



Indexable Milling • Slot Milling

KTMS • T-Slot Platform	U2–U5
KVNS • Very-Narrow Slotting Platform.....	U6–U10
SN • Popular Square Inserted Cutter	U12–U15
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➤ KTMS™ Slotting Cutter

Primary Application

KTMS slotting cutters produce “T” slots in machine beds as well as small radial depths of cut for machining shallow radial slots. There is always a need to prepare the slot before using this type of cutter — preparation is the key to success.

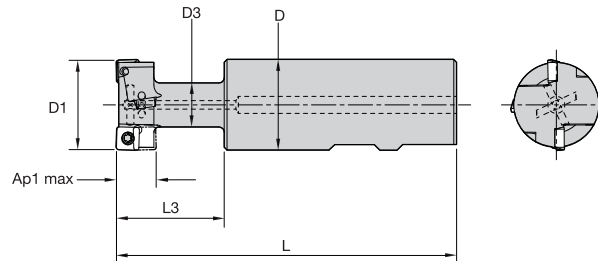
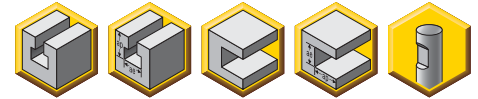
See the technical information for information about the pre-machining on page U5.

Features and Benefits

- Only available in metric dimensions.
- Slot widths from 9–22mm.
- Three different insert sizes.
- Preparing the component before slotting is the key to success.
- Prepare workpiece with a slot.
- Honed insert edges.
- Feed rates between 0,10–0,15mm; lower feed rates will induce vibration.
- Use air flow to evacuate chips.
- Always start the cutting process with a new cutting edge.



- Prepare workpiece with a slot.
- Honed insert edges.
- Feed rates between 0,10–0,15mm;
lower feed rates will induce vibration.
- Use air flow to evacuate chips.
- Always start the cutting process with
a new cutting edge.



■ KTMS • T-Slot Cutter with Through Coolant • Metric

order number	catalogue number	D1	D	D3	L	L3	Ap1 max	Z	Z U	insert 1	kg
3577119	KTMS21S25SD06H	21	25	11	109	29	9,0	2	1	SDMT060304EGG	0,35
3577121	KTMS25S25SD06H	25	25	13	112	32	11,0	4	2	SDMT060304EGG	0,36
3577133	KTMS32S32SD08H	32	32	16	120	38	14,0	4	2	SDMT080308EGG	0,60
3577135	KTMS40S32SD12H	40	32	21	130	50	18,0	4	2	SDMT120408EGG	0,66
3577137	KTMS50S32SD12H	50	32	27	140	60	22,0	4	2	SDMT120408EGG	0,85

■ Spare Parts



D1	insert screw	Nm	Torx driver
21	MS2206	1,2	DT8
25	MS2206	1,2	DT8
32	MS2207	2,0	DT10
40	MS2208	3,5	DT15
50	MS2208	3,5	DT15

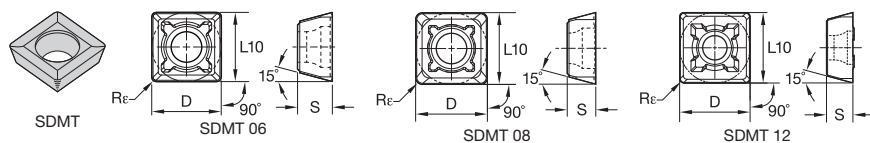
Slot Milling

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance				toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	..EGG	KC735M	..EGG	KC735M	..EGG	KC735M
P3-P4	..EGG	KC735M	..EGG	KC735M	..EGG	KC735M
P5-P6	..EGG	KC735M	..EGG	KC735M	..EGG	KC735M
M1-M2	-	-	-	-	-	-
M3	-	-	-	-	-	-
K1-K2	..EGG	KC505M	..EGG	KC505M	..EGG	KC505M
K3	..EGG	KC505M	..EGG	KC505M	..EGG	KC505M
N1-N2	-	-	-	-	-	-
N3	-	-	-	-	-	-
S1-S2	-	-	-	-	-	-
S3	-	-	-	-	-	-
S4	-	-	-	-	-	-
H1	-	-	-	-	-	-

Indexable Insert • T-Slot Cutters SDMT • EGG

- Honed insert edges.
- Four cutting edges.



- first choice
- alternate choice

P	●	●	●
M	●	●	●
K	●	●	●
N	●	●	●
S	●	●	●
H	●	●	●
	KC505M	KC730M	KC735M

SDMT-EGG

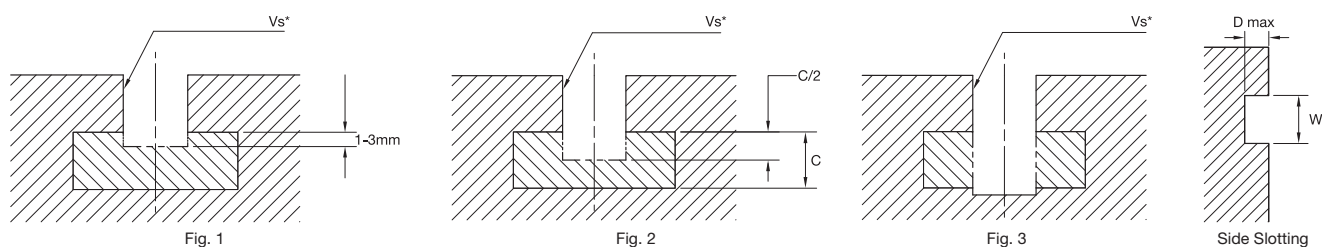
catalogue number	D	S	L10	Rε	hm	cutting edges	KC505M	KC730M	KC735M
SDMT060304EGG	6,35	3,18	6,35	0,4	0,06	4	●	●	●
SDMT080308EGG	8,00	3,18	8,00	0,8	0,06	4	●	●	●
SDMT120408EGG	12,70	4,76	12,70	0,8	0,06	4	●	●	●

Recommended Starting Feeds

Recommended Starting Feeds [mm]

■ Recommended Starting Feeds [mm]											Light Machining			General Purpose			Heavy Machining		
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry			
	5%			10%			20%			30%			40–100%						
.06..EGG	0,20	0,46	0,70	0,14	0,33	0,50	0,11	0,25	0,38	0,09	0,22	0,33	0,08	0,20	0,30	.06..EGG			
.08..EGG	0,20	0,53	0,82	0,14	0,38	0,59	0,11	0,29	0,44	0,09	0,25	0,39	0,08	0,23	0,35	.08..EGG			
.12..EGG	0,20	0,59	0,92	0,14	0,43	0,66	0,11	0,32	0,50	0,09	0,28	0,43	0,08	0,25	0,40	.12..EGG			

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22-X37 for recommended starting speeds.



■ Steel

- Machining a vertical slot, depth to be kept at a minimum as shown in Figure 1.
- If the depth is greater than Figure 1, chip evacuation problems could occur.
- Vibrations could occur when the T-slot cutter diameter increases; use Figure 1 as the starting point.
- If chattering is a concern, adopt the Figure 2 solution.

■ Cast Iron

- Fewer problems with chip evacuation and reduced cutting forces enable deeper vertical slots as shown in Figures 2 and 3.
- Air blast is recommended to disperse the chips; this can be used for steel and cast iron.

■ Cutting Data Table • Slotting

	material type	catalogue number	cutting conditions vc (m/min)	feed per tooth (mm)	Vs*
P	carbon steel/ alloy steel	KTMS21S25SD06H	120	0,10	Figure 1
		KTMS25S25SD06H	120	0,10	Figure 1
		KTMS32S32SD08H	100	0,10	Figure 1
		KTMS40S32SD12H	80	0,15	Figure 2
		KTMS50S32SD12H	not recommended due to frequent chattering		
K	cast iron	KTMS21S25SD06H	120	0,12	Figure 1, 2, 3
		KTMS25S25SD06H	120	0,12	Figure 1, 2, 3
		KTMS32S32SD08H	120	0,12	Figure 1, 2, 3
		KTMS40S32SD12H	120	0,12	Figure 2,3
		KTMS50S32SD12H	120	0,15	Figure 3

* Vs = Vertical slot preparation for T-slot.

■ Side Slot Machining

side slot dimension	W -0.1 / -0.3 mm	D max mm
KTMS21S25SD06H	9	4,4
KTMS25S25SD06H	11	5,4
KTMS32S32SD08H	14	6,9
KTMS40S32SD12H	18	8,9
KTMS50S32SD12H	22	10,9

NOTE: KTMS T-slot is available to side slot as per drawing.

■ Cutting Data • Side Machining

	material type	catalogue number	cutting conditions vc (m/min)	n (RPM)	feed per tooth (mm)
P	carbon steel/ alloy steel	KTMS21S25SD06H	120	1820	0,10
		KTMS25S25SD06H	120	1530	0,10
		KTMS32S32SD08H	120	1190	0,10
		KTMS40S32SD12H	120	960	0,10
		KTMS50S32SD12H	120	760	0,10
K	cast iron	KTMS21S25SD06H	150	2270	0,12
		KTMS25S25SD06H	150	1910	0,12
		KTMS32S32SD08H	150	1490	0,12
		KTMS40S32SD12H	150	1190	0,15
		KTMS50S32SD12H	150	960	0,15

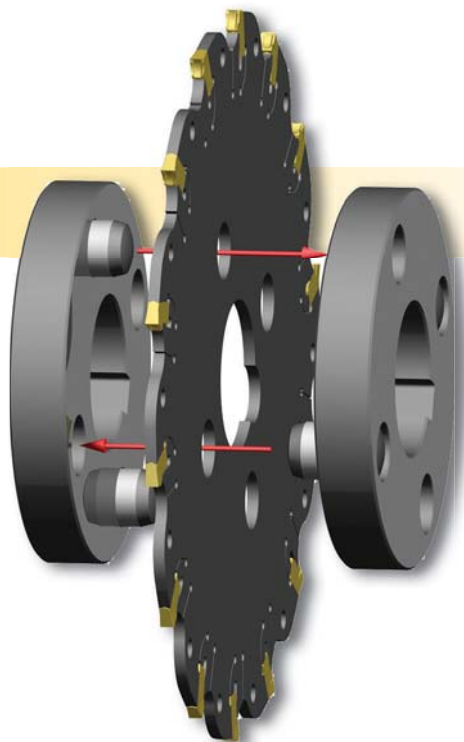
➤ KVNS™ Slotting Cutter

Primary Application

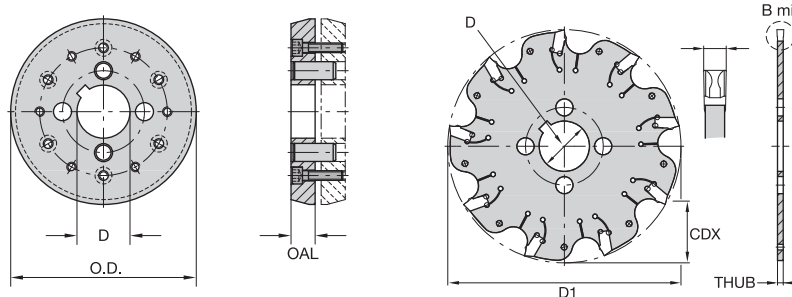
The KVNS slotting cutter enables diameters from 63–250mm and insert widths from 1,6–4mm. It is a perfect solution for small groove widths, grades, and geometries and suits most materials. Drive rings and support rings are available; use these items to get the maximum support for the cutter body.

Features and Benefits

- Slot widths from 1,6–4mm.
- Grades and geometries to suit most workpiece materials.
- Positive chipforming inserts are standard.
- Self-clamping inserts.
- Self-clamping insert seat with fixed stop.
- Excellent for all flat-bottom slotting and cut-off operations.
- Two drive hubs are required for each cutter body, except when using two drive supports.
- Drive rings and support rings available, must be ordered separately (in pairs).



- Positive chip forming inserts are standard.
- Self-clamping insert seat with fixed stop.
- Excellent for all flat-bottom slotting and cut-off operations.
- Two drive rings required for each cutter body (must be ordered separately, in pairs).



■ A2 • Cutting Width 1,6mm

order number	catalogue number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	kg
1246114	4.97060116	63	16	1,6	15,0	1,3	5	5100	3.90016	1177888	0,03
1246122	4.97080116	80	16	1,6	21,0	1,3	7	4000	3.90016	1247091	0,04
1246131	4.97101116	100	22	1,6	27,0	1,3	9	3200	3.90016	1247085	0,07
1246138	4.97123116	125	32	1,6	35,0	1,3	11	2600	3.90016	1247087	0,10

■ A2 • Cutting Width 2,2mm

order number	catalogue number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	kg
1246124	4.97080122	80	16	2,2	21,0	1,8	7	4000	3.90022	1247091	0,05
1246132	4.97101122	100	22	2,2	27,0	1,8	9	3200	3.90022	1247085	0,08
1246140	4.97123122	125	32	2,2	35,0	1,8	11	2600	3.90022	1247087	0,12
1246147	4.97164122	160	40	2,2	40,0	1,8	14	2000	3.90022	1247082	0,30



■ A2 • Cutting Width 3mm

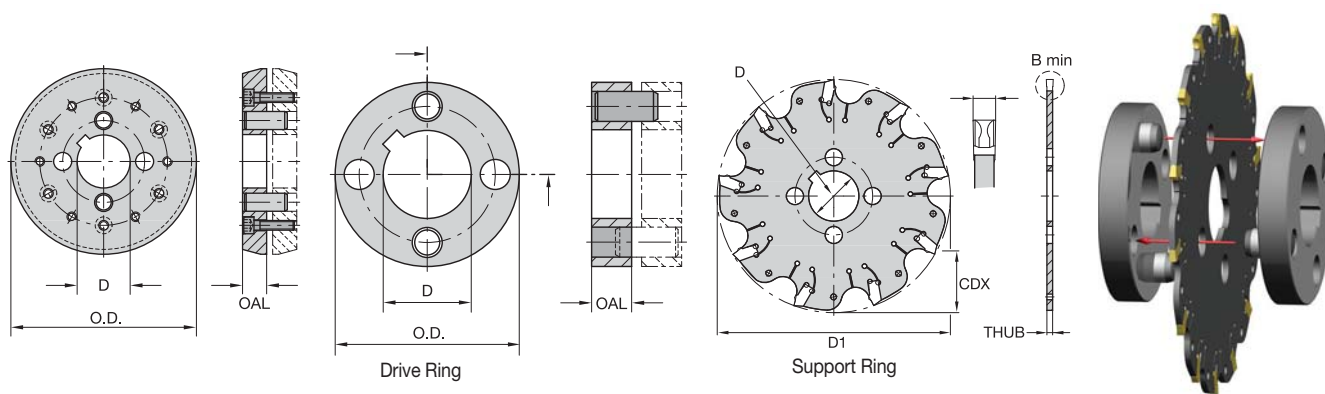
order number	catalogue number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	kg
1246118	4.97060130	63	16	3,0	15,0	2,4	4	5100	3.90030	1247088	0,05
1246126	4.97080130	80	16	3,0	21,0	2,4	6	4000	3.90030	1247091	0,08
1246134	4.97101130	100	22	3,0	27,0	2,4	9	3200	3.90030	1247085	0,13
1246142	4.97123130	125	32	3,0	35,0	2,4	11	2600	3.90030	1247087	0,20
1246149	4.97164130	160	40	3,0	40,0	2,4	14	2000	3.90030	1247082	0,35
1246153	4.97204130	200	40	3,0	60,0	2,4	19	1600	3.90030	1247082	0,50
1246157	4.97254130	250	40	3,0	85,0	2,4	24	1300	3.90030	1247082	0,80



