	X 1 NiCrMoCuN 25 20 5	Z 1 NCDU 25 20	–	2562	–	–	1.4539	ATI 904L™
348	X 5 CrNiNb 18 10	S 527	–	J92640	–	–	X 6 CrNiNb 18 11	–	–	–	1.4546	ATI 348™
–	X 5 CrNiNb 19 9	–	SUS Y 347	S34780	X 5 CrNiNb 20 10 KE	Z 6 CNNb 20-10	–	–	–	–	1.4551	–
–	GX 7 NiCrMoCuNb 42 20	–	–	–	GX 7 NiCrMoCuNb 4220	–	–	–	–	–	1.4559	–
–	X 5 CrNiMoNb 19 12	318 S 96	–	S31980	X 5 CrNiMoNb 19 12 03 KE	Z 4 CNDSNb 19-12-03	–	–	–	–	1.4576	–
–	X 2 CrAlTi 18 2	–	–	–	X 2 CrAlTi 18-2	DMV 59	X 2 CrAlTi 18-2	–	–	–	1.4605	–
–	X 10 CrAl 7	–	–	–	X 10 CrAl 7	–	–	–	–	–	1.4713	–

NOTE: For legend, see page Y217.

(continued)

P5 Workpiece Materials Listing • Steel • P5 *(continued)*

P5 Ferritic, Martensitic, and PH Stainless Steels *Tensile Strength RM (MPa)*: 600–900* *Hardness (HB): <330 (HRC): <35*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	X 215 Cr 12	–	–	–	–	–	–	–	–	–	1.4721	–
H-12	X 10 CrAl 13	BH 12	SUS 405	T20812	X 10 CrAl 13	Z 10 C 13	X 10 CrAl 12	–	–	–	1.4724	–
430	X 10 CrAl 18	(430 S 15)	SUH 21	S43000	–	Z 10 CAS 18	(X 8 Cr 17)	–	–	–	1.4742	–
446	X 10 CrAl 25	–	SUH 442	S44600	X 10 CrAl 24	Z 10 CAS 24	X 16 Cr 26	2322	–	–	1.4762	–
–	GX 40 CrNiSi 27 4	–	–	J92605	–	–	–	–	–	–	1.4823	–
–	X 12 CrNi 22 12	311 S 94	SUS Y 309	S30980	X 15 CrNi 23 13	–	X 16 CrNi 23 14	–	–	309	1.4829	–
–	X 9 CrNiSiNCe 21 11 2	–	–	–	X 9 CrNiSiNCe 21-11-2	–	–	–	–	–	1.4835	–
314	X 15 CrNiSi 25 20	314 S 25	SUH 310	S31400	X 15 CrNiSi 25 20	Z 15 CNS 25.20	X 16 CrNiSi 25 20	–	–	–	1.4841	Cronifer® 2520
–	X 12 CrNi 25 20	310 S 94	–	S31080	X 12 CrNi 26 21 KE	Z 12 CN 26-21	–	–	–	–	1.4842	–
–	CrNi 25 20	–	SCS 18	S31400	–	–	–	–	–	–	1.4843	–
310 S	X 12 CrNi 25 21	310 S 24	SUS 310 S	S31008	X 8 CrNi 25 21	Z 12 CN 25.20	X 6 CrNi 25 20	2361	–	–	1.4845	ATI 310S™
HK	X 40 CrNiSi 25 20	310 C 40	SCH 21	J94204	–	–	GX 40 CrNi 26 20	–	–	–	1.4848	–
–	GX 40 NiCrSiNb 38-18	–	–	–	3072.76	–	–	–	–	–	1.4849	–
–	GX 10 NiCrNb 32 20	–	–	J95151	–	–	–	–	–	–	1.4859	–
330	X 12 NiCrSi 35 16	NA 17	SUH 330	N08330	X 12 NiCrSi 35 1 6	Z 12 NCS 37.18	–	–	–	–	1.4864	–
–	X40NiCrSi38-18	330 C 40	SCH15/SCH16	J94605	330C11/330C40/331C40	–	GX50NiCr39-19	–	–	–	1.4865	–
–	GX 50 CrNi 30-30	–	–	N08801	–	Z5NCT3220	–	–	–	–	1.4868	–
B163	X 10 NiCrAlTi 32 20	NA 15	NCF800(TP)	–	NA15(H)	Z10NC32.21	–	–	B163	–	1.4876	B163
–	X 6 NiCrNbCe 32 27	–	–	–	X 6 NiCrNbCe 32-27	–	–	–	–	–	1.4877	–
–	X 12 NiCrSi 35 19	–	–	N08830	X1 0 NiCrSi 35 19	–	–	–	–	–	1.4886	330
–	X 10 NiCrSiNb 35 22	–	–	–	X10NiCrSiNb35-22	–	–	–	–	–	1.4887	–
–	X 10 CrMoV 9 1	–	–	S59180	X 10 CrMoV 9-1	–	–	–	–	–	1.4903	–
–	X 20 CrMoV 12 1	–	–	–	X 20 CrMoV 11-1	–	X 20 CrMoV 12 01 KW	2317	–	–	1.4922	–
–	GX 22 CrMoV 12 1	–	–	–	G-X 22 CrMoV 12 1	GX23CrMoV12-1	G X 23 CrMoV 12-1	–	–	–	1.4931	–
422	X 20 CrMoWV 12 1	–	SUH 616	S42200	–	–	X 22 CrMoWV 12 1	–	–	–	1.4935	–
661	X 12 CrCoNi 21 20	–	SUH 661	R30155	–	–	–	–	–	–	1.4971	–
R30155	X 12 CrCoNiMoWNb 21 20 20	–	–	R30155	X 12 CrCoNiMoWNb 21 20 20	Z 12 CKNDWNb 21.20.20	N-155	–	–	–	1.4974	–
–	X 40 CoCrNi 20 20	–	–	–	–	Z 42 CNKDWNb	–	–	–	–	1.4977	–
403	X 6 Cr 13	403 S 17	SUS 403	S 40300	X 6 Cr 13	Z 6 C 13	X 6 Cr 13	2301	–	A240	1.4000	ATI 410S™
439	X 6 CrTi 17	–	SUS 430 LX	S 43035	X 8 CrTi 1 7	Z 8 CT 1 7	X 6 CrTi 17	–	–	–	1.4510	430 Ti
–	X 22 CrMoV 1 -1 = ST12T	–	–	–	–	–	–	–	–	A437-76 Grade B4B	–	ATI FV448™
409 Cb	–	–	–	–	–	–	–	–	–	–	–	ATI 409Cb™
436 S	–	–	–	–	–	–	–	–	–	–	–	ATI 436S™
439 HP	–	–	–	S43035	–	–	–	–	–	–	–	ATI 439 HP™
441 HP	–	–	–	–	–	–	–	–	–	–	–	ATI 441 HP™
–	–	–	–	S44735	–	–	–	–	–	A240	–	AL 29-4C®
–	–	–	–	–	–	–	–	–	–	B625	–	ATI E-BRITE®
403Cb	–	–	–	–	–	–	–	–	–	–	–	T656
420 modified	–	–	–	–	–	–	–	–	–	–	–	Stavax ESR
–	–	–	–	–	–	–	–	–	–	–	–	420HC
–	–	–	–	–	–	–	–	–	–	–	–	CPM 154
–	–	–	–	–	–	–	–	–	–	–	–	CPM® S30V®
–	–	–	–	–	–	–	–	–	–	–	–	CPM® S35VN®
420 V	–	–	–	–	–	–	–	–	–	–	–	CPM® S90V®
–	–	–	–	–	–	–	–	–	–	–	–	M390
422	–	–	–	S42200	–	–	–	–	–	–	–	616

P6 Workpiece Materials Listing • Steel • P6

P6 High-Strength Ferritic, Martensitic, and PH Stainless Steels *Tensile Strength RM (MPa)*: 900–1350*
Hardness (HB): 350–450 (HRC): 35–48

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	17-7 PH	301 S 81	SUS 631	S17700	X 7 CrNiAl 17-7	X7CrNiAl17-7; Z9CNA17-07	X 7 CrNiAl 17-7	2388	–	A693	1.4564	ATI 17-7™
–	GX 22 CrNi 17	ANC 2	–	J91803	–	Z 20 CN 17.2 M	–	–	–	CB30	1.4059	–
–	GX 30 CrSi 6	–	–	–	–	–	–	–	–	–	1.4710	–
–	GX 4 CrNi 13 4	–	–	–	GX 4 CrNi 13-4	GX 4 CrNi 13-4	GX 4 CrNi 13-4	–	–	–	1.4317	–
–	GX 40 CrSi 17	–	–	–	–	–	GX 35 Cr 17	–	–	–	1.4740	–
–	GX 40 CrSi 24	–	SCH 1	–	–	–	GX 35 Cr 13	–	–	–	1.4745	–
–	GX 40 CrSi 28	452 C 11	SCH 2	J92605	–	–	GX 35 Cr 28	–	–	CC50	1.4776	–
–	X 105 CrCoMo 18 2	–	–	–	–	–	–	–	–	–	1.4528	N690
440 C	X 105CrMo 17	–	SUS 440C	S44004	X 105 CrMo 17	Z 100 CD 17	X 105 CrMo 17	–	–	–	1.4125	ATI 440C™
–	X 110 CrMoV 15	–	SUS 430 LX	–	–	Z 4 CN b 17	X 6 CrNb 17	–	–	–	1.4111	–
5718.9	X 12 CrNiMo 12	S.151	–	S64152	–	Z12CNDV12	–	–	–	–	1.4939	ATI Jethete™ M152
–	X 12 CrNiMoV 12 3	–	–	–	X 12 CrNiMoV 12-3	X 12 CrNiMoV 12-3	–	–	–	–	1.4938	T522
–	X 15 TN	–	–	–	420S25	Z40CDV16-02	X40CrMoVN16-2	–	–	F899	1.4123	X 15 TN
15-5 PH	X 15 U 5 W	–	–	S15500	–	Z6CNU15.05	–	–	–	A564/ A693/A705	1.4545	ATI 15-5™
–	X 19 CrMoNbVN 11 1	–	–	–	–	Z 21 CDNbV 11	–	–	–	–	1.4913	Jethete X19
431	X 19 CrNi 17 2	431 S 29	SUS 431	S 43100	X 19 CrNi 17 2	Z 15 CN 16.02	X 16 CrNi 16	2321	–	–	1.4057	431 (HT)
–	X 20 CrMo 17 1	–	–	–	–	–	–	–	–	–	1.4115	B17MoFe
420F Mod	X 22 CrMoNiS 13 1	–	–	–	–	–	–	–	–	–	1.4121	Bioline 4C27A
–	X 22 CrMoV 12 1	762	–	–	X 22 CrMoV 12-1	Z 21 CDV 12	X 22 CrMoV 12 1	–	–	–	1.4923	Jethete X20
420	X 29 CrS 13	416 S 37	SUS 416	–	X 29 CrS 13	Z29CF13	X 29 CrS 13	–	–	–	1.4029	–
–	X 3 CrNiCuTi 12 9	–	–	S45500	–	–	X 6 CrNiNb 18 11	–	–	–	1.4543	ATI 455™
13-8 PH	X 3 CrNiMoAl 13 8 2	–	–	S13800	–	Z4 CNDAT 13 09	–	–	–	–	1.4534	ATI 13-8Mo™
420 F	X 30 Cr 13	420 S 45	SUS420J2	S42020	X 30 Cr 13	Z 30 C 13	X 30 Cr 13	2304	–	CA40	1.4028	–
–	X 30CrMoN 15 1	–	–	–	420S45	Z33C13	–	2304	–	–	1.4108	N360
–	X 35 CrMo 17	–	–	–	X 39 CrMo 17 1	X39CrMo17-1	X 35 CrMo 17	–	–	–	1.4122	–
–	X 4 CrNiCuNb 16 4	–	–	J92200	–	Z 4 CNUNb 16.4 M	–	–	–	–	1.4540	–
415 M	X 4 CrNiMo 16 5 1	–	–	–	X 4 CrNiMo 16 5 1	Z 6 CND 16.05.01	–	2387	–	–	1.4418	APX4
–	X 40 CrNi 25 21	310 S 98	SCH 13	–	–	–	–	–	–	–	1.4846	–
–	X 40 CrSiMo 10 2	–	SUH3	–	X 40 CrSiMo 10-2	Z40CSD10	–	–	–	–	1.4731	–
420	X 45 Cr 13	(420 S45)	–	–	X 45 Cr 13	Z 40 C 14	X 40 Cr 14	–	–	–	1.4034	–
–	X 45 CrMoV 15	–	–	–	X 50 CrMoV 15	Z 50 CD 15	X 50 CrMo V 15	–	–	–	1.4116	UGI 4116N
HNV3	X 45 CrSi 9 3	–	SUH1	–	401S45	Z45CS9	X45CrSi8	–	HNV3	–	1.4718	–
HNV 2	X 45 SiCr 4	–	–	S64006	–	–	–	–	–	–	1.4704	–
CA 6-NM	X 5 CrNi 134	425 C 11	SCS 5	J91540	X 3 CrNiMo 13 4	Z 4 CDN 13.4	X 6 CrNi 13 04	2385	–	–	1.4313	–
630	X 5 CrNiCuNb 16 4	–	SUS 630	–	X 5 CrNiCuNb 16-4	Z6CNU17.04	–	–	–	CB7Cu	1.4542	UGIMA® 4542
17-4 PH	X 5 CrNiCuNb 17 4 4	–	SUS 630	S17400	X 5 CrNiCuNb 16-4	X5CrNiCuNb16.4	–	–	–	A693	1.4548	–
–	X 5 CrNiMoCuNb 14 5	–	–	–	X 5 CrNiMoCuNb 14-5	X 5 CrNiMoCuNb 14-5	X 5 CrNiMoCuNb 14-5	–	–	–	1.4594	–
–	X 50 CoCrNi 20 20	–	–	–	–	–	–	–	–	–	1.4978	–
EV8	X 53 CrMnNiN 2 9	349 S 54	SUH35/SUH36	S63008	349S54	Z52CMN21.09	X53CrMnNiN21-9	–	EV8	–	1.4871	–
–	X 55 CrMo 14	–	–	–	–	Z 50 CD 13	–	–	–	–	1.4110	–
–	X 60 CrMnMoVNbN 21 10	–	–	–	–	Z 60 CMDVNb 21-10 Az	–	–	–	–	1.4785	–
440 A	X 65 CrMo 14	–	SUS 440A	S44002	X 70 CrMo 15	Z 70 CD 14	–	–	–	–	1.4109	ATI 440A™
–	X 7 CrNiAl 17 7	301 S 81	SUS 631	S17700	X 7 CrNiAl 17-7	X7CrNiAl17-7;Z9CNA17-07	X 7 CrNiAl 17-7	2388	–	A693	1.4568	–
632	X 7 CrNiMoAl 15 7	–	–	S15700	–	–	–	–	–	–	1.4574	PH 15-7 Mo®
–	X 8 CrCoNiMo 10 6	Z 9 CKD 11	–	–	S152	Z10CKD10	–	–	–	–	1.4911	ATI FV535™
15-7 PH	X 8 CrNiMoAl 15 7 2	–	–	S15700	X 8 CrNiMoAl 15-7-2	Z8CNDA15.07	X 8 CrNiMoAl 15-7-2	–	–	A693	1.4532	ATI 15-7™
HNV 6	X 80 CrNiSi 20	443 S 65	SUH 4	S65006	X 80 CrNiSi 20	Z 80 CSN 20.02	X 80 CrSiNi 20	–	–	–	1.4747	–
–	X 85 CrMoV 18 2	–	–	–	X 85 CrMoV 18 2	Z 85 CDMV 18.02	X 85 CrMoV 19 3	–	–	–	1.4748	–
440 B	X 90 CrMoV 18	409 S 1 9	SUS 440 B	S44003	X 90 CrMoV 18	Z 3 CT 1 2	X 6 Cr Ti 1 2	–	–	–	1.4112	–
–	X45CrNiW18-9	331 S 40	SUH31	–	X 45 CrNiW 18 9	Z35CNWS14.14	X45CrNiW18-9	–	–	–	1.4873	–

NOTE: For legend, see page Y217.

