



Slotting Cutters

KTMS • T-Slot PlatformQ2-Q6
KVNS • Very Narrow Slotting Cutter PlatformQ8-Q13
SN • Popular Square Inserted CutterQ14-Q17
LN • Adjustable Width Cutter SystemQ18-Q25
KSSM10 • Neutral and Right- and Left-Hand Cutters, 10mm I/CQ26-Q43
KSSM12 • Neutral and Right- and Left-Hand Cutters, 12mm I/CQ44-Q61

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 Q6.

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.



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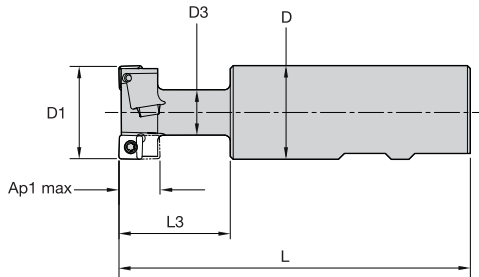
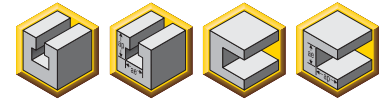


Fig. 1

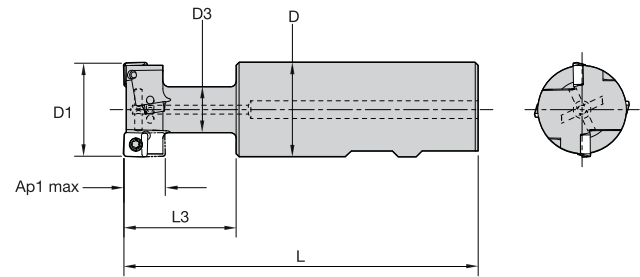


Fig. 2

■ KTMS • T-Slot Cutter • Metric

order number	catalogue number	D1	D	D3	L	L3	Ap1 max	Z	Z U	figure	insert 1	kg
3577118	KTMS21S25SD06	21	25	11	109	29	9,0	2	1	FIG 1	SDMT060304EGG	0,37
3577120	KTMS25S25SD06	25	25	13	112	32	11,0	4	2	FIG 1	SDMT060304EGG	0,38
3577122	KTMS32S32SD08	32	32	16	120	38	14,0	4	2	FIG 1	SDMT080308EGG	0,62
3577134	KTMS40S32SD12	40	32	21	130	50	18,0	4	2	FIG 1	SDMT120408EGG	0,69
3577136	KTMS50S32SD12	50	32	27	140	60	22,0	4	2	FIG 1	SDMT120408EGG	0,88

■ KTMS • T-Slot Cutter • Metric

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

■ Spare Parts

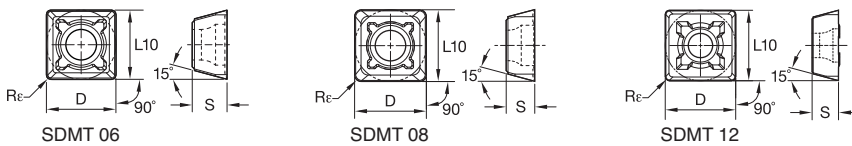


D1	insert screw	Nm	Torx driver	anti-seize lube
21	MS2206	1	DT8	ASL3GT
25	MS2206	1	DT8	ASL3GT
32	MS2207	2	DT10	ASL3GT
40	MS2208	4	DT15	ASL3GT
50	MS2208	4	DT15	ASL3GT

Insert Selection Guide

Material Group	Light Machining		General Purpose		Heavy Machining	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	.E..GG	KC730M	.E..GG	KC730M	.E..GG	KC735M
P3-P4	.E..GG	KC730M	.E..GG	KC730M	.E..GG	KC735M
P5-P6	.E..GG	KC730M	.E..GG	KC735M	.E..GG	KC735M
M1-M2	—	—	—	—	—	—
M3	—	—	—	—	—	—
K1-K2	.E..GG	K110M	.E..GG	K110M	.E..GG	KC505M
K3	.E..GG	K110M	.E..GG	KC505M	.E..GG	KC505M
N1-N2	—	—	—	—	—	—
N3	—	—	—	—	—	—
S1-S2	—	—	—	—	—	—
S3	—	—	—	—	—	—
S4	—	—	—	—	—	—
H1	—	—	—	—	—	—

Indexable Insert • T-Slot Cutters SDMT • EGG



● first choice
○ alternate choice

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

	K110M	KC505M	KC730M	KC735M
●	●	●	●	●
○	○	○	○	○

SDMT Inserts

catalogue number	D	S	L10	Re	hm	cutting edges	K110M	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	●	●	●	●

Slotting Cutters

Recommended Starting Speeds [m/min]

Material Group		KC110M			KC505M			KC730M			KC735M		
P	1	—	—	—	—	—	—	130	120	100	160	140	130
	2	—	—	—	—	—	—	120	110	105	140	130	120
	3	—	—	—	—	—	—	110	100	90	130	120	110
	4	—	—	—	—	—	—	100	90	80	120	110	100
	5	—	—	—	—	—	—	90	80	75	110	90	80
	6	—	—	—	—	—	—	80	75	70	90	80	70
M	1	—	—	—	—	—	—	—	—	—	—	—	—
	2	—	—	—	—	—	—	—	—	—	—	—	—
	3	—	—	—	—	—	—	—	—	—	—	—	—
K	1	130	120	115	150	140	120	—	—	—	—	—	—
	2	115	105	100	140	120	105	—	—	—	—	—	—
	3	100	90	80	105	95	80	—	—	—	—	—	—
N	1-2	—	—	—	—	—	—	—	—	—	—	—	—
	3	—	—	—	—	—	—	—	—	—	—	—	—
S	1	—	—	—	—	—	—	—	—	—	—	—	—
	2	—	—	—	—	—	—	—	—	—	—	—	—
	3	—	—	—	—	—	—	—	—	—	—	—	—
	4	—	—	—	—	—	—	—	—	—	—	—	—
H	1	—	—	—	—	—	—	—	—	—	—	—	—

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50-100%			
.E..GG	0,14	0,30	0,50	0,11	0,23	0,38	0,09	0,20	0,33	0,09	0,18	0,31	0,08	0,18	0,30	.E..GG

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



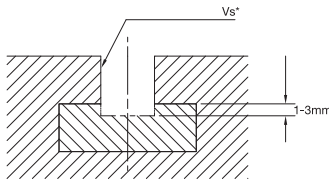


Fig. 1

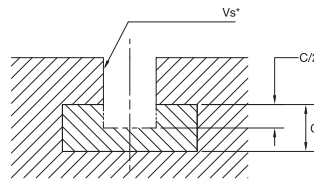


Fig. 2

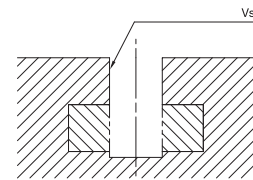
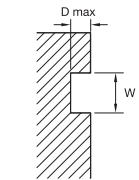


Fig. 3



Side Slotting

Steel

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

Cast Iron

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

Cutting Data Table • Slotting

	material type	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	Figures 1, 2, 3
		KTMS25S25SD06H	120	0,12	Figures 1, 2, 3
		KTMS32S32SD08H	120	0,12	Figures 1, 2, 3
		KTMS40S32SD12H	120	0,12	Figures 2, 3
		KTMS50S32SD12H	120	0,15	Figure 3

* Vs = Vertical slot preparation for T-slot.

Side Slot Machining

Slotting Cutters

side slot dimension	W -0.1/-0.3 mm	D max mm
catalogue number		
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



KSRM™

Multipurpose Milling Cutters

Specially developed for machining titanium and stainless steel. KSRM platform enables you to pocket, profile, ramp, and plunge with up to 1 mm (.039") fz with consistent performance, providing outstanding metal removal rates with the lowest cutting forces in roughing applications.

