



MASTER CATALOG 2018

VOLUME TWO | **ROTATING TOOLS**



HOLEMAKING | TAPPING | SOLID END MILLING | INDEXABLE MILLING

Indexable Milling • Slot Milling

KTMS • T-Slot Platform.....	U2–U5
KVNS • Very-Narrow Slotting Platform.....	U6–U10
SN • Popular Square Inserted Cutter	U12–U15
LN • Adjustable Width Cutter System.....	U16–U22
KSSM10 • Neutral, Right-, and Left-Hand Cutters, 10mm IC	U24–U31
KSSM12 • Neutral, Right-, and Left-Hand Cutters, 12mm IC	U32–U41

➤ KTMS™ Slotting Cutter

Primary Application

KTMS slotting cutters produce “T” slots in machine beds as well as small radial depths of cut for machining shallow radial slots. There is always a need to prepare the slot before using this type of cutter — preparation is the key to success. See the technical information for information about the pre-machining on page U5.

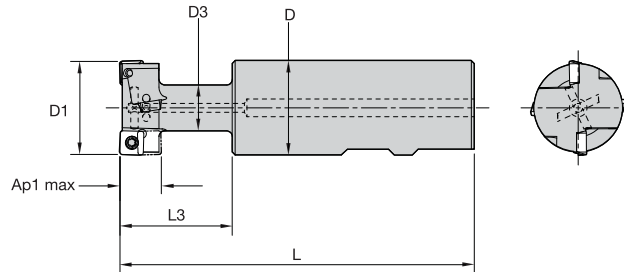
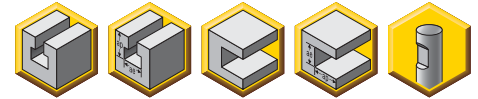
Please note that all of these cutters have metric diameters, speeds, and feeds.



Features and Benefits

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

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



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

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

■ Spare Parts



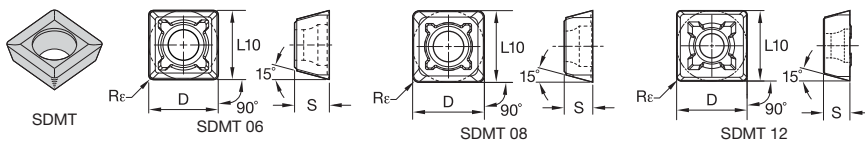
D1	insert screw	Nm	Torx driver
21	MS2206	1,2	DT8
25	MS2206	1,2	DT8
32	MS2207	2,0	DT10
40	MS2208	3,5	DT15
50	MS2208	3,5	DT15

Insert Selection Guide

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

Indexable Insert • T-Slot Cutters SDMT • EGG

- Honed insert edges.
- Four cutting edges.



- first choice
- alternate choice

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

SDMT-EGG

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

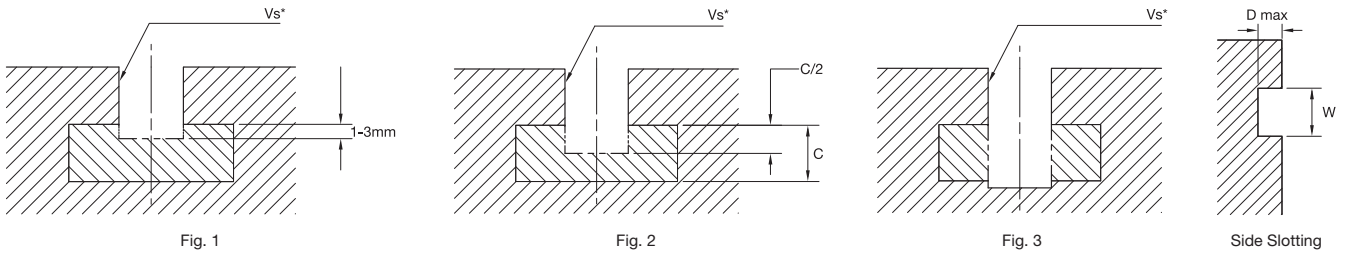
Recommended Starting Feeds

Recommended Starting Feeds [mm]

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

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry	
	5%			10%			20%			30%			40-100%			
.06..EGG	0.20	0.46	0.70	0.14	0.33	0.50	0.11	0.25	0.38	0.09	0.22	0.33	0.08	0.20	0.30	.06..EGG
.08..EGG	0.20	0.53	0.82	0.14	0.38	0.59	0.11	0.29	0.44	0.09	0.25	0.39	0.08	0.23	0.35	.08..EGG
.12..EGG	0.20	0.59	0.92	0.14	0.43	0.66	0.11	0.32	0.50	0.09	0.28	0.43	0.08	0.25	0.40	.12..EGG

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



Steel

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

Cast Iron

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

Cutting Data Table • Slotting

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

* Vs = Vertical Slot Preparation for T-slot.

Side Slot Machining

side slot dimension	(unit: mm)	
catalog number	W -0.1 / -0. (mm)	D max (mm)
KTMS21S25SD06H	9	4,4
KTMS25S25SD06H	11	5,4
KTMS32S32SD08H	14	6,9
KTMS40S32SD12H	18	8,9
KTMS50S32SD12H	22	10,9

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

Cutting Data Table • Side Machining

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

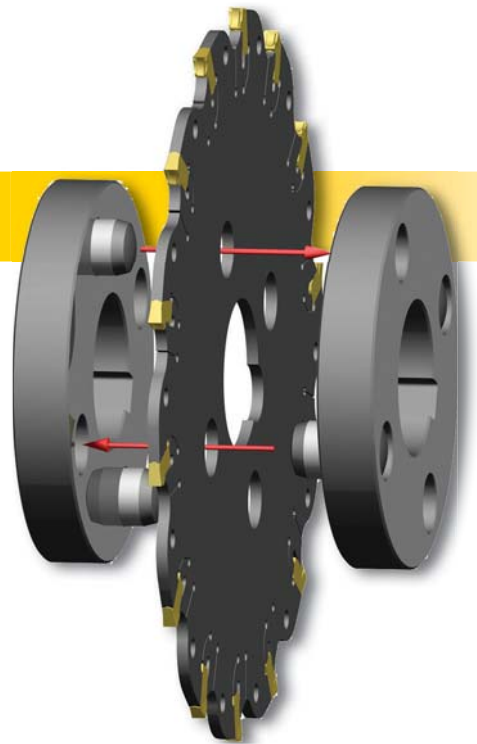
➤ KVNS™ Slotting Cutter

Primary Application

The KVNS slotting cutter enables diameters from 2.50–10" and insert widths from .063–.245". It is a perfect solution for small groove widths, grades, and geometries and suits most materials. Drive rings and support rings are available; use these items to get the maximum support for the cutter body.

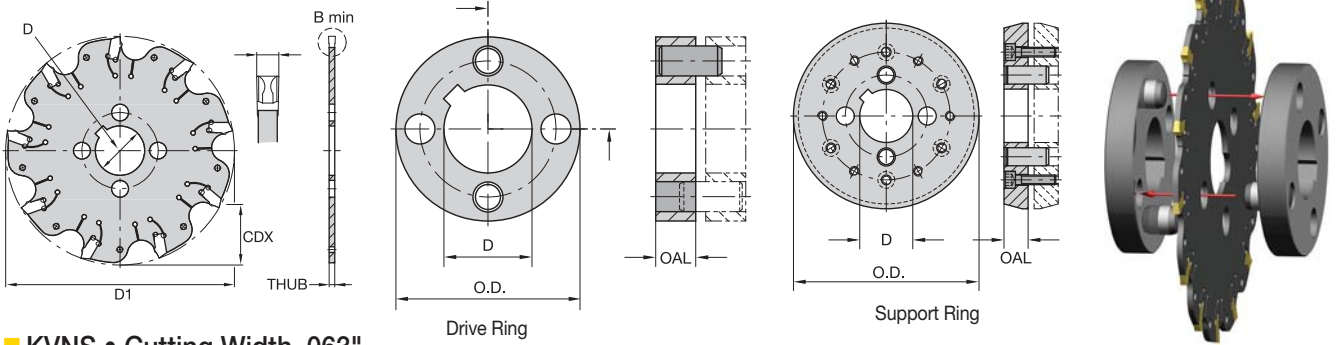
Features and Benefits

- Slot widths from .063–.245".
- Grades and geometries to suit most workpiece materials.
- Self-clamping inserts.
- Positive chipforming inserts are standard.
- Self-clamping insert seat with fixed stop.
- Excellent for all flat-bottom slotting and cut-off operations.
- Two drive hubs required for each cutter body, except when using two drive supports.
- Drive rings and support rings available, must be ordered separately (in pairs).





- .063–.245" slot width range.
- Positive chipforming inserts are standard.
- Self-clamping insert seat with fixed stop.
- Excellent for all flat-bottom slotting and cut-off operations.
- Two drive rings required for each cutter body, except when using two drive supports (must be ordered separately, in pairs).


■ KVNS • Cutting Width .063"

order number	catalog number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	lbs
1247698	KVNS02063OD	2.500	.625	.063	.625	.051	5	5100	OD_1063_	1247652	<2.00
1247710	KVNS03063OD	3.000	.625	.063	.875	.051	7	4000	OD_1063_	1247675	<2.00
1247725	KVNS04063OD	4.000	1.000	.063	1.063	.051	9	3200	OD_1063_	1247660	<2.00
1247738	KVNS05063OD	5.000	1.250	.063	1.375	.051	11	2600	OD_1063_	1247663	<2.00

■ KVNS • Cutting Width .087"

order number	catalog number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	lbs
1247712	KVNS03087OD	3.000	.625	.089	.875	.071	7	4000	OD_2087_	1247675	<2.00
1247727	KVNS04087OD	4.000	1.000	.089	1.063	.071	9	3200	OD_2087_	1247660	<2.00
1247740	KVNS05087OD	5.000	1.250	.089	1.375	.071	11	2600	OD_2087_	1247663	<2.00
1247753	KVNS06087OD *	6.000	1.250	.089	1.438	.071	14	2000	OD_2087_	1247666	<2.00