M1 Workpiece Materials Listing • Stainless Steel • M1

M1 Austenitic Stainless Steel *Tensile Strength RM (MPa)*: <600* *Hardness (HB): 130–200*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
CF-8	X 6 CrNi 18 9	304 C 15	SCS 13	–	X 2 CrNiN 18 7	Z 6 CN 18.10 M	G X 5 CrNi 19-10	2333	–	CF8	1.4308	CF-8
–	X 2 NiCr 18 16	–	–	–	–	Z 3 CDT 18-02	–	–	–	–	1.4321	–
–	X 1 CrNi 25 21	–	–	–	X 1 CrNi 25 21	X1CrNi25-21	X 1 CrNi 25-21	–	–	–	1.4335	Uranus 65
610	X1CrNiSi 18-15-4	–	–	S30600	X 1 CrNiSi 18-15-4	Z1 CNS 17.5	X 1 CrNiSi 18-15-4	–	–	A240-97A	1.4361	ATI 610™
CF-8M	X 6 CrNiMo 18 10	316 C 16	SCS 14	J92900	GX 5 CrNiMo 19-11-2	GX5CrNiMo 19-11-2	G X 5 CrNiMo 19-11-2	2343	–	–	1.4408	–
–	GX 2 CrNiMo 19 11 2	–	–	–	GX 2 CrNiMo 19-11-2	GX 2 CrNiMo 19-11-2	GX 2 CrNiMo 19-11-2	–	–	–	1.4409	–
–	ER0 4412 AHMo	–	–	J92900	GX 5 CrNiMo19-11-3	GX 5 CrNiMo 19-11-3	–	–	–	A743CF8M	1.4412	–
–	ER0 4416 AHCRMo	–	–	–	GX 2 NiCrMoN 25-20-5	GX2NiCrMoN 25-20-5	–	–	–	–	1.4416	–
–	GX 6 CrNiMo 18 12	317 C 12	–	–	–	–	–	–	–	–	1.4437	–
–	X 2 CrNiMo 18 16 5	–	–	S31780	–	–	–	–	–	–	1.4440	–
–	GX 2 CrNiMoN 17 1 3 4	–	–	–	GX 2 CrNiMoN 17 1 3 4	–	–	–	–	–	1.4446	–
–	GX 6 CrNiMo 17 13	317 C 16	–	J93000	–	–	–	–	–	CG8M	1.4448	–
–	GX 2 NiCrMo 28 20 2	–	–	–	GX 2 NiCrMo 28-20-2	GX 2 NiCrMo 28-20-2	GX 2 NiCrMo 28-20-2	–	–	–	1.4458	–
–	GX 4 NiCrCuMo 30 20 4	–	–	–	GX 4 NiCrCuMo 30-20-4	GX 4 NiCrCuMo 30-20-4	–	–	–	–	1.4527	–
–	GX 5 CrNiNb 18 9	347 C 17	SCS 21	J92710	GX 5 CrNiNb 19-11	Z 4 CNNb 19.10 M	G-X 5 CrNiNb 19-11	–	–	–	1.4552	–
–	GX 2 CrNiMoCuN 20 18 6	–	–	–	GX 2 CrNiMoCuN 20-18-6	GX 2 CrNiMoCuN 20-18-6	–	–	–	–	1.4557	–
–	X 3 CrNiCuMo 17 11 3 2	–	–	–	X 3 CrNiCuMo17 11 3 2	X3CrNiCuMo 17-11-3-2	X 3 CrNiCuMo 17-11-3-2	–	–	–	1.4578	–
–	GX 5 CrNiMoNb 18 10	318 C 17	SCS 22	–	GX 5 CrNiMoNb 19-11-2	Z 4 CNDNb 18.12 M	GX 6 CRNOMONB 20 11	–	–	–	1.4581	–
–	GX 2 NiCrMoCu 25 2 0 5	–	–	–	GX 2 NiCrMoCu 25-20-5	GX 2 NiCrMoCu 25-20-5	–	–	–	–	1.4584	–
–	GX 7 CrNiMoCuNb 18 18	–	–	J94651	–	–	–	–	–	–	1.4585	–
–	GX 2 NiCrMoCuN 29 25 5	–	–	–	GX 2 NiCrMoCuN 29-25-5	GX 2 NiCrMoCuN 29-25-5	–	–	–	–	1.4587	–
–	GX 2 NiCrMoCuN 25 20 6	–	–	–	GX 2 NiCrMoCuN 25-20-6	GX 2 NiCrMoCuN 25-20-6	–	–	–	–	1.4588	–
–	GX 25 CrNiSi 18 9	302 C 35	–	J92602	–	–	G X 16 CrNi 20 10	–	–	CF20	1.4825	–
–	GX 40 CrNiSi 22 9	–	SCH 12	J92603	–	–	–	–	–	–	1.4826	–
–	GX 50 CrNiNb 25 22	–	–	–	–	–	–	–	–	–	1.4836	–
–	GX 40 CrNiSi 25 12	309 C 30	SCS 17	J93503	–	–	GX 35 CrNi 25 12	–	–	CE30	1.4837	–
334	X 8 CrNiAlTi 20 20	–	–	S33400	–	–	–	–	–	–	1.4847	ATI 334™
–	GX 40 NiCrSiNb 38 18	–	–	N08004	–	–	–	–	–	–	1.4849	–
–	GX 40 NiCrSiNb 35 25	–	–	–	–	–	–	–	–	–	1.4852	–
–	GX 40 NiCrSi 35 25	–	–	J95705	–	–	GX 50 NiCr 35 25	–	–	–	1.4857	–
105 MA	BGH 4892	–	–	–	–	–	–	–	–	–	1.4892	–
–	X 3 CrNi 18 11	–	–	–	–	–	X 2 CrNiN 18 11	–	–	–	1.4949	–
–	X 2 CrNiMo 19 12	316 S 93	–	S31683	x 2 CrNiMo 19 13 03 KE	Z 2 CND 19-12-03	–	–	–	–	1.4430	–
–	GX 7 NiCrMoCuNb 25 20	–	SCS 23	J95150	10.204.3.1B	Z 3 NCDU 25.20 M	GX 5 NiCrCuMo 29 21	–	–	–	1.4500	–
–	X 3 CrNiCu 19 9 2	–	–	–	S 124 M	PHYHQ 4560	304 RH1	–	–	–	1.4560	ACX276
–	–	–	–	S63198	–	–	–	–	19-9 DL	–	–	19-9 DL
–	X 2 CrNiMoN 17 13 3	–	–	–	–	Z 2 CND 17.13	X 2 CrNiMoN 17 13 3	–	–	–	–	–
332	–	–	–	N08800	–	–	–	–	–	–	–	ATI 332™
–	–	–	–	N08367	–	–	–	–	–	–	–	AL-6XN®
611	–	–	–	S30601	–	–	–	–	–	A240-97A	–	ATI 611™

M2 Workpiece Materials Listing • Stainless Steel • M2

M2 High-Strength Austenitic Stainless and Cast Stainless Steels *Tensile Strength RM (MPa)*: 600–800*
Hardness (HB): 150–230 (HRC): <25

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
304 H	X 5 CrNi 18 10	304 S 15	SUS 304	S30409	X 6 CrNi 18 10 KD	Z 6 CN 18.09	X 5 CrNi 18 10	2332	–	–	1.4301	–
–	X 5 CrNi 19 9	308 S 96	–	S30888	X 6CrNi 20 10 KE	–	–	–	–	–	1.4302	–
305	X 4 CrNi 18 12	305 S 19	SUS 305	S30500	X 4 CrNi18 12 KD	Z 5 CN 18.12	X 4 CrNi 19 10	–	–	–	1.4303	–
303	X 10 CrNiS 18 9	303 S 21	SUS 303	S30300	X 10 CrNiS 18 9	Z 10 CNF 18.09	X 10 CrNiS 18 09	2346	–	–	1.4305	ATI 303™
304 L	X 2 CrNi 19 11	304 C 12	SUS 304L	S30403	X 3 CrNi18 10 KD	Z 2 CN 18.09	GX 2 CrNi 19 10	2352	–	CF3	1.4306	ATI 304L™
304 L	X 2 CrNi 18 9	304 S 11	SUS 304L	–	X 2 CrNi 18 9	CLC18.9.L	X 2 CrNi 18-9	–	–	–	1.4307	–
–	GX 2 CrNi 19 11	304 C 12	–	J92500	GX2CrNi19-11	GX2CrNi19-11	GX2CrNi19-11	2352	–	CF3	1.4309	–
304 LN	X 2 CrNiN 18 10	304 S 62	SUS 304 LN	S30453	X 2 CrNiN 18 10	Z 8 CN 18.12	X 8 CrNi 19 10	2371	–	–	1.4311	–
305	GX 10 CrNi 18 8	302 C 25	SCS 12	–	–	Z 10 CN 18.9 M	–	–	–	–	1.4312	ATI 305™
308 L	X 2 CrNi 19 9	308 S 92	SUS Y 308L	S30883	X 2 CrNi 20 10 KE	Z 2 CN 20.10	–	–	–	–	1.4316	–
–	X 2 CrNiN 18 7	–	–	–	X 2 CrNiN 18-7	18-7L	18-7L	–	–	–	1.4318	–
302	X 10 CrNi 18 9	302 S 26	SUS 302	S20200	302S31	Z10CN18-09	X 10 CrNi 18 09	2330	–	–	1.4319	ATI 302™
301	X 10 CrNi 18 9	302 S 26	–	J92501	X 10 CrNi 18 9	–	–	–	–	–	1.4324	–
–	X 10 CrNi 30 9	312 S 94	–	–	X 12 CrNi 30 09 KE	Z 10 CN 31-10	–	–	–	–	1.4337	–
–	X 3 CrNi 13 4	–	–	S41086	X 3 CrNi 14 04 KE	–	–	–	–	–	1.4351	410NiMo
202	X 3CrMnNiN 18 8 7	–	–	–	284S16	Z8CMN18-08-05	–	–	–	–	1.4371	–
201	X 12 CrMnNiN 17 7 5	284 S 16	SUS 201	–	X 12 CrMnNiN 17-7-5	X 12 CrMnNiN17-7-5	X 12 CrMnNiN 17-7-5	–	–	–	1.4372	ACX060
316	X 5 CrNiMo 17 12 2	316 S 16	SUS 316	S31600	X6 CrNiMo 17 12 2 KD	Z 6 CND 17.11	X 5 CrNiMo 17 12	2347	–	–	1.4401	ATI 316™
316L	X 2 CrNiMo 17 13 2	316 S 12	SUS 316 L	S31603	GX 3 CrNiMo 17 12 2 KD	Z 3 CND 19.10 M	GX 2 CrNiMo 19 11	2348	–	–	1.4404	ATI 316L™
316 LN	X 2 CrNiMoN 17 12 2	316 S 61	SUS 316 LN	S31653	X 3 CrNiMoN 17 12 2	Z 2 CND 17.12 Az	X 2 CrNiMoN 17 12	2353	–	–	1.4406	ATI 316LN™
–	X 5 CrNiMo 13 4	–	–	J91550	–	Z 6 CND 16.05.01	–	–	–	–	1.4407	–
–	X12CrNiMoS18-11	–	–	–	–	Z3CNDF17-13	–	–	–	–	1.4427	Chronifer® Special KL
316L	X 2 CrNiMo 17 12 3	316 S 13	SUS 316L	–	X 2 CrNiMo 17 12 2	Z 3 CND 17-13-30	X 2 CrNiMo 17-12-3	2348/2353/2354	–	–	1.4432	–
–	X 2 CrNiMoN 18 12 4	–	–	–	317 LN	CLC18.12.4.LN	X2CrNiMoN1812-4	–	–	–	1.4434	–
316 L	X 2 CrNiMo 18 14 3	316 S 11	SCS 16	S31603	X 2 CrNiMo 18 16	Z 2 CND 17.13	X 2 CrNiMo 17 13	2353	–	–	1.4435	–
316	X 5 CrNiMo 17 1 3 3	316 S 16	SUS 316	S31600	X6 CrNiMo 18 13 3 KD	Z 6 CND 17.12	X 5 CrNiMo 17 13	2343	–	–	1.4436	–
317 L	X 2 CrNiMo 18 16 4	317 S 12	SUS 317 L	S31703	X 3 CrNiMo 18 16 4	Z 2 CND 19.15	X 2 CrNiMo 18 15	2367	–	–	1.4438	ATI 317L™
–	X 2 CrNiMoN 17 13 5	–	–	–	X 3 CrNiMo 17 13 5	Z 3 CND 18.14-05 AZ	–	–	–	–	1.4439	–
–	X 2 CrNiMo 18 15 4	–	–	S31675	–	X 3 CrNiMoN 19-14	–	–	–	–	1.4442	–
317	X 5 CrNiMo 17 13	317 S 16	SUS 317	S31700	–	–	X 5 CrNiMo 18 15	–	–	–	1.4449	AL 317L+E55
–	X 5 CrNiCuNb 16 4	–	–	–	–	Z7CNU16.04	–	–	–	–	1.4452	–
–	–	–	–	S21904	–	–	–	–	–	A666	1.4454	ATI 219
–	X 2 CrNiMnMoN 20 16	–	–	–	X 2 CrNiMnMoN 20 15 08 KE	–	–	–	–	–	1.4455	–
–	X 1 CrNiMoN 25 2 5 2	–	–	S31050	–	–	–	–	–	–	1.4465	2RE69

(continued)

M2 Workpiece Materials Listing • Stainless Steel • M2 *(continued)*

M2 High-Strength Austenitic Stainless and Cast Stainless Steels *Tensile Strength RM (MPa)*: 600–800*
Hardness (HB): 150–230 (HRC): <25