■ A2 • Cutting Width 4mm

order number	catalogue number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	kg
1246120	4.97060140	63	16	4,0	15,0	3,4	4	5100	3.90040	1247088	0,06
1246129	4.97080140	80	16	4,0	21,0	3,4	6	4000	3.90040	1247091	0,10
1246136	4.97101140	100	22	4,0	27,0	3,4	9	3200	3.90040	1247085	0,15
1246145	4.97123140	125	32	4,0	35,0	3,4	11	2600	3.90040	1247087	0,25
1246150	4.97164140	160	40	4,0	40,0	3,4	14	2000	3.90040	1247082	0,40
1246154	4.97204140	200	40	4,0	60,0	3,4	19	1600	3.90040	1247082	0,65





■ Drive Rings

order number	D1	O.D.	OAL	bore size	drive ring	kg
1177888	63	32	8	16	460.889	0,03
1247088	63	32	8	16	460.898	0,04
1247091	80	38	8	16	460.899	0,06
1247085	100	46	10	22	460.890	0,10
1247087	125	55	10	32	460.897	0,12
1247082	160	80	12	40	460.888	0,34
1247082	200	80	12	40	460.888	0,34
1247082	250	80	12	40	460.888	0,34

■ Support Rings



D1	order number	support ring	bore size	CDX	O.D.	OAL	clamp screw	Allen key	Allen key size	kg
200	1247080	460.887	40	30	140	12	125.616	170.005	5mm	1,15
250	1247080	460.887	40	55	140	12	125.616	170.005	5mm	1,15
250	1247078	460.886	40	30	190	12	125.616	170.005	5mm	2,35

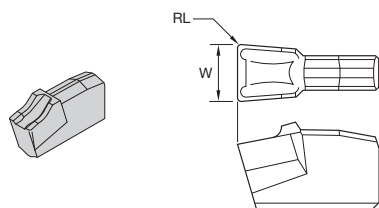
NOTE: For CDX value, refer to drive ring and support ring tables.
Insert wrench 170.183 (order code 1124601) must be ordered separately

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance ←————→ toughness					
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.S..GD	KC735M	.S..GD	KCPK30	.S..GB	KCPK30
P3–P4	.S..GD	KC735M	.S..GD	KCPK30	.S..GB	KCPK30
P5–P6	.S..GD	KC735M	.S..GB	KCPK30	.S..GB	KCPK30
M1–M2	.S..GD	KC735M	.S..GD	KCPK30	.S..GB	KCPK30
M3	.S..GD	KCPK30	.S..GB	KCPK30	.S..GB	KCPK30
K1–K2	.S..GD	KCPK30	.S..GD	KCPK30	.S..GB	KCPK30
K3	.S..GD	KCPK30	.S..GD	KCPK30	.S..GB	KCPK30
N1–N2	.E..GD	KMF	.E..GD	KMF	.E..GD	KMF
N3	.E..GD	KMF	.E..GD	KMF	.E..GD	KMF
S1–S2	.E..GD	KMF	.E..GD	KMF	.E..GD	KMF
S3	.E..GD	KMF	.E..GD	KMF	.E..GD	KMF
S4	.E..GD	KMF	.E..GD	KMF	.E..GD	KMF
H1	–	–	–	–	–	–

Indexable Inserts • KVNS A2

- Very narrow slotting/slitting operations.
- Positive chipforming insert geometry.



- first choice
- alternate choice

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

1,6mm

catalogue number	W	RL	hm	KC735M	KCPK30	KMF
3.90016ECGD	1,60	0,15	0,08	○	○	○
3.90016SNGB	1,60	0,15	0,08	●	●	○
3.90016SNGD	1,60	0,15	0,08	●	●	○

2,2mm

catalogue number	W	RL	hm	KC735M	KCPK30	KMF
3.90022ECGD	2,20	0,20	0,08	○	○	○
3.90022SNGB	2,20	0,20	0,08	●	●	○
3.90022SNGD	2,25	0,20	0,08	●	●	○

3mm

catalogue number	W	RL	hm	KC735M	KCPK30	KMF
3.90030ECGD	3,05	0,20	0,08	○	○	○
3.90030SNGB	3,05	0,20	0,08	●	●	○
3.90030SNGD	3,05	0,20	0,08	●	●	○

4mm

catalogue number	W	RL	hm	KC735M	KCPK30	KMF
3.90040ECGD	4,05	0,20	0,08	○	○	○
3.90040SNGB	4,05	0,20	0,08	●	●	○
3.90040SNGD	4,05	0,20	0,08	●	●	○

■ Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
--------------------	--------------------	--------------------

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry	
	5%			10%			20%			30%			40–100%			
.E..GD	0,23	0,41	0,63	0,17	0,29	0,46	0,13	0,22	0,34	0,11	0,19	0,30	0,10	0,18	0,27	.E..GD
.S..GD	0,23	0,46	0,71	0,17	0,33	0,51	0,13	0,25	0,38	0,11	0,22	0,33	0,10	0,20	0,30	.S..GD
.S..GB	0,23	0,46	0,74	0,17	0,33	0,54	0,13	0,25	0,40	0,11	0,22	0,35	0,10	0,20	0,32	.S..GB

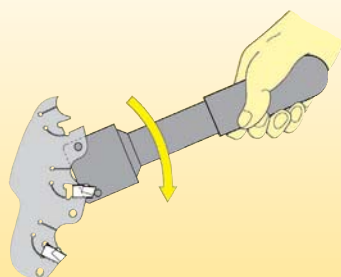
NOTE: Use "Light Machining" values as starting feed rate.

% = $ae/Dc \cdot 100$ (ae = radial depth of cut, Dc = cutting diameter)

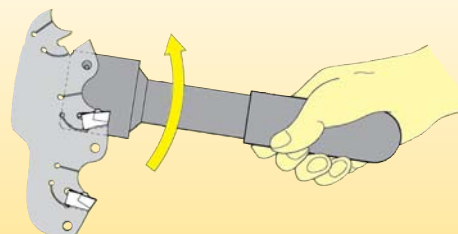
Please see pages X22-X37 for recommended starting speeds.

Slotting Cutters • Technical Information

■ Secure clamping self-clamping insert seat for maximum machining safety



Using the assembly wrench:
Fitting the insert



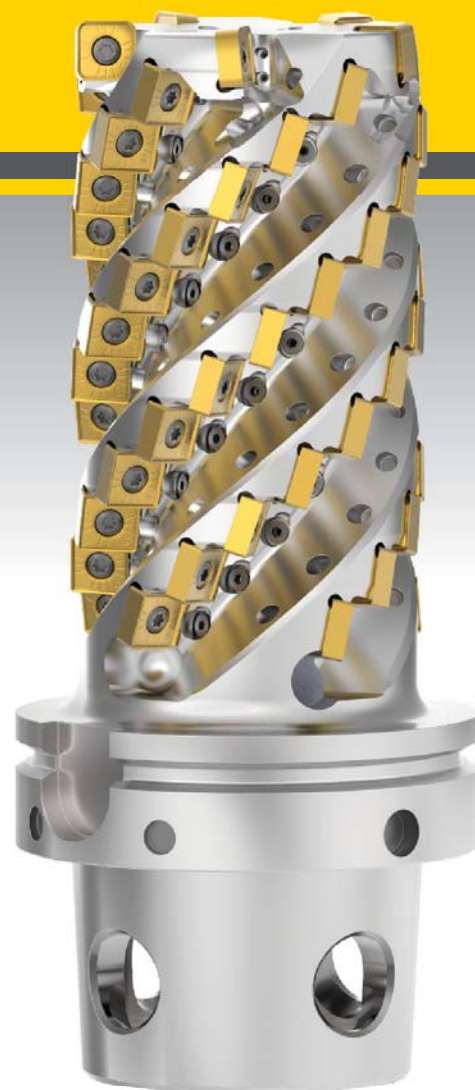
Removing the insert

- Exact position of the insert guaranteed by the positive stop.
- Maximum possible insert repeatability with dual positive prism clamping.
- Powerful, secure clamping guarantees high peripheral speeds.

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Achieving maximum metal removal rates with highly engineering solutions from Kennametal.

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 - 7713 Series
 - 7792 Series
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- KCSM40 milling grade is the first choice for high metal removal jobs in titanium structural aerospace components.
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➤ SN Slotting Cutter

Primary Application

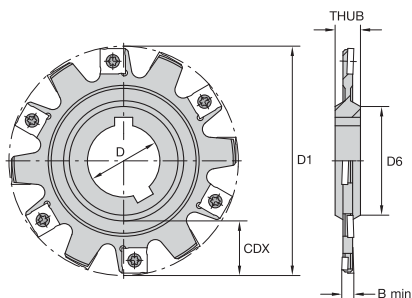
SN slotting cutters are perfect for deeper applications that require the cutting load to be shared from one insert to the other. Provides groove widths from 4–14mm and cutter diameters from 80–250mm as well as an economical way to achieve balanced cutting.

Features and Benefits

- Cutters available in arbour mount.
- Inserts with four indexes.
- Staggered key ways in mounting bore, used for multiple ganged cutters.
- Slot width 4–14mm.
- Three insert geometries available: -GP, -GE, and -T.
- Requires only one spare part.



- 4–14mm slot widths range.
- Four indexes per insert.
- Three chip formers available.
- Two keyways for staggered mounting.
- Requires only one spare part.



■ SN • Arbour Mount • Full-Side Cutting

order number	catalogue number	D1	D	D6	B min	CDX	THUB	Z	Z S	insert 1	kg
1244389	4.96082-204	80	27	45	4,0	15	12,0	10	5	SNHX1102__	0,30
1191306	4.96102-204	100	27	45	4,0	25	12,0	12	6	SNHX1102__	0,40
1244398	4.96102-205	100	27	45	5,0	25	12,0	12	6	SNHX11T3__	0,40
1244368	4.96102-206	100	27	45	6,0	25	12,0	10	5	SNHX1203__	0,40
1244370	4.96124-204	125	40	58	4,0	30	12,0	14	7	SNHX1102__	0,50
1244371	4.96124-205	125	40	58	5,0	30	12,0	14	7	SNHX11T3__	0,60
1244374	4.96124-210	125	40	58	10,0	30	12,0	12	6	SNHX12L5__	0,80
1244375	4.96124-212	125	40	58	12,0	30	12,0	12	4	SNHX12L5__	0,90
1244394	4.96164-204	160	40	68	4,0	44	12,0	18	9	SNHX1102__	0,90
1244376	4.96164-205	160	40	68	5,0	44	12,0	18	9	SNHX11T3__	0,90
1244379	4.96164-210	160	40	68	10,0	44	12,0	16	8	SNHX12L5__	1,40
1244395	4.96205-208	200	50	72	8,0	62	12,0	18	6	SNHX1203__	1,80
1244385	4.96255-206	250	50	72	6,0	86	12,0	24	12	SNHX1203__	4,20
1244386	4.96255-208	250	50	72	8,0	86	12,0	24	8	SNHX1203__	4,50

■ Spare Parts



order number	D1	B min	insert screw	Nm	Torx driver
1244389	80	4	192.529	1,0	170.023
1191306	100	4	192.529	1,0	170.023
1244398	100	5	192.530	1,0	170.023
1244368	100	6	192.531	3,0	170.025
1244370	125	4	192.529	1,0	170.023
1244371	125	5	192.530	1,0	170.023
1244374	125	10	192.532	3,0	170.025
1244375	125	12	192.532	3,0	170.025
1244394	160	4	192.529	1,0	170.023
1244376	160	5	192.530	1,0	170.023
1244379	160	10	192.532	3,0	170.025
1244395	200	8	192.531	3,0	170.025
1244385	250	6	192.531	3,0	170.025
1244386	250	8	192.531	3,0	170.025

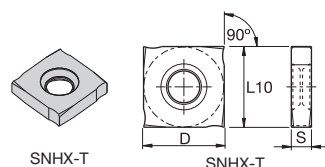
Slot Milling

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance				toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	.T..GP	KCPM40	.T..GP	KCPM40	..T	KCPM40
P3-P4	.T..GP	KCPK30	.T..GP	KCPM40	..T	KCPM40
P5-P6	.T..GP	KCPK30	..T	KCPK30	..T	KCPM40
M1-M2	.T..GP	KC725M	.T..GP	KC725M	..T	KC725M
M3	.T..GP	KCPM40	.T..GP	KCPM40	..T	KCPM40
K1-K2	..T	KC520M	..T	KC520M	..T	KC520M
K3	.T..GP	KCPK30	.T..GP	KCPK30	..T	KCPK30
N1-N2	.F..GE	KC510M	.F..GE	KC510M	.T..GP	K110M
N3	.T..GP	K110M	.T..GP	K110M	.T..GP	K110M
S1-S2	.T..GP	KC725M	.T..GP	KC725M	..T	KC725M
S3	.T..GP	KCPM40	.T..GP	KCPM40	..T	KCPM40
S4	.T..GP	KC725M	..T	KC725M	..T	KC725M
H1	.F..GE	KC510M	-	-	-	-

Indexable Inserts • SNHX-T • SNHX-NGE

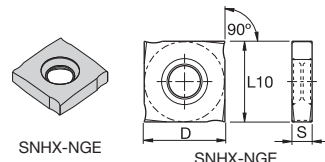
- Medium to heavy machining.
- With T-land geometry.
- Four cutting edges.