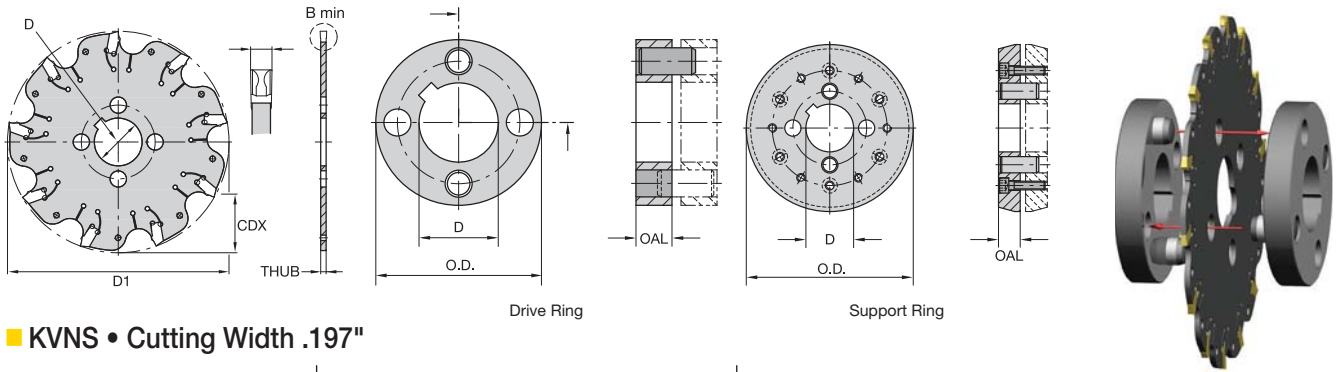
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

■ KVNS • Cutting Width .118"

order number	catalog number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	lbs
1247704	KVNS02118OD	2.500	.625	.126	.625	.095	4	5100	OD_3125_	1247650	<2.00
1247716	KVNS03118OD	3.000	.625	.126	.875	.095	6	4000	OD_3125_	1247675	<2.00
1247730	KVNS04118OD	4.000	1.000	.126	1.063	.095	9	3200	OD_3125_	1247660	<2.00
1247742	KVNS05118OD	5.000	1.250	.126	1.375	.095	11	2600	OD_3125_	1247663	<2.00
1247757	KVNS06118OD	6.000	1.250	.126	1.438	.095	14	2000	OD_3125_	1247666	<2.00
1247768	KVNS08118OD	8.000	2.000	.126	2.250	.095	19	1600	OD_3125_	1247668	<2.00
1247778	KVNS10118OD	10.000	2.000	.126	3.250	.095	24	1300	OD_3125_	1247668	<2.00

■ KVNS • Cutting Width .158"

order number	catalog number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	lbs
1247718	KVNS03158OD	3.000	.625	.164	.875	.134	6	4000	OD_4158_	1247675	<2.00
1247732	KVNS04158OD	4.000	1.000	.164	1.063	.134	9	3200	OD_4158_	1247660	<2.00
1247746	KVNS05158OD	5.000	1.250	.164	1.375	.134	11	2600	OD_4158_	1247663	<2.00



■ KVNS • Cutting Width .197"

order number	catalog number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	lbs
1247721	KVNS03197OD *	3.000	.625	.206	.875	.173	5	4000	OD_5197_	1247675	<2.00

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

■ KVNS • Cutting Width .236"

order number	catalog number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	drive ring	lbs
1247722	KVNS03236OD	3.000	.625	.245	.875	.213	5	4000	OD_6236_	1247675	<2.00
1247735	KVNS04236OD	4.000	1.000	.245	1.063	.213	8	3200	OD_6236_	1247660	<2.00
1247785	KVNS10236OD	10.000	2.000	.245	3.250	.213	24	1300	OD_6236_	1247668	<2.00

NOTE: Insert wrench 170.183 (order number 1124601) must be ordered separately.

■ Drive Rings

order number	D1	O.D.	OAL	bore size	drive ring	lbs
1247650	2.500	1.250	.315	.625	KAP1250632	.07
1247652	2.500	1.250	.315	.625	KAP1250634	.08
1247675	3.000	1.250	.315	.625	KAP1250764	.11
1247660	4.000	1.875	.394	1.000	KAP1871004	.20
1247663	5.000	2.250	.394	1.250	KAP2251254	.26
1247666	6.000	3.125	.472	1.250	KAP3121254	.75
1247668	8.000	3.500	.472	2.000	KAP3502004	.75
1247668	10.000	3.500	.472	2.000	KAP3502004	.75

NOTE: KAP1250634 is for use with KVNS020630D.
KAP1250632 is for use with KVNS021180D.

■ Support Rings

order number	catalog number	D1	O.D.	OAL	clamp screw	Allen key	bore size	lbs
1247669	KAP5502004	8.000	5.500	.472	125.616	170.005	2.000	2.53
1247669	KAP5502004	10.000	5.500	.472	125.616	170.005	2.000	2.53

■ Spare Parts



D1	support ring screw
8.000	125.616
10.000	125.616

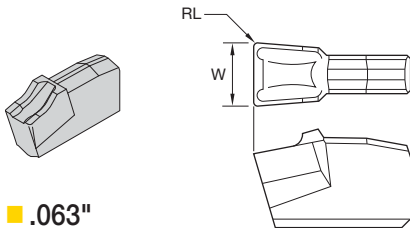
Slot Milling

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	.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

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



- first choice
- alternate choice

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

.063"

catalog number	W	RL	hm	KC735M	KCPK30	KMF
ODG1063ISGD	.063	.006	.003	●	●	-
ODG1063ISGB	.063	.006	.003	●	●	-
ODC1063IEGD	.063	.006	.003	-	-	●

.087"

catalog number	W	RL	hm	KC735M	KCPK30	KMF
ODG2087ISGD	.087	.008	.003	●	●	-
ODG2087ISGB	.087	.008	.003	●	●	-
ODC2087IEGD	.087	.008	.003	-	-	●

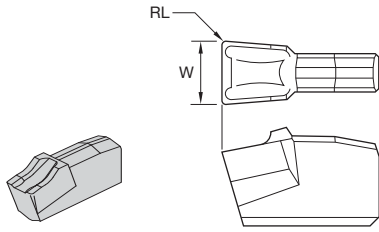
.118"

catalog number	W	RL	hm	KC735M	KCPK30	KMF
ODG3125ISGD	.120	.008	.003	●	●	-
ODG3125ISGB	.120	.008	.003	●	●	-
ODC3125IEGD	.119	.008	.003	-	-	●

.158"

catalog number	W	RL	hm	KC735M	KCPK30	KMF
ODG4158ISGD	.160	.008	.003	●	●	-
ODG4158ISGB	.160	.008	.003	●	●	-
ODC4158IEGD	.159	.008	.003	-	-	●





■ .197"

catalog number	W	RL	hm				
ODG5197ISGB	.199	.012	.003	●	KC735M	-	KCPK30

■ .236"

catalog number	W	RL	hm				
ODG6236ISGB	.238	.012	.003	●	KC735M	●	KCPK30

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

● first choice
○ alternate choice

Recommended Starting Feeds

■ Recommended Starting Feeds [IPT]

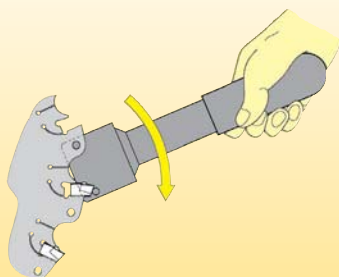
Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
.E..GD	.009	.015	.024	.007	.011	.017	.005	.008	.013	.004	.007	.011	.004	.007	.010	.E..GD
.S..GD	.009	.017	.026	.007	.013	.019	.005	.009	.014	.004	.008	.012	.004	.008	.011	.S..GD
.S..GB	.009	.017	.028	.007	.013	.020	.005	.009	.015	.004	.008	.013	.004	.008	.012	.S..GB

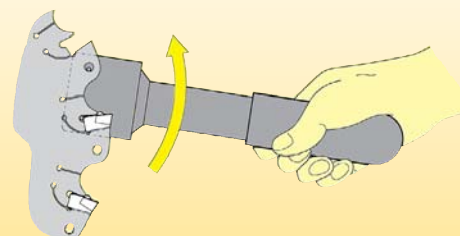
NOTE: Use "Light Machining" values as starting feed rate.
% = ae/Dc * 100 (ae = radial depth of cut, Dc = cutting diameter)
Please see pages X22-X37 for recommended starting speeds.

Slotting Cutters • Technical Information

■ 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.

Slot Milling

Kennametal on the Web

kennametal.com

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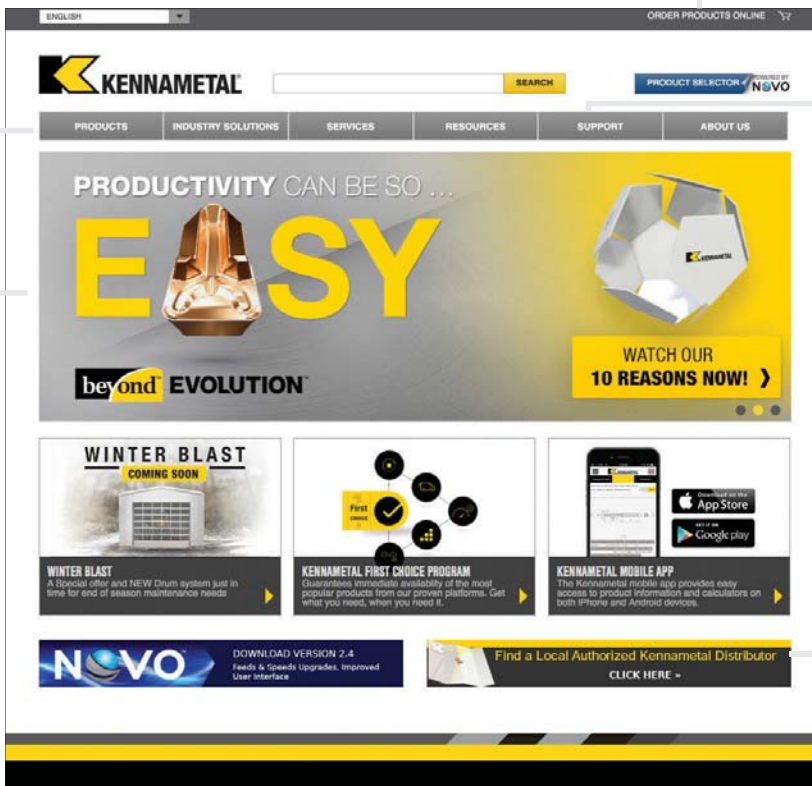
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➤ SN Slotting Cutter

Primary Application

SN slotting cutters are perfect for deeper applications that require the cutting load to be shared from one insert to the other. Provides groove widths from .161–.187" and cutter diameters from 4–6" as well as an economical way to achieve balanced cutting.