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	X 1 CrNiMoN 25 22 2	–	–	–	725 LN	DMV 25.22.2	X 1 CrNiMoN 25-22-2	–	–	–	1.4466	–
–	X 1 NiCrMoCuN 25 20 6	–	–	–	–	–	–	–	–	–	1.4529	Uranus B26 6Mo
–	GX 2 NiCrMoCuN 25 20	–	–	J94650	GX 2 CrNiMoCuN 25-20-6	–	–	–	–	–	1.4536	–
–	X 1 CrNiMoCuN 25 25 5	–	–	–	X 1 CrNiMoCuN 25-25-5	X 1 CrNiMoCuN 25-25-5	X 1 CrNiMoCuN 25-25-5	–	–	–	1.4537	–
321	X 6 CrNiTi 18 10	321 S 12	SUS 321	S32100	X 6 CrNiTi 18 10	Z 6 CNT 18.10	X 6 CrNiTi 18 11	2337	–	–	1.4541	ATI 321™
321	A 700	304 S 31	–	J92630	–	Z 10 CNT 18 11	X 6 CrNiTi 18 11	–	–	–	1.4544	–
–	X 1 CrNiMoCuN 20 18 7	X 1 CrNiMoCuN 20 18 7	–	S31254	X 1 CrNiMoCuN 20-18-7	X 1 CrNiMoCuN 20-18-7	X 1 CrNiMoCuN 20-18-7	–	–	–	1.4547	Uranus B25 6Mo
–	X 2 NiCrAlTi 32 20	–	NCF 800 TB	–	–	–	–	–	–	–	1.4558	–
–	X 1 NiCrMoCuN 31 27 4	–	–	–	X 1 NiCrMoCu 31 27 4	X 1 NiCrMoCuN 31 -27-4	X 1 NiCrMoCuN 31 -27-4	2584	–	–	1.4563	–
–	X 3 CrNiCu 18 9 4	394 S 17	SUS XM7	–	X3CrNiCu18-9-4	304CU	304K	–	–	–	1.4567	–
316 Ti	X 6 CrNiMoTi 17 12 2	320 S 31	SUS 316Ti	–	X 6 CrNiMoTi 17 12 2	Z 6 CNDT 17.12	X 6 CrNiMoTi 17 12	2350	–	–	1.4571	ATI 316Ti™
–	GX 5 CrNiMoNb 23 9	–	–	–	–	–	–	–	–	–	1.4572	–
316 Ti	X 10 CrNiMoTi 18 12	320 S 33	SUS 316Ti	S31635	–	–	X 6 CrNiMoTi 17 13	–	–	–	1.4573	–
318	X 10 CrNiMoNb 18 12	–	–	–	–	–	X 6 CrNiMoNb 17 13	–	–	–	1.4583	–
–	X 2 CrNiCu 19 10	–	–	–	X 2 CrNiCu 19-10	TX 304L	–	–	–	–	1.4650	–
–	X1CrNiMoCuN24-22-8	–	–	S32654	–	–	–	–	–	–	1.4652	654 SMO®
–	153 MA	–	–	S30415	X 6 CrNiSiNCe 19 10	–	–	–	–	–	1.4818	153 MA™
–	X 20 CrNiSi 25 4	–	–	S44635	X 15 CrNiSi 25 4	Z 20 CNS 25.04	X 20 CrNiSi 25 4	–	–	–	1.4821	–
309	X 15 CrNiSi 20 12	309 S 24	SUH 309	S30900	X 15 CrNiSi 20 12	Z 15 CNS 20.12	X 16 CrNiSi 25,20	–	–	–	1.4828	ATI 309™
309 S	X 7 CrNi 23 14	309 S 24	SUS 309 S	J93400	X 12 CrNi 23 13	Z 15 CN 24.13	X 6 CrNi 23 14	–	–	–	1.4833	–
–	353 MA	–	–	S35315	X 6 NiCrSiNCe 35-25	–	–	–	–	–	1.4854	353 MA®
–	X 8 NiCrSi 38 18	NA 17	–	N08330	–	Z 12 NCS 37.18	–	–	–	–	1.4862	–
–	X 33 CrNiMnN 23 8	–	–	–	X 33 CrNiMnN 23-8	X 33 CrNiMnN 23-8	–	–	–	–	1.4866	–
EV 12	X 55 CrMnNiN 20 8	–	–	S63012	X 55 CrMnNiN 20-8	Z 55 CMN 20.08 Az	–	–	–	–	1.4875	–
321	X 12 CrNiTi 18 9	321 S 20	SUS 321	S32100	X 10 CrNiTi 18 10	Z 6 CNT 18.12	X 6 CrNiTi 18.11	2337	–	–	1.4878	ACX315
EV 11	X 70 CrMnNiN 21 6	–	–	S63011	–	–	X 70 CrMnNiN 21 6	–	–	–	1.4881	–
–	X 50 CrMnNiNbN 21 9	–	–	–	X 50 CrMnNiNbN 21-9	Z 50 CMNNb 21.09	–	–	–	–	1.4882	–
–	X 7 CrNiNb 18 10	–	SUS347H	S34709	X7CrNiNb18-10	X7CrNiNb18-10	–	–	–	–	1.4912	–
316 H	X 6 CrNiMo 17 13	316 S 51	–	S31609	X 6 CrNiMo 17 12 2	Z 6 CND 17-13 B	–	–	–	–	1.4919	–
321 H	X 8 CrNiTi 18 10	–	–	–	X 6 CrNiTiB 18-10	Z 6 CNT 18-10 B	X 6 CrNiTiB 11	–	–	–	1.4941	–
A660	X 4 NiCrTi 25 15	HR251	SUH 660	S66286	–	Z 6 NCTDV 25.15 B	–	–	–	–	1.4943	Discaloy
–	X 6 CrNiWNb 16 16	–	–	–	–	–	–	–	–	–	1.4945	–
–	X 6 CrNi 18 11	304 S 51	–	S30480	X 6 CrNi 18 10	Z 6 CN 18-09	X 5 CrNi 18 10 KW	2333	–	–	1.4948	–
–	X 6 CrNi 25 20	–	–	–	310 H	–	–	–	–	–	1.4951	–
–	X 8 CrNiNb 16 13	347 S 51	–	–	–	–	–	–	–	–	1.4961	–
–	Esshete12 50	–	–	S21500	X 10 CrNiMoMnNbVB 15-10-1	X 10 CrNiMoMnNbVB 15-10-1	–	–	–	A213	1.4982	Esshete 1250
–	X 8 CrNiMoBNb 16 16	–	–	–	X 7 CrNiMoBNb 16-16	–	–	–	–	–	1.4986	–
301	X 12 CrNi 17 7	301 S 21	SUS 301	S30100	X 12 CrNi 17 7	Z 12 CN 17.07	X 12 CrNi 17 07	2331	–	–	1.4310	ATI 301™
–	GX 40 CrNi 27 4	–	–	J92615	–	–	GX 35 CrNi 28 05	–	–	–	1.4340	–
304	X 5 CrNi 18 9	304 S 31	SUS 304	S30400	1	Z6CN18.09	X5CrNi1810	2332/2333	–	A276	1.4350	ATI 304™
–	X 15 CrNiMn 18 8	307 S 98	–	–	X 15 CrNiMn 18 08 KE	Z 8 CNM 19-09-07	–	–	–	–	1.4370	–
S32750	GX 10 CrNiMo 18 9	–	SCS 14 A	S32750	X 2 CrNiMoN 25-7-4	Z 5 CND 20.10 M	X 2 CrNiMoN 25-7-4	–	–	–	1.4410	–
–	X 5 CrNiMo 18 11	315 S 16	–	–	–	–	–	2340	–	–	1.4420	–
347	X 6 CrNiNb 18 10	347 S 17	SUS 347	S34700	X 6 CrNiNb 18 10	Z 6 CNNb 18.10	X 6 CrNiNb 18 11	2338	–	–	1.4550	ATI 347™
316 Cb	X 6 CrNiMoNb 17 12 2	318 S 17	–	–	X 6 CrNiMoNb 17 12 2	Z 6 CNDNb 17.12	X 6 CrNiMoNb 17 12	–	–	–	1.4580	–
–	X 3 CrNiMoN 17 13	–	–	–	X 3 CrNiMoN 17-13-3	–	X 2 CrNiMoN 17 12	–	–	–	1.4910	–
–	X 6 CrNi 23 13	–	–	–	309 H	–	–	–	–	–	1.4950	–
A286	X 6 NiCrTiMoVB 25-15-2	286 S 31	–	S66286	X 6 NiCrTiMoVB 21-15-2	–	–	–	–	–	1.4980	Incoloy A 286
XM-19	–	–	–	S20910	–	–	–	–	–	F1314	–	ATI XM-19™
303 plus X	–	–	–	S30310	–	–	–	–	–	XM-5	–	303 plus X
–	X 2 CrNi 18 13 3	–	–	–	–	–	–	–	–	–	–	Staybrite® 4435NCu
218	–	–	–	S21800	–	–	–	–	–	–	–	Nitronic 60
201LN	–	–	–	S20153	–	–	–	–	–	–	–	ATI 201LN™-MIL
–	X 2 CrNiMoN 17 13 3	–	–	–	–	Z 2 CND 17.13	X 2 CrNiMoN 17 13 3	–	–	–	–	AL 316LXN
–	–	–	–	S31675	–	–	–	–	–	F1586	–	ATI REX 734™
–	–	–	–	–	–	–	–	–	–	–	–	P558
–	X 1 NiCrMoCu 22 24 6	–	–	–	–	–	–	–	–	–	–	Uranus B66
–	–	–	–	–	–	–	–	–	–	–	–	ATI Datalloy 2®
–	–	–	–	–	–	–	–	–	–	–	–	ATI Staballoy® AG17®
–	–	–	–	–	–	–	–	–	–	–	–	P530
–	X 1 NiCrMoCu 31 27 4	–	–	N08028	–	–	–	–	–	–	–	Uranus B28
–	–	–	–	–	–	–	–	–	–	–	–	P750
–	–	–	–	–	–	–	–	–	–	–	–	P750-I
–	X 4 CrNiMoN 21 9 4	–	–	–	–	–	–	–	–	F1586	–	M30NW
–	–	–	–	–	–	–	–	–	–	–	–	P550
–	–	–	–	–	–	–	–	–	–	–	–	P580
–	–	–	–	–	–	–	–	–	–	–	–	P650
–	–	–	–	–	–	–	–	–	–	–	–	ATI Datalloy HP™

NOTE: For legend, see page Y217.

M3 ■ Workpiece Materials Listing • Stainless Steel • M3

M3 Duplex Stainless Steel *Tensile Strength RM (MPa)*: <800* *Hardness (HB): 135–275 (HRC): <30*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	GX 120 CrMo 29 2	–	–	–	–	–	–	–	–	F30M	1.4138	PK324
–	X 2 CrMnNiN 21 5 1	–	–	S32101	–	–	–	–	–	–	1.4162	LDX2101
–	GX 6 CrNiN 26 7	–	–	–	GX 6 CrNiN 26-7	–	–	–	–	–	1.4347	–
S32304	X 2 CrNiN 23 4	–	–	S32304	SAF 2304	35 N	X 2 CrNiN 23-4	2327	–	A240	1.4362	ATI 2304™
S31500	X 2 CrNiMoSi 19 5	–	–	S39215	GX 2 CrNiMoN 25-7-3	GX 2 CrNiMoN 25-7-3	–	2376	–	–	1.4417	–
S31803	X 2 CrNiMoN 22 5 3	318 S 13	SUS 329J 3L	S31803, S32205	X 2 CrNiMoN 22 5 3	Z 3 CND 22.05 AZ	X 2 CrNiMoN 22-5-3	2377	F51	2205	1.4462	ATI 2205™
–	GX 6 CrNiMo 24 8 2	–	–	–	–	–	–	–	–	–	1.4463	–
–	GX 2 CrNiMoN 25 6 3	–	–	–	GX 2 CrNiMoN 25-6-3	GX 2 CrNiMoN 25-6-3	–	–	–	–	1.4468	–
–	GX 2 CrNiMoN 26 7 4	–	–	J93404	GX 2 CrNiMoN 26-7-4	GX 2 CrNiMoN 26-7-4	GX 2 CrNiMoN 26-7-4	–	–	–	1.4469	–
–	X 2 CrNiMoCuWN 25 7 4	–	–	S32760	X 2 CrNiMoCuWN 25 7 4	X 2 CrNiMoCuWN 25-7-4	X 2 CrNiMoCuWN 25-7-4	–	–	F 55	1.4501	F55
2507	X 2 CrNiMoCuN 25 6 3	–	–	–	X 2 CrNiMoCuN 25-6-3	DMV25.7Cu	329SK	–	–	–	1.4507	Uranus 52N+
–	GX 2 CrNiMoCuWN 25 8 4	–	–	–	X 6 CrNiCu 18 10 4 KD	Z 4 CNUD 17-11-03 FF	–	–	–	–	1.4508	–
–	GX 2 CrNiMoCuN 25 6 3 3	–	–	–	GX 2 CrNiMoCuN 25-6-3-3	GX 2 CrNiMoCuN 25-6-3-3	GX 2 CrNiMoCuN 25-6-3-3	–	–	–	1.4517	–
–	X 4 CrNiMoNb 25 7	–	SCS 22	–	–	–	–	–	–	–	1.4582	PK343
–	BGH 4593	–	–	–	GX 3 CrNiMoCuN 24 6 2 3	–	–	–	–	–	1.4593	Noridur®
329	X 4 CrNiMo 27 5 2	–	SUS 329 J1	S32900	X 3 CrNiMo 27 5 2	X 2 CrNiMo 25-7-3	X 3 CrNiMo 27-5-2	2324	–	A240	1.4460	10RE51
–	GX 2 CrNiMoN 22 5 3	–	–	–	GX 2 CrNiMoN 22-5-3	GX 2 CrNiMoN 22-5-3	GX 2 CrNiMoN 22-5-3	–	–	–	1.4470	–
S32550	–	–	–	S32550	–	–	–	–	–	–	–	Ferralium® alloy 255
–	–	–	–	S32003	–	–	–	–	–	–	–	ATI 2003®
–	–	–	–	S80211	–	–	–	–	–	–	–	ATI 2102™
–	–	–	–	S32550	–	–	–	–	–	–	–	ATI 255™
–	–	–	–	S34565	–	–	–	–	–	–	–	ATI 4565™
–	X 2 CrNiMoN 25 6 3	–	–	–	–	–	–	–	–	–	–	Uranus 47N+
–	–	–	–	–	–	–	F60	–	–	32760	–	Zeron® 100

Cast Iron

K1 ■ Workpiece Materials Listing • Cast Iron • K1

K1 Grey Cast Iron *Tensile Strength RM (MPa)*: 125–500* *Hardness (HB): 120–290 (HRC): <32*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	GG-150HB	–	–	–	GJL-HB 170	–	–	–	–	–	0.6012	–
A48-25 B	GG-15	Grade 150	FC 150	–	GJL-150	FGL 150	G 15	0115-00	–	A 48 Class 25	0.6015	–
–	GG-170HB	–	–	N06985	GJL-HB 205	–	–	–	–	–	0.6017	–
–	GG-190HB	–	–	N06022	GJL-HB 230	–	–	–	–	–	0.6022	–
A48-35 B	GG-25	Grade 260	FC 250	–	GJL-250	FGL 250	G 25	0125-00	–	A 48 Class 35	0.6025	–
–	GG-26	–	FC260	–	–	–	G 26	0126-00	–	–	0.6026	–
–	GG-220HB	–	–	W06027	GJL-HB 250	FGL 250	–	–	–	–	0.6027	–
–	GG-240HB	–	–	–	GJL-HB 275	–	–	–	–	–	0.6032	–
A48-50 B	GG-35	Grade 350	FC 350	–	GJL-350	FGL 350	G 35	0135-00	–	A 48 Class 50	0.6035	–
–	GG-260HB	–	–	–	GJL-HB 275	–	–	–	–	–	0.6037	–
A48-20 B	GG-10	Grade 100	FC 100	–	GJL-100	FGL 100	G 10	0110-00	–	A 48 Class 20	0.6010	–
A48-30 B	GG-20	Grade 220	FC 200	W06020	GJL-200	FGL 200	G 20	0120-00	–	A 48 Class 30	0.6020	–
A48-45 B	GG-30	Grade 300	FC 300	–	GJL-300	FGL 300	G 30	0130-00	–	A 48 Class 45	0.6030	–
A48-55 B	GG-40	Grade 400	–	–	GJL-400	FGL 400	–	0140-00	–	A 48 Class 55	0.6040	–
A48-40	–	–	–	–	–	–	–	–	–	A 48 Class 40	–	–
A48-60	–	–	–	–	–	–	–	–	–	A 48 Class 60	–	–
–	–	–	–	–	–	–	–	–	G1800	A 159 G1800	–	–
–	–	–	–	–	–	–	–	–	G3000	A 159 G3000	–	–
–	–	–	–	–	–	–	–	–	G10H18	A 159 G3000	–	–
–	–	–	–	–	–	–	–	–	G11H18	A 159 G3000	–	–
–	–	–	–	–	–	–	–	–	G3500	A 159 G3500	–	–
–	–	–	–	–	–	–	–	–	G11H20	A 159 G3500	–	–
–	–	–	–	–	–	–	–	–	G4000	A 159 G4000	–	–
–	–	–	–	–	–	–	–	–	G13H19	A 159 G4000	–	–
–	–	–	–	–	–	–	–	–	G12H21	A 159 G4000	–	–
–	–	–	–	–	–	–	–	–	G9H12	A 159 G1800	–	–
–	GG-26-Cr	–	–	–	–	–	–	–	–	–	–	–
–	GG-25-Cr	–	–	–	–	–	–	–	–	–	–	–