- Anti-rotation feature with eight indexes.
- High positive topography with strong cutting edges.
- High clearance on the cutters and inserts.
- Wide cutter offering with internal coolant.
- Ground and PSTS inserts.
- Provides more stability and reliability.
- Lower cutting forces generated.
- Cutters can run with higher feed rates and better ramping capacities.
- Cover extensive workpiece materials.
- Superior productivity and better insert utilisation/cost per edge.
- Able to convert all milling applications.
- Improve tool life and chip evacuation.
- Superior overall performance.

Experience the advantages at your Authorised Kennametal Distributor or at www.kennametal.com.

www.kennametal.com

 **KENNAMETAL®**

KVNS™ Slotting Cutter

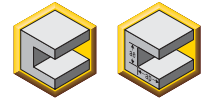
Primary Application

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.

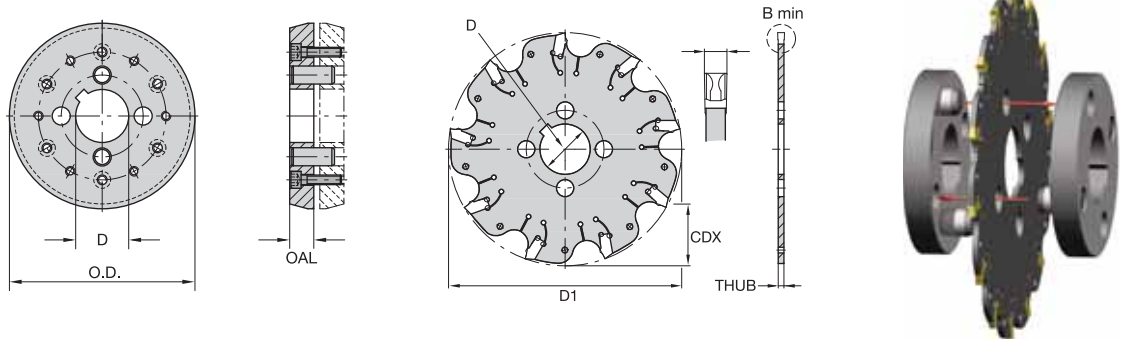
Features and Benefits

- Slot widths from 1,6–4mm.
- Grades and geometries to suit most workpiece materials.
- Drive rings and support rings available, must be ordered separately (in pairs).
- Self clamping inserts.
- 1,6–4mm 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 hubs required for each cutter body, except when using two drive supports (must be ordered separately, in pairs).





- 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 (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	kg
1246114	4.97060116	63	16	1,6	15	1,3	5	5100	3.90016__	0,03
1246122	4.97080116	80	16	1,6	21	1,3	7	4000	3.90016__	0,04
1246131	4.97101116	100	22	1,6	27	1,3	9	3200	3.90016__	0,07
1246138	4.97123116	125	32	1,6	35	1,3	11	2600	3.90016__	0,10

■ A2 • Cutting Width 2,2mm

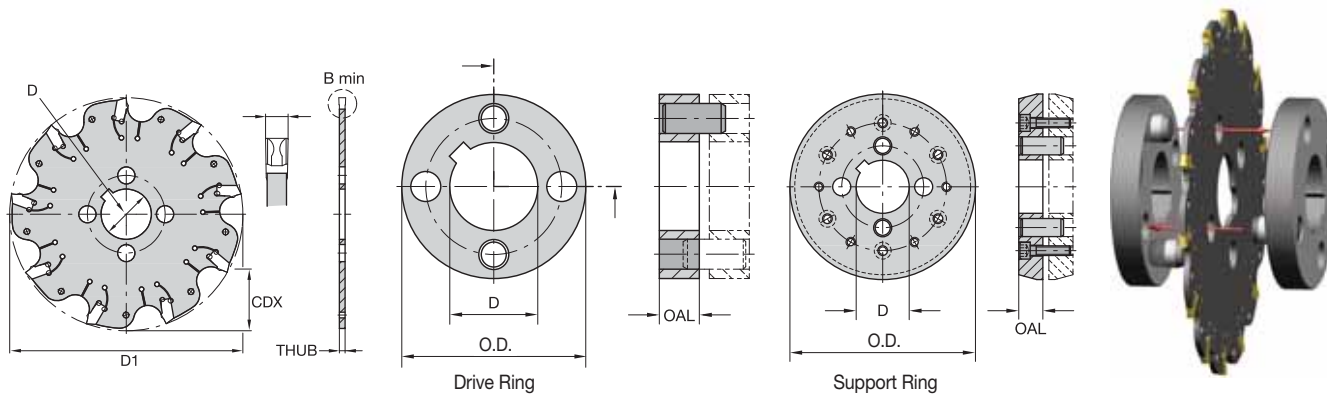
order number	catalogue number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	kg
1246124	4.97080122	80	16	2,2	21	1,8	7	4000	3.90022__	0,05
1246132	4.97101122	100	22	2,2	27	1,8	9	3200	3.90022__	0,08
1246140	4.97123122	125	32	2,2	35	1,8	11	2600	3.90022__	0,12
1246147	4.97164122	160	40	2,2	40	1,8	14	2000	3.90022__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

■ A2 • Cutting Width 3mm

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

■ A2 • Cutting Width 4mm

order number	catalogue number	D1	D	B min	CDX	THUB	Z	max RPM	insert 1	kg
1246120	4.97060140	63	16	4,0	15,000	3,4	4	5100	3.90040__	0,06
1246129	4.97080140	80	16	4,0	21,000	3,4	6	4000	3.90040__	0,10
1246136	4.97101140	100	22	4,0	27,000	3,4	9	3200	3.90040__	0,15
1246145	4.97123140	125	32	4,0	35,000	3,4	11	2600	3.90040__	0,25
1246150	4.97164140	160	40	4,0	40,000	3,4	14	2000	3.90040__	0,40
1246154	4.97204140	200	40	4,0	60,000	3,4	19	1600	3.90040__	0,65



■ Drive Rings

order number	D1	O.D.	OAL	bore size	drive ring	kg
1247091	80	38	8	16	460.899	0,06
1177888	63	32	8	16	460.889	0,03
1247088	63	32	8	16	460.898	0,04
1247085	100	46	10	22	460.890	0,10
1247087	125	55	10	32	460.897	0,12
1247080	200	140	12	40	460.887	1,15
1247082	200	80	12	40	460.888	0,34

■ Support Rings

D1	cutter 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

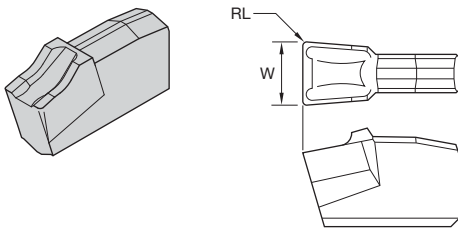
NOTE: For CDX value, refer to drive ring and support ring tables.
 Insert wrench 170.183 (order code 1124601) must be ordered separately

Slotting Cutters

Insert Selection Guide

Material Group	Light Machining		General Purpose		Heavy Machining	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	.S..GD	KCPK30	.S..GD	KCPK30	.S..GB	KCPK30
P3-P4	.S..GD	KCPK30	.S..GD	KCPK30	.S..GB	KCPK30
P5-P6	.S..GD	KCPK30	.S..GB	KC735M	.S..GB	KCPK30
M1-M2	.S..GD	KC735M	.S..GD	KCPK30	.S..GB	KC735M
M3	.S..GD	KCPK30	.S..GB	KC735M	.S..GB	KCPK30
K1-K2	.S..GD	KCPK30	.S..GD	KCPK30	.S..GB	KCPK30
K3	.S..GD	KCPK30	.S..GB	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	—	—
H1	—	—	—	—	—	—