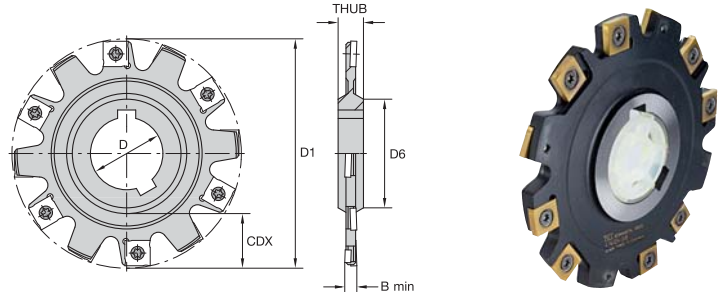
Features and Benefits

- Cutters available in arbor mount.
- Inserts with four indexes.
- Staggered key ways in mounting bore, used for multiple ganged cutters.
- Slot width .161–.187".
- Three insert geometries available: -GP, -GE, and -T.
- Requires only one spare part.





- .161–.187" slotting width range.
- Four indexes per insert.
- Three chipformers available.
- Two keyways for staggered mounting.
- Requires only one spare part.



■ SN • Cutting Width .161"

order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z U	max RPM	insert 1	lbs
1247681	KS426SNH1102	4.000	1.000	1.620	.161	1.120	.500	12	6	9530	SNHX1102T	<2.00
1247684	KS526SNH1102	5.000	1.250	1.880	.161	1.500	.500	14	7	8520	SNHX1102T	<2.00

■ SN • Cutting Width .187"

order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z U	max RPM	insert 1	lbs
1247686	KS333SNH1103	3.000	1.000	1.620	.187	.620	.500	10	5	10000	SNHX1103T	<2.00
1247688	KS433SNH1103	4.000	1.000	1.620	.187	1.120	.500	12	6	8660	SNHX1103T	<2.00
1247691	KS533SNH1103	5.000	1.250	1.880	.187	1.500	.500	14	7	7745	SNHX1103T	<2.00
1247694	KS633SNH1103	6.000	1.250	1.880	.187	2.000	.500	18	9	7070	SNHX1103T	2.00

■ Spare Parts



D1	insert screw	in. lbs.	Torx driver
3.000	192.530	10	DT7
4.000	192.530	10	DT7
5.000	192.530	10	DT7
6.000	192.530	10	DT7

NOTE: Slot width tolerance is +/- .003" over standard insert.
Bottom slot angle is 2°.

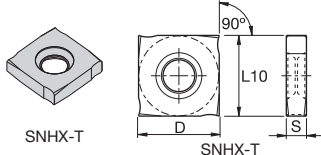
Slot Milling

■ 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.



- first choice
- alternate choice

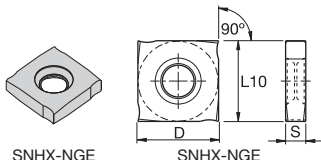
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M	○	○	○	○	○	○
K	○	○	○	○	○	○
N	○	○	○	○	○	○
S	○	○	○	○	○	○
H	○	○	○	○	○	○

■ SNHX-T

catalog number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
SNHX1102T	.433	.091	.433	.006	4	-	-	-	●	-	●
SNHX1103T	.433	.106	.433	.006	4	-	-	-	●	-	●
SNHX1203T	.500	.126	.500	.006	4	-	-	-	●	-	●
SNHX1204T	.500	.157	.500	.004	4	-	-	-	●	-	●
SNHX12045T	.500	.177	.500	.004	4	-	-	-	●	-	●
SNHX1205T	.500	.213	.500	.004	4	-	-	-	●	-	●

NOTE: Inch cutter bodies for SNHX12* inserts are available upon request.

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



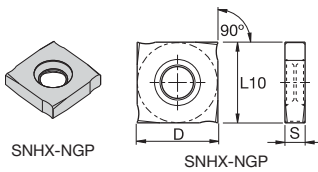
■ SNHX-NGE

catalog number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
SNHX11T3PZFNGE	.433	.106	.433	.002	4	-	●	-	-	-	-
SNHX1203PZFNGE	.500	.126	.500	.002	4	-	●	-	-	-	-
SNHX12L5PZFNGE	.500	.213	.500	.002	4	●	●	-	-	-	-

NOTE: Inch cutter bodies for SNHX12* inserts are available upon request.

Slot Milling

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



● first choice
○ alternate choice

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

■ SNHX-NGP

catalog number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KCPK30	KCPM40
SNHX1102PZTNGP	.433	.091	.433	.006	4	●	-	-	●	●	●
SNHX11T3PZTNGP	.433	.106	.433	.006	4	-	-	-	●	-	●
SNHX1203PZTNGP	.500	.126	.500	.006	4	●	-	-	●	●	●
SNHX12L4PZTNGP	.500	.177	.500	.006	4	-	-	-	-	●	-
SNHX12L5PZTNGP	.500	.213	.500	.006	4	●	-	-	●	●	-

NOTE: Inch cutter bodies for SNHX12* inserts are available upon request.

Recommended Starting Feeds

■ Recommended Starting Feeds [IPT]

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

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
.F..GE	.005	.017	.028	.004	.012	.020	.003	.009	.015	.002	.008	.013	.002	.007	.012	.F..GE
.T..GP	.009	.018	.027	.007	.013	.020	.005	.010	.015	.004	.009	.013	.004	.008	.012	.T..GP
..T	.009	.022	.032	.007	.016	.023	.005	.012	.017	.004	.010	.015	.004	.009	.014	..T

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

➤ LN Slotting Cutter

Primary Application

LN slotting cutters offer arbor and shell mill cutter options, groove widths from .250–.539", and cutter diameters from 3–8". Easy to adjust radially in .020" increments.

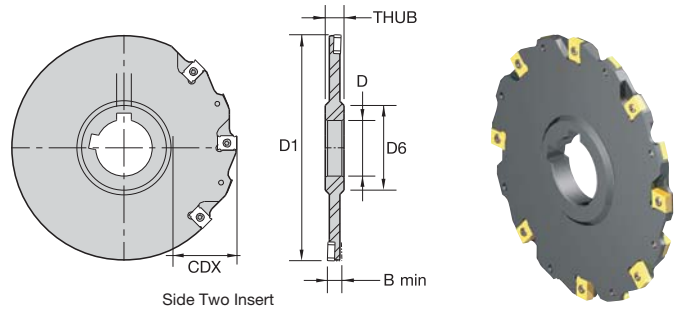


Features and Benefits

- Cutter available in arbor and shell mounts.
- Groove width .250–.500".
- Groove width can be increased by .020" or .040". Please consult the charts "Technical Information: Possible Insert Combinations".
NOTE: This involves changing the insert and insert screw.
- Easy width adjustment through insert thickness.
- Staggered internal keys.
- Positive chip grooves.
- Full side cutting.
- Neutral and positive chip forming inserts are standard.
- Four insert cutting edges.
- Requires only one spare part.



- .250–.500" slot width range.
- Easy width adjustment through insert thickness.
- Full side cutting.
- Neutral and positive chip forming inserts are standard.
- Four insert cutting edges.
- Two keyways for staggered mounting.
- Requires only one spare part.
- Base slot angle: 2°.
- Maximum slot width tolerance: +/- 0,001".



■ LN • Cutting Width .250"

order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	insert 1	lbs
1025930	KS34LNE1240	3.000	1.000	1.500	.250	.594	.500	8	4	9470	MS1281	TT15	35	LNE_1240__	.36
1025931	KS44LNE1240	4.000	1.250	1.880	.250	.904	.500	10	5	8200	MS1281	TT15	35	LNE_1240__	.66
1025895	KS54LNE1240	5.000	1.250	1.880	.250	1.404	.500	12	6	7300	MS1281	TT15	35	LNE_1240__	1.08
1025932	KS64LNE1240	6.000	1.500	2.250	.250	1.747	.500	16	8	6700	MS1281	TT15	35	LNE_1240__	1.54
1025933	KS84LNE1240	8.000	1.500	2.250	.250	2.719	.500	18	9	5800	MS1281	TT15	35	LNE_1240__	2.87

■ LN • Cutting Width .312"

order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	insert 1	lbs
1025964	KS45LNE1245	4.000	1.250	1.880	.312	.935	.500	10	5	7400	MS1282	TT15	35	LNE_1245__	.81
1025896	KS55LNE1245	5.000	1.250	1.880	.312	1.435	.500	12	6	6600	MS1282	TT15	35	LNE_1245__	1.33
1025965	KS65LNE1245	6.000	1.500	2.250	.312	1.750	.500	16	8	6000	MS1282	TT15	35	LNE_1245__	1.93
1025897	KS85LNE1245	8.000	1.500	2.250	.312	2.750	.500	18	9	5200	MS1282	TT15	35	LNE_1245__	3.62

■ LN • Cutting Width .375"

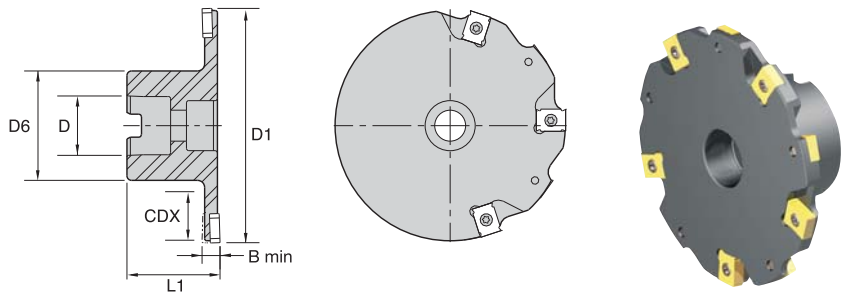
order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	insert 1	lbs
1025966	KS46LNE1245	4.000	1.250	1.880	.375	.966	.500	9	3	7400	MS1282	TT15	35	LNE_1245__	.96
1025898	KS56LNE1245	5.000	1.250	1.880	.375	1.466	.500	12	4	6600	MS1282	TT15	35	LNE_1245__	1.57
1025967	KS66LNE1245	6.000	1.500	2.250	.375	1.809	.500	15	5	8000	MS1282	TT15	35	LNE_1245__	1.56
1025968	KS86LNE1245	8.000	1.500	2.250	.375	2.781	.500	18	6	5200	MS1282	TT15	35	LNE_1245__	1.56

■ LN • Cutting Width .500"

order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	insert 1	lbs
1025969	KS48LNE1255	4.000	1.250	1.880	.500	1.060	.500	9	3	4900	MS1284	TT15	35	LNE_1255__	1.23
1025899	KS58LNE1255	5.000	1.250	1.880	.500	1.560	.500	12	4	4400	MS1284	TT15	35	LNE_1255__	2.07
1025970	KS68LNE1255	6.000	1.500	2.250	.500	1.844	.500	15	5	4000	MS1284	TT15	35	LNE_1255__	3.04
1025971	KS88LNE1255	8.000	1.500	2.250	.500	2.875	.500	18	6	3500	MS1284	TT15	35	LNE_1255__	5.83

NOTE: Slot width tolerance is +/- .003" over standard insert.