K2 Workpiece Materials Listing • Cast Iron • K2

K2 Low- and Medium-Strength Ductile Irons (Nodular Irons) and Compacted Graphite Irons (CGI) *Tensile Strength RM (MPa)*: <600*
Hardness (HB): 130–260 (HRC): <28

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	GGL-NiMn137	L-NiMn 13 7	FCA NiMn 13 7	F43000	GJLA-XNiMn 13-7	L-NM 13 7	–	–	–	–	0.6652	–
A 436 Type 1	GGL- NiCuCr1562	L-NiCuCr 15 6 2	FCA-NiCuCr 15 6 2	F41000	GJLA-XNiCuCr 15-6-2	L-NUC 15 6 2	–	–	–	–	0.6655	–
A 436 Type 1b	GGL-NiCuCr1563	L-NiCuCr 15 6 3	FCA-NiCuCr 15 6 3	F41001	GJLA-XNiCuCr 15-6-3	L-NUC 15 6 3	–	–	–	–	0.6656	–
A 436 Type 2b	GGL-NiCr203	L-NiCr 20 3	FCA-NiCr 20 3	F41003	GJLA-XNiCr 20-3	L-NC 20 3	–	–	–	–	0.6661	–
–	GGL-NiSiCr2053	L-NiSiCr 20 5 3	FCA-NiSiCr 20 5 3	–	GJLA-XNiSiCr 20-5-3	L-NSC 20 5 3	–	–	–	–	0.6667	–
A 436 Type 3	GGL- NiCr303	L-NiCr 30 3	FCA-NiCr 30 3	F41004	GJLA-XNiCr 30-3	L-NC 30 3	–	–	–	–	0.6676	–
–	GGG-35.3	–	–	–	GJS-350-22	–	–	0717-15	–	–	0.7033	–
–	GGG-40.3	SNG 370/17	FCD 370	–	GJS-400-18	FGS 370-17	GSO 42/15	0717-15	–	–	0.7043	–
–	GGG-45	–	FCD 450	–	–	–	–	–	–	–	0.7045	–
–	–	–	–	–	–	FGS450.10	–	–	–	–	0.7049	–
–	GGG-65	–	–	–	–	–	–	–	–	–	0.7065	–
–	GGG-NiMn137	S-NiMn 13 7	FCDA-NiMn 13 7	–	GJSA-XNiMn 13-7	S-Mn 13 7	–	0772-00	–	–	0.7652	–
–	GGG-NiCrNb202	S2W	FCDA-NiCrNb 20 2	–	GJSA-XNiCrNb 20-2	–	–	–	–	–	0.7659	–
A 439 Type D-2B	GGG-NiCr203	S-NiCr 20 3	FCDA-NiCr 20 3	F43001	GJSA-XNiCr 20-3	–	–	–	–	–	0.7661	–
–	GGG-NiSiCr2052	S-NiSiCr 20 5 2	FCDA-NiSiCr 20 5 2	–	GJSA-XNiSiCr 20-5-2	S-NSC 20 5 2	–	–	–	–	0.7665	–
A 571 Type D-2M	GGG-NiMn234	S-NiMn 23 4	FCDA-NiMn 23 4	–	GJSA-XNiMn 23-4	S-NM 23 4	–	–	–	–	0.7673	–
A 439 Type D-3	GGG-NiCr303	S-NiCr 30 3	FCDA-NiCr 30 3	F43003	GJSA-XNiCr 30-3	S-NC 30 3	–	–	–	–	0.7676	–
A 439 Type D-3A	GGG-NiCr301	S-NiCr 30 1	FCDA-NiCr 30 1	F43004	GJSA-XNiCr 30-1	S-NC 30 1	–	–	–	–	0.7677	–
–	GGG-NiSiCr3055	–	FCDA-NiSiCr 30 5 5	–	GJSA-XNiSiCr 30-5-5	–	–	–	–	–	0.7679	–
A 439 Type D-5	GGG-Ni35	S-Ni 35	FCDA-Ni 35	F43006	GJSA-XNi 35	S-N 35	–	–	–	–	0.7683	–
A 439 Type D-5A	GGG-NiCr353	S-NiCr 35 3	FCDA-NiCr 35 3	F43007	GJSA-XNiCr 35-3	S-NC 35 3	–	–	–	–	0.7685	–
–	GGG-NiSiCr3552	–	FCDA-NiSiCr 35 5 2	–	GJSA-XNiSiCr 35-5-2	FGS Ni35 Si 5 Cr2	–	–	–	–	0.7688	–
–	GTW-35-04	W 35-04	FCMW 330 class 1	–	GJMW-35-0-4	MB 35-7	W 35-04	–	–	–	0.8035	–
–	GTW-S-38-1 2	W 38-12	–	–	GJMW-360-12	MB 300-12	–	–	–	–	0.8038	–
–	GTW-45-07	W 45-07	FCMWP 440 class 3	–	GJMW-450-7	MB 450-7	GMB 45	–	–	–	0.8045	–
–	GTW-55	–	–	–	–	–	GMB 55	–	–	–	0.8055	–
–	GTW-65	–	–	–	–	–	GMB 65	–	–	–	0.8065	–
32510	GTS-35-10	B 340/12	FCMP 330	–	GJMB-350-10	MN 350-10	–	815	–	–	0.8135	–
40010	GTS-45-06	P 440/7	FCMP 440	–	GJMB-450-6	MN 450 - 6	P 45-06	852	–	–	0.8145	–
50005	GTS-55-04	P 510/4	FCMP 490	–	GJMB-550-4	MN 550-4	P 55-04	854	–	–	0.8155	–
70003	GTS-65-02	P 570/3	FCMP 540	–	GJMB-650-2	MN 650-3	P 65-02	0858-00, 0856-00	–	–	0.8165	–
90001	GTS-70-02	P 690/2	FCMP 690	–	GJMB-700-2	MN 700-2	P 70-02	0862-03; 0864-03	–	–	0.8170	–
–	GGV-30	–	–	–	GJV-300	–	–	–	–	–	0.9991	–
A 436 Type 2	GGL-NiCr202	L-NiCr 20 2	FCA-NiCr 20 2	F41002	GJLA-XNiCr 20-2	L-NC 20 2	–	0523-00	–	–	0.6660	–
A 436 Type 4	GGL- NiSiCr3055	L-NiSiCr 30 5 5	FCA-NiSiCr 30 5 5	F41005	GJLA-XNiSiCr 30-5-5	L-NSC 30 5 5	–	–	–	–	0.6680	–
60-40-18	GGG-40	SNG 420/12	FCD 400 class 1	F32800	GJS-400-15	FGS400-12	GS400-12	0717-02	60-40-18	60-40-18	0.7040	–
65-45-12	GGG-50	SNG 500/7	FCD 500	F33100	GJS-500-7	FGS 500-7	GS 500/7	0727-02	65-45-12	65-45-12	0.7050	–
–	GGG-60	SNG 600/3	FCD 600-3	–	GJS-600-3	–	GS 600/3	–	80-55-06	80-55-06	0.7060	–
100-70-03	GGG-70	SNG 700/2	FCD 700	F34800	GJS-700-2	FGS 700-2	GS 700-2	0737-01	100-70-03	100-70-03	0.7070	–
120-90-02	GGG-80	SNG 800/2	FCD 800	F36200	GJS-800-2	FGS 800-2	GS 800-2	–	120-90-02	120-90-02	0.7080	–
A 439 Type D-2	GGG-NiCr202	L-NiCuCr 20 2	FCDA-NiCr 20 2	–	GJSA-XNiCr 20-2	L-NC 20 2	–	0523-00	–	–	0.7660	–
A 439 Type D-2C	GGG-Ni22	S-Ni 22	FCDA-Ni 22	F43002	GJSA-XNi 22	S-N 22	–	–	–	–	0.7670	–
A 439 Type D-4	GGG-NiSiCr3053	S-NiSiCr 30 5 5	FCDA-NiSiCr 30 5 4	F43005	GJSA-XNiSiCr 30-5-3	S-NSC 30 5 5	–	–	–	–	0.7680	–
–	GTW-40-05	W 40-05	FCMW 370	–	GJMW-400-5	MB 400-5	GMB 40	–	–	–	0.8040	–
–	GGV-40	–	–	–	GJV-400	–	–	–	–	–	0.9990	–
80-55-06	–	–	–	F33800	–	FGS 350-22	–	0732-03	D5506	–	–	–
–	–	–	–	–	–	–	–	–	D4018	–	–	–
–	–	–	–	–	–	–	–	–	D400	–	–	–
–	–	–	–	–	–	–	–	–	D4512	–	–	–
–	–	–	–	–	–	–	–	–	D450	–	–	–
–	–	–	–	–	–	–	–	–	M3210	–	–	–
–	–	–	–	–	–	–	–	–	M4504	–	–	–
–	–	–	–	–	–	–	–	–	M5003	–	–	–
–	–	–	–	–	–	–	–	–	M5503	–	–	–
–	–	–	–	–	–	–	–	–	M7002	–	–	–
–	–	–	–	–	–	–	–	–	D7003	–	–	–
–	–	–	–	–	–	–	–	–	M8501	A 602 M8501	–	–
–	GGV-45	–	–	–	GJV-450	–	–	–	–	–	–	–
–	GGG-SiMo3.08	–	–	–	–	–	–	–	–	–	–	–
–	GGG-SiMo4.10	–	–	–	–	–	–	–	–	–	–	–
–	GGG-SiMo5.10	–	–	–	–	–	–	–	–	–	–	–
–	–	–	–	–	–	–	–	–	–	–	–	HPI C13 06
–	GGV-35	–	–	–	GJV-350	–	–	–	–	–	–	–
–	GGV-50	–	–	–	GJV-500	–	–	–	–	–	–	–

K3 Workpiece Materials Listing • Cast Iron • K3

K3 High-Strength Ductile Irons and Austempered Ductile Iron (ADI) *Tensile Strength RM (MPa)*: >600* *Hardness (HB): 180–350 (HRC): <43*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	–	–	–	–	–	–	–	–	–	A 897 125-80-10	–	–
–	–	–	–	–	–	–	–	–	–	A 897 150-100-7	–	–
–	–	–	–	–	–	–	–	–	–	A 897 175-125-4	–	–
–	–	–	–	–	–	–	–	–	–	A 897 200-150-1	–	–
–	–	–	–	–	–	–	–	–	–	A 897 230-185	–	–

NOTE: For legend, see page Y217.

N1 Workpiece Materials Listing • Non-Ferrous Metals • N1

N1 Wrought Aluminium

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
1080	Al99.8	–	1A	–	–	–	–	–	–	–	3.0128	–
1050	Al99.5	L 31	1B	–	–	A 59050 C	–	–	–	–	3.0255	–
–	SG-Al 99,5	–	–	–	–	–	–	–	–	–	3.0259	–
1070	Al99.7	–	–	–	–	–	4508	–	–	–	3.0275	–
3103	AlMn	–	N3	–	–	–	–	–	–	–	3.0515	–
3003	AlMnCu	–	–	–	–	–	–	–	–	–	3.0517	–
3005	AlMn1Mg0.5	–	–	–	–	–	–	–	–	–	3.0525	–
3004	AlMn1Mg1	–	–	–	–	–	–	–	–	–	3.0526	–
–	AlMgSiPb	–	–	–	–	–	–	–	–	–	3.0615	–
–	SG-Al 99,5Ti	–	–	–	–	–	–	–	–	–	3.0805	–
–	SG-Al 99,5 Ti	–	–	–	–	–	–	–	–	–	3.0805	–
2014	AlCuSiMn	–	H15	–	–	A-U4SG	3581	–	–	–	3.1255	–
2017	AlCuMg 1	–	–	–	AW-2017 A	A-U4G	3579	–	–	–	3.1325	–
2024	AlCuMg 2	–	L97	–	AW-2024	A-U4G1	–	–	–	–	3.1355	–
–	AlCuMgPb	–	–	–	–	–	–	–	–	–	3.1645	–
2011	AlCuBiPb	–	FC1	–	–	A-U5PbBi	6362	–	–	–	3.1655	–
6082	AlMgSi 1	–	H30	–	AW-6005 A	A-SGM0.7	3571	–	–	–	3.2315	–
6060	AlMgSi0.5	–	–	–	–	–	–	–	–	–	3.3206	–
6063	AlMgSi0.7	–	H9	–	–	A-GS	3569	–	–	–	3.3206	–
6463	EAlMgSi0.5	–	91E	–	–	–	–	–	–	–	3.3207	–
5005	AlMg 1	–	N41	–	AW-6082	A-G0.6	5764-66	–	–	–	3.3315	–
5050	–	–	–	–	–	–	–	–	–	–	3.3316	–
5052	AlMg2.5	–	2L56	–	–	A-G2.5C	4574	–	–	–	3.3523	–
5754	AlMg 3	–	N5	–	–	A-G3M	3575	–	–	–	3.3535	–
5454	AlMg2.5Mn	–	N51	–	–	A-G2.5MC	7789	–	–	–	3.3537	–
5086	AlMg4Mn	–	–	–	–	–	–	–	–	–	3.3545	–
–	SG-Al Mg 4,5 Mn Zr	–	–	–	–	–	–	–	–	–	3.3546	–
5083	AlMg4,5Mn	–	N8	–	–	A-G4.5MC	7790	–	–	–	3.3547	–
5056	AlMg5	–	N6	–	–	A-G5	3576	–	–	–	3.3549	–
–	AlMg 5	–	–	–	–	–	–	–	–	–	3.3555	–
7050	AlZnMgCu0,5	L 86	–	–	–	AZ 4 GU/9051	811-04	–	–	–	3.4144	–
7020	AlZn4.5Mg1	–	H17	–	–	A-Z5G	–	–	–	–	3.4335	–
7022	AlZnMgCu0.5	–	–	–	–	–	–	–	–	–	3.4345	–
–	AlZn5,5MgCu	–	–	–	–	–	–	–	–	–	3.4365	–
7075	AlZnMgCu 1.5	–	DTD5074	A97075	AL-P7075	A-Z5GU	3735	–	7075	–	3.4365	–
1000	Al99.5H	L31	–	–	–	A59050C	–	–	–	–	3.0250	–
–	Al99.8	–	–	–	–	–	–	–	–	–	3.0280	–
–	AlMg3Mn	–	–	–	–	–	–	–	–	–	–	–
2025	–	–	A 2025 FD	A92025	–	–	–	–	2025	B 247 2025	–	–
1100	–	–	–	–	–	–	–	–	–	–	–	–
3105	–	–	–	–	–	–	–	–	–	–	–	–
5657	AlMg0.8Si	–	–	–	–	–	–	–	–	–	–	–
6070	–	–	–	–	–	–	–	–	–	–	–	–
6262	–	–	–	–	–	–	–	–	–	–	–	–
7003	–	–	–	–	–	–	–	–	–	–	–	–
2050	–	–	–	–	–	–	–	–	–	–	–	–
7475	–	–	–	–	–	–	–	–	–	–	–	–
7175	–	–	–	–	–	–	–	–	–	–	–	–
7178	–	–	–	–	–	–	–	–	–	–	–	–
5251	AlMg2Mo3	–	N4	–	–	A-G2M	3574	–	–	–	–	–
6151	–	–	–	–	–	–	–	–	–	–	–	–
7001	–	–	–	–	–	–	–	–	–	–	–	–
7040	–	–	–	–	–	–	–	–	–	–	–	–