Indexable Inserts • KVNS A2



● 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	●	●	●

Slotting Cutters

■ Recommended Starting Speeds [m/min]

Material Group		KC735M			KCPK30			KMF		
P	1	—	—	—	455	395	370	—	—	—
	2	—	—	—	280	255	230	—	—	—
	3	—	—	—	255	230	205	—	—	—
	4	—	—	—	190	175	160	—	—	—
	5	—	—	—	260	230	210	—	—	—
	6	—	—	—	160	135	—	—	—	—
M	1	105	90	80	205	185	155	—	—	—
	2	95	85	75	185	160	140	—	—	—
	3	70	60	—	145	130	115	—	—	—
K	1	—	—	—	295	265	240	—	—	—
	2	—	—	—	235	210	190	—	—	—
	3	—	—	—	195	175	160	—	—	—
N	1-2	—	—	—	—	—	—	335	300	270
	3	—	—	—	—	—	—	220	200	170
S	1	—	—	—	—	—	—	30	25	20
	2	—	—	—	—	—	—	30	25	20
	3	—	—	—	—	—	—	30	25	20
	4	—	—	—	—	—	—	25	25	25
H	1	—	—	—	—	—	—	—	—	—

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

■ Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
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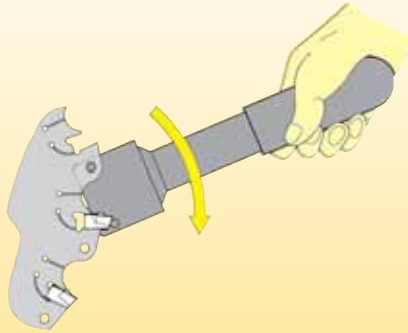
Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50-100%			
.E..GD	0,17	0,27	0,37	0,13	0,20	0,28	0,11	0,17	0,24	0,10	0,16	0,23	0,10	0,16	0,22	.E..GD
.S..GD	0,17	0,33	0,46	0,13	0,25	0,34	0,11	0,22	0,30	0,10	0,20	0,28	0,10	0,20	0,27	.S..GD
.S..GB	0,17	0,43	0,54	0,13	0,32	0,40	0,11	0,28	0,35	0,10	0,26	0,33	0,10	0,25	0,32	.S..GB

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

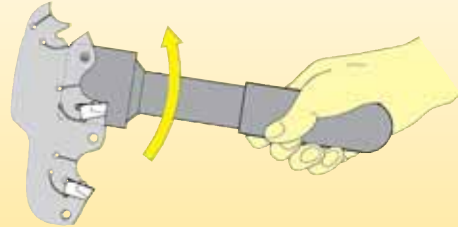


Slotting Cutters

■ **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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Check the Kennametal website!



 **Indexable Milling**

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SN Slotting Cutter

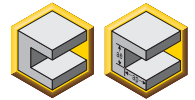
Primary Application

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.

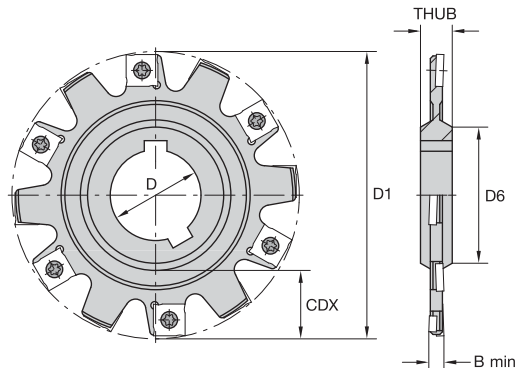
Features and Benefits

- Cutters available in arbor 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.
- Economical to use.





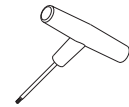
- 4–14mm slot widths range.
- Four indexes per insert.
- Three chipformers available.
- Two keyways for staggered mounting.
- Requires only one spare part.
- Economical to use.



■ SN • Arbor 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
1244388	4.96255-214	250	50	72	14,0	86	14,0	24	8	SNHX12L5__	5,20

■ Spare Parts

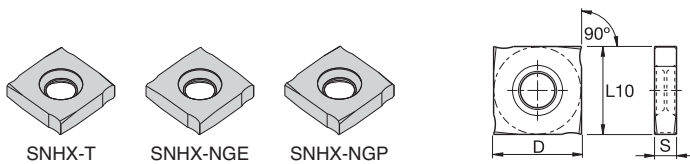


order number	D1	B min	insert screw	Nm	Torx wrench
1244389	80	4	192.529	1	170.023
1191306	100	4	192.529	1	170.023
1244398	100	5	192.530	1	170.023
1244368	100	6	192.531	3	170.025
1244370	125	4	192.529	1	170.023
1244371	125	5	192.530	1	170.023
1244374	125	10	192.532	3	170.025
1244375	125	12	192.532	3	170.025
1244394	160	4	192.529	1	170.023
1244376	160	5	192.530	1	170.023
1244379	160	10	192.532	3	170.025
1244395	200	8	192.531	3	170.025
1244385	250	6	192.531	3	170.025
1244386	250	8	192.531	3	170.025
1244388	250	14	192.532	3	170.025

■ Insert Selection Guide

Material Group	Light Machining		General Purpose		Heavy Machining	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	.T..GP	KC725M	.T..GP	KC725M	.T..	KC725M
P3-P4	.T..GP	KC725M	.T..GP	KCPK30	.T..	KCPK30
P5-P6	.T..GP	KCPK30	.T..	KC735M	.T..	KCPK30
M1-M2	.T..GP	KC725M	.T..GP	KC725M	.T..	KC725M
M3	.T..GP	KC725M	.T..GP	KCPK30	.T..	KCPK30
K1-K2	.F..GE	K110M	.T..GP	KCPK30	.T..	KCPK30
K3	.T..GP	KCPK30	.T..	KCPK30	.T..	KCPK30
N1-N2	.F..GE	K110M	.F..GE	K110M	.F..GE	KC510M
N3	.F..GE	K110M	.F..GE	KC510M	.T..GP	K110M
S1-S2	.T..GP	KC725M	.T..GP	KC725M	.T..	KC725M
S3	.T..GP	KC725M	.T..GP	KC725M	.T..	KC725M
S4	.T..GP	KC725M	.T..	KC725M	—	—
H1	—	—	—	—	—	—

Indexable Inserts • SNHX-T • SNHX-NGE • SNHX-NGP



● first choice
○ alternate choice

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

■ SNHX-T

catalogue number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KC735M	KCPK30
SNHX1102T	11,00	2,38	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	○	○	○	○	○	○

■ SNHX-NGE

catalogue number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KC735M	KCPK30
SNHX1102PZFNGE	11,00	2,30	11,00	0,02	4	○	○	○	○	○	○
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	○	○	○	○	○	○

■ SNHX-NGP

catalogue number	D	S	L10	hm	cutting edges	K110M	KC510M	KC520M	KC725M	KC735M	KCPK30
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	○	○	○	○	○	○

Slotting Cutters

Recommended Starting Speeds [m/min]