SNHX-T

catalogue number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
SNHX1102T	11,00	2,30	11,00	0,16	4	-	-	-	•	-	•
SNHX1103T	11,00	2,70	11,00	0,16	4	-	-	-	•	•	•
SNHX1203T	12,70	3,20	12,70	0,16	4	-	-	-	•	-	•
SNHX1204T	12,70	4,00	12,70	0,11	4	-	-	-	•	-	-
SNHX12045T	12,70	4,50	12,70	0,11	4	-	-	-	•	-	-
SNHX1205T	12,70	5,40	12,70	0,11	4	-	-	-	•	-	-

- Positive geometry for lighter machining.
- Four cutting edges.



SNHX-NGE

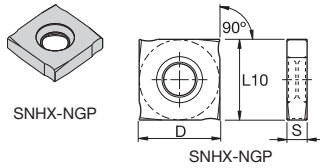
catalogue number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
SNHX11T3PZFNGE	11,00	2,70	11,00	0,05	4	-	•	-	-	-	-
SNHX1203PZFNGE	12,70	3,20	12,70	0,04	4	-	•	-	-	-	-
SNHX12L5PZFNGE	12,70	5,40	12,70	0,04	4	•	•	-	-	-	-

P	•	•	•	•	•	•
M	•	•	•	•	•	•
K	•	•	•	•	•	•
N	•	•	•	•	•	•
S	•	•	•	•	•	•
H	•	•	•	•	•	•

• first choice

○ alternate choice

- Four cutting edges.
- High-feed capabilities up to 55 HRC.



- first choice
- alternate choice

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

■ SNHX-NGP

catalogue number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
SNHX1102PZTNGP	11,00	2,30	11,00	0,14	4	●	-	-	●	●	●
SNHX11T3PZTNGP	11,00	2,70	11,00	0,14	4	-	-	-	●	-	-
SNHX1203PZTNGP	12,70	3,20	12,70	0,14	4	●	-	-	●	●	●
SNHX12L4PZTNGP	12,70	4,00	12,70	0,14	4	-	-	-	●	●	-
SNHX12L5PZTNGP	12,70	5,40	12,70	0,14	4	●	-	-	●	●	-

Recommended Starting Feeds

■ Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
-----------------	-----------------	-----------------

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry	
	5%			10%			20%			30%			40–100%			
.F..GE	0,13	0,42	0,70	0,09	0,30	0,50	0,07	0,23	0,38	0,06	0,20	0,33	0,06	0,18	0,30	.F..GE
.T..GP	0,23	0,47	0,70	0,17	0,34	0,50	0,13	0,25	0,38	0,11	0,22	0,33	0,10	0,20	0,30	.T..GP
..T	0,23	0,56	0,82	0,17	0,40	0,59	0,13	0,30	0,44	0,11	0,26	0,38	0,10	0,24	0,35	..T

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22-X37 for recommended starting speeds.

➤ LN Slotting Cutter

Primary Application

LN slotting cutters offer arbour and shell mill cutter options, groove widths from 6–13mm, and cutter diameters from 80–160mm. Easy to adjust radially in 0,50mm increments.

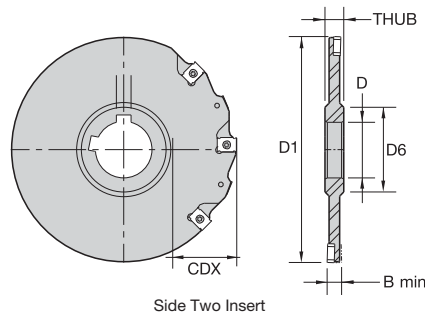


Features and Benefits

- Cutter available in arbour and shell mounts.
- Groove width 6–13mm.
- Groove width can be increased by 0,5mm or 1mm. Please consult the chart “Technical Information: Possible Insert Combinations”.
NOTE: This involves changing inserts and insert screws.
- Easy width adjustment through insert thickness.
- Staggered internal keys.
- Positive chip grooves.
- Full side cutting.
- Neutral and positive chip forming inserts are standard.
- Four insert cutting edges.
- Requires only one spare part.



- 6–13mm slot width range.
- Easy width adjustment through insert thickness.
- Full side cutting.
- Neutral and positive chip forming inserts are standard.
- Four insert cutting edges.
- Two keyways for staggered mounting.
- Requires only one spare part.
- Base slot angle: 2°
- Maximum slot width tolerance: +/- 0,05mm



■ LN • Arbour Mount • Full-Side Cutting

order number	catalogue number	D1	D	D6	B min	CDX	THUB	Z	Z S	insert 1	kg
1131438	80F08NS90LN12N06	80	27	44	6	16	12,0	8	4	LNE_1235__	0,30
1131447	80F08NS90LN12N08	80	27	44	8	16	12,0	8	4	LNE_1245__	0,35
1150508	100G10NS90LN12N06	100	32	52	6	22	12,0	10	5	LNE_1235__	0,40
1130249	100G10NS90LN12N08	100	32	52	8	22	12,0	10	5	LNE_1245__	0,50
1130477	125H12NS90LN12N06	125	40	63	6	30	12,0	12	6	LN_1235	0,70
1130615	160H16NS90LN12N06	160	40	63	6	46	12,0	16	8	LNE_1235__	1,10
1130595	160H15NS90LN12N10	160	40	63	10	46	12,0	15	5	LNE_1245	1,60
1130608	160H15NS90LN12N12	160	40	63	12	46	12,0	15	5	LNE_1255__	1,60
1150527	200J18NS90LN12N08 *	200	50	75	8	60	12,0	18	9	LNE_1245__	2,00

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

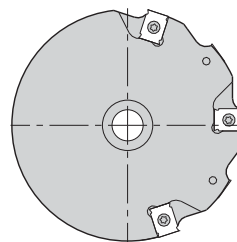
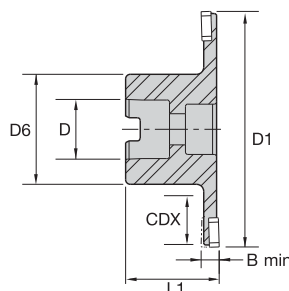
■ Spare Parts



order number	D1	B min	insert screw	Nm	Torx driver
1131438	80	6	MS1280	3,0	DT15
1131447	80	8	MS1282	3,0	DT15
1150508	100	6	MS1280	3,0	DT15
1130249	100	8	MS1282	3,0	DT15
1130477	125	6	MS1280	3,0	DT15
1130615	160	6	MS1280	3,0	DT15
1130595	160	10	MS1282	3,0	DT15
1130608	160	12	MS1284	3,0	DT15
1150527	200	8	MS1282	3,0	DT15

Slot Milling

- 6–11mm slot width range.
- Easy width adjustment through insert thickness.
- Right-hand and full-side cutting versions.
- Neutral and positive chip forming inserts are standard.
- Four insert cutting edges.
- Requires only one spare part.
- Base slot angle: 2°.
- Maximum slot width tolerance: +/- 0,05mm.



■ LN • Shell Mount • Full-Side Cutting

order number	catalogue number	D1	D	D6	B min	CDX	L1	Z	Z U	insert 1	kg
1131463	80Y08RS90LN12N06	80	22	40	6	16,00	50,0	8	4	LNE_1235__	0,65
1131472	80Y08RS90LN12N08	80	22	40	8	16,00	50,0	8	4	LNE_1245__	0,75
1130277	100Y10RS90LN12N06	100	27	50	6	22,00	50,0	10	5	LNE_1235__	1,00
1130283	100Y10RS90LN12N08	100	27	50	8	22,00	50,0	10	5	LNE_1245__	1,20
1130506	125Y12RS90LN12N10	125	40	70	10	26,00	50,0	12	4	LNE_1245__	1,50
1150511	160Y16RS90LN12N06	160	40	70	6	43,00	50,0	16	8	LNE_1235__	1,85
1150513	160Y16RS90LN12N08	160	40	70	8	43,00	50,0	16	8	LNE_1245__	2,15
1150524	160Y15RS90LN12N10	160	40	70	10	43,00	50,0	15	5	LNE_1245__	2,45

■ Spare Parts



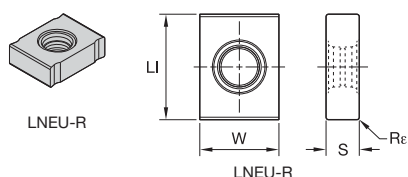
order number	D1	B min	insert screw	Nm	Torx driver
1131463	80	6	MS1280	3,0	DT15
1131472	80	8	MS1282	3,0	DT15
1130277	100	6	MS1280	3,0	DT15
1130283	100	8	MS1282	3,0	DT15
1130506	125	10	MS1282	3,0	DT15
1150511	160	6	MS1280	3,0	DT15
1150513	160	8	MS1282	3,0	DT15
1150524	160	10	MS1282	3,0	DT15

Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance				toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	LNE..	KCPM40	LNE..	KCPM40	.S..GP	KCPM40
P3-P4	LNE..	KCPK30	LNE..	KCPM40	.S..GP	KCPM40
P5-P6	LNE..	KC725M	.S..GP	KC725M	.S..GP	KCPM40
M1-M2	LNE..	KC725M	LNE..	KC725M	.S..GP	KC725M
M3	LNE..	KC725M	LNE..	KCPM40	.S..GP	KCPM40
K1-K2	LNE..	KC520M	LNE..	KCK15	LNE..	KCK15
K3	LNE..	KC520M	LNE..	KCK15	LNE..	KCPK30
N1-N2	-	-	-	-	-	-
N3	-	-	-	-	-	-
S1-S2	LNE..	KC725M	LNE..	KC725M	.S..GP	KC725M
S3	LNE..	KC725M	LNE..	KCPM40	.S..GP	KCPM40
S4	LNE..	KC725M	.S..GP	KC725M	.S..GP	KC725M
H1	-	-	-	-	-	-

Slotting Mills • 90° LN Slot LNEU

- Light machining.
- Four cutting edges.



- first choice
- alternate choice

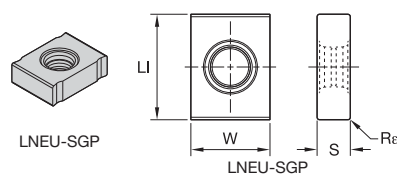
P	•	•	•	•
M	•	•	○	○
K	•	•	○	○
N	•	•	•	•
S	•	•	•	•
H	•	•	•	•

LNEU-R

catalogue number	LI	W	S	Rε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40
LNEU1235R03 4	12,70	9,52	3,50	0,3	0,05	4	•	•	-	-	•
LNEU1240R03 4	12,70	9,52	4,00	0,3	0,05	4	•	•	-	-	•
LNEU1245R04	12,70	9,52	4,50	0,4	0,05	4	•	•	-	•	•
LNEU1250R04	12,70	9,52	5,00	0,4	0,04	4	-	•	-	-	-
LNEU1250R04	12,70	9,52	5,00	0,4	0,05	4	-	-	-	-	•
LNEU1255R04	12,70	9,52	5,50	0,4	0,04	4	-	•	-	-	•
LNEU1260R04	12,70	9,52	6,00	0,4	0,04	4	-	•	-	-	•
LNEU1240R08 4	12,70	9,52	4,00	0,8	0,04	4	•	•	-	-	•
LNEU1245R08	12,70	9,52	4,50	0,8	0,04	4	•	•	-	-	•
LNEU1250R08	12,70	9,52	5,00	0,8	0,04	4	-	•	-	-	-
LNEU1250R08	12,70	9,52	5,00	0,8	0,05	4	-	-	-	-	•
LNEU1255R08	12,70	9,52	5,50	0,8	0,04	4	•	•	-	-	•
LNEU1240R16 4	12,70	9,52	4,00	1,6	0,04	4	-	•	-	-	-
LNEU1245R16	12,70	9,52	4,50	1,6	0,04	4	•	•	-	-	-
LNEU1255R16	12,70	9,52	5,50	1,6	0,04	4	-	•	-	-	-
LNEU1245R32	12,70	9,52	4,50	3,2	0,04	4	•	•	-	-	-
LNEU1255R32	12,70	9,52	5,50	3,2	0,04	4	-	•	-	-	-

Slot Milling

- Four cutting edges.
- Medium machining with chip groove.



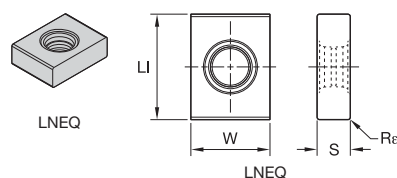
- first choice
- alternate choice

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

■ LNEU-SGP

catalogue number	LI	W	S	R _ε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40
LNEU1235R03SGP 4	12,70	9,52	3,50	0,3	0,09	4	-	●	-	-	-
LNEU1240R03SGP 4	12,70	9,52	4,00	0,3	0,09	4	-	●	-	-	-
LNEU1245R04SGP	12,70	9,52	4,50	0,4	0,09	4	-	●	-	-	-
LNEU1250R04SGP	12,70	9,52	5,00	0,4	0,09	4	-	●	-	-	-
LNEU1245R08SGP	12,70	9,52	4,50	0,8	0,09	4	-	●	-	-	●
LNEU1250R08SGP	12,70	9,52	5,00	0,8	0,09	4	-	●	-	-	-
LNEU1245R16SGP	12,70	9,52	4,50	1,6	0,09	4	-	●	-	-	-

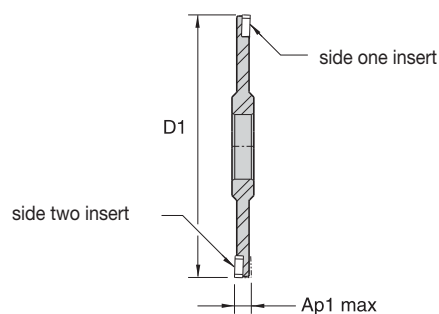
- Very strong geometry for roughing application.
- Four cutting edges.