N2 Workpiece Materials Listing • Non-Ferrous Metals • N2

N2 Low-Silicon Aluminium Alloys and Magnesium Alloys *Content: Si <12,2%*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	SG-Al99,8	–	–	–	–	–	–	–	–	–	3.0286	–
–	G-AlCu 4 TiMg	–	–	–	–	–	–	–	–	–	3.1371	–
–	G-AlCu 4 TiMg	–	–	–	–	–	–	–	–	–	3.1371	–
–	G-AlCu 5 Ni 1,5	–	–	–	–	–	–	–	–	–	3.1754	–
–	G-AlCu 4 Ti	–	–	–	–	–	–	–	–	–	3.1841	–
–	G-AlSi 5 Cu 1	–	–	–	–	–	–	–	–	–	3.2131	–
–	G-AlSi 6 Cu 4	–	–	–	–	–	–	–	–	–	3.2151	–
–	G-AlSi 8 Cu 3	–	–	–	–	–	–	–	–	–	3.2161	–
–	G-AlSi 9 Cu 3	–	–	–	–	–	–	–	–	–	3.2163	–
–	G-AlSi 1 1	–	–	–	–	–	–	–	–	–	3.2211	–
–	SG-AlSi 5	–	–	–	–	–	–	–	–	–	3.2245	–
–	SG-AlSi 5	–	–	–	–	–	–	–	–	–	3.2245	–
–	G-AlSi 5 Mg	–	–	–	–	–	–	–	–	–	3.2341	–
4218 B	G-AlSi 7 Mg	–	–	–	–	–	–	–	–	–	3.2371	–
–	G-AlSi 9 Mg	–	–	–	–	–	–	–	–	–	3.2373	–
–	G-AlSi 10 Mg	–	–	–	–	–	–	–	–	–	3.2381	–
–	G-D AlSi 10 Mg	–	–	–	–	–	–	–	–	–	3.2382	–
A 360.2	G-AlSi 10 Mg(Cu)	LM 9	–	–	–	–	–	4253	–	–	3.2383	–
A 413.0	G-D AlSi 12	–	–	–	–	–	–	4247	–	–	3.2582	–
–	SG-AlSi 12	–	–	–	–	–	–	–	–	–	3.2585	–
–	G-D AlSi 12(Cu)	–	–	–	–	–	–	–	–	–	3.2982	–
6061	AlMgSiCu	–	H20	–	–	A-GSUC	6170	–	–	–	3.3211	–
–	G-AlMg 3 Si	–	–	–	–	–	–	–	–	–	3.3241	–
–	G-AlMg 5 Si	–	–	–	–	–	–	–	–	–	3.3261	–
–	G-D AlMg 9	–	–	–	–	–	–	–	–	–	3.3292	–
–	G-AlMg5Si(Cu,Mn)	–	–	–	–	–	–	–	–	–	3.3458	–
–	SG-AlMg 3	–	–	–	–	–	–	–	–	–	3.3536	–

(continued)

N2 Workpiece Materials Listing • Non-Ferrous Metals • N2 *(continued)*

N2 Low-Silicon Aluminium Alloys and Magnesium Alloys *Content: Si <12,2%*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	G-AlMg 3	–	–	–	–	–	–	–	–	–	3.3541	–
–	SG-AlMg 4,5 Mn	–	–	–	–	–	–	–	–	–	3.3548	–
–	SG-AlMg 5	–	–	–	–	–	–	–	–	–	3.3556	–
–	G-AlMg 5	–	–	–	–	–	–	–	–	–	3.3561	–
ZE 41	G-MgZn 4 SE 1 Zr 1	MAG 5	–	–	MCMgZn 4 RE 1 Zr	G-Z 4 TR	–	–	–	–	3.5101	–
–	G-MgZn 5 Th 2 Zr 1	–	–	–	–	–	–	–	–	–	3.5102	–
EZ 33	MgSE 3 Zn 2 Zr 1	MAG 6	–	–	MCMgRE 3 Zn 2 Zr	G-TR 3 Z 2	–	–	–	–	3.5103	–
–	MgAl 9 Zn 1	–	–	–	–	–	–	–	–	–	3.5104	–
–	G-MgTh 3 Zn 2 Zr 1	–	–	–	–	–	–	–	–	–	3.5105	–
QE 22	G-MgAg 3 SE 2 Zr 1	MAG 12	–	–	MCMgRE 2 Ag 2 Zr	G-Ag 22,5	–	–	–	–	3.5106	–
–	G-D MgAl 6 Zn 1	–	–	–	–	–	–	–	–	–	3.5612	–
–	G-D MgAl 6	–	–	–	–	–	–	–	–	–	3.5662	–
AZ 81	G-MgAl 8 Zn 1	MAG 1	–	–	MCMgAl 8 Zn 1	G-A 9	–	–	–	–	3.5812	–
AZ 91	G-MgAl 9 Zn 1	MAG 7	–	–	MCMgAl 9 Zn 1	G-A 9 Z 1	–	–	–	–	3.5912	–
–	G-MgAl 8 Zn 1	–	–	–	–	–	–	–	–	–	3.5200	–
AS 41	G-D MgAl 4 Si 1	–	–	–	MCMgAl4Si	G-A4S 1	–	–	–	–	3.5470	–
–	G-AlZn10Si8Mg	–	–	–	–	–	–	–	–	–	–	–
AS 7 G	AlSi7Mg	–	–	–	–	–	–	–	–	–	–	–
2117	–	–	–	–	–	–	–	–	–	–	–	–
2218	AlCuMgNi2	–	–	–	–	–	–	–	–	–	–	–
2091	–	–	–	–	–	–	–	–	–	–	–	–
8090	–	–	–	–	–	–	–	–	–	–	–	–
2090	–	–	–	–	–	–	–	–	–	–	–	–
2224	–	–	–	–	–	–	–	–	–	–	–	–
2094	–	–	–	–	–	–	–	–	–	–	–	–
2095	–	–	–	–	–	–	–	–	–	–	–	–
2097	–	–	–	–	–	–	–	–	–	–	–	–
2098	–	–	–	–	–	–	–	–	–	–	–	–
2099	–	–	–	–	–	–	–	–	–	–	–	–
2195	–	–	–	–	–	–	–	–	–	–	–	–
2196	–	–	–	–	–	–	–	–	–	–	–	–
2197	–	–	–	–	–	–	–	–	–	–	–	–
2198	–	–	–	–	–	–	–	–	–	–	–	–
2297	–	–	–	–	–	–	–	–	–	–	–	–
2397	–	–	–	–	–	–	–	–	–	–	–	–
8017	–	–	–	–	–	–	–	–	–	–	–	–
8024	–	–	–	–	–	–	–	–	–	–	–	–
8091	–	–	–	–	–	–	–	–	–	–	–	–
8093	–	–	–	–	–	–	–	–	–	–	–	–
2199	–	–	–	–	–	–	–	–	–	–	–	–

N3 Workpiece Materials Listing • Non-Ferrous Metals • N3

N3 High-Silicon Aluminium Alloys and Magnesium Alloys *Content: Si >12,2%*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
A 413.1	G-AlSi 12(Cu)	LM 20	–	–	–	–	–	4260	–	–	3.2583	–
A 413.2	G-AlSi 12	LM 6	–	–	–	–	–	4261	–	–	3.2581	–
–	G-AlSi17Cu4Mg	–	–	–	–	–	–	–	–	–	–	–
–	GK-AlSi18CuNiMg	–	–	–	–	–	–	–	–	–	–	–
–	GK-AlSi21CuNiMg	–	–	–	–	–	–	–	–	–	–	–
–	GK-AlSi12CuNiMg	–	–	–	–	–	–	–	–	–	–	–
–	GK-AlSi25CuNiMg	–	–	–	–	–	–	–	–	–	–	–
–	G-AlSi 21 CuNiMg	–	–	–	–	–	–	–	–	–	–	–
4032	–	–	–	–	–	–	–	–	–	–	–	–

N4 Workpiece Materials Listing • Non-Ferrous Metals • N4

N4 Copper-, Brass-, Zinc-Based on Machinability Index Range of 70–100

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
C 11000	E-Cu 58	C 101	–	–	–	Cn-a2	–	–	–	–	2.0065	–
C 81100	G-CuL 45	HCC 1	–	–	–	–	–	–	–	–	2.0082	–
C 81100	G-Cu L 50	HCC 1	–	–	–	–	–	–	–	–	2.0085	–
–	CuZn 40 MnPb	–	–	–	–	–	–	–	–	–	2.0241	–
C 26000	CuZn 30	CZ 102	C 2600	–	–	CuZn 30	–	–	–	–	2.0265	–
C 27200	CuZn 37	CZ 108	–	–	–	CuZn 37	C 2720	–	–	–	2.0321	–
–	CuZn 36 Pb 1.5	–	–	–	–	–	–	–	–	–	2.0331	–
–	S-CuZn40	–	–	–	–	–	–	–	–	–	2.0366	–
–	CuZn 39 Pb 3 + D567	–	–	–	–	–	–	–	–	–	2.0401	–
–	CuZn 40 Pb 2	–	–	–	–	–	–	–	–	–	2.0402	–
B-198	G-CuZn 15Si 4	–	–	–	–	–	–	–	–	–	2.0492	–
–	CuZn 40Al 1	–	–	–	–	–	–	–	–	–	2.0561	–
–	G-KCuZn 38 Al	–	–	–	–	–	–	–	–	–	2.0591	–
C 86500	G-CuZn 35 Al 1	HTB 1	–	–	–	U-Z 36 N 3	–	–	–	–	2.0592	–
–	G-KCuZn 37 Al 1	–	–	–	–	–	–	–	–	–	2.0595	–
C 86200	G-CuZn 34 Al 2	HTB 1	–	–	–	U-Z 36 N 3	–	–	–	–	2.0596	–
–	G-CuZn 25 Al 5	–	–	–	–	–	–	–	–	–	2.0598	–
–	S - CuNi 30 Fe	–	–	–	–	–	–	–	–	–	2.0837	–
–	CuNi 10 Fe 1 Mn	–	–	–	–	–	–	–	–	–	2.0872	–

NOTE: For legend, see page Y217.

(continued)

N4 Workpiece Materials Listing • Non-Ferrous Metals • N4 *(continued)*

N4 Copper-, Brass-, Zinc-Based on Machinability Index Range of 70–100

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	S - CuNi 10 Fe	–	–	–	–	–	–	–	–	–	2.0873	–
–	CuNi 30 Mn 1 Fe	–	–	–	–	–	–	–	–	–	2.0882	–
–	SG-Cu Al 8	–	–	–	–	–	–	–	–	–	2.0921	–
–	SG-CuAl 8 Ni 2	–	–	–	–	–	–	–	–	–	2.0922	–
–	SG-CuAl 9 Ni5 Fe	–	–	–	–	–	–	–	–	–	2.0927	–
–	CuAl 10 Fe 3 Mn 2	CA 103	–	–	–	U-A 10 Fe	–	–	–	–	2.0936	–
–	SG-Cu Al 10 Fe	–	–	–	–	–	–	–	–	–	2.0937	–
C 63000	CuAl 10 Ni 5 Fe 4	Ca 104	–	–	–	U-A 10 N	–	–	–	–	2.0966	–
B-148-52	G-CuAl 10 Ni	–	–	–	–	–	–	–	–	–	2.0975	–
–	SG-Cu Sn	–	–	–	–	–	–	–	–	–	2.1006	–
–	SG-Cu Sn 6	–	–	–	–	–	–	–	–	–	2.1022	–
C 90800	G-CuSn 12	Pb 2	–	–	–	UE 12 P	–	–	–	–	2.1052	–
–	G-CuSn 12 Pb	–	–	–	–	–	–	–	–	–	2.1061	–
–	G-CuSn 10 Zn	–	–	–	–	–	–	–	–	–	2.1086	–
C 93200	G-CuSn 7 ZnPb	–	–	–	–	U-E 7 Z 5 Pb 4	–	–	–	–	2.1091	–
–	G-CuSn 6 ZnNi	LG 4	–	–	–	–	–	–	–	–	2.1093	–
C 83600	G-CuSn 5 ZnPb	LG 2	–	–	–	U-E 5 Pb 5 Z 5	–	–	–	–	2.1096	–
–	G-CuSn 2 ZnPb	–	–	–	–	–	–	–	–	–	2.1098	–
C 93700	G-CuPb 10 Sn	LB 2	–	–	–	U-E 10 Pb 10	–	–	–	–	2.1176	–
C 93800	G-CuPb 15 Sn	LB 1	–	–	–	U-Pb 15 E 8	–	–	–	–	2.1182	–
C 94100	G-CuPb 20 Sn	LB 5	–	–	–	U-Pb 20	–	–	–	–	2.1188	–
C 81500	G-CuCrF 35	CC1-FF	–	–	–	–	–	–	–	–	2.1292	–
C 18200	CuCrZr	CC 102	–	–	–	U-Cr 0,8 Zr	–	–	–	–	2.1293	–
–	SG-Cu Mn 13 Al 7	–	–	–	–	–	–	–	–	–	2.1367	–
–	SG-Cu Si 3	–	–	–	–	–	–	–	–	–	2.1461	–
CuSi 3 Mn	–	–	–	–	–	–	–	–	–	–	2.1525	–
–	OF-Cu	–	–	–	–	–	–	–	–	–	2.0040	–
B-120	E-Cu 57	–	–	–	–	–	–	–	–	–	2.0060	–
C 10300	SE-Cu	C 101	–	–	–	Cu-c1	–	–	–	–	2.0070	–
–	CuZn 5	–	–	–	–	–	–	–	–	–	2.0220	–
C 23000	CuZn 15	CZ 102	C 2300	–	–	CuZn 15	–	–	–	–	2.0240	–
–	G-CuZn 33 Pb	–	–	–	–	–	–	–	–	–	2.0290	–
–	CuZn 36 Pb 2	–	–	–	–	–	–	–	–	–	2.0330	–
–	G-CuZn 37 Pb	–	–	–	–	–	–	–	–	–	2.0340	–
–	CuZn 40	–	–	–	–	–	–	–	–	–	2.0360	–
–	CuZn 39 Pb 2	–	–	–	–	–	–	–	–	–	2.0380	–
–	CuZn 20 Al 2	–	–	–	–	–	–	–	–	–	2.0460	–
–	CuZn 37Al 1	–	–	–	–	–	–	–	–	–	2.0510	–
–	CuZn 40 Al 2	–	–	–	–	–	–	–	–	–	2.0550	–
–	G-CuZn 40 Fe	–	–	–	–	–	–	–	–	–	2.0590	–
–	G-CuAl 10 Fe	–	–	–	–	–	–	–	–	–	2.0940	–
C 90700	G-CuSn 10	CT 1	–	–	–	–	–	–	–	–	2.1050	–
C 91700	G-CuSn 12 Ni	–	–	–	–	–	–	–	–	–	2.1060	–
–	C35100	–	–	–	–	–	–	–	–	–	–	–
–	17665	–	–	C95500	–	–	–	–	–	–	–	–
–	MS60	–	–	–	–	–	–	–	–	–	–	–

N5 Workpiece Materials Listing • Non-Ferrous Metals • N5

N5 Nylon, Plastics, Rubbers, Phenolics, Resins, Fibreglass

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	LEXAN	–	–	–	–	–	–	–	–	–	–	–
–	HOSTALEN	–	–	–	–	–	–	–	–	–	–	–
–	Polystyrol	–	–	–	–	–	–	–	–	–	–	–
–	Makralon	–	–	–	–	–	–	–	–	–	–	–

N6 Workpiece Materials Listing • Non-Ferrous Metals • N6

N6 Carbon, Graphite Composites, CFRP

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	GFK	–	–	–	–	–	–	–	–	–	–	–
–	CFK	–	–	–	–	–	–	–	–	–	–	–
Graphite	–	–	–	–	–	–	–	–	–	–	–	–
CFRP	–	–	–	–	–	–	–	–	–	–	–	–