- .250–.500" slot width range.
- Easy width adjustment through insert thickness.
- Full side cutting.
- Neutral and positive chip forming inserts are standard.
- Four insert cutting edges.
- Requires only one spare part.
- Base slot angle: 2°.
- Maximum slot width tolerance: +/- 0,001".



■ LN • Cutting Width .250"



order number	catalog number	D1	D	D6	B min	CDX	L1	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	flat-head cap screw	socket-head cap screw	insert 1
1067765	KS254BLNE1240	2.500	.750	1.580	.250	.560	1.875	6	3	10400	MS1281	TT15	35	S1903	—	LNE_1240__
1025861	KS44BLNE1240	4.000	1.000	1.880	.250	.940	1.570	10	5	8200	MS1281	TT15	35	—	S458	LNE_1240__

■ LN • Cutting Width .312"



order number	catalog number	D1	D	D6	B min	CDX	L1	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	flat-head cap screw	socket-head cap screw	insert 1
1067766	KS255BLNE1245	2.500	.750	1.580	.312	.560	1.875	6	3	9400	MS1282	TT15	35	S1903	—	LNE_1245__
1025862	KS45BLNE1245	4.000	1.000	1.880	.312	.942	1.570	10	5	7400	MS1282	TT15	35	—	S458	LNE_1245__

■ LN • Cutting Width .375"



order number	catalog number	D1	D	D6	B min	CDX	L1	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	socket-head cap screw	insert 1
1025863	KS46BLNE1245	4.000	1.000	1.880	.375	.942	1.570	9	3	7400	MS1282	TT15	35	S458	LNE_1245__

■ LN • Cutting Width .500"



order number	catalog number	D1	D	D6	B min	CDX	L1	Z	Z U	max RPM	insert screw	Torx wrench	in. lbs.	socket-head cap screw	insert 1
1025894	KS48BLNE1255	4.000	1.000	1.880	.500	.940	2.000	9	3	4900	MS1284	TT15	35	S458	LNE_1255__

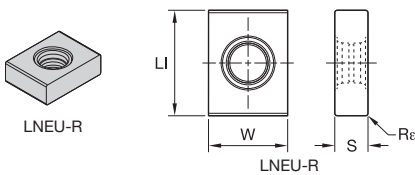
NOTE: Slot width tolerance is +/- .003" over standard insert.

■ Insert Selection Guide

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

Indexable Inserts • 0° LN Slot LNEU

- Light machining.
- Four cutting edges.



- first choice
- alternate choice

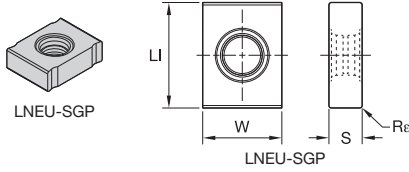
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M	●	○	○	○	○
K	●	○	○	○	○
N	○	○	○	○	○
S	●	○	○	○	○
H	○	○	○	○	○

■ LNEU-R

catalog number	LI	W	S	Re	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40
LNEU1235R03 4	.500	.375	.138	.012	.002	4	●	●	-	-	●
LNEU1240R03 4	.500	.375	.157	.012	.002	4	●	●	-	-	●
LNEU1245R04	.500	.375	.177	.016	.002	4	●	●	-	-	●
LNEU1250R04	.500	.375	.197	.016	.002	4	-	●	-	-	●
LNEU1255R04	.500	.375	.217	.016	.002	4	-	●	-	-	●
LNEU1260R04	.500	.375	.236	.016	.002	4	-	●	-	-	●
LNEU1240R08 4	.500	.375	.157	.031	.002	4	●	●	-	-	●
LNEU1245R08	.500	.375	.177	.031	.002	4	●	●	-	-	●
LNEU1250R08	.500	.375	.197	.031	.002	4	-	●	-	-	●
LNEU1255R08	.500	.375	.217	.031	.002	4	●	●	-	-	●
LNEU1240R16 4	.500	.375	.157	.062	.002	4	-	●	-	-	-
LNEU1245R16	.500	.375	.177	.062	.002	4	●	●	-	-	-
LNEU1255R16	.500	.375	.217	.062	.002	4	-	●	-	-	-
LNEU1245R32	.500	.375	.177	.125	.002	4	●	●	-	-	-
LNEU1255R32	.500	.375	.217	.125	.002	4	-	●	-	-	-



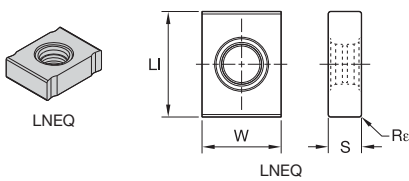
- Medium machining with chip groove.
- Four cutting edges.



LNEU-SGP

catalog number	LI	W	S	Rε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40
LNEU1235R03SGP 4	.500	.375	.138	.012	.004	4	-	●	-	-	-
LNEU1240R03SGP 4	.500	.375	.157	.012	.004	4	-	●	-	-	-
LNEU1245R04SGP	.500	.375	.177	.016	.004	4	-	●	-	-	-
LNEU1250R04SGP	.500	.375	.197	.016	.004	4	-	●	-	-	-
LNEU1245R08SGP	.500	.375	.177	.031	.004	4	-	●	-	-	●
LNEU1250R08SGP	.500	.375	.197	.031	.004	4	-	●	-	-	-
LNEU1245R16SGP	.500	.375	.177	.063	.004	4	-	●	-	-	-

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



LNEQ

catalog number	LI	W	S	Rε	hm	cutting edges	KC520M	KC725M	KCK15	KCPK30	KCPM40
LNEQ1235R03 4	.500	.375	.138	.012	.002	4	-	●	●	-	-
LNEQ1240R03 4	.500	.375	.157	.012	.002	4	-	●	-	●	-
LNEQ1245R04	.500	.375	.177	.016	.002	4	●	●	●	●	-
LNEQ1250R04	.500	.375	.197	.016	.002	4	-	-	●	-	-
LNEQ1255R04	.500	.375	.217	.016	.002	4	-	●	●	-	-
LNEQ1260R04	.500	.375	.236	.016	.002	4	-	●	●	-	●

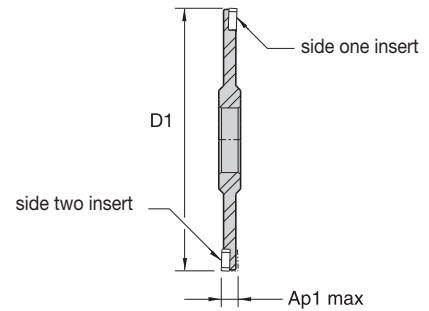
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M	●	○	○	○
K	●	●	○	○
N	○	○	○	○
S	●	○	○	○
H	○	○	○	○

- first choice
- alternate choice



Slot Milling

- Utilizes wider inserts in standard cutter bodies.
- Cutting width of the unique LNE insert style for narrow slotting cutters can be varied by using an insert one size thicker.
- The width can be increased in .020" or .040" increments.
- Refer to the insert combination in the table "LN Slotting Cutter Widths" for insert and screw selection.



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

cutter catalog number	D1	Ap1 max	Ap1 max (new)	side one insert*	screw**	side two insert*	screw**
KS34LNE	3.000	.250	.270	LNE1240	MS-1281	LNE1245	MS-1282
KS44LNE	4.000	.250	.270	LNE1240	MS-1281	LNE1245	MS-1282
KS54LNE	5.000	.250	.289	LNE1245	MS-1282	LNE1245	MS-1282
KS64LNE	6.000	.250	.289	LNE1245	MS-1282	LNE1245	MS-1282
KS84LNE	8.000	.250	.289	LNE1245	MS-1282	LNE1245	MS-1282
KS45LNE	4.000	.312	.332	LNE1245	MS-1282	LNE1250	MS-1283
KS55LNE	5.000	.312	.332	LNE1245	MS-1282	LNE1250	MS-1283
KS65LNE	6.000	.312	.351	LNE1250	MS-1283	LNE1250	MS-1283
KS85LNE	8.000	.312	.351	LNE1250	MS-1283	LNE1250	MS-1283
KS46LNE	4.000	.375	.395	LNE1245	MS-1282	LNE1250	MS-1283
KS56LNE	5.000	.375	.395	LNE1245	MS-1282	LNE1250	MS-1283
KS66LNE	6.000	.375	.414	LNE1250	MS-1283	LNE1250	MS-1283
KS86LNE	8.000	.375	.414	LNE1250	MS-1283	LNE1250	MS-1283
KS48LNE	4.000	.500	.520	LNE1255	MS-1284	LNE1260	MS-1285
KS58LNE	5.000	.500	.520	LNE1255	MS-1284	LNE1260	MS-1285
KS68LNE	6.000	.500	.539	LNE1260	MS-1285	LNE1260	MS-1285
KS88LNE	8.000	.500	.539	LNE1260	MS-1285	LNE1260	MS-1285

■ Example: Cutting Width of .289"

cutter catalog number	D1	Ap1 max (new)	side one insert*	screw**	side two insert*	screw**
KS34LNE	3.000	.289	LNE1245	MS-1282	LNE1245	MS-1282

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

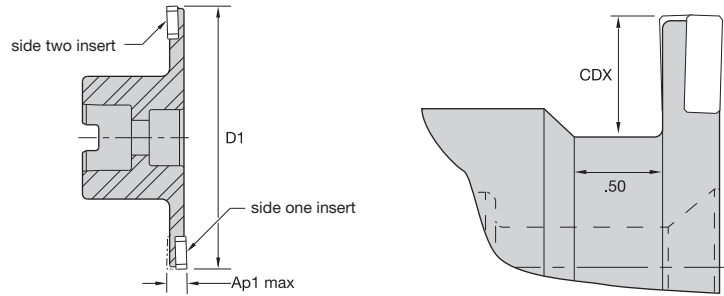
**When changing to wider insert thickness, use the necessary longer screw.

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

When using inserts that employ a radius of .094" or .125", the corner radius under the insert on the cutter body must be modified to a .10" radius or an optional .10" x 45° chamfer; see chart for detail.



- Utilizes wider inserts in standard cutter bodies.
- Cutting width of the unique LNE insert style for narrow slotting cutters can be varied by using an insert one size thicker.
- The width can be increased in .020" or .040" increments.
- Refer to the insert combination table below for insert selection.