■ LNEQ

catalogue number	LI	W	S	R _ε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40
LNEQ1235R03 4	12,70	9,52	3,50	0,3	0,05	4	-	●	●	-	-
LNEQ1240R03 4	12,70	9,52	4,00	0,3	0,05	4	-	●	-	●	-
LNEQ1245R04	12,70	9,52	4,50	0,4	0,05	4	●	●	●	●	-
LNEQ1250R04	12,70	9,52	5,00	0,4	0,05	4	-	-	●	-	-
LNEQ1255R04	12,70	9,52	5,50	0,4	0,05	4	-	●	●	-	-
LNEQ1260R04	12,70	9,52	6,00	0,4	0,05	4	-	●	●	-	●

- LNE narrow slotting 6–13mm slot width.
- Utilises wider inserts in standard cutters.
- Cutting width of this unique LNE insert style for narrow slotting cutters can be adjusted.
- The width can be increased in increments of 0,5mm or 1mm.
- Refer to the insert combination in the table below for insert and screw selection.



■ LN Slotting Cutter Widths: Adjust Width by Changing Inserts and Screws • Arbour Mount

catalogue number	D1	Ap1 max	Ap1 max (new)	side one insert*	screw**	side two insert*	screw**
80F08NS90LN12N06	80	6	6.5	LNE1235	MS-1281	LNE1240	MS-2267
80F08NS90LN12N06	80	6	7	LNE1240	MS-2267	LNE1240	MS-2267
80F08NS90LN12N08	80	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
80F08NS90LN12N08	80	8	9	LNE1250	MS-1283	LNE1250	MS-1283
100G10NS90LN12N06	100	6	6.5	LNE1235	MS-1281	LNE1240	MS-2267
100G10NS90LN12N06	100	6	7	LNE1240	MS-2267	LNE1240	MS-2267
100G10NS90LN12N08	100	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
100G10NS90LN12N08	100	8	9	LNE1250	MS-1283	LNE1250	MS-1283
125H12NS90LN12N06	125	6	6.5	LNE1235	MS-1281	LNE1240	MS-2267
125H12NS90LN12N06	125	6	7	LNE1240	MS-2267	LNE1240	MS-2267
125H12NS90LN12N10	125	10	10.5	LNE1245	MS-1282	LNE1250	MS-1283
125H12NS90LN12N10	125	10	11	LNE1250	MS-1283	LNE1250	MS-1283
160H16NS90LN12N06	160	6	6.5	LNE1235	MS-1281	LNE1240	MS-2267
160H16NS90LN12N06	160	6	7	LNE1240	MS-2267	LNE1240	MS-2267
160H16NS90LN12N08	160	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
160H16NS90LN12N08	160	8	9	LNE1250	MS-1283	LNE1250	MS-1283
160H15NS90LN12N10	160	10	10.5	LNE1245	MS-1282	LNE1250	MS-1283
160H15NS90LN12N10	160	10	11	LNE1250	MS-1283	LNE1250	MS-1283
160H15NS90LN12N12	160	12	12.5	LNE1255	MS-1284	LNE1260	MS-1285
160H15NS90LN12N12	160	12	13	LNE1260	MS-1285	LNE1260	MS-1285
200J18NS90LN12N06	200	6	6.5	LNE1235	MS-1281	LNE1240	MS-2267
200J18NS90LN12N06	200	6	7	LNE1240	MS-2267	LNE1240	MS-2267
200J18NS90LN12N08	200	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
200J18NS90LN12N08	200	8	9	LNE1250	MS-1283	LNE1250	MS-1283
200J18NS90LN12N10	200	10	10.5	LNE1245	MS-1282	LNE1250	MS-1283
200J18NS90LN12N10	200	10	11	LNE1250	MS-1283	LNE1250	MS-1283
200J18NS90LN12N12	200	12	12.5	LNE1255	MS-1284	LNE1260	MS-1285
200J18NS90LN12N12	200	12	13	LNE1260	MS-1285	LNE1260	MS-1285

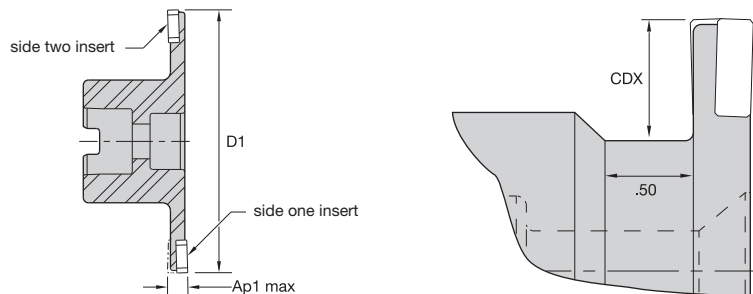
* Caution: Variation in cutting width range limited to one size (thickness) greater than the standard insert thickness.

** When changing to a wider insert thickness, use the necessary longer screw; see chart for detail.

NOTE: When cutters have 3 rows of inserts, the above table only refers to the outer insert on both sides of the cutter.

When using inserts with a radius of 2,40mm or greater there is a need to modify the insert pocket; modify to 2.50 x 45° chamfer.

- LNE narrow slotting 6–11mm slot width.
- Utilises wider inserts in standard cutters.
- Cutting width of this unique LNE insert style for narrow slotting cutters can be adjusted.
- The width can be increased in increments of 0,5mm or 1mm.
- Refer to the insert combinations in the table below for insert selection.



■ LN Slotting Cutter Widths: Adjust Width by Changing Inserts and Screws • Shell Mill

catalogue number	D1	Ap1 max	Ap1 max (new)	side one insert*	screw**	side two insert*	screw**
80Y08RS90LN12N06	80	6	6.5	LNE1235	MS-1280	LNE1240	MS-1281
80Y08RS90LN12N06	80	6	7	LNE1240	MS-1281	LNE1240	MS-1281
80Y08RS90LN12N08	80	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
80Y08RS90LN12N08	80	8	9	LNE1250	MS-1283	LNE1250	MS-1283
100Y10RS90LN12N06	100	6	6.5	LNE1235	MS-1280	LNE1240	MS-1281
100Y10RS90LN12N06	100	6	7	LNE1240	MS-1281	LNE1240	MS-1281
100Y10RS90LN12N08	100	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
100Y10RS90LN12N08	100	8	9	LNE1250	MS-1283	LNE1250	MS-1283
125Y12RS90LN12N10	125	10	10.5	LNE1245	MS-1282	LNE1250	MS-1283
125Y12RS90LN12N10	125	10	11	LNE1250	MS-1283	LNE1250	MS-1283
160Y16RS90LN12N06	160	6	6.5	LNE1235	MS-1280	LNE1240	MS-1281
160Y16RS90LN12N06	160	6	7	LNE1240	MS-1281	LNE1240	MS-1281
160Y16RS90LN12N08	160	8	8.5	LNE1245	MS-1282	LNE1250	MS-1283
160Y16RS90LN12N08	160	8	9	LNE1250	MS-1283	LNE1250	MS-1283
160Y16RS90LN12N10	160	10	10.5	LNE1245	MS-1282	LNE1250	MS-1283
160Y16RS90LN12N10	160	10	11	LNE1250	MS-1283	LNE1250	MS-1283

■ Example: Cutting Width of 6,50mm

catalogue number	D1	Ap1 max	Ap1 max (new)	side one insert*	screw**	side two insert*	screw**
80Y08RS90LN12N06	80	6	6.5	LNE1235	MS-1280	LNE1240	MS-1281

* Caution: Variation in cutting width range limited to one size (thickness) greater than the standard insert thickness.

** When changing to a wider insert thickness, use the necessary longer screw; see chart for detail.

NOTE: When cutters have 3 rows of inserts, the above table only refers to the outer insert on both sides of the cutter.

When using inserts with a radii of 2,40mm or greater there is a need to modify the insert pocket; modify to 2.50 x 45° chamfer.

Recommended Starting Feeds

■ Recommended Starting Feeds [mm]

■ Recommended Starting Feeds [mm]											Light Machining		General Purpose		Heavy Machining	
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry	
	5%			10%			20%			30%		40–100%				
...	0,17	0,47	0,70	0,12	0,34	0,50	0,09	0,26	0,38	0,08	0,22	0,33	0,07	0,20	0,30	...
.S..GP	0,23	0,52	0,81	0,17	0,37	0,58	0,13	0,28	0,43	0,11	0,24	0,38	0,10	0,22	0,35	.S..GP

NOTE: Use "Light Machining" values as starting feed rate.

Please see pages X22–X37 for recommended starting speeds.

Light Machining	General Purpose	Heavy Machining
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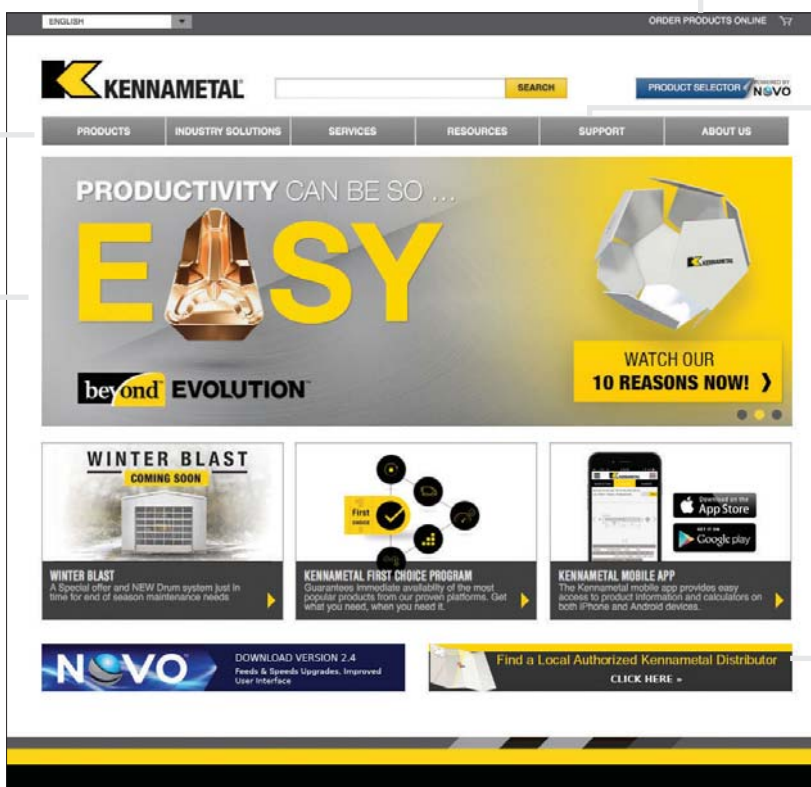
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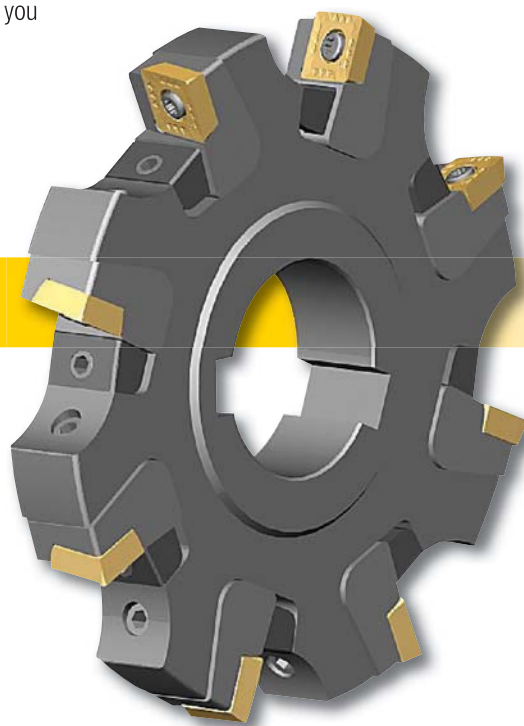
➤ KSSM™ Slotting Cutter

Primary Application

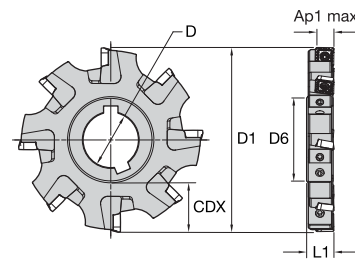
Cutters available in fixed and adjustable groove widths: Cutters available in arbour and shell mounts, as well as in fixed and adjustable groove widths, with insert grades and geometries for most materials, KSSM fixed-width slotting cutters are a cost effective solution for the general engineering market. Very precise adjustments to achieve consistent widths are possible with the variable width and enable you to change the tool from right hand to left hand with a change of cartridge.

Features and Benefits

- Cutters available in arbour and shell mounts, as well as in fixed and adjustable groove widths.
- Maximum groove widths:
 - Fixed cutters IC 10: 9,1mm and 15,8mm.
 - Fixed cutters IC 12: 11,7mm and 19,8mm.
 - Adjustable cutters IC 10: 14–18mm.
 - Adjustable cutters IC 12: 18–23,30mm.
- Rapid adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Faceted inserts for superior surface finish.
- Cutter diameter range is 100–315mm.
- Insert corner radii from 0,4–6,35mm.



- Right-hand and left-hand cutters with 9,1mm width of cut.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Various radii available.
- Faceted inserts for superior surface finishes.



■ Arbour Mount • 10mm IC • Right Hand

order number	catalogue number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	kg
3330528	100G10RP90SP10 *	100	32	46,8	26,3	16,0	9,1	10	10	17200	0,54
3330531	125H11RP90SP10 *	125	40	54,8	34,8	16,0	9,1	11	11	15400	0,86
3330974	160H11RP90SP10	160	40	54,8	52,6	16,0	9,1	11	11	13660	1,57
3330977	200J13RP90SP10	200	50	68,8	65,3	16,0	9,1	13	13	12200	2,56

NOTE: For superior surface finish, use right-hand inserts.

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

■ Arbour Mount • 10mm IC • Left Hand

order number	catalogue number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	kg
3330975	160H11LP90SP10	160	40	54,8	52,6	16,0	9,1	11	11	13660	1,57
3330978	200J13LP90SP10	200	50	68,8	65,3	16,0	9,1	13	13	12200	2,56

NOTE: For superior surface finish, use left-hand inserts.
 Insert radii $\geq 1,6\text{mm}$ (.062") has no facet.

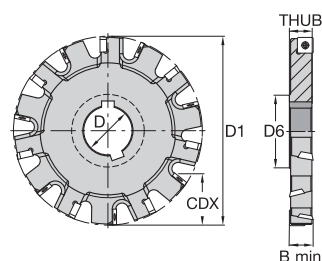
■ Spare Parts



D1	insert screw	Nm	Torx Plus driver
100	MS2148	2,0	DT9IP
125	MS2148	2,0	DT9IP
160	MS2148	2,0	DT9IP
200	MS2148	2,0	DT9IP

Slot Milling

- Neutral (full slotting) cutters.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Faceted inserts for superior surface finishes.