S1 Workpiece Materials Listing • High-Temp Alloys • S1

S1 Iron-Based, Heat-Resistant Alloys *Tensile Strength RM (MPa)*: 500–1200* *Hardness (HB): 160–260 (HRC): 25–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	X 10 Cr 25	–	–	–	–	–	–	–	–	–	1.3811	–
–	D 1 a	–	–	–	–	–	–	–	–	–	1.3915	–
–	D 3	BD 3	–	–	X 210 Cr 1 2	Z 200 C 12	X 205 Cr 12 KU	–	–	–	1.3916	–
–	RNi 12	–	–	–	–	–	–	–	–	–	1.3926	–
–	RNi 8	–	–	–	–	–	–	–	–	–	1.3927	–
–	GX 2 NiCoMoTi1 7 10	–	–	–	–	–	–	–	–	–	1.6351	Maraging
6501, 6512, 6520	X 2 NiCoMo 18 8 5	–	–	UNS K92890	S162	Z2NKD18.8	–	–	–	ASTM A646	1.6359	ATI VascoMax® C-250
–	X 2 NiCoMo 18-8-5	–	–	K92890	–	–	–	–	–	–	1.6359	Maraging
–	X 1 CrNiCoMo 13 8 5	–	–	–	–	–	–	–	–	–	–	Maraging
–	Ni 36	–	–	–	–	–	–	–	–	–	1.3910	Magnifer 36
–	Ni 46	–	–	–	–	–	–	–	–	–	1.3920	–
–	X 2 CrNiCoMo 12 8 5	–	–	–	–	–	–	–	–	–	1.6980	Maraging
ASTM B463	–	–	–	UNS N08020	–	–	–	–	–	ASTM B463	2.4660	20CB-3
ASTM A666	–	–	–	–	–	–	–	–	–	ASTM A666	–	6/21/09
ASTM B753	–	–	–	–	–	–	–	–	–	ASTM B753	–	AL 4750
S66286	–	–	NAS 660	UNS S66286	–	–	A-286	–	–	–	–	ATI A286™
–	–	–	–	UNS K92810	–	–	–	–	–	–	–	ATI VascoMax® C-200
6514	–	–	–	UNS K93120	–	–	–	–	–	–	–	ATI VascoMax® C-300
–	–	–	–	–	–	–	–	–	–	–	–	ATI VascoMax® C-350
–	–	–	–	–	–	–	–	–	–	–	–	ATI VascoMax® T-200
6518, 6519, 6591	–	–	–	–	–	–	–	–	–	–	–	ATI VascoMax® T-250
–	–	–	–	–	–	–	–	–	–	–	–	ATI VascoMax® T-300
5725	–	–	–	–	–	Z3NCT25	–	–	SAE 16-25-6	–	–	Discaloy 16-25-6
ASTM A638	–	–	–	–	–	Z3NCT25	–	–	Discaloy	ASTM A638	–	Discaloy 24
–	–	–	–	R30556	–	–	–	–	–	–	–	Haynes® 556
5768	X 12 CrCoNi 21 20	–	–	–	–	Z12CKNDWNb21.20.20	–	–	–	–	–	Haynes 556
ASTM F30	–	–	–	–	–	–	–	–	Invar	ASTM F30	–	Invar 42
5768	–	–	–	UNS R30155	–	Z12CNKDW20	–	–	–	–	–	Multimet N-155
–	–	–	–	–	–	–	–	–	–	–	–	Multimet N-156
5533	X 40 CoCrNi 20 20	–	–	–	–	Z42CKNDW	–	–	–	–	–	S 590
–	X 2 NiCrAlTi 32 20	–	–	–	–	–	–	–	–	–	–	Sanicro 30
AISI:665	–	–	–	–	–	Z8NCTDA2613	–	–	–	–	–	W-545

S2 Workpiece Materials Listing • High-Temp Alloys • S2

S2 Cobalt-Based, Heat-Resistant Alloys *Tensile Strength RM (MPa)*: 1000–1450* *Hardness (HB): 250–450 (HRC): 25–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	CoCr 26 Ni 9 Mo	–	–	–	–	–	–	–	–	–	2.4681	–
–	CoCr 25 NiW	–	–	–	–	KC25WN	–	–	–	ASTM A567	2.4682	Stellite® 31 (X40)
–	CoCr 22 NiW	–	–	–	–	–	–	–	–	–	2.4683	–
–	CoCr 28 Mo	–	–	–	–	KC27D5NFe	–	–	–	ASTM F-75	2.4691	HS 21
–	CoCr 20 Ni 15 Mo	–	–	–	–	–	–	–	–	–	2.4711	–
–	CoCr 29 Mo	–	–	–	–	–	–	–	–	–	2.4723	–
–	CoCr 33 W	–	–	–	–	–	–	–	–	–	2.4775	–
–	CoCr 28	–	–	–	–	–	–	–	–	–	2.4778	–
–	CoCr 28 Nb	–	–	–	–	–	–	–	–	–	2.4779	–
–	–	–	–	–	–	–	–	–	–	ASTM F90	2.4964	F 90
–	–	–	–	R30605	–	KC20WN	–	–	–	–	2.4964	Haynes 25
–	CoCr 20 W 15 Ni	HR 240	–	R30605	–	KC20WN	–	–	–	5759	2.4964	L 605
–	CoCr 20 W 15 Ni	–	–	CAST Version of L605	–	KC20WN	–	–	–	5759	2.4964	Stellite 25
AMS 5399	NiCr 19 Co 11 MoTi	–	–	–	–	NC 19 KDT	–	–	–	–	2.4973	–
–	CoCr 20 Ni 20 W	–	–	–	–	–	–	–	–	5534	2.4979	S 816
–	CoCr20NiW	–	–	–	–	–	–	–	–	–	2.4989	–
–	–	–	–	R31537 & R31538	–	CoCr28Mo	–	–	–	ASTM F1537	–	F 1537
–	–	–	–	–	–	–	–	–	–	ASTM F562	–	F 562
–	–	–	–	–	–	–	–	–	–	ASTM F563	–	F 563
–	–	–	–	R30188	–	KC22N22W14Fe	–	–	–	–	–	Haynes 188
AISI 670	CoCr 20 W 15 Ni	–	–	–	–	KC20WN	–	–	–	–	–	HS 25
–	CoCr 26 Ni 14 Mo	–	–	–	–	–	–	–	–	5380	–	HS 30
–	CoCr 19 W 14 NiB	–	–	–	–	–	–	–	–	–	–	HS 36
–	–	–	–	–	–	–	–	–	–	–	–	L 251
–	CoCrW 10 TaZrB	–	–	–	–	KC21W10Ta9	–	–	–	–	–	MAR-M 302
–	CoCr 22 W 9 TaZrNb	–	–	–	–	KC21W9Ta	–	–	–	–	–	MAR-M 322
–	CoCr 24 Ni 10 WTaZrB	–	–	–	–	KC23N10W7Ta	–	–	–	–	–	MAR-M 509
–	–	–	–	–	–	KC20N20Ta7	–	–	–	–	–	MAR-M 905
–	CoCr 20 Ni 20 Ta	–	–	–	–	KC20N20Ta7	–	–	–	–	–	MAR-M 918
–	–	–	–	R30159	–	–	–	–	–	–	–	MP159
–	–	–	–	R30035	–	–	–	–	–	–	–	MP35N
–	–	–	–	–	–	KC33W13	–	–	–	–	–	Stellite 1
–	–	–	–	–	–	KC28W8	–	–	–	–	–	Stellite 12
–	–	–	–	–	–	KC22N22W14Fe	–	–	–	–	–	Stellite 188
–	–	–	–	–	–	KC26NW	–	–	–	–	–	Stellite 6
–	–	–	–	–	–	–	–	–	–	–	–	Stellite 8 (F75)
–	CoCr 25 Ni 20 MoWNb	–	–	–	–	KC25N20DFeWNb	–	–	–	–	–	V-36
–	CoCr 21 Mo 11 W	–	–	–	–	KC21W11ANbT	–	–	–	–	–	WI-52
–	–	–	–	–	–	KC25N10W7Fe	–	–	–	–	–	X 45
–	–	–	–	–	–	–	–	–	J-1570	–	–	–
–	K13C20N126Fe15D7	–	–	R3003 & R3008	–	K13C20N126Fe15D7	–	–	–	ASTM F1058	–	–

NOTE: For legend, see page Y217.

S3 Workpiece Materials Listing • High-Temp Alloys • S3

S3 Nickel-Based, Heat-Resistant Alloys *Tensile Strength RM (MPa)*: 600–1700* *Hardness (HB): 160–450 (HRC): <48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	X 7 NiCrCoMo 54 20	–	–	–	–	–	–	–	–	–	1.2789	–
–	Ni 99,7 Mg 0,07	–	–	J24053	–	–	–	–	–	A 915 J24053	2.4053	–
–	LC-Ni 99,6	–	–	N02201	–	–	–	–	–	–	2.4061	–
–	–	–	–	N02200	–	–	–	–	–	–	2.4066	200
Nickel 200	Ni 99,2	NA 11	–	N02200	–	–	–	–	–	–	2.4066	–
–	–	–	–	N02201	–	–	–	–	–	–	2.4068	201
Nickel 201	LC-Ni 99	NA 12	–	–	–	–	–	–	–	–	2.4068	–
–	NiMn 1	–	–	–	–	–	–	–	–	–	2.4106	–
–	NiMn 1 C	–	–	–	–	–	–	–	–	–	2.4108	–
–	NiMn 1,5	–	–	–	–	–	–	–	–	–	2.4109	–
–	NiMn 3 Al	–	–	–	–	–	–	–	–	–	2.4122	–
–	NiMn 3 SiMg	–	–	–	–	–	–	–	–	–	2.4126	–
–	NiCr 2 Mn	–	–	–	–	–	–	–	–	–	2.4145	–
–	NiCr 2 MnSi	–	–	–	–	–	–	–	–	–	2.4146	–
–	NiCr 5 MnSi	–	–	–	–	–	–	–	–	–	2.4151	–
–	SG-NiTi 4	NA32	–	–	NA 32	–	–	–	–	–	2.4155	–
CZ-100	G-Ni 93 C	–	–	–	–	–	–	–	–	–	2.4175	–
–	NiCr 4 Mn	–	–	–	–	–	–	–	–	–	2.4199	–
M 35-1/2	G-NiCu 30 Nb	–	–	N24030	–	–	–	–	–	–	2.4365	–
–	EL-NiCu 30 Mn	–	–	N04402	–	–	–	–	–	–	2.4366	–
M 30-H	G-NiCu 30 Si 3	–	–	–	–	–	–	–	–	–	2.4367	–
M-255	G-NiCu 30 Si 4	–	–	–	–	–	–	–	–	–	2.4368	–
–	NiCu 30 Al	–	–	–	–	–	–	–	–	–	2.4374	–
–	NiCu 30 Al	NA 18	–	N05500	3072.76	NU 30 AT	–	–	–	–	2.4375	Monel® K500
–	SG-NiCu 30 MnTi	NA 33	–	–	–	–	–	–	–	–	2.4377	–
–	NiFe 16 CuCr	–	–	–	–	–	–	–	–	–	2.4501	–
–	G-NiMo 16 CrW	–	–	–	–	–	–	–	–	–	2.4537	–
–	NiCr 21 Mo 14 W	–	–	N26022	–	–	–	–	–	–	2.4602	INCONEL® alloy 622
–	NiCr 30 FeMo	–	–	–	–	–	–	–	–	–	2.4603	Hastelloy® G-30
–	–	–	–	N06059	–	–	–	–	–	ASTM B575	2.4605	Allcorr
–	NiCr 23 Mo 16 Al	–	–	–	–	–	–	–	–	–	2.4605	–
–	SG/UP-NiCr 23 Mo 16	–	–	–	–	–	–	–	–	–	2.4607	–
–	NiCr 26 MoW	–	–	–	–	–	–	–	–	–	2.4608	–
–	SG-NiMo 27	–	–	–	–	–	–	–	–	–	2.4615	–
–	NiMo 28	–	–	N10665	–	NiMo 28	–	–	–	–	2.4617	–
–	NiCr 22 Mo 6 Cu	–	–	–	–	–	–	–	–	–	2.4618	–
–	–	–	–	N06985	–	–	–	–	–	–	2.4619	Hastelloy G-3
–	NiCr 22 Mo 7 Cu	–	–	N06985	–	–	–	–	–	–	2.4619	–
–	SG-NiCr 23 Al	NA 49	–	–	–	–	–	–	–	–	2.4626	–
–	SG-NiCr 22 Co 12 Mo	NA 50	–	–	–	–	–	–	–	–	2.4627	–
–	NiCr 20 Ti	HR5	–	N06075	HR5, 203.4	NC 20 T	–	–	–	–	2.4630	Nimonic® 75
–	NiCr 20 TiAl	NA 20	NCF 80A	N07080	HR401, 601	NC 20 TA	–	–	–	–	2.4631	Nimonic 80A
–	NiCr 20 Co 18 Ti	NA 36	–	N07090	HR2, 202	NC20KTA	–	–	–	–	2.4632	Nimonic 90
–	NiCo 20 Cr 15 MoAlTi	–	–	N13021	HR3	NCKD20ATV	–	–	–	–	2.4634	Nimonic 105
–	NiCo 15 Cr 15 MoAlTi	HR4	–	–	HR401, 601	NCVK15ATD	–	–	–	–	2.4636	Nimonic 115
AISI 687	NiCo 15 Cr 15 MoAlTi	–	–	–	–	NCKD20AT	–	–	–	–	2.4636	Udimet® 700
–	NiCr 22 Mo 8 AlCuTi	–	–	–	–	–	–	–	–	–	2.4637	–
–	SG-NiCr 20	NA 34	–	–	–	–	–	–	–	–	2.4639	–
–	NiCr 21 Mo 6 Cu	–	NCF 600 TP	–	–	–	–	–	–	–	2.4641	–
–	NiCr 29 Fe	–	NCF 690	N06690	–	NC 30 Fe	–	–	–	–	2.4642	INCONEL® alloy 690
–	NiCr 25 FeAlYC	–	–	–	–	–	–	–	–	–	2.4647	–
–	NiCr 20 CoMoTi	NA 38	NCF 690	N07263	HR10	NCK 20 D	–	–	–	–	2.4650	Nimonic C263
–	EL-NiCr 26 Mo	–	–	–	–	–	–	–	–	–	2.4652	–
–	NiCr 19 Co 14 Mo 4 Ti	–	–	N07001	–	NC20K14Y	–	–	–	–	2.4654	Waspaloy
–	SG-NiCr 29 Mo	–	–	–	–	–	–	–	–	–	2.4656	–
–	NiCr 70 30	–	–	N06008	–	–	–	–	–	–	2.4658	–
–	SG-NiCr 30 Mo 5 W	–	–	–	–	–	–	–	–	–	2.4659	–
–	EL-NiCr 29 Mo 5 W	–	–	–	–	–	–	–	–	–	2.4661	–
–	NiFe 35 Cr 14 MoTi	–	–	N09901	–	Z8NCDT42	–	–	–	–	2.4662	INCOLOY® 901
–	NiCr 13 Mo 6 Ti 3	–	–	N09901	–	Z8NCDT42	–	–	–	–	2.4662	Nimonic 901
–	NiCr 23 Co 12 Mo	–	–	N06617	–	NC22K12D9A	–	–	–	–	2.4663	INCONEL® alloy 617
–	NiCr 22 FeMo	–	–	N06002	HR6, 204	NC22FeD	–	–	–	–	2.4665	Hastelloy X
–	NiCr 22 Fe 18 Mo	NA 40	–	N06002	–	NC22FeD	–	–	–	–	2.4665	INCONEL alloy HX
–	NiCr 18 CoMo	–	–	–	–	NKCD20ATU	–	–	–	–	2.4666	Nimonic PK25
–	SG-NiCr 19 NbMoTi	NA 51	–	–	–	–	–	–	–	–	2.4667	–
–	NiCr 19 FeNbMo	–	–	N07718	HR8	NC 19 Fe Nb	–	–	–	–	2.4668	INCONEL alloy 718
–	NiCr 15 Fe 7 TiAl	–	–	N07750	–	NC 15 Fe 7 TA	–	–	–	–	2.4669	INCONEL alloy X750
–	G-NiCr 12 Al 6 MoNb	–	–	–	–	–	–	–	–	–	2.4671	–
–	G-NiCr 20 Co 20 MoTi	–	–	–	–	–	–	–	–	–	2.4672	–
–	NiCo 15 Cr 10 MoAlTi	–	–	N13100	–	NK15CAT	–	–	–	–	2.4674	IN 100
–	NiCo 15 Cr 10 MoAlTi	–	–	–	–	NK15C10A5T	–	–	–	–	2.4674	René 100
–	G-NiCo 15 Cr 10 AlTiMo	–	–	–	–	–	–	–	–	–	2.4674	–
–	G-NiCo 10 W 10 CrAlNb	–	–	–	–	–	–	–	–	–	2.4676	–
–	G-NiCr 50	–	–	–	–	–	–	–	–	–	2.4678	–
–	G-NiCr 35	–	–	–	–	–	–	–	–	–	2.4679	–
–	–	–	–	N10665	–	–	–	–	–	N7M	2.4685	Hastelloy B-2
CW-12 MW	G-NiMo 17 CrW	–	–	–	–	–	–	–	–	–	2.4686	–
–	NiCr 25 Mo 7 Ti	–	–	–	–	–	–	–	–	–	2.4693	–
–	NiCr 16 Fe 7 TiAl	–	–	N 07751	–	–	–	–	–	–	2.4694	INCONEL alloy 751
–	G-NiCr 20 Mo 15	–	–	–	–	–	–	–	–	–	2.4697	–
–	NiCr 22 W 14 Mo	–	–	–	–	–	–	–	–	–	2.4733	–
–	NiCr 20 AlY	–	–	–	–	–	–	–	–	–	2.4764	–
–	NiCr 17 AlWY	–	–	–	–	–	–	–	–	–	2.4765	–
–	SG-NiCr 20 Nb	NA 35	–	–	–	–	–	–	–	–	2.4806	–
–	G-NiCr 50 Nb	–	–	–	–	–	–	–	–	–	2.4813	–
–	NiCr 15 Fe	NA 14	NCF 600	N06600	3072.76	NC 15 Fe	–	–	–	–	2.4816	INCONEL alloy 600
–	G-NiMo 30	–	–	N10276	–	NC 15 D 14 KFe	–	–	–	–	2.4819	Hastelloy C-276
ASME SB575	NiMo 16 Cr 15 W	–	–	N10276	–	NC 17 D	–	–	–	–	2.4819	Nimonic C276