Material Group		KC110M			KC510M			KC520M		
P	1	—	—	—	—	—	—	—	—	—
	2	—	—	—	—	—	—	—	—	—
	3	—	—	—	—	—	—	—	—	—
	4	—	—	—	—	—	—	—	—	—
	5	—	—	—	—	—	—	—	—	—
	6	—	—	—	—	—	—	—	—	—
M	1	—	—	—	—	—	—	—	—	—
	2	—	—	—	—	—	—	—	—	—
	3	—	—	—	—	—	—	—	—	—
K	1	130	120	115	295	265	240	270	245	215
	2	115	105	100	230	205	190	210	190	175
	3	100	90	80	195	175	160	175	160	145
N	1-2	505	475	450	640	570	525	—	—	—
	3	410	365	320	—	—	—	—	—	—
S	1	—	—	—	—	—	—	—	—	—
	2	—	—	—	—	—	—	—	—	—
	3	—	—	—	—	—	—	—	—	—
	4	—	—	—	—	—	—	—	—	—
H	1	—	—	—	—	—	—	—	—	—

Material Group		KC725M			KC735M			KCPK30		
P	1	260	230	215	—	—	—	455	395	370
	2	220	190	160	—	—	—	280	255	230
	3	200	170	140	—	—	—	255	230	205
	4	180	150	120	—	—	—	190	175	160
	5	150	135	120	—	—	—	260	230	210
	6	130	100	80	—	—	—	160	135	—
M	1	170	150	135	105	90	80	205	185	155
	2	155	130	110	95	85	75	185	160	140
	3	115	100	80	70	60	—	145	130	115
K	1	—	—	—	—	—	—	295	265	240
	2	—	—	—	—	—	—	235	210	190
	3	—	—	—	—	—	—	195	175	160
N	1-2	—	—	—	—	—	—	—	—	—
	3	—	—	—	—	—	—	—	—	—
S	1	35	30	25	—	—	—	—	—	—
	2	35	30	25	—	—	—	—	—	—
	3	45	35	25	—	—	—	—	—	—
	4	60	45	30	—	—	—	—	—	—
H	1	—	—	—	—	—	—	—	—	—

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

Recommended Starting Feeds [mm]

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

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)														Insert Geometry	
	10%			20%			30%			40%			50-100%			
.F..GE	0,08	0,17	0,33	0,06	0,13	0,25	0,06	0,11	0,22	0,05	0,10	0,20	0,05	0,10	0,20	.F..GE
.T..GP	0,17	0,35	0,49	0,13	0,26	0,37	0,11	0,23	0,32	0,10	0,21	0,30	0,10	0,21	0,29	.T..GP
.T..	0,17	0,43	0,59	0,13	0,32	0,44	0,11	0,28	0,38	0,10	0,26	0,36	0,10	0,25	0,35	.T..

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



LN Slotting Cutter

Primary Application

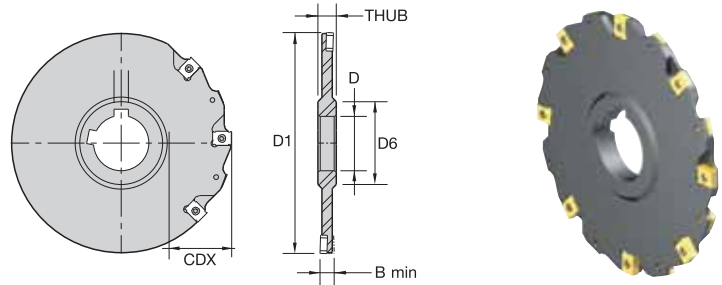
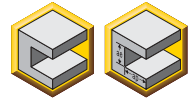
LN slotting cutters offer arbor and shell mill cutter options, groove widths from 6–13mm, and cutter diameters from 80–200mm. Easy to adjust radially in 0,50mm increments.

Features and Benefits

- Cutter available in arbor and shell mounts.
- Groove width 6–13mm.
- Groove width can be changed by consulting additional chart; this involves changing insert and insert screw.
- Staggered internal keys.
- Positive chip grooves.
- Easy width adjustment through insert thickness.
- Full side and face cutting.
- Neutral and positive chipforming inserts are standard.
- Four insert cutting edges.
- Requires only one spare part.



- 6–13mm slot width range.
- Easy width adjustment through insert thickness.
- Right-hand and full-side cutting versions.
- Neutral and positive chipforming inserts are standard.
- Four insert cutting edges.
- Two keyways for staggered mounting.
- Requires only one spare part.



Side Two Insert

■ LN • Arbor 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	6,0	16	12,0	8	4	LNE_1235__	0,30
1131447	80F08NS90LN12N08	80	27	44	8,0	16	12,0	8	4	LNE_1245__	0,35
1150508	100G10NS90LN12N06	100	32	52	6,0	22	12,0	10	5	LNE_1235__	0,40
1130249	100G10NS90LN12N08	100	32	52	8,0	22	12,0	10	5	LNE_1245__	0,50
1130477	125H12NS90LN12N06	125	40	63	6,0	30	12,0	12	6	LN_1235	0,70
1130615	160H16NS90LN12N06	160	40	63	6,0	46	12,0	16	8	LNE_1235__	1,10
1130595	160H15NS90LN12N10	160	40	63	10,0	46	12,0	15	5	LNE_1245	1,60
1130608	160H15NS90LN12N12	160	40	63	12,0	46	12,0	15	5	LNE_1255__	1,60
1150527	200J18NS90LN12N08	200	50	75	8,0	60	12,0	18	9	LNE_1245__	2,00

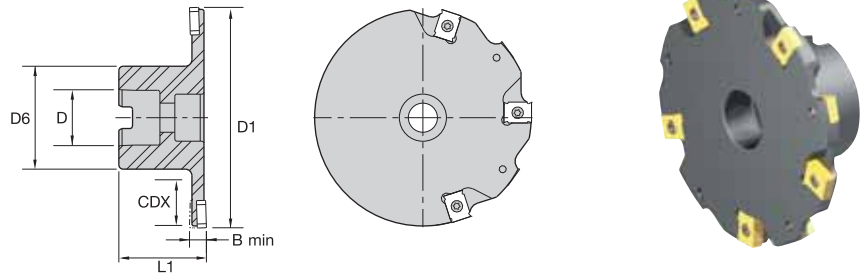
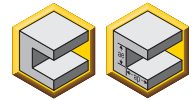
■ Spare Parts



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

Slotting Cutters

- 6–11mm slot width range.
- Easy width adjustment through insert thickness.
- Right-hand and full-side cutting versions.
- Neutral and positive chipforming inserts are standard.
- Four insert cutting edges.
- Requires only one spare part.



■ 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	6,0	16	50,0	8	4	LNE_1235__	0,65
1131472	80Y08RS90LN12N08	80	22	40	8,0	16	50,0	8	4	LNE_1245__	0,75
1130277	100Y10RS90LN12N06	100	27	50	6,0	22	50,0	10	5	LNE_1235__	1,00
1130283	100Y10RS90LN12N08	100	27	50	8,0	22	50,0	10	5	LNE_1245__	1,20
1130506	125Y12RS90LN12N10	125	40	70	10,0	26	50,0	12	4	LNE_1245__	1,50
1150511	160Y16RS90LN12N06	160	40	70	6,0	43	50,0	16	8	LNE_1235__	1,85
1150513	160Y16RS90LN12N08	160	40	70	8,0	43	50,0	16	8	LNE_1245__	2,15
1150524	160Y15RS90LN12N10	160	40	70	10,0	43	50,0	15	5	LNE_1245__	2,45

■ Spare Parts



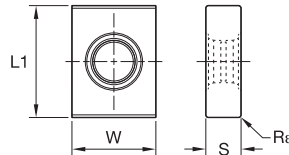
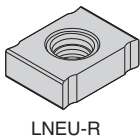
order number	D1	B min	insert screw	Nm	Torx driver
1131463	80	6	MS1280	3	DT15
1131472	80	8	MS1282	3	DT15
1130277	100	6	MS1280	3	DT15
1130283	100	8	MS1282	3	DT15
1130506	125	10	MS1282	3	DT15
1150511	160	6	MS1280	3	DT15
1150513	160	8	MS1282	3	DT15
1150524	160	10	MS1282	3	DT15