■ Arbour Mount • 10mm IC • Neutral (Full Slotting)

order number	catalogue number	D1	D	D6	CDX	THUB	B min	Z	Z S	max RPM	kg
3330527	100G10NP90SP10N16K *	100	32	46,8	26,4	13,9	15,83	10	5	17200	0,46
3330530	125H12NP90SP10N16K	125	40	54,8	34,9	13,9	15,83	12	6	15400	0,76
3330973	160H12NP90SP10N16K	160	40	54,8	52,2	13,9	15,83	12	6	13660	1,40
3330976	200J14NP90SP10N16K	200	50	68,8	65,2	13,9	15,83	14	7	12200	2,26

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

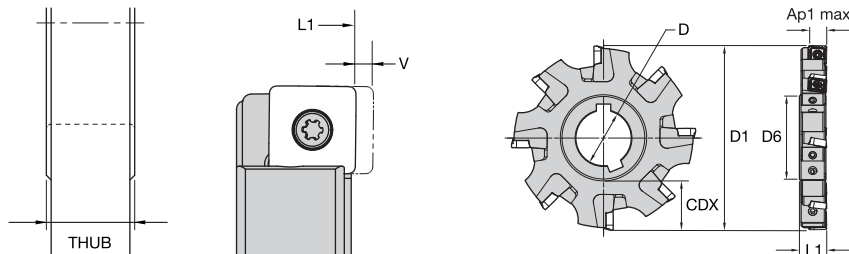
■ Spare Parts



D1	insert screw	Nm	Torx Plus driver
100	MS2148	2,0	DT9IP
125	MS2148	2,0	DT9IP
160	MS2148	2,0	DT9IP
200	MS2148	2,0	DT9IP

NOTE: For superior surface finish, use right- and left-hand inserts.
 Insert radii $\geq 1,6\text{mm}$ (.062") has no facet.

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



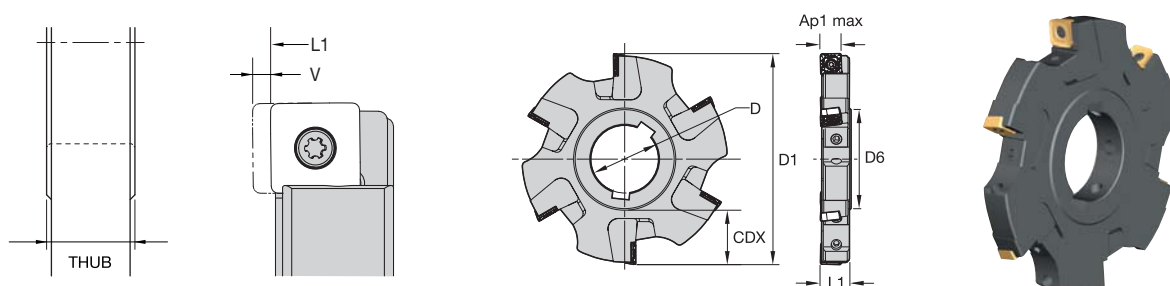
■ Arbour Mount • Half-Side Cutting • Right Hand

order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2442596	100G06RK90SP10N14K	100	32	46,8	25,9	13,9	13,9	1,0	9,1	6	6	17250	0,50
2442602	125H08RK90SP10N14K	125	40	54,8	34,4	13,9	13,9	1,0	9,1	8	8	15450	0,80
2443456	160H10RK90SP10N14K	160	40	54,8	51,9	13,9	13,9	1,0	9,1	10	10	13650	1,50

■ Spare Parts

D1	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
100	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM32
125	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11
160	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



■ Arbour Mount • Half-Side Cutting • Left Hand

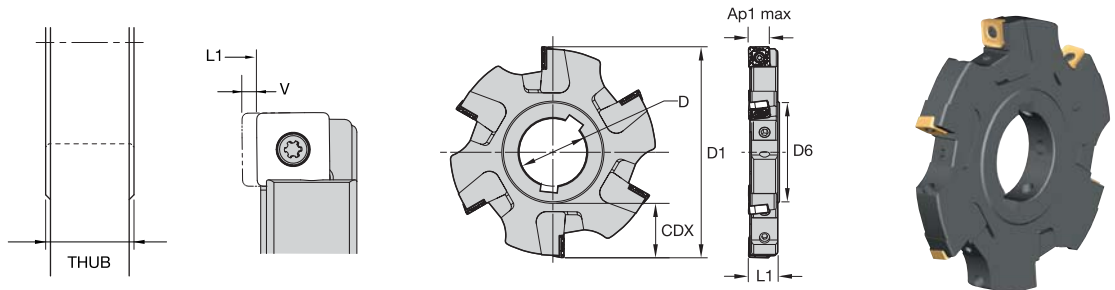
order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2442597	100G06LK90SP10N14K	100	32	46,8	25,9	13,9	13,9	1,0	9,1	6	6	17250	0,50
2443457	160H10LK90SP10N14K	160	40	54,8	51,9	13,9	13,9	1,0	9,1	10	10	13650	1,50

■ Spare Parts



D1	cartridge left-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
100	LK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM32
160	LK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



■ Arbour Mount • Half-Side Cutting • Left Hand

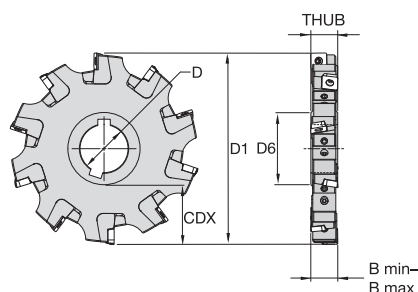
order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2443484	200J14LK90SP10N16K	200	50	68,8	64,9	15,9	15,9	1,0	9,1	14	14	12200	2,80
2443505	250J18LK90SP10N16K	250	50	68,8	89,9	15,9	15,9	1,0	9,1	18	18	10900	4,70

■ Spare Parts



D1	cartridge left-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
200	LK90SP1016	W16	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11
250	LK90SP1016	W16	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11

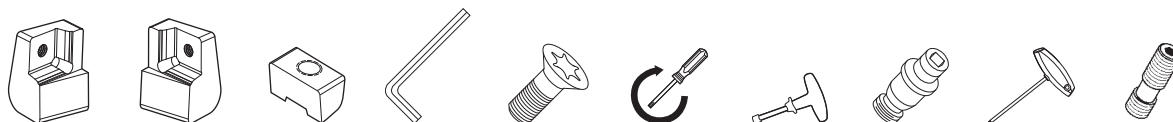
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



■ Arbour Mount Slotting Cutter • 14–16mm Adjustment Range

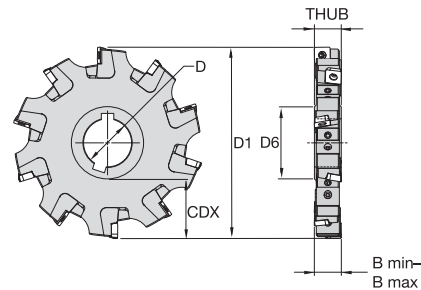
order number	catalogue number	D1	D	D6	CDX	THUB	B min	B max	Z	Z S	max RPM	kg
2442595	100G06NK90SP10N14K	100	32	46,8	25,9	13,9	14	16	6	3	17250	0,50
2442601	125H08NK90SP10N14K	125	40	54,8	34,4	13,9	14	16	8	4	15450	0,80
2443455	160H10NK90SP10N14K	160	40	54,8	51,9	13,9	14	16	10	5	13650	1,50
2443479	200J14NK90SP10N14K	200	50	68,8	64,9	13,9	14	16	14	7	12200	2,40

■ Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
100	LK90SP1014	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM32
125	LK90SP1014	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11
160	LK90SP1014	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11
200	LK90SP1014	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11

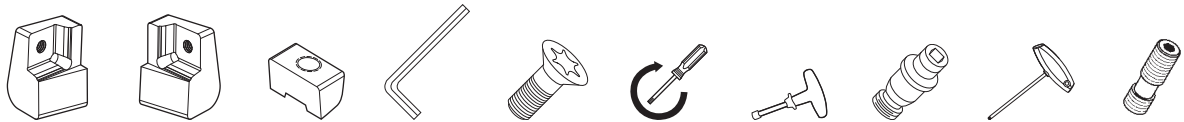
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



■ Arbour Mount Slotting Cutter • 16–18mm Adjustment Range

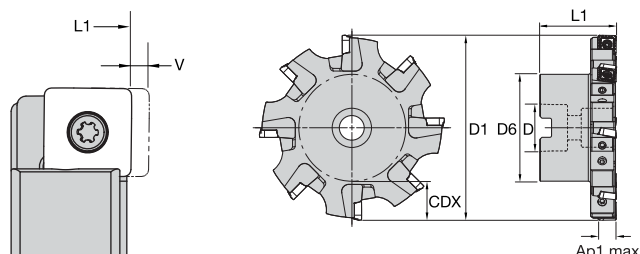
order number	catalogue number	D1	D	D6	CDX	THUB	B min	B max	Z	Z S	max RPM	kg
2443434	125H08NK90SP10N16K	125	40	54,8	34,4	15,9	16	18	8	4	15450	1,00
2443458	160H10NK90SP10N16K	160	40	54,8	51,9	15,9	16	18	10	5	13650	1,80
2443503	250J18NK90SP10N16K	250	50	68,8	89,9	15,9	16	18	18	9	10900	4,70
2443521	315K20NK90SP10N16K	315	60	83,8	114,9	15,9	16	18	20	10	9700	7,70

■ Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
125	LK90SP1016	RK90SP1016	W16	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11
160	LK90SP1016	RK90SP1016	W16	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11
250	LK90SP1016	RK90SP1016	W16	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11
315	LK90SP1016	RK90SP1016	W16	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ Shell Mount • Half-Side Cutting • Right Hand

order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2442599	100Y06RK90SP10N14K *	100	27	48,0	24,4	50,8	1,0	9,1	6	6	17250	0,90
2443444	125Y08RK90SP10N14K	125	32	58,0	31,9	50,8	1,0	9,1	8	8	15450	1,40
2443468	160Y10RK90SP10N14K	160	40	70,0	43,4	50,8	1,0	9,1	10	10	13650	2,00

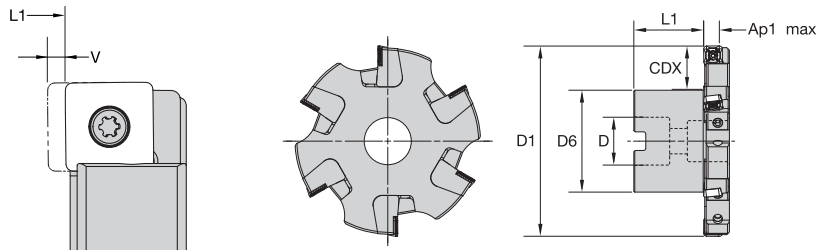
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

■ Spare Parts



D1	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
100	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	MS1556
125	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	MS1559
160	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	—

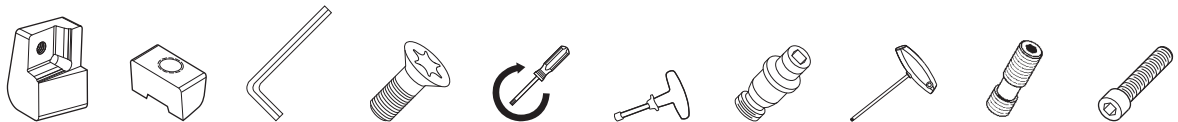
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ Shell Mount • Half-Side Cutting • Left Hand

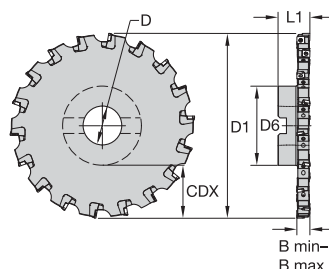
order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2442600	100Y06LK90SP10N14K	100	27	48,0	24,4	36,8	1,0	9,1	6	6	17250	0,90
2443445	125Y08LK90SP10N14K	125	32	58,0	31,9	36,8	1,0	9,1	8	8	15450	1,40
2443469	160Y10LK90SP10N14K	160	40	70,0	43,4	36,8	1,0	9,1	10	10	13650	2,00
2443493	200Y14LK90SP10N14K	200	40	90,0	53,4	36,8	1,0	9,1	14	14	12200	3,70

■ Spare Parts



D1	cartridge left-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
100	LK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	MS1556
125	LK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	MS1559
160	LK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	—
200	LK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	—

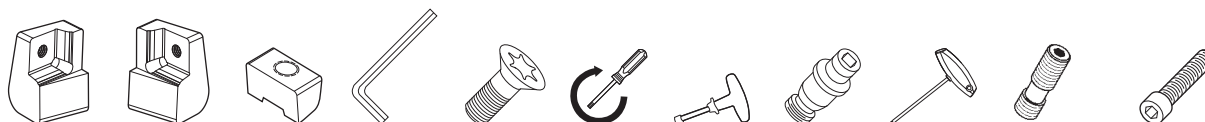
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ Shell Mount Slotting Cutters • 14–16mm Adjustment Range

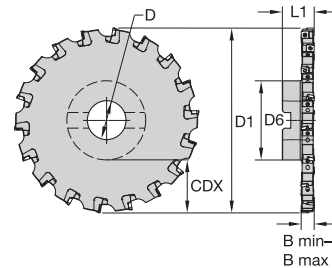
order number	catalogue number	D1	D	D6	CDX	L1	V	B min	B max	Z	Z S	max RPM	kg
2442598	100Y06NK90SP10N14K	100	27	48,0	24,4	50,8	1,0	14	16	6	3	17250	0,90
2443443	125Y08NK90SP10N14K	125	32	58,0	31,9	50,8	1,0	14	16	8	4	15450	1,40
2443467	160Y10NK90SP10N14K	160	40	70,0	43,4	50,8	1,0	14	16	10	5	13650	2,00
2443491	200Y14NK90SP10N14K	200	40	90,0	53,4	50,8	1,0	14	16	14	7	12200	3,70

■ Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
100	LK90SP1014	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	MS1556
125	LK90SP1014	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	MS1559
160	LK90SP1014	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	—
200	LK90SP1014	RK90SP1014	W14	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	—

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.