(continued)

S3 Workpiece Materials Listing • High-Temp Alloys • S3 *(continued)*

S3 Nickel-Based, Heat-Resistant Alloys *Tensile Strength RM (MPa)*: 600–1700* *Hardness (HB): 160–450 (HRC): <48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	SG-NiCr 21 Mo 9 Nb	–	–	–	–	–	–	–	–	–	2.4831	–
–	NiCr 20 Mo 15	–	–	–	–	–	–	–	–	–	2.4836	–
–	SG-NiCr 20 Mo 15	–	–	–	–	–	–	–	–	–	2.4839	–
–	–	–	–	N06601	–	–	–	–	–	–	2.4851	Haynes® 601
–	NiCr 23 Fe	–	NCF 601	N06601	–	NC 23 Fe 14 A	–	–	–	–	2.4851	INCONEL alloy 601
–	NiFe 33 Cr 25 Co	–	–	–	–	–	–	–	–	–	2.4854	–
–	NiCr 19 Mo 9 Si	–	–	–	–	–	–	–	–	–	2.4855	–
ASME SB443	NiCr 22 Mo 9 Nb	–	–	N06625	–	NC 22 Fe DNb	–	–	–	–	2.4856	Haynes 625
ASME SB443.4	NiCr 22 Mo 9 Nb	NA 21	NCF 625	N06625	–	NC 22 Fe DNb	–	–	–	–	2.4856	INCONEL alloy 625
ASME SB163	NiCr 21 Mo	–	–	N08825	3072.76	NC21FeDU	–	–	–	–	2.4858	INCOLOY® 825
–	NiCr 60 15	–	–	–	–	–	–	–	–	–	2.4867	–
–	NiCr 80 20	–	–	–	–	–	–	–	–	–	2.4869	–
–	NiCr 20 AlSi	–	–	–	–	–	–	–	–	–	2.4872	–
–	G-NiCr 28 W	–	–	–	–	–	–	–	–	–	2.4879	Centralloy® 4879
–	NiCr 17 Mo 17 FeW	–	–	N10002	–	NC17DWY	–	–	–	CW12MW	2.4883	Hastelloy C
–	G-NiMo 16 Cr	–	–	–	–	–	–	–	–	–	2.4883	–
–	SG-NiMo 16 cr 16 W	NA 48	–	–	–	–	–	–	–	–	2.4886	–
–	G-NiCr 13 MoAl	–	–	–	–	–	–	–	–	–	2.4888	–
–	NiCr 20 Ti	HR 5	–	N06621	–	NC 20 T	–	–	–	–	2.4951	–
–	NiCr 20 TiAl	NA 20	NCF 80 A	N07080	–	NC 20 TA	–	–	–	–	2.4952	–
–	NiFe 25 Cr 20 NbTi	–	–	–	NiFe 25 Cr 20 NbTi	–	–	–	–	–	2.4955	–
–	NiCr 20 Co 18 Ti	NA 19	–	N07090	–	–	–	–	–	–	2.4969	–
–	NiCr 22 W 12 Fe	–	–	–	–	–	–	–	–	–	2.4972	–
–	NiCr 19 Co 11 MoTi	–	–	N07041	–	NC19KDT	–	–	–	–	2.4973	René 41
–	NiFeCr 12 Mo	–	–	–	–	–	–	–	–	–	2.4975	–
–	NiCr 20 Mo	–	–	–	–	–	–	–	–	–	2.4976	–
–	NiCr 20 CoMo	–	–	–	–	–	–	–	–	–	2.4982	–
–	NiCr 18 Co	–	–	N07500	–	–	–	–	–	–	2.4983	Co500
AISI 684	NiCr 18 CoMoAlTi	–	–	N07500	–	NCK19DAT	–	–	–	–	2.4983	Udimet® 500
–	Ni 99,6	NA 46	–	–	–	–	–	–	–	–	2.4060	–
–	NiMn 2	–	–	–	–	–	–	–	–	–	2.4110	–
SZ-100	G-Ni 95	–	–	–	–	–	–	–	–	–	2.4170	–
–	G-Ni 93 Si	–	–	–	–	–	–	–	–	–	2.4180	–
–	NiCu 30 Fe	–	–	N04400	3072.76	NU30	–	–	–	–	2.4360	Monel® 400
–	NiCu 30 Ti	–	–	–	–	–	–	–	–	–	2.4370	Monel 60
–	NiFe 44	–	–	–	–	–	–	–	–	–	2.4420	Magnifer 53
–	NiFe 16 CuMo	–	–	–	–	–	–	–	–	–	2.4530	Perm 77
–	NiFeK 6040	–	–	–	–	–	–	–	–	–	2.4560	–
–	NiMo 16 Cr 16 Ti	NA 45	–	N26455	–	–	–	–	–	–	2.4610	Hastelloy C-4
–	–	–	–	–	–	20CB-3	–	–	–	ASTM B463	2.4660	INCOLOY 020
–	NiCr 20 CuMo	–	–	N08020	–	–	–	–	–	–	2.4660	–
–	G-NiCr 13 Al 16 MoNb	–	–	–	HC203	NC13AD	–	–	–	–	2.4670	Nimocast 713
–	G-NiCr 50 Nb	–	–	–	–	–	–	–	–	–	2.4680	–
–	NiMo 23 Cr 8 Fe	–	–	–	–	–	–	–	–	–	2.4710	–
–	NiMo 30	–	–	–	–	ND27FeV	–	–	–	N-12 MV	2.4810	Hastelloy B
–	NiCr 45 23	–	–	–	–	–	–	–	–	–	2.4890	–
–	–	–	–	N13017	–	NK17C15D5AT	–	–	–	–	–	Astroloy
–	–	–	–	–	–	–	–	–	–	–	–	Centralloy® 60HTD
AISI 686	–	–	–	–	–	NC15Fe10D5AT	–	–	–	–	–	GMR 235
–	NiCr 16 MoAl	–	–	–	–	NC15D5FeAT	–	–	–	–	–	GMR 235-D
–	–	–	–	–	–	–	–	–	–	CW6M	–	Hastelloy C-22
–	–	–	–	N06007	–	NC22Fe19D6KTa	–	–	–	–	–	Hastelloy G
–	–	–	–	N10003	–	–	–	–	–	–	–	Hastelloy N
–	–	–	–	N06635	–	NC15D14KFe	–	–	–	–	–	Hastelloy S
–	–	–	–	N10004	–	–	–	–	–	–	–	Hastelloy W
–	–	–	–	N07263	–	NC20K20D6T	–	–	–	–	–	Haynes® 263
–	–	–	–	–	–	–	–	–	–	–	–	Haynes 282
–	NiCr 15 Fe	–	–	N06600	–	–	–	–	–	–	–	Haynes 600
–	–	–	–	–	–	–	–	–	–	–	–	Haynes 75
–	NiCo 32 Cr 26 Mo	–	–	–	–	–	–	–	–	–	–	HS27
–	–	–	–	N06102	–	–	–	–	–	–	–	IN 102
ASME SB409	X 10 NiCrAlTi 32-20	–	–	N08800	3082.76	Z10NC3221	–	–	–	–	–	INCOLOY 800
–	–	–	–	–	–	Z4NC3221	–	–	–	–	–	INCOLOY 802
–	–	–	–	–	–	NC29Fe25	–	–	–	–	–	INCOLOY 804
–	NiFe 42 K 15 Nb	–	–	N19903	–	Z3NK28	–	–	–	–	–	INCOLOY 903
–	–	–	–	N19907	–	–	–	–	–	–	–	INCOLOY 907
–	–	–	–	N09925	–	–	–	–	–	–	–	INCOLOY 925
–	–	–	–	N09945	–	–	–	–	–	–	–	INCOLOY 945
ASME SB575	–	–	–	–	–	NiMo16Cr15	–	–	–	–	–	INCONEL alloy 22
–	–	–	–	–	–	–	–	–	–	–	–	INCONEL alloy 230
–	–	–	–	–	–	–	–	–	–	–	–	INCONEL alloy 600SP
–	–	–	–	–	–	–	–	–	–	–	–	INCONEL alloy 62
–	–	–	–	N06626	–	–	–	–	–	–	–	INCONEL alloy 625LCF
–	–	–	–	–	–	NC15A	–	–	–	–	–	INCONEL alloy 702
–	–	–	–	N09706	–	NFe10C16NbT	–	–	–	–	–	INCONEL alloy 706
–	–	–	–	N07718	–	–	–	–	–	–	–	INCONEL alloy 718 OP
–	–	–	–	–	–	NC16Fe8TM	–	–	–	–	–	INCONEL alloy 721
–	NiCr 16 FeTi	–	–	N07722	–	NC16FeTi	–	–	–	–	–	INCONEL alloy 722
–	–	–	–	R30783	–	–	–	–	–	–	–	INCONEL alloy 783
–	–	–	–	N09925	–	–	–	–	–	B983 N09925	–	INCONEL alloy 925
–	–	–	–	N10276	–	–	–	–	–	–	–	INCONEL alloy C-276
–	–	–	–	N07754	–	–	–	–	–	–	–	INCONEL alloy MA754
–	–	–	–	N07751	–	–	–	–	–	–	–	INCONEL alloy X751
–	–	–	–	K93600 K93603	–	–	–	–	–	ASTM F1684	–	INVAR® 36
–	NiCr 20 Co 18 Ti	–	–	–	–	–	–	–	–	–	–	Jessop G81
–	G-NiCr 19 Co	–	–	N07252	–	–	–	–	–	–	–	M 252
–	–	–	–	N04405	–	–	–	–	–	–	–	Monel® R405

NOTE: For legend, see page Y217.

(continued)

S3 Workpiece Materials Listing • High-Temp Alloys • S3 *(continued)*

S3 Nickel-Based, Heat-Resistant Alloys *Tensile Strength RM (MPa)*: 600–1700* *Hardness (HB): 160–450 (HRC): <48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
–	NiFe 33 Cr 17 Mo	–	–	–	–	–	–	–	–	–	–	Nimocast PD16
–	–	–	–	–	HC202	NC20N13	–	–	–	–	–	Nimocast PE10
–	–	–	–	–	–	NC19K18Fe5TA	–	–	–	–	–	Nimonic® 95
ASME SB575	–	–	–	N06022	–	–	–	–	–	–	–	Nimonic C22
–	NiCr 22 Fe 18 Mo	–	–	–	HR6, 204	NC22FeD	–	–	–	–	–	Nimonic PE13
–	NiFe 33 Cr 17 Mo	–	–	–	HR207	NW11AC	–	–	–	–	–	Nimonic PE16
–	NiCr 20 Co 16 MoTi	–	–	–	–	NC19KDUN	–	–	–	–	–	Nimonic PK33
–	–	–	NCF 3015	–	–	–	–	–	–	–	–	NiReVa 3015
AISI 686	–	–	–	–	–	–	–	–	–	–	–	R-235
AISI 690	–	–	–	–	–	Z6NKCDT38	–	–	–	–	–	Refractaloy 26
–	–	–	–	–	–	NK10C8W7ATaTD	–	–	–	–	–	René 125
–	–	–	–	–	–	NK15C14D6AWT	–	–	–	–	–	René 65
–	–	–	–	–	–	NC15K15ADT	–	–	–	–	–	René 77
–	–	–	–	–	–	NC14K9T5DWA	–	–	–	–	–	René 80
–	–	–	–	–	–	NC14K8	–	–	–	–	–	René 95
–	NiTa 9 Co 8 W 6 CrAl	–	–	–	–	NTa9K7C6W5A5DT	–	–	–	–	–	TRW VIA
–	NiCr 19 NbMo	–	–	–	–	NC18Fe18Nb6DWT	–	–	–	–	–	Udimet® 630
–	–	–	–	–	–	NCK18TDA	–	–	–	–	–	Udimet 710
–	–	–	–	–	–	NC18K15TDA	–	–	–	–	–	Udimet 720