Slotting Cutters

Insert Selection Guide

Material Group	Light Machining		General Purpose		Heavy Machining	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	—	KC725M	—	KC725M	.S..GP	KC725M
P3-P4	—	KC725M	—	KCPK30	.S..GP	KC725M
P5-P6	—	KC735M	—	KCPK30	.S..GP	KC735M
M1-M2	—	KC725M	—	KC725M	.S..GP	KC725M
M3	—	KC735M	—	KCPK30	.S..GP	KC725M
K1-K2	—	KC520M	—	KCK15	—	KCPK30
K3	—	KCK15	—	KCPK30	—	KCPK30
N1-N2	—	—	—	—	—	—
N3	—	—	—	—	—	—
S1-S2	—	KC725M	—	KC725M	.S..GP	KC725M
S3	—	KC735M	.S..GP	KC735M	.S..GP	KC725M
S4	—	KC725M	.S..GP	KC725M	—	—
H1	—	—	—	—	—	—

Indexable Inserts • 90° • LNEU-R • LNEU-SGP • LNEQ



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

● first choice
 ○ alternate choice

LNEU-R

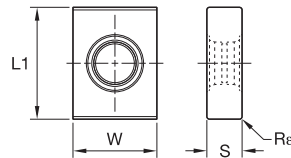
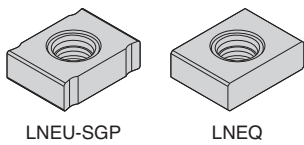
catalogue number	L1	W	S	Re	hm	cutting edges	KC520M	KC725M	KC735M	KCK15	KCPK30
LNEU1235R03 4	12,70	9,60	3,50	0,3	0,04	4	●	●	○	○	○
LNEU1240R03 4	12,70	9,60	4,00	0,3	0,04	4	●	●	○	○	○
LNEU1240R08 4	12,70	9,60	4,00	0,8	0,04	4	●	●	○	○	○
LNEU1240R16 4	12,70	9,60	4,00	1,6	0,04	4	●	●	○	○	○
LNEU1245R04	12,70	9,60	4,50	0,4	0,04	4	●	●	○	○	○
LNEU1245R08	12,70	9,60	4,50	0,8	0,04	4	●	●	○	○	○
LNEU1245R16	12,70	9,60	4,50	1,6	0,04	4	●	●	○	○	○
LNEU1245R32	12,70	9,60	4,50	3,2	0,04	4	●	●	○	○	○
LNEU1250R04	12,70	9,60	5,00	0,4	0,04	4	●	●	○	○	○
LNEU1250R08	12,70	9,60	5,00	0,8	0,04	4	●	●	○	○	○
LNEU1255R04	12,70	9,60	5,50	0,4	0,04	4	●	●	○	○	○
LNEU1255R08	12,70	9,60	5,50	0,8	0,04	4	●	●	○	○	○
LNEU1255R16	12,70	9,60	5,50	1,6	0,04	4	●	●	○	○	○
LNEU1255R32	12,70	9,60	5,50	3,2	0,04	4	●	●	○	○	○
LNEU1260R04	12,70	9,60	6,00	0,4	0,04	4	●	●	○	○	○

Slotting Cutters

■ Insert Selection Guide

Material Group	Light Machining		General Purpose		Heavy Machining	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	—	KC725M	—	KC725M	.S..GP	KC725M
P3-P4	—	KC725M	—	KCPK30	.S..GP	KC725M
P5-P6	—	KC735M	—	KCPK30	.S..GP	KC735M
M1-M2	—	KC725M	—	KC725M	.S..GP	KC725M
M3	—	KC735M	—	KCPK30	.S..GP	KC725M
K1-K2	—	KC520M	—	KCK15	—	KCPK30
K3	—	KCK15	—	KCPK30	—	KCPK30
N1-N2	—	—	—	—	—	—
N3	—	—	—	—	—	—
S1-S2	—	KC725M	—	KC725M	.S..GP	KC725M
S3	—	KC735M	.S..GP	KC735M	.S..GP	KC725M
S4	—	KC725M	.S..GP	KC725M	—	—
H1	—	—	—	—	—	—

Indexable Inserts • 90° • LNEU-R • LNEU-SGP • LNEQ



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

● first choice
○ alternate choice

■ LNEU-SGP

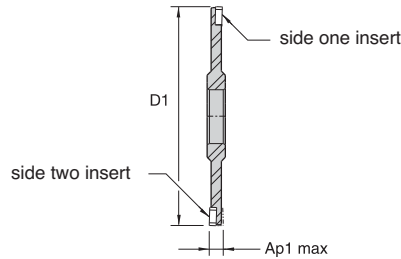
catalogue number	L1	W	S	Re	hm	cutting edges	KC520M	KC725M	KC735M	KCK15	KCPK30
LNEU1235R03SGP 4	12,70	9,60	3,50	0,3	0,09	4	●	●	●	●	●
LNEU1240R03SGP 4	12,70	9,60	4,00	0,3	0,08	4	●	●	●	●	●
LNEU1245R04SGP	12,70	9,60	4,50	0,4	0,08	4	●	●	●	●	●
LNEU1245R08SGP	12,70	9,60	4,50	0,8	0,09	4	●	●	●	●	●
LNEU1245R16SGP	12,70	9,60	4,50	1,6	0,09	4	●	●	●	●	●
LNEU1250R04SGP	12,70	9,60	5,00	0,4	0,09	4	●	●	●	●	●
LNEU1250R08SGP	12,70	9,60	5,00	0,8	0,09	4	●	●	●	●	●

■ LNEQ

catalogue number	L1	W	S	BS	Re	hm	cutting edges	KC520M	KC725M	KC735M	KCK15	KCPK30
LNEQ1235R03 4	12,70	9,53	3,50	—	0,3	0,04	4	●	●	●	●	●
LNEQ1240 4	12,70	9,53	4,00	0,30	—	0,05	4	●	●	●	●	●
LNEQ1240R03 4	12,70	9,53	4,00	—	0,3	0,05	4	●	●	●	●	●
LNEQ1245R04	12,70	9,53	4,50	—	0,4	0,04	4	●	●	●	●	●
LNEQ1250R04	12,70	9,53	5,00	—	0,4	0,05	4	●	●	●	●	●
LNEQ1255	12,70	9,53	5,50	0,40	—	0,05	4	●	●	●	●	●
LNEQ1255R04	12,70	9,53	5,50	—	0,4	0,04	4	●	●	●	●	●
LNEQ1260R04	12,70	9,53	6,00	—	0,4	0,05	4	●	●	●	●	●

Slotting Cutters

- LNEx narrow slotting 6–13mm slot width.
- Utilises wider inserts in standard cutters.
- Cutting width of this unique LNEx insert style for narrow slotting cutters can be adjusted.
- The width can be increased by 0–1mm increments.
- Refer to the insert combinations in the table below for insert selection.



■ LN Slotting Cutter Widths (Additional Widths Available)

catalogue number	D1	Ap1 max	Ap1 max (new)	side one insert *	screw **	side two insert *	screw **
80F08NS90LN12N06	80	6	6.5	LNE1235	MS-1280	LNE1240	MS-1281
80F08NS90LN12N06	80	6	7	LNE1240	MS-1281	LNE1240	MS-1281
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-1280	LNE1240	MS-1281
100G10NS90LN12N06	100	6	7	LNE1240	MS-1281	LNE1240	MS-1281
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-1280	LNE1240	MS-1281
125H12NS90LN12N06	125	6	7	LNE1240	MS-1281	LNE1240	MS-1281
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-1280	LNE1240	MS-1281
160H16NS90LN12N06	160	6	7	LNE1240	MS-1281	LNE1240	MS-1281
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-1280	LNE1240	MS-1281
200J18NS90LN12N06	200	6	7	LNE1240	MS-1281	LNE1240	MS-1281
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.