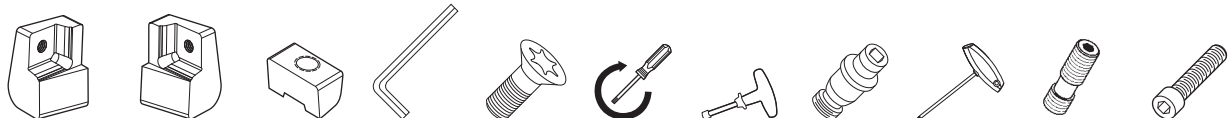


■ Shell Mount Slotting Cutters • 16–18mm Adjustment Range

order number	catalogue number	D1	D	D6	CDX	L1	V	B min	B max	Z	Z S	max RPM	kg
2443446	125Y08NK90SP10N16K *	125	32	58,0	31,9	50,8	1,0	16	18	8	4	15450	1,60
2443470	160Y10NK90SP10N16K	160	40	70,0	43,4	50,8	1,0	16	18	10	5	13650	2,20
2443494	200Y14NK90SP10N16K *	200	40	90,0	53,4	50,8	1,0	16	18	14	7	12200	4,10
2443512	250Y18NK90SP10N16K	250	60	130,0	58,4	50,8	1,0	16	18	18	9	10900	6,40
2443530	315Y20NK90SP10N16K	315	60	130,0	90,9	50,8	1,0	16	18	20	10	9700	9,50

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

■ Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	LK90SP1016	RK90SP1016	W16	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	MS1559
160	LK90SP1016	RK90SP1016	W16	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	—
200	LK90SP1016	RK90SP1016	W16	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	—
250	LK90SP1016	RK90SP1016	W16	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	—
315	LK90SP1016	RK90SP1016	W16	MW25	MS2148	2,0	TTP9	CP1416	THW3M	STCM11	—

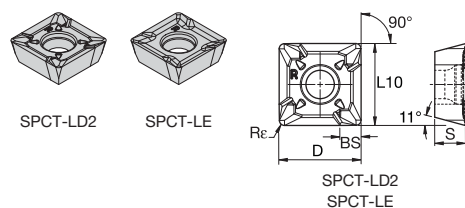


■ Insert Selection Guide

Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)		
	wear resistance						toughness
	Geometry	Grade	Geometry	Grade	Geometry	Grade	
P1-P2	.E..LD2	KCPM40	.E..GB2	KCPM40	.S..GB2	KCPK30	
P3-P4	.E..LD2	KCPM40	.E..GB2	KCPK30	.S..GB2	KCPK30	
P5-P6	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M	
M1-M2	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M	
M3	.E..LD2	KCPM40	.E..GB2	KCPM40	.S..GB2	KC725M	
K1-K2	.E..LD2	KC520M	.E..GB2	KCK15	.S..GB2	KCK15	
K3	.E..LD2	KC520M	.E..GB2	KC520M	.S..GB2	KC520M	
N1-N2	.F..LE	KC410M	.F..LE	KC410M	.F..LE	KC410M	
N3	.F..LE	KC410M	.F..LE	KC410M	.F..LE	KC410M	
S1-S2	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M	
S3	.E..LD2	KCPM40	.E..GB2	KCPM40	.S..GB2	KC725M	
S4	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M	
H1	-	-	-	-	-	-	

Indexable Inserts for KSSM™ SP.T10T3...

- Light-duty insert.
- Four cutting edges.



- first choice
- alternate choice

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

■ SPCT-LD2

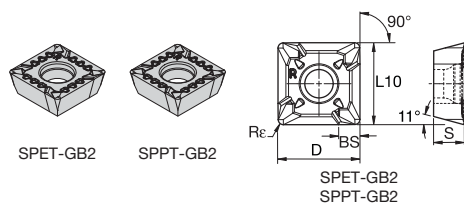
catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTDBK20
SPCT10T304PPELLD2	10	3,97	10,00	2,70	0,4	0,04	4	-	-	●	-	-	-	-	-
SPCT10T304PPERLD2	10	3,97	10,00	2,70	0,4	0,04	4	-	-	●	-	-	-	-	-
SPCT10T3PPELLD2	10	3,97	10,00	2,70	0,8	0,04	4	-	-	●	-	-	-	-	-
SPCT10T3PPERLD2	10	3,97	10,00	2,70	0,8	0,04	4	-	●	●	-	-	●	-	-
SPCT10T312PPELLD2	10	3,97	10,00	2,70	1,2	0,04	4	-	-	●	-	-	-	-	-
SPCT10T312PPERLD2	10	3,97	10,00	2,70	1,2	0,04	4	-	-	●	-	-	-	-	-
SPCT10T316ENLD2	10	3,97	10,00	—	1,6	0,04	4	-	-	●	-	-	-	●	-
SPCT10T320ENLD2	10	3,97	10,00	—	2,0	0,04	4	-	-	●	-	-	-	-	-

- Light-duty insert.
- Four cutting edges.

■ SPCT-LE

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTBK20		
SPCT10T304PPFLLE	10	3,97	10,00	2,70	0,4	0,02	4	●	-	-	-	-	-	-	-	-	-
SPCT10T304PPFRLE	10	3,97	10,00	2,70	0,4	0,02	4	●	-	-	-	-	-	-	-	-	-
SPCT10T3PPFLLE	10	3,97	10,00	2,70	0,8	0,02	4	●	-	-	-	-	-	-	-	-	-
SPCT10T3PPFRLE	10	3,97	10,00	2,70	0,8	0,02	4	●	-	-	-	-	-	-	-	-	-
SPCT10T312PPFRLE	10	3,97	10,00	2,70	1,2	0,02	4	●	-	-	-	-	-	-	-	-	-
SPCT10T320FNLE	10	3,97	10,00	—	2,0	0,02	4	●	-	-	-	-	-	-	-	-	-

Slot Milling



- alternate choice

[illegible]

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTBK20
SPET10T304PPELGB2	10	3,97	10,00	2,70	0,4	0,08	4	-	-	●	●	●	-	-	-
SPET10T304PPERGB2	10	3,97	10,00	2,70	0,4	0,08	4	-	-	●	●	●	-	-	-
SPET10T3PPELGB2	10	3,97	10,00	2,70	0,8	0,08	4	-	●	●	●	●	-	-	-
SPET10T3PPERGB2	10	3,97	10,00	2,70	0,8	0,08	4	-	●	●	●	●	●	-	-
SPET10T3PPSLGB2	10	3,97	10,00	2,70	0,8	0,13	4	-	-	●	-	●	-	-	-
SPET10T3PPSRGB2	10	3,97	10,00	2,70	0,8	0,13	4	-	●	●	●	●	-	-	-

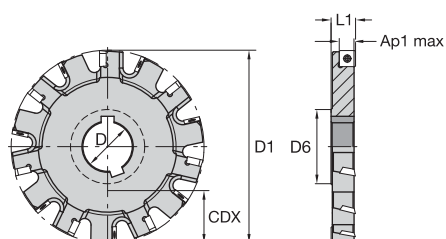
catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTBK20
SPPT10T3PPERGB2	10	3,97	10,00	2,70	0,8	0,08	4	-	-	-	●	●	-	-	-
SPPT10T3PPSRGB2	10	3,97	10,00	2,70	0,8	0,13	4	-	-	-	●	●	-	-	-

Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LE	0,12	0,42	0,70	0,08	0,30	0,50	0,06	0,23	0,38	0,06	0,20	0,33	0,05	0,18	0,30	.F..LE
.F..LD	0,12	0,42	0,70	0,08	0,30	0,50	0,06	0,23	0,38	0,06	0,20	0,33	0,05	0,18	0,30	.F..LD
.E..LD2	0,12	0,46	0,81	0,09	0,33	0,58	0,07	0,25	0,43	0,06	0,22	0,38	0,05	0,20	0,35	.E..LD2
.E..LD	0,17	0,47	0,82	0,12	0,34	0,59	0,09	0,26	0,44	0,08	0,22	0,38	0,07	0,20	0,35	.E..LD
.E..GB2	0,23	0,53	0,89	0,17	0,38	0,64	0,13	0,29	0,48	0,11	0,25	0,41	0,10	0,23	0,38	.E..GB2
.S..GB	0,23	0,59	0,95	0,17	0,43	0,68	0,13	0,32	0,51	0,11	0,28	0,44	0,10	0,25	0,41	.S..GB
.S..GB2	0,23	0,59	0,95	0,17	0,43	0,68	0,13	0,32	0,51	0,11	0,28	0,44	0,10	0,25	0,41	.S..GB2
.S..GN	0,23	0,59	0,95	0,17	0,43	0,68	0,13	0,32	0,51	0,11	0,28	0,44	0,10	0,25	0,41	.S..GN

Slot Milling

- Right- and left-hand cutters.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Faceted inserts for superior surface finishes.



■ Arbour Mount • 12mm IC • Right Hand

order number	catalogue number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	kg
3330984	160H12RP90SD12	160	40	54,8	52,6	20,0	11,7	12	12	9170	1,96
3330987	200J14RP90SD12	200	50	68,8	65,6	20,0	11,7	14	14	8210	3,18
3330990	250J16RP90SD12 *	250	50	68,8	90,6	20,0	11,7	16	16	7300	5,29

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

■ Arbour Mount • 12mm IC • Left Hand

order number	catalogue number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	kg
3330985	160H12LP90SD12	160	40	54,8	52,6	20,0	11,7	12	12	9170	1,96
3330988	200J14LP90SD12	200	50	68,8	65,6	20,0	11,7	14	14	8210	3,18
3330991	250J16LP90SD12 *	250	50	68,8	90,6	20,0	11,7	16	16	7300	5,29

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

■ Spare Parts



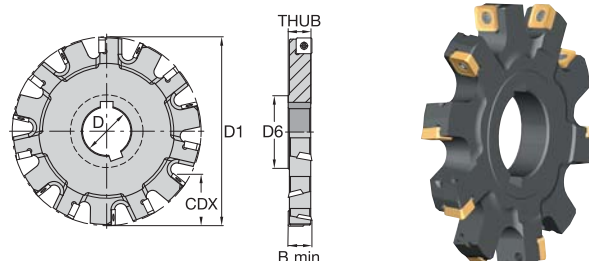
Slot Milling



D1	insert screw	Nm	Torx Plus driver
160	MS2078	4,0	DT15IP
200	MS2078	4,0	DT15IP
250	MS2078	4,0	DT15IP

NOTE: For superior surface finish, use left-hand inserts.
Insert radii $\geq 1,6\text{mm}$ (.062") has no facet.

- Neutral (full slotting) cutters.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Faceted inserts for superior surface finishes.



■ Arbour Mount • 12mm IC • Neutral (Full Slotting)

order number	catalogue number	D1	D	D6	CDX	THUB	B min	Z	Z S	max RPM	kg
3330983	160H14NP90SD12N20K	160	40	54,8	52,2	17,9	19,8	14	7	9170	1,85
3330986	200J18NP90SD12N20K	200	50	68,8	65,2	17,9	19,8	18	9	8210	3,11
3330989	250J22NP90SD12N20K	250	50	68,8	90,4	17,9	19,8	22	11	7300	5,14

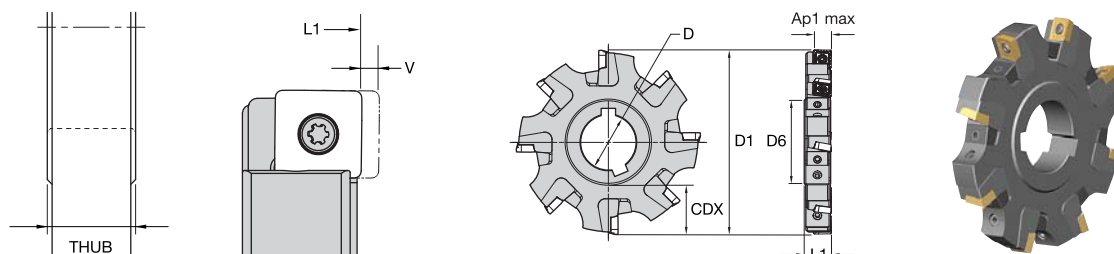
■ Spare Parts



D1	insert screw	Nm	Torx Plus driver
160	MS2078	4,0	DT15IP
200	MS2078	4,0	DT15IP
250	MS2078	4,0	DT15IP

NOTE: For superior surface finish, use left-hand inserts.
 Insert radii $\geq 1,6\text{mm}$ (.062") has no facet.