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

cutter catalog number	D1	Ap1 max	Ap1 max (new)	side one insert*	screw**	side two insert*	screw**
KS254BLNE1240	2.500	.250	.270	LNE1240	MS-1281	LNE1245	MS-1282
KS44BLNE1240	4.000	.250	.289	LNE1245	MS-1282	LNE1245	MS-1282
KS255BLNE1245	2.500	.312	.332	LNE1245	MS-1282	LNE1250	MS-1283
KS45BLNE1245	4.000	.312	.351	LNE1250	MS-1283	LNE1250	MS-1283
KS46BLNE1245	4.000	.375	.395	LNE1245	MS-1282	LNE1250	MS-1283
KS46BLNE1245	4.000	.375	.414	LNE1250	MS-1283	LNE1250	MS-1283
KS48BLNE1255	4.000	.500	.520	LNE1255	MS-1284	LNE1260	MS-1285
KS48BLNE1255	4.000	.500	.539	LNE1260	MS-1285	LNE1260	MS-1285

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

**When changing to wider insert thickness, use the necessary longer screw.

NOTE: When using inserts with a radius of .094" or .125", the corner radius under the insert on the cutter body must be modified to a .10" radius or an optional .10" x 45° chamfer.

Recommended Starting Feeds

■ Recommended Starting Feeds [IPT]

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

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry	
	5%			10%			20%			30%			40-100%			
...	.007	.019	.027	.005	.013	.020	.004	.010	.015	.003	.009	.013	.003	.008	.012	...
.S..GP	.009	.020	.032	.007	.015	.023	.005	.011	.017	.004	.010	.015	.004	.009	.014	.S..GP

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

Slot Milling

NOVO KNOWS CAD/CAM

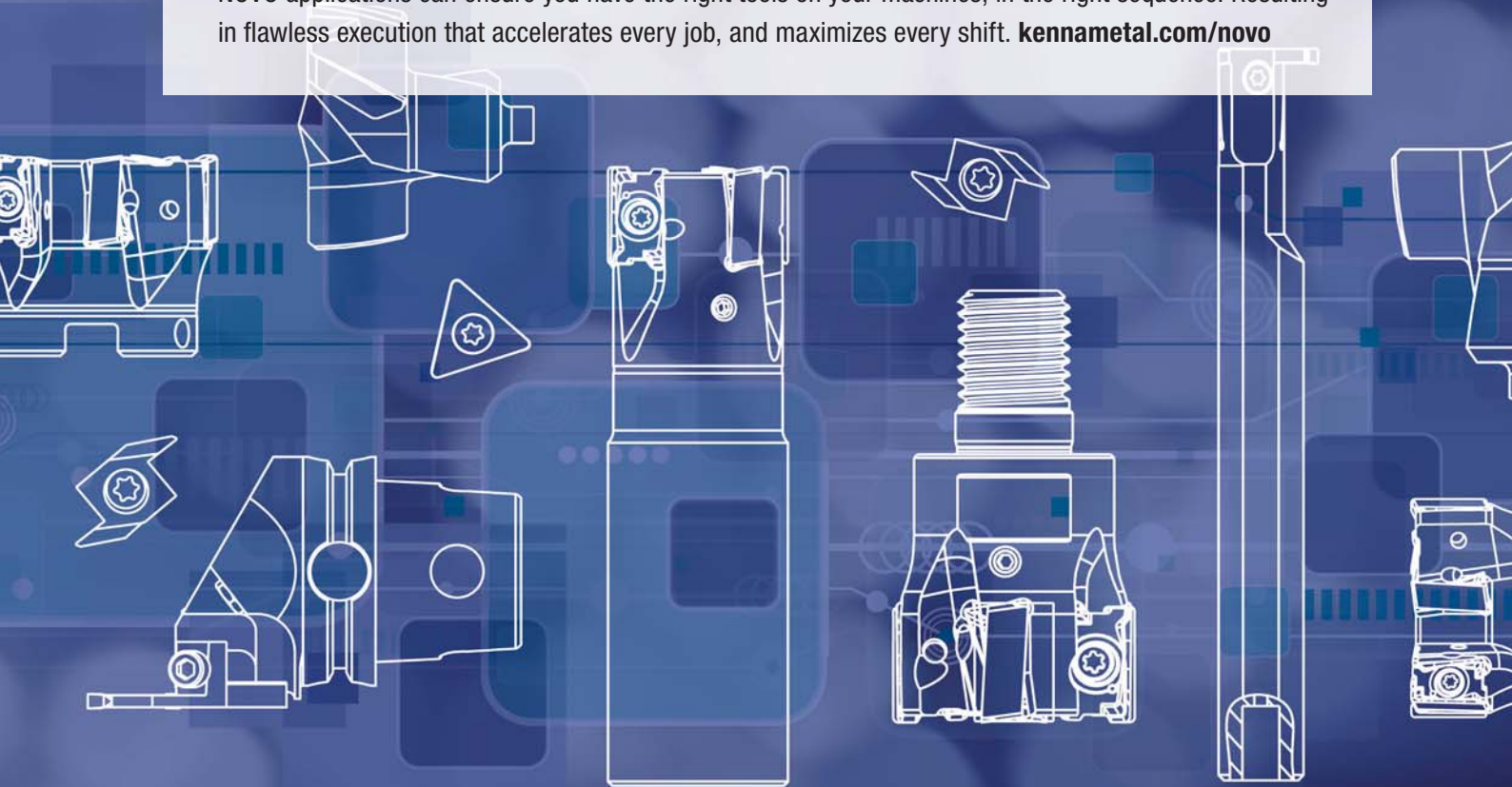
With the addition of NOVO™ applications to your team, your CAD/CAM capabilities become much more accurate, streamlined, and productive.

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

The concern is that assumptions are made, and only partial tooling information is entered.

With NOVO: The powerful digital intelligence of NOVO applications not only help the programmer find the right tool for the metalcutting job, but also automatically integrates all the tooling data into a complete CAD/CAM solution. The integration of all the tooling data increases the viability of the part being programmed, and is delivered quickly — saving you time.

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

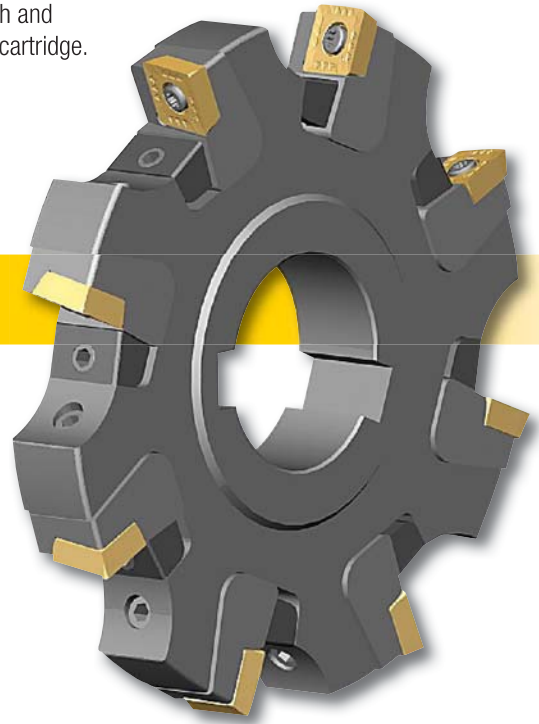


➤ KSSM™ Slotting Cutter

Primary Application

Cutters available in fixed and adjustable groove widths:

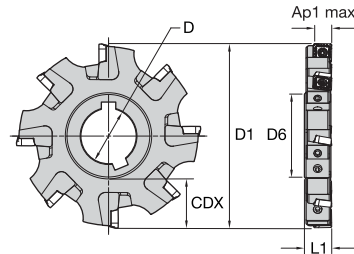
Cutters available in arbor and shell mounts, as well as in fixed and adjustable groove widths, with insert grades and geometries for most materials, KSSM fixed-width slotting cutters are a cost effective solution for the general engineering market. Very precise adjustments to achieve consistent widths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



Features and Benefits

- Cutters available in arbor and shell mounts, as well as in fixed and adjustable groove widths.
- Maximum groove widths:
 - Fixed cutters IC 10: .359" and .614".
 - Fixed cutters 1/2" IC: .461" and .739".
 - Adjustable cutters IC 10: .551–.709".
 - Adjustable cutters 1/2" IC: .709–.917".
- Rapid adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Faceted inserts for superior surface finish.
- Cutter diameter range is 4–12".
- Insert corner radii from 0.016–0.125".

- Right-hand and left-hand cutters with .359" width of cut.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Insert radii available.
- Faceted inserts for superior surface finishes.



■ Arbor Mount • 10mm IC • Right Hand

order number	catalog number	D1	D	D6	B min	CDX	L1	Ap1 max	Z	Z S	max RPM	lbs
3330528	100G10RP90SP10 *	3.937	1.260	1.841	.359	1.035	.630	.359	10	10	17200	1.20
2629770	KSSS400ASP10R625	4.000	1.250	1.880	—	1.038	.625	.359	10	10	17100	1.22
3330531	125H11RP90SP10 *	4.921	1.575	2.156	.359	1.370	.630	.359	11	11	15400	1.89

NOTE: For superior surface finish, use right-hand inserts.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

■ Arbor Mount • 10mm IC • Left Hand

order number	catalog number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	lbs
2629769	KSSS400ASP10L625	4.000	1.250	1.880	1.038	.625	.359	10	10	17100	1.22
2629772	KSSS500ASP10L625 *	5.000	1.500	2.250	1.353	.625	.359	11	11	15300	1.98

NOTE: For superior surface finish, use left-hand inserts.
Insert radii ≥ .062" (1,6mm) has no facet.
*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

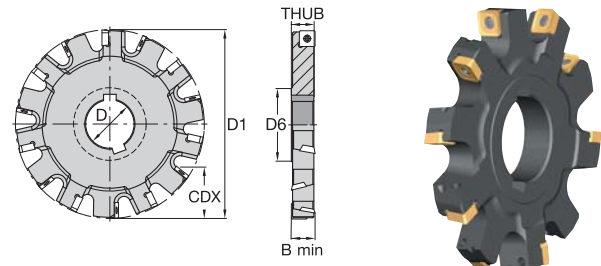
■ Spare Parts



D1	insert screw	in. lbs.	Torx Plus driver
4.000	MS2148	17	DT9IP
5.000	MS2148	17	DT9IP



- Neutral slot width (B min) is .614" + .010".
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide selection of insert radii.
- Faceted inserts for superior surface finishes.