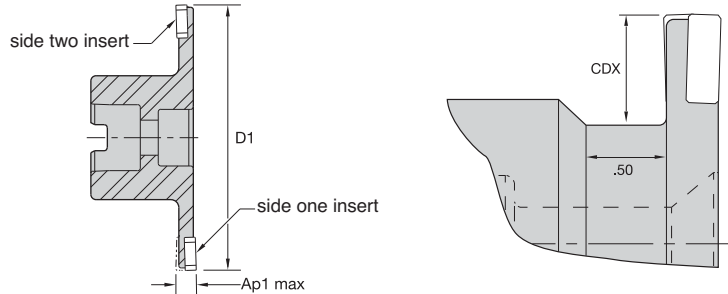
** When changing to a wider insert thickness, use the necessary longer screw; see chart for detail.

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



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



■ LN Slotting Cutter Widths (Additional Widths Available)

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 Speeds [m/min]

Material Group		KC520M			KC725M			KC735M			KCK15			KCPK30		
P	1	—	—	—	260	230	215	—	—	—	—	—	—	455	395	370
	2	—	—	—	220	190	160	—	—	—	—	—	—	280	255	230
	3	—	—	—	200	170	140	—	—	—	—	—	—	255	230	205
	4	—	—	—	180	150	120	—	—	—	—	—	—	190	175	160
	5	—	—	—	150	135	120	—	—	—	—	—	—	260	230	210
	6	—	—	—	130	100	80	—	—	—	—	—	—	160	135	—
M	1	—	—	—	170	150	135	105	90	80	—	—	—	205	185	155
	2	—	—	—	155	130	110	95	85	75	—	—	—	185	160	140
	3	—	—	—	115	100	80	70	60	—	—	—	—	145	130	115
K	1	270	245	215	—	—	—	—	—	—	420	385	340	295	265	240
	2	210	190	175	—	—	—	—	—	—	335	295	275	235	210	190
	3	175	160	145	—	—	—	—	—	—	280	250	230	195	175	160
N	1-2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
S	1	—	—	—	35	30	25	—	—	—	—	—	—	—	—	—
	2	—	—	—	35	30	25	—	—	—	—	—	—	—	—	—
	3	—	—	—	45	35	25	—	—	—	—	—	—	—	—	—
	4	—	—	—	60	45	30	—	—	—	—	—	—	—	—	—
H	1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

■ Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50-100%			
—	0,12	0,34	0,51	0,09	0,26	0,38	0,08	0,22	0,33	0,07	0,21	0,31	0,07	0,20	0,31	—
.S..GP	0,17	0,39	0,58	0,13	0,29	0,44	0,11	0,25	0,38	0,10	0,24	0,36	0,10	0,23	0,35	.S..GP

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

KSSM™ Slotting Cutter

Primary Application

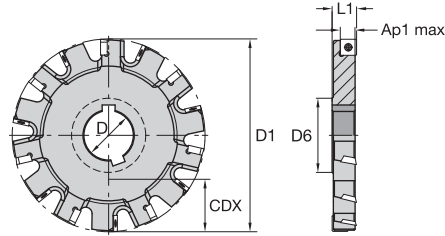
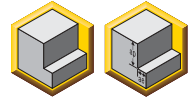
With insert grades and geometries for most materials, the KSSM fixed-width slotting cutters are a cost effective solution for the general engineering market. Very precise adjustments to achieve consistent widths are possible with the variable width and enables customers to change the tool from right hand to left hand with a change of cartridge.

Features and Benefits

- Cutters available in arbor and shell mounts.
- Cutters right and left hand and full slotting have fixed widths.
- Groove widths: Fixed 15,80mm; Adjustable 14–23,30mm.
- Rapid adjustment mechanism.
- Large insert selection — grades and geometries.
- Wiper inserts.
- Insert radii from 0,15–6,35mm.
- Right-hand and left-hand cutters with .359" depth of cut.
- Diameter range is 100–200mm.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Five insert radii available.
- Faceted inserts for superior surface finishes.



- 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.



Arbor 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	0,85
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

Spare Parts



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

Arbor Mount • 10mm IC • Left Hand

order number	catalogue number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	kg
3330529	100G10LP90SP10	100	32	46,8	26,3	16,0	9,1	10	10	17200	0,54
3330532	125H11LP90SP10	125	40	54,8	34,8	16,0	9,1	11	11	15400	0,85
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

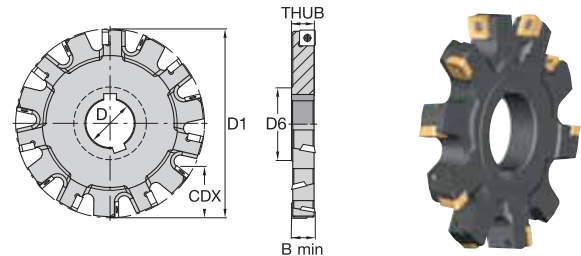
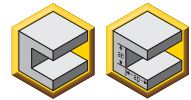
Spare Parts



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

NOTE: For superior surface finish, use right- and 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.
- Wide choice of insert radii.
- Faceted inserts for superior surface finishes.



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

order number	catalogue number	D1	D	D6	CDX	THUB	B min	Z	Z S	kg	max RPM
3330527	100G10NP90SP10N16K	100	32	46,8	26,4	13,9	15,8	10	5	0,46	17200
3330530	125H12NP90SP10N16K	125	40	54,8	34,9	13,9	15,8	12	6	0,76	15400
3330973	160H12NP90SP10N16K	160	40	54,8	52,2	13,9	15,8	12	6	1,40	13660
3330976	200J14NP90SP10N16K	200	50	68,8	46,1	13,9	15,8	14	7	2,27	12200

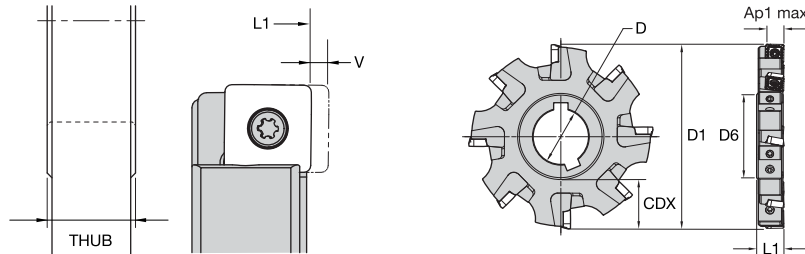
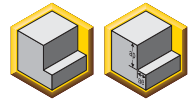
■ Spare Parts



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



■ Arbor Mount • Half-Side Cutting • Right Hand

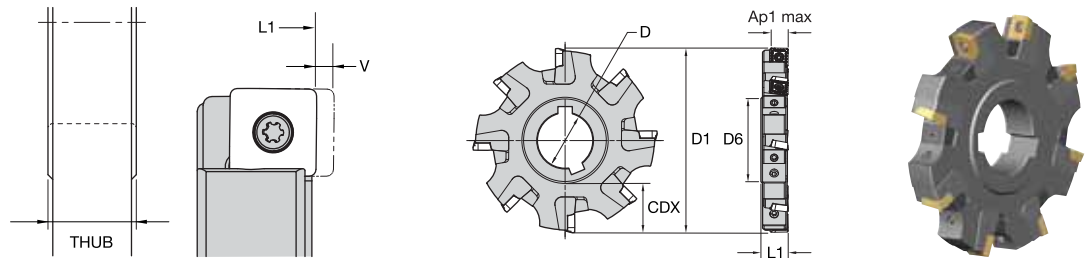
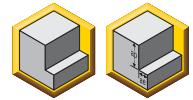
order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2442596	100G06RK90SP10N14K	100	32	46,8	25,9	13,9	13,9	1,0	9,1	6	6	17250	0,50
2442602	125H08RK90SP10N14K	125	40	54,8	34,4	13,9	13,9	1,0	9,1	8	8	15450	0,80
2443456	160H10RK90SP10N14K	160	40	54,8	51,9	13,9	13,9	1,0	9,1	10	10	13650	1,50
2443480	200J14RK90SP10N14K	200	50	68,8	64,9	13,9	13,9	1,0	9,1	14	14	12200	2,40