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



■ Arbour Mount • Half-Side Cutting • Right Hand

order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2443438	125H08RK90SD12N18K	125	40	54,8	34,0	18,1	18,2	1,3	11,7	8	8	10350	1,00
2443462	160H10RK90SD12N18K	160	40	54,8	51,5	18,1	18,2	1,3	11,7	10	10	9150	1,80

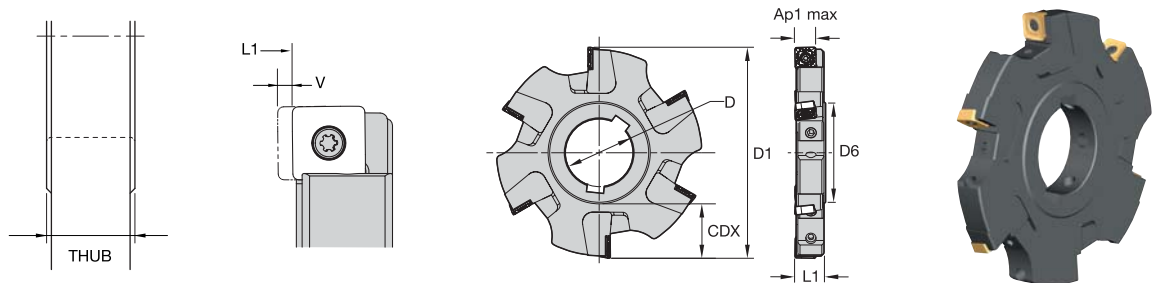
■ Spare Parts



D1	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
125	RK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11
160	RK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11



- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



■ Arbour Mount • Half-Side Cutting • Left Hand

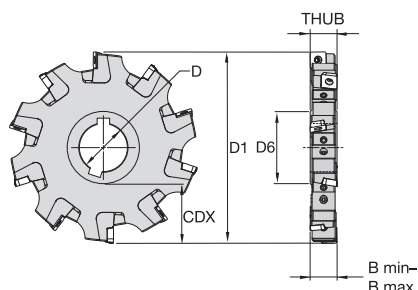
order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2443439	125H08LK90SD12N18K	125	40	54,8	34,0	18,1	18,2	1,3	11,7	8	8	10350	1,00
2443463	160H10LK90SD12N18K	160	40	54,8	51,5	18,1	18,2	1,3	11,7	10	10	9150	1,80
2443526	315K18LK90SD12N18K	315	60	83,8	114,5	18,1	18,2	1,3	11,7	18	18	6500	8,40

■ Spare Parts



D1	cartridge left-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
125	LK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11
160	LK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11
315	LK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



■ Arbour Mount Slotting Cutter • 18–20,7mm Adjustment Range

order number	catalogue number	D1	D	D6	B min	B max	CDX	THUB	Z	Z S	max RPM	kg
2443437	125H08NK90SD12N18K	125	40	54,8	18	20,7	34,0	18,2	8	4	10350	1,00
2443461	160H10NK90SD12N18K	160	40	54,8	18	20,7	51,5	18,2	10	5	9150	1,80
2443485	200J14NK90SD12N18K	200	50	68,8	18	20,7	64,5	18,2	14	7	8200	3,00
2443506	250J16NK90SD12N18K *	250	50	68,8	18	20,7	89,5	18,2	16	8	7350	5,00
2443524	315K18NK90SD12N18K	315	60	83,8	18	20,7	114,5	18,2	18	9	6500	8,40

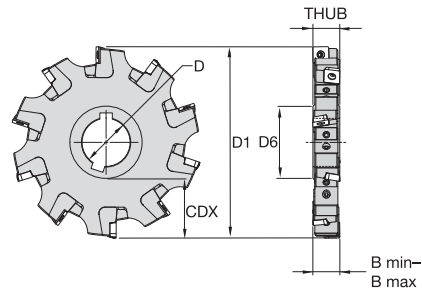
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

■ Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
125	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11
160	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11
200	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11
250	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11
315	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



■ Arbour Mount Slotting Cutter • 20,7–23,3mm Adjustment Range

order number	catalogue number	D1	D	D6	B min	B max	CDX	THUB	Z	Z S	max RPM	kg
2443440	125H08NK90SD12N20K	125	40	54,8	20,7	23,3	34,0	20,8	8	4	10350	1,20
2443464	160H10NK90SD12N20K *	160	40	54,8	20,7	23,3	51,5	20,8	10	5	9150	2,10
2443488	200J14NK90SD12N20K *	200	50	68,8	20,7	23,3	64,5	20,8	14	7	8200	3,50
2443527	315K18NK90SD12N20K	315	60	83,8	20,7	23,3	114,5	20,8	18	9	6500	9,70

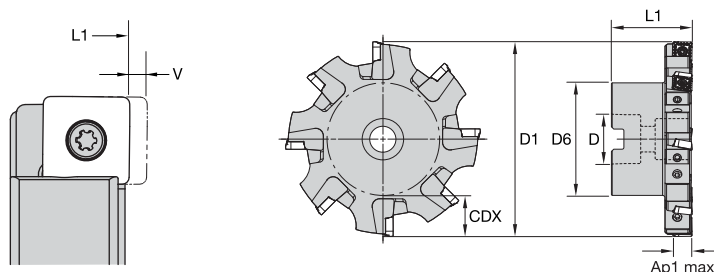
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

■ Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw
125	LK90SD1220	RK90SD1220	W20	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11
160	LK90SD1220	RK90SD1220	W20	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11
200	LK90SD1220	RK90SD1220	W20	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11
315	LK90SD1220	RK90SD1220	W20	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11

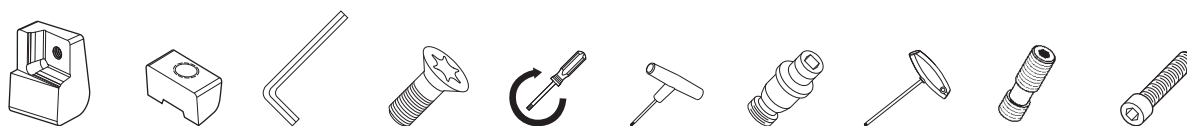
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ Shell Mount • Half-Side Cutting • Right Hand

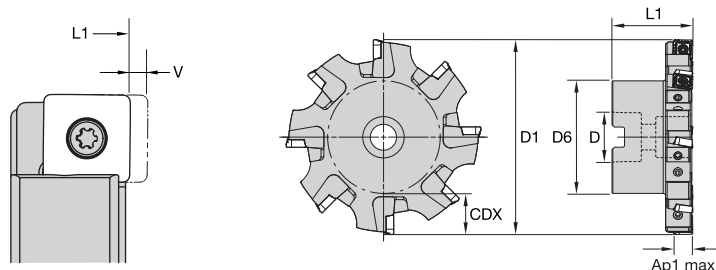
order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2443450	125Y08RK90SD12N18K	125	32	58,0	31,9	51,0	1,3	11,7	8	8	10350	1,60

■ Spare Parts



D1	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	RK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	MS1559

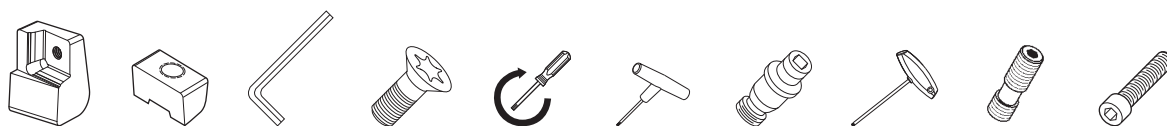
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ Shell Mount • Half-Side Cutting • Right Hand

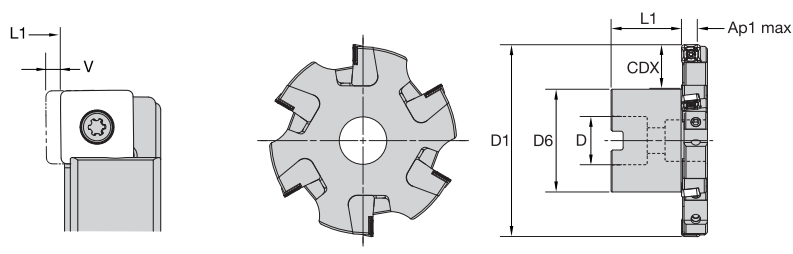
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2443453	125Y08RK90SD12N20K	125	32	58,0	31,9	51,0	1,3	11,7	8	8	10350	1,70

■ Spare Parts



D1	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	RK90SD1220	W20	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	MS1559

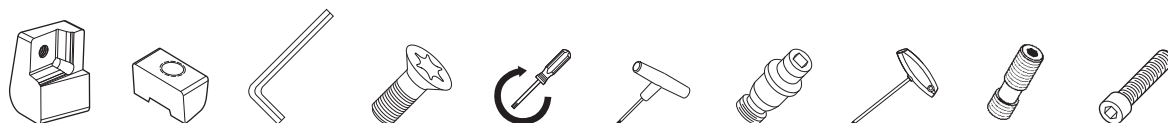
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ Shell Mount • Half-Side Cutting • Left Hand

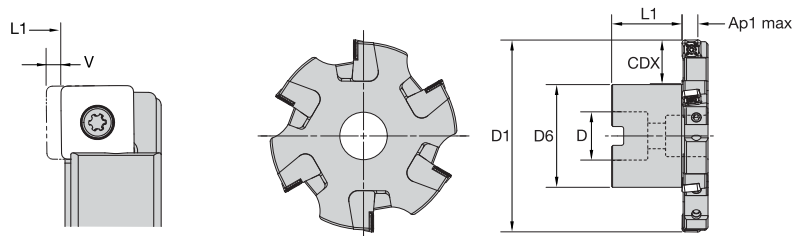
order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2443451	125Y08LK90SD12N18K	125	32	58,0	31,9	33,0	1,3	11,7	8	8	10350	1,60
2443475	160Y10LK90SD12N18K	160	40	70,0	43,4	33,0	1,3	11,7	10	10	9150	2,30

■ Spare Parts



D1	cartridge left-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	LK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	MS1559
160	LK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	—

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.

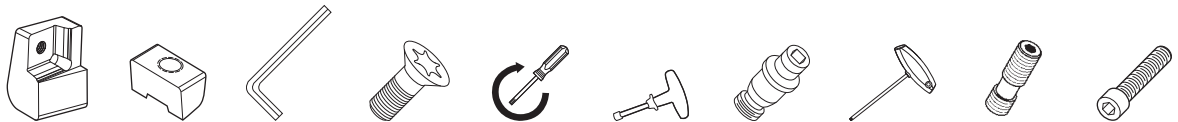


■ Shell Mount • Half-Side Cutting • Left Hand

order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2443454	125Y08LK90SD12N20K	125	32	58,0	31,9	30,4	1,3	11,7	8	8	10350	1,70
2443502	200Y14LK90SD12N20K *	200	40	90,0	53,4	30,4	1,3	11,7	14	14	8200	4,60

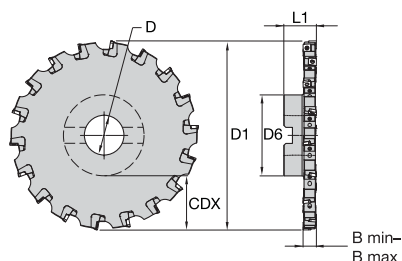
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

■ Spare Parts



D1	cartridge left-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin wrench	wedge wrench	wedge screw	socket-head cap screw
125	LK90SD1220	W20	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	MS1559
200	LK90SD1220	W20	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	—

- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.

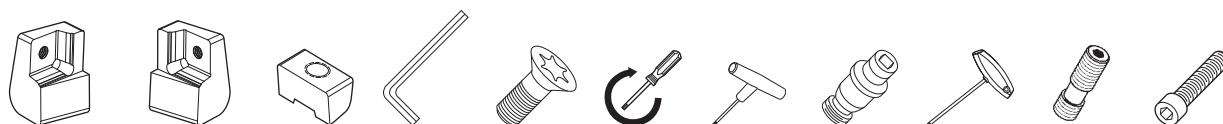


■ Shell Mount • Slotting Width • 18–20,7mm Adjustment Range

order number	catalogue number	D1	D	D6	B min	B max	CDX	L1	Z	Z S	max RPM	kg
2443449	125Y08NK90SD12N18K	125	32	58,0	18	20,7	31,9	51,0	8	4	10350	1,60
2443473	160Y10NK90SD12N18K	160	40	70,0	18	20,7	43,4	51,0	10	5	9150	2,30
2443515	250Y16NK90SD12N18K *	250	60	130,0	18	20,7	58,4	51,0	16	8	7350	6,70
2443536	315Y18NK90SD12N18K *	315	60	130,0	18	20,7	90,9	51,0	18	9	6500	10,04

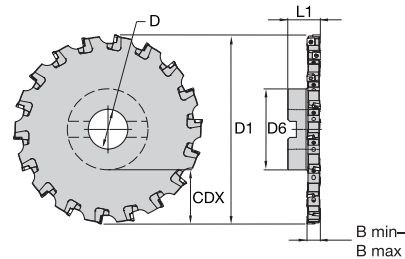
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

■ Spare Parts



D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	MS1559
160	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	—
250	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	—
315	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	—

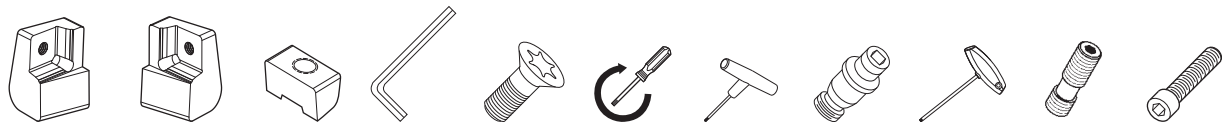
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ Shell Mount • Slotting Width • 20,7–23,3mm Adjustment Range

order number	catalogue number	D1	D	D6	B min	B max	CDX	L1	Z	Z S	max RPM	kg
2443452	125Y08NK90SD12N20K	125	32	58,0	20,7	23,3	31,9	51,0	8	4	10350	1,70
2443476	160Y10NK90SD12N20K	160	40	70,0	20,7	23,3	43,4	51,0	10	5	9150	2,50
2443500	200Y14NK90SD12N20K	200	40	90,0	20,7	23,3	53,4	51,0	14	7	8200	4,60
2443518	250Y16NK90SD12N20K	250	60	130,0	20,7	23,3	58,4	51,0	16	8	7350	7,30
2443533	315Y18NK90SD12N20K	315	60	130,0	20,7	23,3	90,9	51,0	18	9	6500	11,30

■ Spare Parts



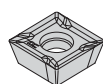
D1	cartridge left-hand	cartridge right-hand	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	LK90SD1220	RK90SD1220	W20	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	MS1559
160	LK90SD1220	RK90SD1220	W20	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	—
200	LK90SD1220	RK90SD1220	W20	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	—
250	LK90SD1220	RK90SD1220	W20	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	—
315	LK90SD1220	RK90SD1220	W20	MW3	MS2077	4,0	TTP15	CP1820	THW3M	STCM11	—

Insert Selection Guide

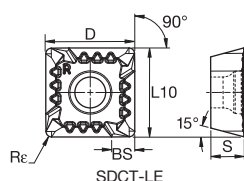
Material Group	Light Machining (Light geometry)		General Purpose		Heavy Machining (Strong geometry)	
	wear resistance		↔		toughness	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	.E..LD2	KCPM40	.E..GB2	KCPM40	.S..GB2	KCPM40
P3-P4	.E..LD2	KCPM40	.E..GB2	KCPK30	.S..GB2	KCPK30
P5-P6	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
M1-M2	.E..LD2	KCSM40	.E..GB2	KCSM40	.S..GB2	KCSM40
M3	.E..LD2	KCPM40	.E..GB2	KCPM40	.S..GB2	KCPM40
K1-K2	.E..LD2	KC520M	.E..GB2	KCK15	.S..GB2	KCK15
K3	.E..LD2	KC520M	.E..GB2	KC520M	.S..GB2	KC520M
N1-N2	.F..LE	KC410M	.F..LE	KC410M	.F..LE	KC410M
N3	.F..LE	KC410M	.F..LE	KC410M	.F..LE	KC410M
S1-S2	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
S3	.E..LD2	KCSM40	.E..GB2	KCSM40	.S..GB2	KCSM40
S4	.E..LD2	KCSM40	.E..GB2	KCSM40	.S..GB2	KCSM40
H1	-	-	-	-	-	-

Indexable Inserts • KSSM SD.T1204...

- Light-duty insert.
- Four cutting edges.