S4 Workpiece Materials Listing • High-Temp Alloys • S4

S4 Titanium and Titanium Alloys *Tensile Strength RM (MPa)*: 900–1600* *Hardness (HB): 300–400 (HRC): 33–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
R 50250	Ti-99.8	2 TA 1	–	UNS R50250	TA6, TA7, TA8, TA9	AIR:9182T35	–	–	–	ASTM B381F1	3.7025	ATI 30 CP Grade 1
R 50400	Ti-99.7	2 TA 2-5	–	UNS R50400	TA2.5	AIR:9182T40	–	–	–	ASTM B381F2	3.7035	ATI 40 CP Grade 2
–	SG-Ti 2	–	–	–	–	–	–	–	–	–	3.7036	–
R 50550	Ti-99.6	TA 3	–	UNS R50550	TA2, TA3, TA4, TA5	AIR:9182T50	–	–	–	ASTM B381F3	3.7055	ATI 55 CP Grade 3
R 50700	Ti-99.5	2 TA 6-9	–	UNS R50700	–	AIR:9182T60	–	–	–	ASTM B381F4	3.7065	ATI 70 CP Grade 4
–	TiNi 0,8 Mo 0,3	–	–	UNS R53400	–	–	–	–	Ti-3Al-1.5Mn	ASTM Grade 12	3.7105	–
Ti 5Al-2.5Sn	TiAl 5 Sn 2,5	–	–	UNS R54520	TA 14,17	T-A5E	–	–	Ti-5Al-2.5Sn	–	3.7115	ATI Grade 6
–	TiCu 2	2 TA 21-24	–	–	–	–	–	–	Ti-2Cu	–	3.7124	–
R 54620	TiAl 6 Sn 2 Zr 4 Mo 2 Si	–	–	UNS R54620	–	–	–	–	Ti-6Al-2Sn-2Zr-4Mo-2Si	–	3.7145	–
–	TiAl 6 ZrMo 0,5	TA 43	–	–	–	–	–	–	Ti-6-5-0.5	–	3.7155	–
R 56400	TiAl 6 V 4	TA 10-13	TC4	UNS R56400	TA10 TA11 TA12 TA13 TA28 TA56	TA6V	–	–	Ti-6Al-4V	–	3.7164	ATI 6-4™
–	TiAl 6 V4	–	TC4	UNS R56400	TA10 TA11 TA12 TA13 TA28 TA56	TA6V; AIR:9183	–	–	Ti-6Al-4V (Beta)	–	3.7164	–
R 56620	TiAl 6 V 6 Sn2	–	–	UNS R56620	–	–	–	–	Ti-6Al-6V-2Sn	–	3.7175	ATI 6-6-2™
–	TiAl 4 Mo 4 Sn 2	TA 45-51	–	–	–	–	–	–	Ti-4Al-4Mo-2Sn	–	3.7185	–
–	TiAl 3 V2.5	–	–	UNS R56320	–	–	–	–	Ti-3Al-2.5V	ASTM Grade 9	3.7195	ATI 3-2.5-MIL™
R 52250	Ti 1 Pd	TP 1	–	UNS R 52250	–	–	–	–	–	ASTM Grade 11	3.7225	–
R 52400	Ti 2 Pd	–	–	UNS R 52400	–	–	–	–	–	ASTM Grade 7	3.7235	–
–	Ti 3 Pd	–	–	–	–	–	–	–	–	–	3.7255	–
–	TiAl 5 Fe 2,5	–	–	–	–	–	–	–	Ti-5Al-2.5Fe	–	3.7110	–
–	TiV13Cr11Al3	–	–	–	–	–	–	–	Ti-13V-11Cr-3Al	–	–	11/13/03
–	Ti-10V-2Fe-3Al	–	–	–	–	–	–	–	Ti-10.2.3	–	–	ATI 10-2-3™
–	–	–	–	UNS R58153	–	–	–	–	Ti-15-333	–	–	ATI 15-333™
–	–	–	–	–	–	–	–	–	Ti-15Mo (Alpha + Beta)	–	–	ATI 15Mo™ (Alpha + Beta)
–	–	–	–	–	–	–	–	–	Ti-15Mo (Beta)	–	–	ATI 15Mo™ (Beta)
–	Ti5Al2Sn2Zr4Cr4Mo	–	–	UNS R58650	–	–	–	–	–	–	–	ATI 17™
–	TIAl 3 V 8 Cr 6 Mo 4 Z 4	–	–	–	–	–	–	–	Ti-3Al-8V-6Cr-4Mo-4Zr	ASTN Grade 19	–	ATI 38-644™
–	–	–	–	UNS R54250	–	–	–	–	Ti-425	ASTM B265	–	ATI 425®
–	–	–	–	–	–	–	–	–	Ti-425 MIL	–	–	ATI 425®-MIL
–	TiAl 4 Mo 4 Sn 2 Si 0.5	–	–	–	5103	T-A4DE	–	–	Ti-4Al-4Mo-2Sn-0.5Si	–	–	ATI 4-4-2™
–	–	–	–	–	–	–	–	–	Ti-45Nb	–	–	ATI 45Nb™
–	–	–	–	–	–	–	–	–	Ti-5Al-5V-5Mo-3Cr	–	–	ATI 5-5-5-3 PM™
–	–	–	–	–	–	–	–	–	Ti-6Al-2Sn-2Zr-2Mn-2Cr-0.2Si	–	–	ATI 6-2222™
–	–	–	–	UNS R54620	–	–	–	–	Ti-6Al-4Zr-2Mo-2Sn	–	–	ATI 6-2-4-2 PM™
–	TiAl6Zr4Mo2Sn2	–	–	UNS R54620 modified	–	–	–	–	Ti-6Al-4Zr-2Mo-2Sn-0.2Si	–	–	ATI 6-2-4-2-Si PM™
–	–	–	–	UNS R56260	–	–	–	–	Ti-6-2-4-6	–	–	ATI 6-2-4-6™
–	–	–	–	UNS R56401	–	–	–	–	Ti-6Al-4V ELI	–	–	ATI 6-4 ELI™
–	TiAl 6 V4	–	–	UNS R56400	TA10 TA11 TA12 TA13 TA28 TA56	TA6V; AIR:9183	–	–	Ti-6Al-4V MIL	–	–	ATI 6-4-MIL™
–	TiAl 6 V4	–	–	UNS R56400	TA10 TA11 TA12 TA13 TA28 TA56	TA6V; AIR:9183	–	–	Ti-6Al-4V MIL (HT)	–	–	ATI 6-4-MIL™
–	–	–	–	UNS R56700	–	–	–	–	Ti-6-7	ASTM F 1295	–	ATI 6-7™
–	TiAl8Mo1V1	–	–	UNS R54810	–	–	–	–	Ti-8Al-1Mo-1V	–	–	ATI 8-1-1™
–	–	–	–	–	–	–	–	–	Ti-15Mo-3Nb-3Al-0.2Si	ASTM Grade 21	–	Beta 21-S
–	–	–	–	–	–	–	–	–	Ti-12Mo-6Zr-2Fe	–	–	TMZF
–	TiAl7Nb	–	–	–	–	–	–	–	Ti-6Al-7Nb	–	–	–
–	TiAl7Mo4	–	–	–	–	–	–	–	–	ASTM B381	–	–
–	TiAl 4 Mo 4 Sn 4 Si 0.5	–	–	–	5203	–	–	–	Ti-4Al-4Mo-4Sn-0.5Si	–	–	–
–	TiA6Zr5Mo0.5Si0.25	–	–	–	–	T.AGZ.50	–	–	Ti-6Al-5Zr-0.5Mo-0.25Si	–	–	–
–	TiAl6Zr5Mo4CuSi0.2	–	–	–	M201	–	–	–	Ti-6Al-5Zr-4Mo-Cu-0.2Si	–	–	–
–	–	–	TC18	–	–	–	–	–	Ti-5Al-5Mo-5V-1Cr-1Fe	–	–	–
–	–	–	–	UNS %58210	–	–	–	–	Ti Beta 21 S	ASTM Grade 21	–	–
Ti 98.8	Ti 98.8	–	–	–	–	–	–	–	–	–	–	–
Ti 99.9	Ti 99.9	–	–	–	–	–	–	–	–	–	–	–
–	TiAL 6 Sn 2 Zr 4 Mo 2	–	–	–	–	–	–	–	–	–	–	–

NOTE: For legend, see page Y217.

H1 ■ Workpiece Materials Listing • Hardened Steels and Irons • H1

H1 Hardened Materials *Hardness (HRC): 44–48*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
H 11	X 38 CrMoV 5 H1	BH 11	SKD 6	T20811	X 38 CrMoV 5 H1	Z 38 CDV 5	X 37 CrMoV 5 1 KU	–	–	–	1.2343	–
H11	X 38 CrMoV 5 H1	BH 11	SKD 6	T20811	X 38 CrMoV 5 H1	Z 38 CDV 5	X 37 CrMoV 5 1 KU	–	–	–	1.2343	–
H 13	X 40 CrMoV 5 1	BH 13	SKD 61	T20813	X 40 CrMoV 5 1	Z 40 CDV 5	X 40 CrMoV 5 1 1 KU	2242	–	–	1.2344	–
H 10	X 32 CrMoV 3 3	BH 10	SKD 7	T 20810	X 32 CrMoV 12H-28	32 DCV 28	30 CrMoV 12 27 KU	–	–	–	1.2365	–
H19	X 45 CrCoVW 5 5 5	–	–	–	–	–	–	–	–	–	1.2678	–
A 532 I B NiCr-LC	GX 260 NiCr 42	Grade 2 A	0512-00	F45001	GJH-X260NiCr 4-2	–	–	0512-00	–	–	0.9620	–
L6	–	–	–	–	–	55 NCDV 07 (HT)	–	–	–	–	–	–

H2 ■ Workpiece Materials Listing • Hardened Steels and Irons • H2

H2 Hardened Materials *Hardness (HRC): 48–55*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
A 532 I A NiCr-HC	G-X 330 NiCr 42	Grade 2 B	0513-00	F45000	GJH-X330NiCr 4-2	FB Ni 4 Cr2 HC	–	0513-00	–	–	0.9625	–
H 21	X 30 WCrV 93	BH 21	SKD 5	T 20821	X 30 WCrV 9 3	Z 30 WCV 9	X 30 WCrV 9 3 KU	–	–	–	1.2581	–
H 12	X 37 CrMoW 5 1	BH 12	SKD 62	T20812	–	Z 35 CWDV 5	X 35 CrMoW 05 KU	–	–	–	1.2606	–
–	G-X 300 NiMo 3 Mg	–	–	–	GJH-X300NiMo 3 Mg	–	–	–	–	–	0.9610	–
A 532 I B NiCr-LC	GX 260 NiCr 42	Grade 2 A	0512-00	F45001	GJH-X260NiCr 4-2	–	–	0512-00	–	–	0.9620	–
A 532 III A 25% Cr	GX 260 Cr 27	Grade 3 D	0466-00	–	GJH-X260Cr 27	–	–	–	–	–	0.9650	–
–	X 2 NiCoMoTi 180905	–	–	–	–	Z 2 NKD 180905	–	–	–	–	–	Durimphy
K12	–	–	–	–	–	–	–	–	–	–	–	ATI K12 MIL

H3 ■ Workpiece Materials Listing • Hardened Steels and Irons • H3

H3 Hardened Materials *Hardness (HRC): 56–60*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
A 532 IIC15% CrMo-HC	G-X 300CrMo 15 3	Grade 3 A	–	–	GJH-X300CrMo 15-3	–	–	–	–	–	0.9635	–
–	G-X 300 CrMoNi 15 2 1	Grade 3 B	–	F45005	GJH-X300CrMoNi15-2-1	–	–	–	–	–	0.9640	–
A 532 IID20% CrMo-LC	GX 260 CrMoNi 20 2 1	Grade 3 C	–	F45007	GJH-X260CrMoNi20-2-1	–	–	–	–	–	0.9645	–
A 532 III A 25% Cr	G-X 300 CrMo 27 1	Grade 3 E	–	–	GJH-X300CrMo 27-1	–	–	–	–	–	0.9655	–
A 2	X 100 CrMoV 5 1	SKD 12	–	–	BA 2	Z 100 CDV 5 (HT)	X 100 CrMoV 51 KU	2260	–	–	1.2363	–
D7 (HT)	–	–	–	T30407	–	Z 230 CVA 12 04	–	–	–	–	1.2378	–
O 2	90 MnCrV 8	BO 2	–	T31502	90 MnV 8	90 MnV 8	90 MnVCr 8 KU	–	–	–	1.2842	–
A 532 I D Ni-HiCr	G-X 300 CrNiSi 95 2	Grade 2 C	0457-00	F45003	GJH-X300CrNiSi 9-5-2	–	–	–	–	–	0.9630	Nihard type 4
S 1	60 WCrV 7	BS 1	–	–	6020 WCrV 8	55 WC 20	55 WCrV 8 KU	–	–	–	1.2550	–
S 1	60 WCrV 7	BS 1	–	–	60 WCrV 8	55 WC 20	55 WCrV 8 UK	–	–	–	1.2550	–
S 7	50 CrMoV 13 14	–	–	–	–	–	–	–	–	–	–	Cryodur 2357
K 12 (HT)	–	–	–	–	–	–	–	–	–	–	–	ATI K12-MIL

H4 ■ Workpiece Materials Listing • Hardened Steels and Irons • H4

H4 Hardened Materials *Hardness (HRC): >60*

AISI**	DIN	BTS	JIS	UNS	EN	AFNOR	UNI	SIS	SAE	ASTM	Material Number	Manufacturer Reference
W 108	C 80 W 1	–	–	T72301	C 80 U	Y1 90	C 80 KU	1880	–	–	1.1525	–
D 2	X 155 CrVMo 12 1	BD 2	SKD §§	T 30402	X 153 CrMoV 12	Z 160 CDV 12	X 155 CrVMo 12 1 KU	2310	–	–	1.2379	–
–	100 WV4	–	SKS 21	–	–	–	–	–	–	–	1.2515	–
D 3	X 210 Cr 12	BD 3	SKD 1	T30403	X 210 Cr 1 2	Z 200 C 12	X 205 Cr 12 KU	–	–	–	1.2080	–
O 7	110 WCrV 5	–	–	–	–	–	–	–	–	–	–	–
–	Mh97 + Pb	–	–	–	–	–	–	–	–	–	–	LAW 100 Pb

■ Workpiece Materials Listing Legend

* 1 Mpa = 145 psi.
** Includes ASTM and SAE material specifications.
AISI — American Iron and Steel Institute
AFNOR — French National Organisation for Standardisation
AMS — Aerospace Material Specifications
ASTM — American Society of Mechanical Engineers
BS — British Standards
DIN — German Institute for Standardisation
EN — European Standards
JIS — Japanese Industrial Standards
SAE — Society of Automotive Engineers
SIS — Swedish Standards Institute
UNI — Italian Organisation for Standardisation
UNS — Unified Numbering System

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METALCUTTING SAFETY

IMPORTANT SAFETY INSTRUCTIONS

Read before using the tools in this catalogue!

Projectile and Fragmentation Hazards:

Modern metalcutting operations involve high spindle and cutter speeds and high temperatures and cutting forces. Hot metal chips may fly off the workpiece during metalcutting. Although cutting tools are designed and manufactured to withstand high cutting forces and temperatures, they can sometimes fragment, particularly if they are subjected to over-stress, severe impact, or other abuse.

To avoid injury:

- Always wear appropriate personal protective equipment, including safety goggles, when operating metalcutting machines or working nearby.
- Always make sure all machine guards are in place.

Breathing and Skin Contact Hazards:

Grinding carbide or other advanced cutting tool materials produces dust or mist containing metallic particles. Breathing this dust or mist — especially over an extended period — can cause temporary or permanent lung disease or make existing medical conditions worse. Contact with this dust or mist can irritate eyes, skin, and mucous membranes and may make existing skin conditions worse.

To avoid injury:

- Always wear breathing protection and safety goggles when grinding.
- Provide ventilation control and collect and properly dispose of dust, mist, or sludge from grinding.
- Avoid skin contact with dust or mist.

For more information, read the applicable Material Safety Data Sheet provided by Kennametal and consult General Industry Safety and Health Regulations, Part 1910, Title 29 of the Code of Federal Regulations.

These safety instructions are general guidelines. Many variables affect machining operations. It is impossible to cover every specific situation. The technical information included in this catalogue and recommendations on machining practices may not apply to your particular operation. For more information, consult the Kennametal Metalcutting Safety booklet, available free from Kennametal at 724 539 5747 or fax 724 539 5439. For specific product safety and environmental questions, contact our Corporate Environmental Health and Safety Office at 724 539 5066 or fax 724 539 5372.

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