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

order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z S	max RPM	lbs
2629768	KSSS400ASP10N625	4.000	1.250	1.880	.614	1.042	.542	10	5	17100	1.05
2629794	KSSS500ASP10N625	5.000	1.500	2.250	.614	1.357	.542	12	6	15300	1.75
2629774	KSSS600ASP10N625	6.000	1.500	2.250	.614	1.857	.542	12	6	14000	2.78

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

■ Spare Parts



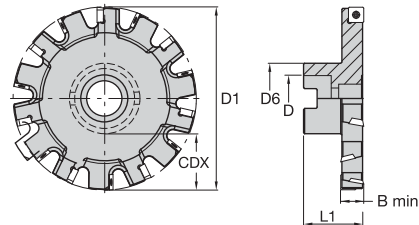
D1	insert screw	in. lbs.	Torx Plus driver
4.000	MS2148	17	DT9IP
5.000	MS2148	17	DT9IP
6.000	MS2148	17	DT9IP



Slot Milling



- Neutral slot width (B min) is .614" + .010".
- Neutral cutting.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide selection of insert radii.
- Faceted inserts for superior surface finishes.



■ **Shell Mount • 10mm IC • Neutral (Full Slotting)**

order number	catalog number	D1	D	D6	B min	CDX	L1	Z	Z S	max RPM	lbs
2629780	KSSS400BSP10N625	4.000	1.000	2.132	.614	.887	1.500	10	5	17100	2.12
2629781	KSSS500BSP10N625	5.000	1.250	2.880	.614	.995	1.750	12	6	15300	3.89
2629783	KSSS800BSP10N625	8.000	1.500	3.810	.614	2.030	2.000	14	7	12100	8.80

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

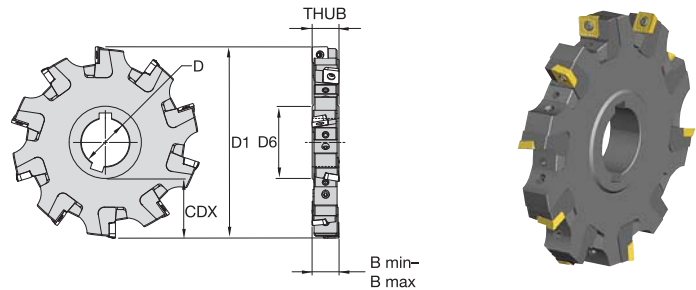
■ **Spare Parts**



D1	insert screw	in. lbs.	Torx Plus driver	socket-head cap screw
4.000	MS2148	17	DT9IP	S2044
5.000	MS2148	17	DT9IP	S467
8.000	MS2148	17	DT9IP	—



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



■ Arbor Mount • Slotting Cutter • .551–.630" Adjustment Range

order number	catalog number	D1	D	D6	B min	B max	CDX	L1	THUB	Z	Z S	max RPM	lbs
2268052	KSSS400ASP10N551-630	4.000	1.250	1.880	.551	.630	1.030	.548	.545	6	3	17100	1.17
2268640	KSSS600ASP10N551-630	6.000	1.500	2.250	.551	.630	1.845	.548	.545	10	5	14000	2.97
2268652	KSSS800ASP10N551-630	8.000	2.000	2.880	.551	.630	2.530	.548	.545	14	7	12100	5.53

■ Spare Parts

D1	cartridge right-hand	cartridge left-hand	wedge	cam pin wrench	insert screw	in. lbs.	Torx Plus wrench	cam pin	wedge wrench	wedge screw
4.000	KSSC551-630R	KSSC551-630L	KSSW551-630	MW25	MS2148	17	TTP9	KSSCP551-709	THW3M	STCM32
6.000	KSSC551-630R	KSSC551-630L	KSSW551-630	MW25	MS2148	17	TTP9	KSSCP551-709	THW3M	STCM11
8.000	KSSC551-630R	KSSC551-630L	KSSW551-630	MW25	MS2148	17	TTP9	KSSCP551-709	THW3M	STCM11

■ Arbor Mount • Slotting Cutter • .630–.709" Adjustment Range

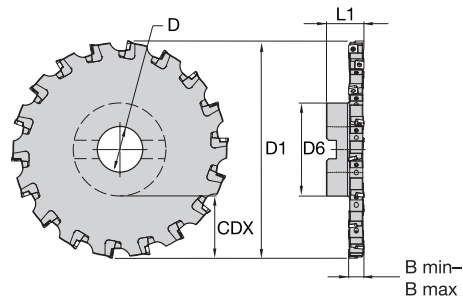
order number	catalog number	D1	D	D6	B min	B max	CDX	L1	THUB	Z	Z S	max RPM	lbs
2268634	KSSS500ASP10N630-709 *	5.000	1.500	2.250	.630	.709	1.345	.627	.624	8	4	15300	2.27
2268670	KSSS1200ASP10N630-709 *	12.000	2.000	2.880	.630	.709	4.530	.627	.624	20	10	9900	15.96

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

■ Spare Parts

D1	cartridge right-hand	cartridge left-hand	wedge	cam pin wrench	insert screw	in. lbs.	Torx Plus wrench	cam pin	wedge wrench	wedge screw
12.000	KSSC630-709R	KSSC630-709L	KSSW630-709	MW25	MS2148	17	TTP9	KSSCP551-709	THW3M	STCM11
5.000	KSSC630-709R	KSSC630-709L	KSSW630-709	MW25	MS2148	17	TTP9	KSSCP551-709	THW3M	STCM11

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



■ **Shell Mount • Slotting Cutting • .551-.630" Adjustment Range**

order number	catalog number	D1	D	D6	B min	B max	CDX	L1	Z	Z S	max RPM	lbs
2268625	KSSS400BSP10N551-630	4.000	1.000	2.132	.551	.630	.872	2.072	6	3	17100	2.49

■ **Spare Parts**

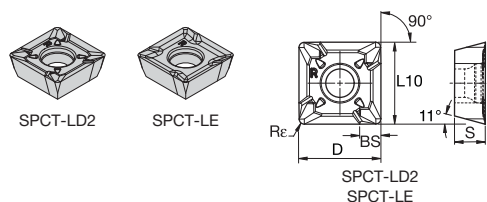
D1	cartridge right-hand	cartridge left-hand	wedge	cam pin wrench	insert screw	in. lbs.	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
4.000	KSSC551-630R	KSSC551-630L	KSSW551-630	MW25	MS2148	17	TTP9	KSSCP551-709	THW3M	STCM11	S458

■ Insert Selection Guide

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

Indexable Inserts for KSSM™ SP.T10T3...

- Light-duty Insert.
- Four cutting edges.



- first choice
- alternate choice

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

■ SPCT-LD2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
SPCT31251PPEL8LD2	.394	.156	.394	.106	.016	.002	4	-	-	●	-	-	-	-	-
SPCT31251PPER8LD2	.394	.156	.394	.106	.016	.002	4	-	-	●	-	-	-	-	-
SPCT3125PPEL8LD2	.394	.156	.394	.106	.031	.002	4	-	-	●	-	-	-	-	-
SPCT3125PPER8LD2	.394	.156	.394	.106	.031	.002	4	-	-	●	-	-	-	-	-
SPCT31253PPEL8LD2	.394	.156	.394	.106	.047	.002	4	-	-	●	-	-	-	-	-
SPCT31253PPER8LD2	.394	.156	.394	.106	.047	.002	4	-	-	●	-	-	-	-	-
SPCT31254ENLD2	.394	.156	.394	-	.063	.002	4	-	-	●	-	-	-	●	-
SPCT31255ENLD2	.394	.156	.394	-	.078	.002	4	-	-	●	-	-	-	-	-

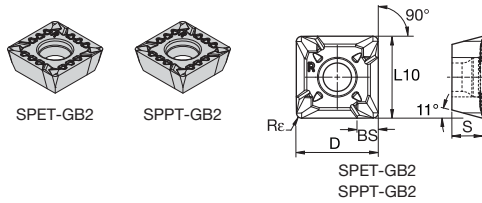
- Light-duty Insert.
- Four cutting edges.

■ SPCT-LE

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
SPCT31251PPFL8LE	.394	.156	.394	.106	.016	.001	4	●	-	-	-	-	-	-	-
SPCT31251PPFR8LE	.394	.156	.394	.106	.016	.001	4	●	-	-	-	-	-	-	-
SPCT3125PPFL8LE	.394	.156	.394	.106	.031	.001	4	●	-	-	-	-	-	-	-
SPCT3125PPFR8LE	.394	.156	.394	.106	.031	.001	4	●	-	-	-	-	-	-	-
SPCT31253PPFR8LE	.394	.156	.394	.106	.047	.001	4	●	-	-	-	-	-	-	-
SPCT31255FNLE	.394	.156	.394	-	.078	.001	4	●	-	-	-	-	-	-	-

Slot Milling

- Light-duty Insert.
- Four cutting edges.



- first choice
- alternate choice

P	●																			
M																				
K																				
N																				
S																				
H																				

■ SPET-GB2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
SPET31251PPEL8GB2	.394	.156	.394	.106	.016	.003	4	-	-	●	●	●	-	-	-
SPET31251PPER8GB2	.394	.156	.394	.106	.016	.003	4	-	-	●	●	●	-	-	-
SPET3125PPEL8GB2	.394	.156	.394	.106	.031	.003	4	-	●	●	●	●	-	-	-
SPET3125PPER8GB2	.394	.156	.394	.106	.031	.003	4	-	●	●	●	●	-	-	-
SPET3125PPSL8GB2	.394	.156	.394	.106	.031	.005	4	-	-	-	●	●	-	-	-
SPET3125PPSR8GB2	.394	.156	.394	.106	.031	.005	4	-	●	●	●	●	-	-	-

■ SPPT-GB2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KTPK20
SPPT3125PPER8GB2	.394	.156	.394	.106	.031	.003	4	-	-	-	●	●	-	-	-
SPPT3125PPSR8GB2	.394	.156	.394	.106	.031	.005	4	-	-	-	●	●	-	-	●

Recommended Starting Feeds

■ Recommended Starting Feeds [IPT]

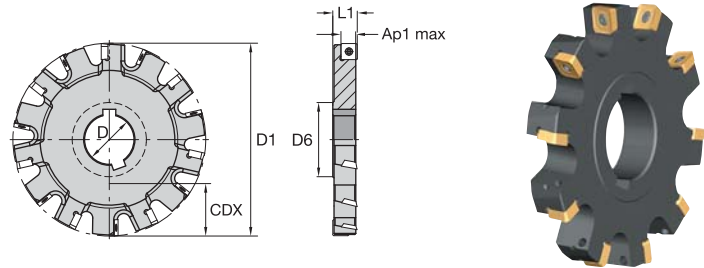
Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry	
	5%		10%			20%		30%		40-100%						
.F..LE	.005	.017	.028	.003	.012	.020	.003	.009	.015	.002	.008	.013	.002	.007	.012	.F..LE
.F..LD	.005	.017	.028	.003	.012	.020	.003	.009	.015	.002	.008	.013	.002	.007	.012	.F..LD
.E..LD2	.005	.018	.032	.004	.013	.023	.003	.010	.017	.002	.009	.015	.002	.008	.014	.E..LD2
.E..LD	.007	.019	.032	.005	.013	.023	.004	.010	.017	.003	.009	.015	.003	.008	.014	.E..LD
.E..GB2	.009	.021	.035	.007	.015	.025	.005	.011	.019	.004	.010	.016	.004	.009	.015	.E..GB2
.S..GB	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GB
.S..GB2	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GB2
.S..GN	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GN