SDCT-LE



- first choice
- alternate choice

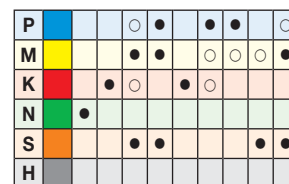
P	●	○	○	○	○	○	○	○	○
M	●	○	○	○	○	○	○	○	○
K	●	○	○	○	○	○	○	○	○
N	●	○	○	○	○	○	○	○	○
S	●	○	○	○	○	○	○	○	○
H	○	○	○	○	○	○	○	○	○

SDCT-LE

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDCT120404PDFLLE	12,70	4,76	12,70	2,70	0,4	0,02	4	●	-	-	-	-	-	-	-	-
SDCT120404PDFRLE	12,70	4,76	12,70	2,70	0,4	0,02	4	●	-	-	-	-	-	-	-	-
SDCT1204PDFLLE	12,70	4,76	12,70	2,70	0,8	0,02	4	●	-	-	-	-	-	-	-	-
SDCT1204PDFRLE	12,70	4,76	12,70	2,70	0,8	0,02	4	●	-	-	-	-	-	-	-	-
SDCT120412PDFLLE	12,70	4,76	12,70	2,70	1,2	0,02	4	●	-	-	-	-	-	-	-	-
SDCT120412PDFRLE	12,70	4,76	12,70	2,70	1,2	0,02	4	●	-	-	-	-	-	-	-	-
SDCT120416FNLE	12,70	4,76	12,70	-	1,6	0,02	4	●	-	-	-	-	-	-	-	-
SDCT120420FNLE	12,70	4,76	12,70	-	2,0	0,02	4	●	-	-	-	-	-	-	-	-
SDCT120424FNLE	12,70	4,76	12,70	-	2,4	0,02	4	●	-	-	-	-	-	-	-	-
SDCT120432FNLE	12,70	4,76	12,70	-	3,2	0,02	4	●	-	-	-	-	-	-	-	-

Slot Milling

- first choice
- alternate choice



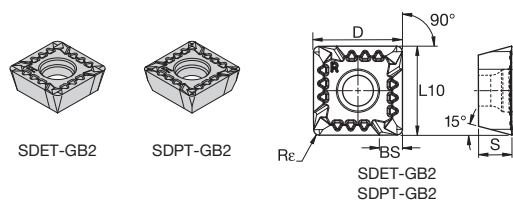
catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KC115	KCPK30	KCPM40	KCSM30	KCSM40
SDCT120404PDELLD2	12,70	4,76	12,70	2,70	0,4	0,04	4	-	-	-	●	-	-	-	-	-
SDCT120404PDERLD2	12,70	4,76	12,70	2,93	0,4	0,04	4	-	-	-	●	-	-	-	-	-
SDCT1204PDELLD2	12,70	4,76	12,70	3,32	0,8	0,04	4	-	-	-	●	-	-	-	-	-
SDCT1204PDERLD2	12,70	4,76	12,70	3,32	0,8	0,04	4	-	●	-	●	-	-	●	-	●
SDCT120412PDELLD2	12,70	4,76	12,70	3,05	1,2	0,04	4	-	-	-	●	-	-	-	-	-
SDCT120412PDERLD2	12,70	4,76	12,70	3,05	1,2	0,04	4	-	-	-	●	-	-	-	-	●
SDCT120416ENLD2	12,70	4,76	12,70	—	1,6	0,04	4	-	-	-	●	-	-	-	-	●
SDCT120420ENLD2	12,70	4,76	12,70	—	2,0	0,04	4	-	-	-	●	-	-	-	-	-
SDCT120424ENLD2	12,70	4,76	12,70	—	2,4	0,04	4	-	-	-	●	-	-	-	-	-
SDCT120432ENLD2	12,70	4,76	12,70	—	3,2	0,04	4	-	-	●	●	-	-	-	●	●
SDCT120464ENLD2	12,70	4,76	12,70	—	6,3	0,04	2	-	-	-	●	-	-	-	-	-

- SDET-GB

catalogue number	D	S	L10	BS	Re	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40			
SDET1204PDERGB	12,70	4,76	12,70	2,56	0,8	0,08	4	-	●	-	-	-	-	-	-	-	●	●	●
SDET1204PDSRGB	12,70	4,76	12,70	2,56	0,8	0,15	4	-	-	-	●	-	●	●	●	●	●	●	●
SDET120412PDERGB	12,70	4,76	12,70	2,19	1,2	0,08	4	-	-	-	●	-	-	●	-	-	●	●	●
SDET120412PDSRGB	12,70	4,76	12,70	2,16	1,2	0,15	4	-	-	-	●	-	-	-	-	-	●	●	●
SDET120416ENGB	12,70	4,76	12,70	—	1,6	0,08	4	-	-	-	-	-	-	-	-	-	●	●	●
SDET120416SNGB	12,70	4,76	12,70	—	1,6	0,15	4	-	-	-	●	-	-	-	-	-	●	●	●
SDET120424ENGB	12,70	4,76	12,70	—	2,4	0,08	4	-	-	-	●	-	-	-	-	-	●	●	●
SDET120424SNGB	12,70	4,76	12,70	—	2,4	0,15	4	-	-	-	●	-	-	-	-	-	●	●	●
SDET120432ENGB	12,70	4,76	12,70	—	3,2	0,08	4	-	-	-	●	-	-	-	-	-	●	●	●
SDET120432SNGB	12,70	4,76	12,70	—	3,2	0,15	4	-	-	-	-	-	-	-	-	-	●	●	●
SDET120448ENGB	12,70	4,76	12,70	—	4,8	0,08	2	-	-	-	●	-	-	-	-	-	●	●	●
SDET120448SNGB	12,70	4,76	12,70	—	4,8	0,15	2	-	-	-	●	-	-	-	-	-	●	●	●
SDET120464ENGB	12,70	4,76	12,70	—	6,4	0,08	2	-	-	-	●	-	-	-	-	-	●	●	●
SDET120464SNGB	12,70	4,76	12,70	—	6,4	0,15	2	-	-	-	●	-	●	-	-	-	●	●	●

Slot Milling

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.



- first choice

- alternate choice

[illegible]

■ SDET-GB2

catalogue number	D	S	L10	BS	Re	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40			
SDET1204PDELGB2	12,70	4,76	12,70	3,32	0,8	0,08	4	-	●	-	●	●	●	-	-	-	-	-	-
SDET1204PDERGB2	12,70	4,76	12,70	3,32	0,8	0,08	4	-	●	-	●	●	●	●	-	-	●	-	-
SDET1204PDSLGB2	12,70	4,76	12,70	3,32	0,8	0,13	4	-	-	-	●	-	●	-	-	-	-	-	-
SDET1204PDSRGB2	12,70	4,76	12,70	3,32	0,8	0,13	4	-	●	-	●	●	●	●	-	-	-	-	-
SDET120412PDELGB2	12,70	4,76	12,70	3,05	1,2	0,08	4	-	●	-	●	●	-	-	-	-	-	-	-
SDET120412PDERGB2	12,70	4,76	12,70	3,05	1,2	0,08	4	-	●	-	●	●	●	●	-	-	-	-	-
SDET120416SNGB2	12,70	4,76	12,70	—	1,6	0,13	4	-	●	-	●	●	●	-	-	-	-	-	-
SDET120420SNGB2	12,70	4,76	12,70	—	2,0	0,13	4	-	●	-	●	●	●	●	-	-	-	-	-
SDET120424SNGB2	12,70	4,76	12,70	—	2,4	0,13	4	-	-	-	●	●	●	-	-	-	-	-	-
SDET120432SNGB2	12,70	4,76	12,70	—	3,2	0,13	4	-	●	-	●	●	●	-	-	-	-	-	-
SDET120432XENGB2	12,70	4,76	12,70	—	3,2	0,08	2	-	-	-	●	-	-	-	-	-	-	-	-
SDET120464SNGB2	12,70	4,76	12,70	—	6,4	0,13	2	-	-	-	-	-	●	-	-	-	-	-	-

- Medium machining.
- Precision ground.
- 5° rake face.
- Four cutting edges.

■ SDPT-GB2

catalogue number	D	S	L10	BS	Re	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDPT1204PDERGB2	12,70	4,76	12,70	2,70	0,8	0,08	4	-	-	-	●	●	●	●	-	-
SDPT1204PDPSRGB2	12.70	4.76	12.70	2.70	0.8	0.13	4	-	-	-	●	●	●	●	-	-

Recommended Starting Feeds

■ Recommended Starting Feeds [mm]

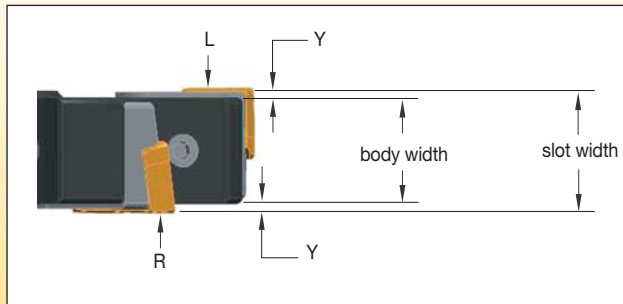
Light Machining	General Purpose	Heavy Machining
-----------------	-----------------	-----------------

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LE	0,12	0,42	0,74	0,08	0,30	0,54	0,06	0,23	0,40	0,06	0,20	0,35	0,05	0,18	0,32	.F..LE
.E..LD	0,17	0,47	0,82	0,12	0,34	0,59	0,09	0,26	0,44	0,08	0,22	0,38	0,07	0,20	0,35	.E..LD
.E..LD2	0,12	0,46	0,81	0,09	0,33	0,58	0,07	0,25	0,43	0,06	0,22	0,38	0,05	0,20	0,35	.E..LD2
.E..GB	0,23	0,53	0,89	0,17	0,38	0,64	0,13	0,29	0,48	0,11	0,25	0,41	0,10	0,23	0,38	.E..GB
.E..GB2	0,23	0,53	0,89	0,17	0,38	0,64	0,13	0,29	0,48	0,11	0,25	0,41	0,10	0,23	0,38	.E..GB2
.S..GB	0,23	0,59	0,95	0,17	0,43	0,68	0,13	0,32	0,51	0,11	0,28	0,44	0,10	0,25	0,41	.S..GB
.S..GB2	0,23	0,59	0,95	0,17	0,43	0,68	0,13	0,32	0,51	0,11	0,28	0,44	0,10	0,25	0,41	.S..GB2
.S..GN	0,23	0,59	0,95	0,17	0,43	0,68	0,13	0,32	0,51	0,11	0,28	0,44	0,10	0,25	0,41	.S..GN

NOTE: Use “Light Machining” values as starting feed rate.

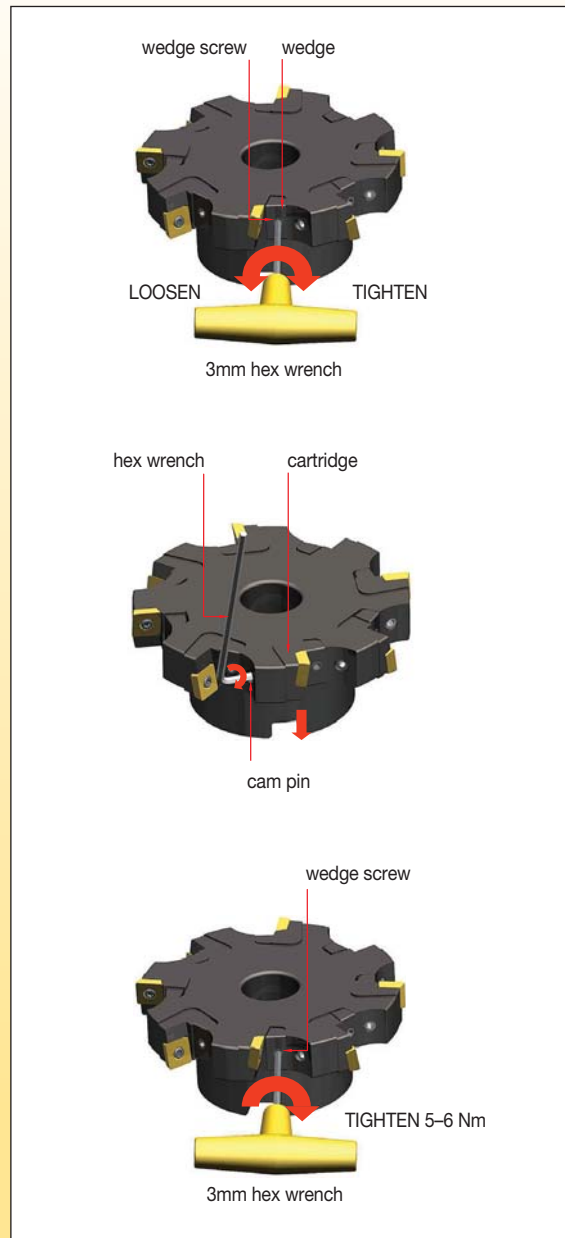
Please see pages X22–X37 for recommended starting speeds.

■ KSSM Slot Width Adjustment Instructions



1. Measure body width at pocket 1 (per stamp on tool body) behind cartridge.
2. Zero tool presetter at pocket 1 behind cartridge.
3. Move presetter over the insert and set distance Y.
 $Y = (\text{Desired Slot Width} - \text{Body Width}) / 2$
4. Zero over insert at starting pocket (pocket 1).
5. Adjust remaining cartridges on the same side.
6. Return to starting pocket and start with step 2 for opposite side of cutter.

■ KSSM Cartridge Adjustment Instructions



1. Insert 3mm hex wrench into STCM Screw.
2. Rotate 3mm hex wrench anti-clockwise to loosen wedge.
3. Rotate 3mm hex wrench clockwise to lightly tighten STCM screw to approximately 1 Nm, so the wedge is touching the cartridge and cutterbody. This creates some slight resistance against the cartridge during the adjustment.

4. Insert hex wrench into cam pin behind cartridge.
5. Rotate wrench to adjust cartridge to desired position.
6. For best accuracy, back cam pin off, so you can feel it is not touching the sides of the slot in the back of the cartridge.
7. Remove wrench from cam pin.

8. Insert 3mm hex wrench into STCM screw.
9. Tighten STCM screw to 5,1–6,2 Nm prior to using the cutter. Kennametal torque wrench KTW45 or alternate torque wrench should be used.
10. Double check cartridge position to assure no movement.