■ Spare Parts



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



■ Arbor 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
2443435	125H08RK90SP10N16K	125	40	54,8	34,4	15,93	15,9	1,0	9,1	8	8	15450	1,00
2443459	160H10RK90SP10N16K	160	40	54,8	51,9	15,93	15,9	1,0	9,1	10	10	13650	1,80
2443483	200J14RK90SP10N16K	200	50	68,8	64,9	15,93	15,9	1,0	9,1	14	14	12200	2,80
2443504	250J18RK90SP10N16K	250	50	68,8	89,9	15,93	15,9	1,0	9,1	18	18	10900	4,70
2443522	315K20RK90SP10N16K	315	60	83,8	114,9	15,93	15,9	1,0	9,1	20	20	9700	7,70

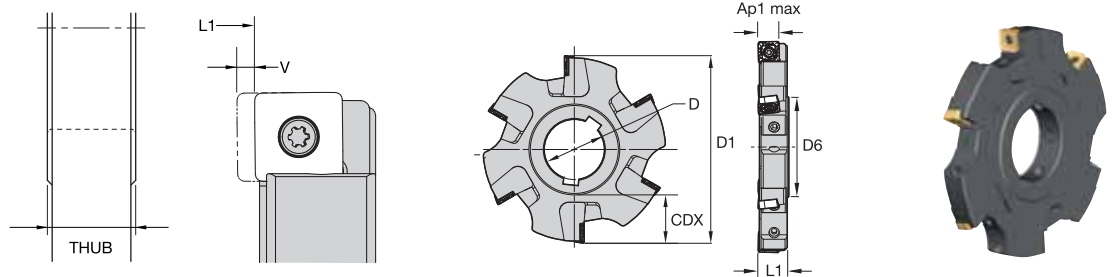
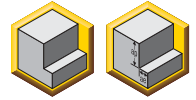
■ Spare Parts



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

Slotting Cutters

- 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.



■ Arbor Mount • Half-Side Cutting • Left Hand

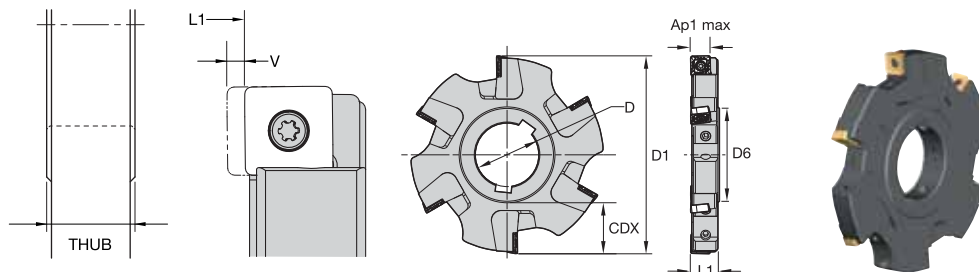
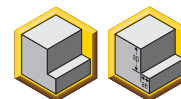
order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2442597	100G06LK90SP10N14K	100	32	46,8	25,9	13,9	13,9	1,0	9,1	6	6	17250	0,50
2443433	125H08LK90SP10N14K	125	40	54,8	34,4	13,9	13,9	1,0	9,1	8	8	15450	0,80
2443457	160H10LK90SP10N14K	160	40	54,8	51,9	13,9	13,9	1,0	9,1	10	10	13650	1,50
2443481	200J14LK90SP10N14K	200	50	68,8	65,2	13,9	13,9	1,0	9,1	14	14	12200	2,40

■ Spare Parts



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



■ Arbor 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
2443436	125H08LK90SP10N16K	125	40	54,8	34,4	15,93	15,9	1,0	9,1	8	8	15450	1,00
2443460	160H10LK90SP10N16K	160	40	54,8	51,9	15,93	15,9	1,0	9,1	10	10	13650	1,80
2443484	200J14LK90SP10N16K	200	50	68,8	64,9	15,93	15,9	1,0	9,1	14	14	12200	2,80
2443505	250J18LK90SP10N16K	250	50	68,8	89,9	15,93	15,9	1,0	9,1	18	18	10900	4,70
2443523	315K20LK90SP10N16K	315	60	83,8	114,9	15,93	15,9	1,0	9,1	20	20	9700	7,70

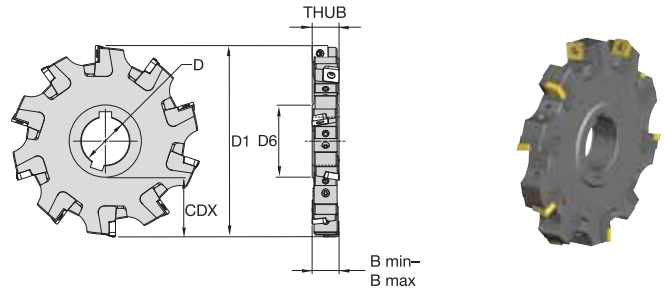
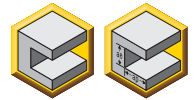
■ Spare Parts



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

Slotting Cutters

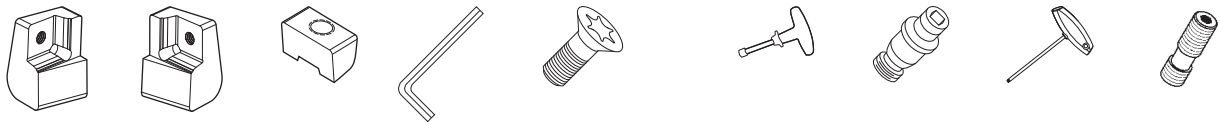
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- Wiper insert facets for superior surface finishes.



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

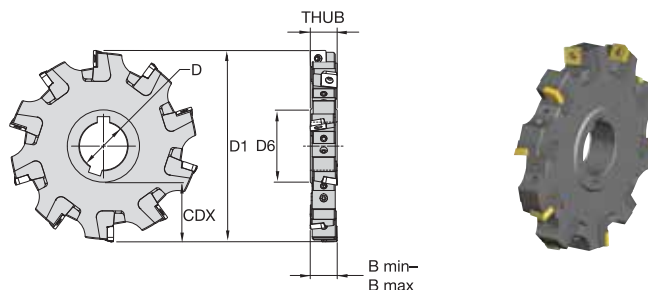
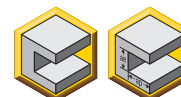
order number	catalogue number	D1	D	D6	CDX	THUB	B min	B max	Z	Z S	max RPM	kg
2442595	100G06NK90SP10N14K	100	32	46,8	25,9	13,9	14	16	6	3	17250	0,50
2442601	125H08NK90SP10N14K	125	40	54,8	34,4	13,9	14	16	8	4	15450	0,80
2443455	160H10NK90SP10N14K	160	40	54,8	51,9	13,9	14	16	10	5	13650	1,50
2443479	200J14NK90SP10N14K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