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



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



■ Arbor Mount • 1/2" IC • Right Hand

order number	catalog number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	lbs
2618969	KSSS600ASD43R750	6.000	1.500	2.250	1.851	.750	.461	12	12	9400	3.73
2629787	KSSS800ASD43R750	8.000	2.000	2.880	2.536	.750	.461	14	14	8150	6.86
2629790	KSSS1000ASD43R750 *	10.000	2.000	2.880	3.536	.750	.461	16	16	7250	11.44

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

■ Arbor Mount • 1/2" IC • Left Hand

order number	catalog number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	lbs
2629784	KSSS600ASD43L750	6.000	1.500	2.250	1.851	.750	.461	12	12	9400	3.73
2629786	KSSS800ASD43L750	8.000	2.000	2.880	2.536	.750	.461	14	14	8150	6.86

■ Spare Parts

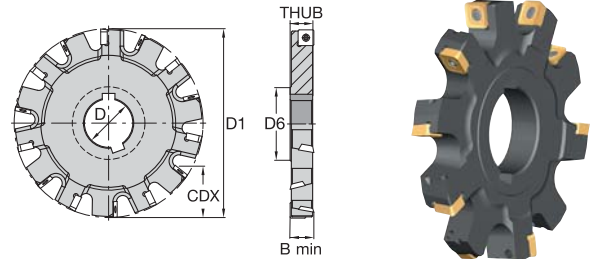


D1	insert screw	in. lbs.	Torx Plus driver
6.000	MS2078	35	DT15IP
8.000	MS2078	35	DT15IP
10.000	MS2078	35	DT15IP

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

Slot Milling

- Neutral slot width (B min) is .739" + .010" wide.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Large selection of insert radii.
- Faceted inserts for superior surface finishes.



■ Arbor Mount • 1/2" IC • Neutral (Full Slotting)

order number	catalog number	D1	D	D6	B min	CDX	THUB	Z	Z S	max RPM	lbs
2618967	KSSS600ASD43N750	6.000	1.500	2.250	.744	1.857	.666	14	7	9400	3.49
2629785	KSSS800ASD43N750	8.000	2.000	2.880	.739	2.542	.666	18	9	8150	6.58
2629788	KSSS1000ASD43N750	10.000	2.000	2.880	.739	3.542	.666	22	11	7250	11.02

■ Spare Parts

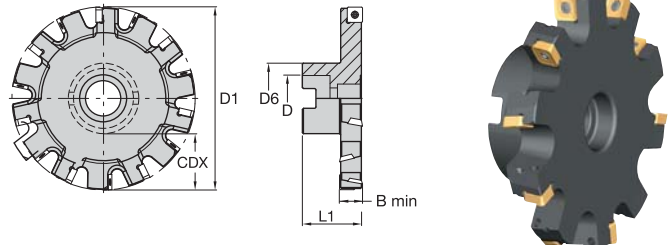


D1	insert screw	in. lbs.	Torx Plus driver
6.000	MS2078	35	DT15IP
8.000	MS2078	35	DT15IP
10.000	MS2078	35	DT15IP

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



- Neutral slot width (B min) is .739" + .010" wide.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Large selection of insert radii.
- Faceted inserts for superior surface finishes.



■ Shell Mount • 1/2" IC • Neutral (Full Slotting)

order number	catalog number	D1	D	D6	B min	CDX	L1	Z	Z S	max RPM	lbs
2629791	KSSS600BSD43N750	6.000	1.500	3.810	.739	1.029	2.000	14	7	9400	6.28
2629792	KSSS800BSD43N750	8.000	1.500	3.810	.739	2.029	2.000	18	9	8150	9.90

■ Spare Parts



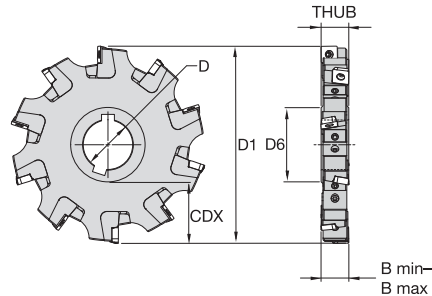
D1	insert screw	in. lbs.	Torx Plus driver
6.000	MS2078	35	DT15IP
8.000	MS2078	35	DT15IP

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





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

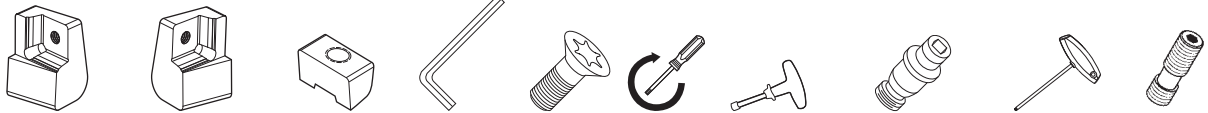


Arbor Mount • Slotting Cutter • .709–.813" Adjustment Range

order number	catalog number	D1	D	D6	B min	B max	CDX	THUB	Z	Z S	max RPM	lbs
2268676	KSSS500ASD43N709-813	5.000	1.500	2.250	.709	.813	1.331	.716	8	4	10300	2.33
2268688	KSSS600ASD43N709-813 *	6.000	1.500	2.250	.709	.813	1.831	.716	10	5	9400	3.62
2268712	KSSS1000ASD43N709-813	10.000	2.000	2.880	.709	.813	3.516	.716	16	8	7250	11.51
2268724	KSSS1200ASD43N709-813	12.000	2.000	2.880	.709	.813	4.516	.716	18	9	6650	17.30

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

Spare Parts



D1	cartridge right-hand	cartridge left-hand	wedge	cam pin wrench	insert screw	in. lbs.	Torx Plus wrench	cam pin	wedge wrench	wedge screw
5.000	KSSC709-813R	KSSC709-813L	KSSW709-813	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	STCM11
6.000	KSSC709-813R	KSSC709-813L	KSSW709-813	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	STCM11
10.000	KSSC709-813R	KSSC709-813L	KSSW709-813	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	STCM11
12.000	KSSC709-813R	KSSC709-813L	KSSW709-813	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	STCM11

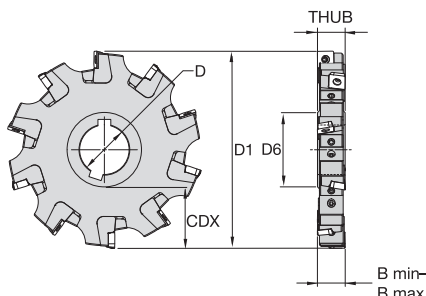
Cartridges • Larger Insert Radii

order number	catalog number
3663324	KSSC709813RX
3663325	KSSC709813LX

NOTE: Use left- or right-hand cartridges for neutral cutters. Fits all larger radii inserts.



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



■ Arbor Mount • Slotting Cutter • .813–.917" Adjustment Range

order number	catalog number	D1	D	D6	B min	B max	CDX	THUB	Z	Z S	max RPM	lbs
2268694	KSSS600ASD43N813-917	6.000	1.500	2.250	.813	.917	1.831	.820	10	5	9400	4.23
2268706	KSSS800ASD43N813-917 *	8.000	2.000	2.880	.813	.917	2.516	.820	14	7	8150	7.99
2268730	KSSS1200ASD43N813-917 *	12.000	2.000	2.880	.813	.917	4.516	.820	18	9	6650	20.20

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

■ Spare Parts

D1	cartridge right-hand	cartridge left-hand	wedge	cam pin wrench	insert screw	in. lbs.	Torx Plus wrench	cam pin	wedge wrench	wedge screw
6.000	KSSC813-917R	KSSC813-917L	KSSW813-917	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	STCM11
8.000	KSSC813-917R	KSSC813-917L	KSSW813-917	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	STCM11
12.000	KSSC813-917R	KSSC813-917L	KSSW813-917	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	STCM11

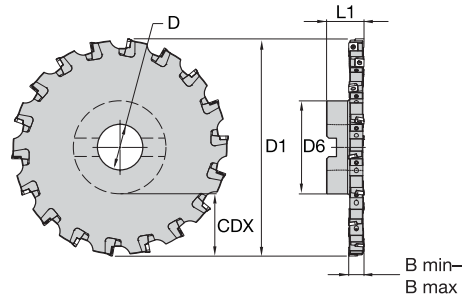
■ Cartridges • Larger Insert Radii

order number	catalog number
3663326	KSSC813917RX
3663327	KSSC813917LX

NOTE: Use left- or right-hand cartridges for neutral cutters. Fits all larger radii inserts.

Slot Milling

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



■ **Shell Mount • Slotting Cutting • .709-.813" Adjustment Range**

order number	catalog number	D1	D	D6	B min	B max	CDX	L1	Z	Z S	max RPM	lbs
2268679	KSSS500BSD43N709-813	5.000	1.250	2.880	.709	.813	.997	2.093	8	4	10300	4.55
2268727	KSSS1200BSD43N709-813	12.000	2.500	5.250	.709	.813	3.312	2.093	18	9	6650	19.83

■ **Spare Parts**

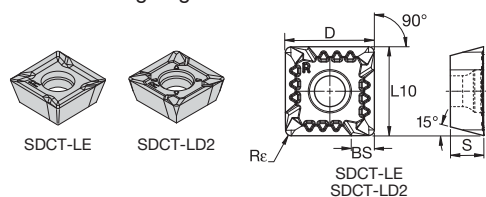
D1	cartridge right-hand	cartridge left-hand	wedge	cam pin wrench	insert screw	in. lbs.	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
5.000	KSSC709-813R	KSSC709-813L	KSSW709-813	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	KSSW709-813	S467
12.000	KSSC709-813R	KSSC709-813L	KSSW709-813	MW3	MS2077	35	TTP15	KSSCP709-917	THW3M	KSSW709-813	—

Insert Selection Guide

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

Indexable Inserts • KSSM™ SD.T1204...

- Light-duty Insert.
- Four cutting edges.



- first choice
- alternate choice

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

SDCT-LE (Ground) 20° Rake Face

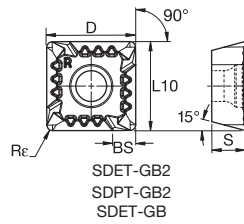
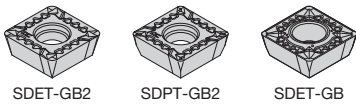
catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDCT431PDFL8LE	.500	.188	.500	.106	.016	.001	4	•	-	-	-	-	-	-	-	-
SDCT431PDFR8LE	.500	.188	.500	.106	.016	.001	4	•	-	-	-	-	-	-	-	-
SDCT43PDFL8LE	.500	.188	.500	.106	.031	.001	4	•	-	-	-	-	-	-	-	-
SDCT43PDFR8LE	.500	.188	.500	.106	.031	.001	4	•	-	-	-	-	-	-	-	-
SDCT433PDFL8LE	.500	.188	.500	.106	.047	.001	4	•	-	-	-	-	-	-	-	-
SDCT433PDFR8LE	.500	.188	.500	.106	.047	.001	4	•	-	-	-	-	-	-	-	-
SDCT434FNLE	.500	.188	.500	-	.063	.001	4	•	-	-	-	-	-	-	-	-
SDCT435FNLE	.500	.188	.500	-	.078	.001	4	•	-	-	-	-	-	-	-	-
SDCT436FNLE	.500	.188	.500	-	.094	.001	4	•	-	-	-	-	-	-	-	-
SDCT438FNLE	.500	.188	.500	-	.125	.001	4	•	-	-	-	-	-	-	-	-

SDCT-LD2 (Ground) 15° Rake Face

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDCT431PDEL8LD2	.500	.188	.500	.106	.016	.002	4	-	-	-	•	-	-	-	-	-
SDCT431PDER8LD2	.500	.188	.500	.115	.016	.002	4	-	-	-	•	-	-	-	-	-
SDCT43PDEL8LD2	.500	.188	.500	.130	.031	.002	4	-	-	-	•	-	-	-	-	-
SDCT43PDER8LD2	.500	.188	.500	.130	.031	.002	4	-	•	-	•	-	-	•	-	•
SDCT433PDEL8LD2	.500	.188	.500	.120	.047	.002	4	-	-	-	•	-	-	-	-	-
SDCT433PDER8LD2	.500	.188	.500	.120	.047	.002	4	-	-	-	•	-	-	-	-	-
SDCT434ENLD2	.500	.188	.500	-	.063	.002	4	-	-	-	•	-	-	-	-	•
SDCT435ENLD2	.500	.188	.500	-	.078	.002	4	-	-	-	•	-	-	-	-	-
SDCT436ENLD2	.500	.188	.500	-	.094	.002	4	-	-	-	•	-	-	-	-	-
SDCT438ENLD2	.500	.188	.500	-	.125	.002	4	-	-	•	•	-	-	-	-	-
SDCT4316ENLD2	.500	.188	.500	-	.250	.002	2	-	-	-	•	-	-	-	-	•

Slot Milling

- Heavy machining.
- Four cutting edges.



- first choice
- alternate choice

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

■ SDET-GB (Ground) 5° Rake Face

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDET43PDER8GB	.500	.188	.500	.101	.031	.003	4	-	●	-	-	-	-	-	-	-
SDET43PDSR8GB	.500	.188	.500	.101	.031	.006	4	-	-	-	-	-	●	●	●	●
SDET433PDER8GB	.500	.188	.500	.086	.047	.003	4	-	-	-	●	-	-	●	-	●
SDET433PDSR8GB	.500	.188	.500	.085	.047	.006	4	-	-	-	●	-	-	●	-	●
SDET434ENGB	.500	.188	.500	-	.062	.003	4	-	-	-	-	-	-	-	-	●
SDET434SNGB	.500	.188	.500	-	.062	.006	4	-	-	-	●	-	-	-	-	●
SDET436ENGB	.500	.188	.500	-	.094	.003	4	-	-	-	●	-	-	-	-	●
SDET436SNGB	.500	.188	.500	-	.094	.006	4	-	-	-	●	-	-	-	-	●
SDET438ENGB	.500	.188	.500	-	.125	.003	4	-	-	-	-	-	-	-	-	●
SDET438SNGB	.500	.188	.500	-	.125	.006	4	-	-	-	-	-	-	-	-	●
SDET4312ENGB	.500	.188	.500	-	.188	.003	2	-	-	-	●	-	-	-	-	●
SDET4312SNGB	.500	.188	.500	-	.188	.006	2	-	-	-	●	-	-	-	-	●
SDET4316ENGB	.500	.188	.500	-	.250	.006	2	-	-	-	●	-	-	-	-	●
SDET4316ENGB	.500	.188	.500	-	.250	.003	2	-	-	-	●	-	-	-	-	●

■ SDET-GB2 (Ground) 5° Rake Face

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDET43PDEL8GB2	.500	.188	.500	.130	.031	.003	4	-	●	-	-	-	-	-	-	-
SDET43PDER8GB2	.500	.188	.500	.130	.031	.003	4	-	●	-	-	-	-	-	-	-
SDET43PDSL8GB2	.500	.188	.500	.130	.031	.005	4	-	-	-	-	-	●	-	-	-
SDET43PDSR8GB2	.500	.188	.500	.130	.031	.005	4	-	●	-	-	-	●	●	-	-
SDET433PDEL8GB2	.500	.188	.500	.120	.047	.003	4	-	●	-	-	-	-	-	-	-
SDET433PDER8GB2	.500	.188	.500	.120	.047	.003	4	-	●	-	-	-	-	-	-	-
SDET434SNGB2	.500	.188	.500	-	.063	.005	4	-	-	-	-	-	-	-	-	-
SDET435SNGB2	.500	.188	.500	-	.078	.005	4	-	●	-	-	-	-	-	-	-
SDET436SNGB2	.500	.188	.500	-	.094	.005	4	-	-	-	-	-	-	-	-	-
SDET438XENGB2	.500	.188	.500	-	.125	.003	2	-	-	-	●	-	-	-	-	-
SDET438SNGB2	.500	.188	.500	-	.125	.005	4	-	●	-	-	-	-	-	-	-
SDET4316SNGB2	.500	.188	.500	-	.250	.005	2	-	-	-	-	-	●	-	-	-

■ SDPT-GB2

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40
SDPT43PDER8GB2	.500	.188	.500	.106	.031	.003	4	-	-	-	●	-	●	●	-	●
SDPT43PDSR8GB2	.500	.188	.500	.106	.031	.005	4	-	-	-	●	-	●	●	-	●



■ Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining
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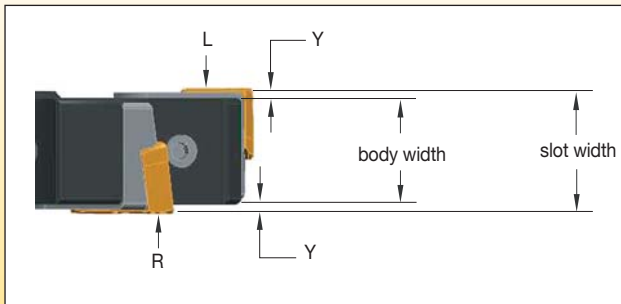
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)														Insert Geometry	
	5%			10%			20%			30%			40-100%			
.F..LE	.005	.017	.030	.003	.012	.021	.003	.009	.016	.002	.008	.014	.002	.007	.013	.F..LE
.E..LD	.007	.019	.032	.005	.013	.023	.004	.010	.017	.003	.009	.015	.003	.008	.014	.E..LD
.E..LD2	.005	.018	.032	.004	.013	.023	.003	.010	.017	.002	.009	.015	.002	.008	.014	.E..LD2
.E..GB	.009	.021	.035	.007	.015	.025	.005	.011	.019	.004	.010	.016	.004	.009	.015	.E..GB
.E..GB2	.009	.021	.035	.007	.015	.025	.005	.011	.019	.004	.010	.016	.004	.009	.015	.E..GB2
.S..GB	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GB
.S..GB2	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GB2
.S..GN	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GN

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



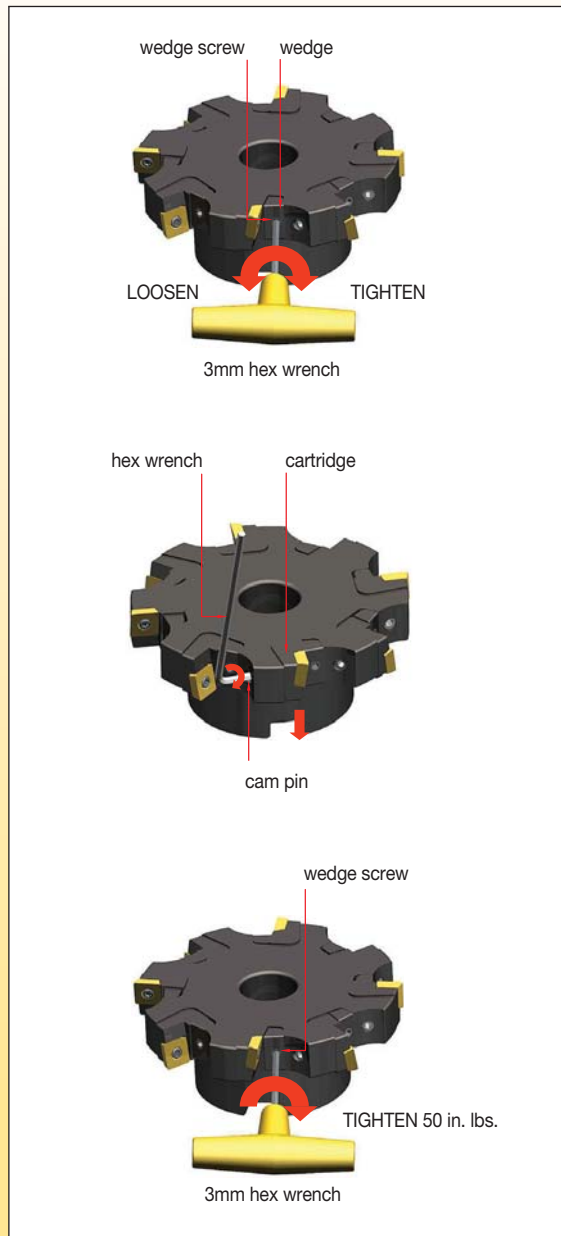
Slot Milling

■ 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 counter-clockwise to loosen wedge.
3. Rotate 3mm hex wrench clockwise to lightly tighten STCM screw to approximately 9 in. lbs., so the wedge is touching the cartridge and cutter body. This creates some slight resistance against the cartridge during the adjustment.

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

8. Insert 3mm hex wrench into STCM screw.
9. Tighten STCM screw to 55 in. lbs. prior to using the cutter. Kennametal torque wrench KTW45 or alternate torque wrench should be used.
10. Double check cartridge position to assure no movement.