■ Spare Parts



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

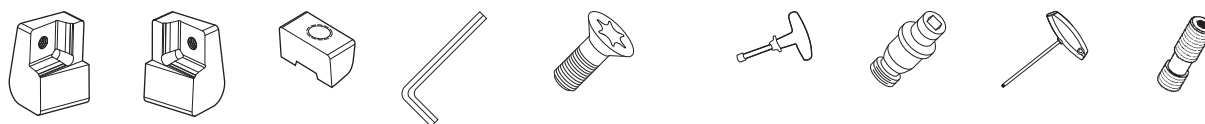
- Rapid adjustment and setting via unique cam adjustment mechanism.
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- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



■ Arbor 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
2443482	200J14NK90SP10N16K	200	50	68,8	64,9	15,9	16	18	14	7	12200	2,80
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

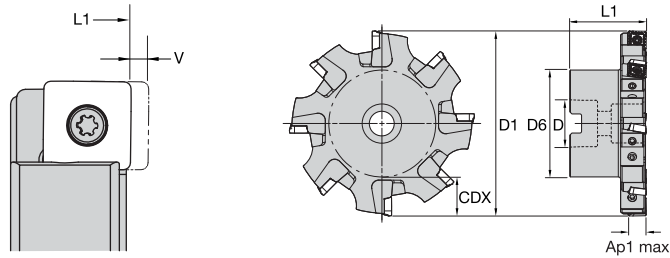
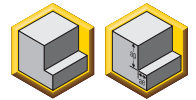
■ Spare Parts



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

Slotting Cutters

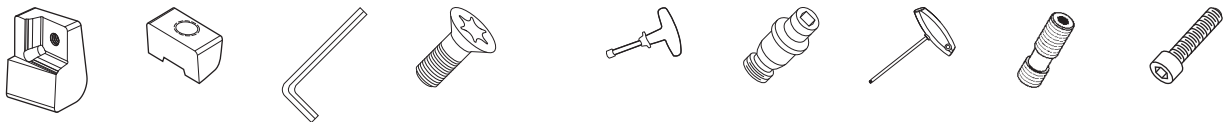
- Rapid adjustment and setting via unique cam adjustment mechanism.
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- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ Shell Mount • Half-Side Cutting • Right Hand

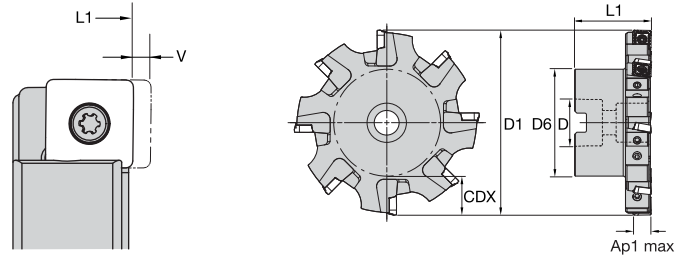
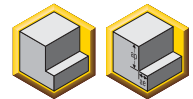
order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2442599	100Y06RK90SP10N14K	100	27	48,0	24,4	50,8	1,0	9,1	6	6	17250	0,90
2443444	125Y08RK90SP10N14K	125	32	58,0	31,9	50,8	1,0	9,1	8	8	15450	1,40
2443468	160Y10RK90SP10N14K	160	40	70,0	43,4	50,8	1,0	9,1	10	10	13650	2,00
2443492	200Y14RK90SP10N14K	200	40	90,0	53,4	50,8	1,0	9,1	14	14	12200	3,70

■ Spare Parts



D1	right-hand cartridge	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	TTP9	CP1416	THW3M	STCM11	MS1556
125	RK90SP1014	W14	MW25	MS2148	2	TTP9	CP1416	THW3M	STCM11	MS1559
160	RK90SP1014	W14	MW25	MS2148	2	TTP9	CP1416	THW3M	STCM11	—
200	RK90SP1014	W14	MW25	MS2148	2	TTP9	CP1416	THW3M	STCM11	—

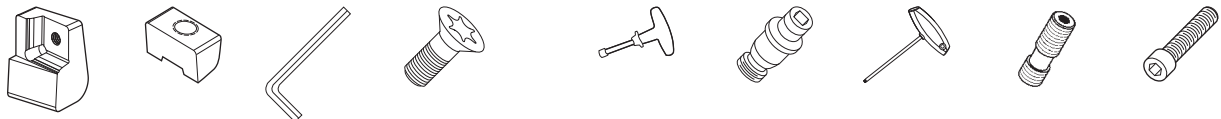
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- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ 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
2443447	125Y08RK90SP10N16K	125	32	58,0	31,9	50,8	1,0	9,1	8	8	15450	1,60
2443471	160Y10RK90SP10N16K	160	40	70,0	43,4	50,8	1,0	9,1	10	10	13650	2,20
2443495	200Y14RK90SP10N16K	200	40	90,0	53,4	50,8	1,0	9,1	14	14	12200	4,10
2443513	250Y18RK90SP10N16K	250	60	130,0	58,4	50,8	1,0	9,1	18	18	10900	6,40
2443531	315Y20RK90SP10N16K	315	60	130,0	90,9	50,8	1,0	9,1	20	20	9700	9,50

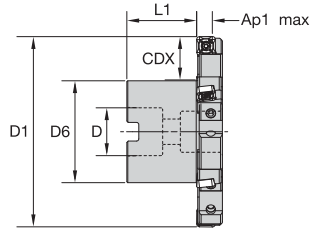
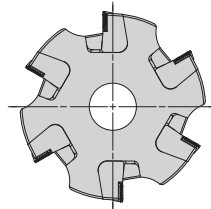
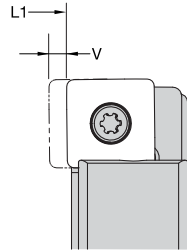
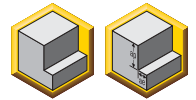
■ Spare Parts



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

Slotting Cutters

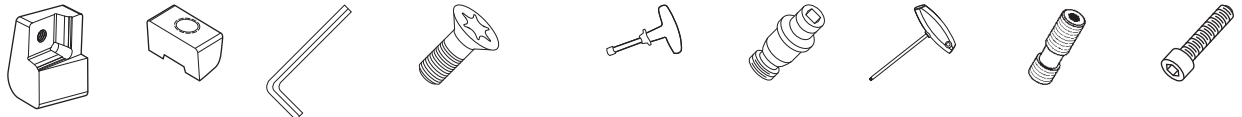
- Rapid adjustment and setting via unique cam adjustment mechanism.
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- Four insert cutting edges.
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- Wiper insert facets for superior surface finishes.



■ Shell Mount • Half-Side Cutting • Left Hand

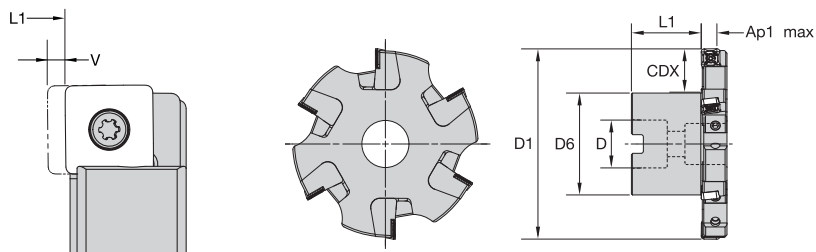
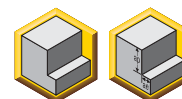
order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2442600	100Y06LK90SP10N14K	100	27	48,0	24,4	36,8	1,0	9,1	6	6	17250	0,90
2443445	125Y08LK90SP10N14K	125	32	58,0	31,9	36,8	1,0	9,1	8	8	15450	1,40
2443469	160Y10LK90SP10N14K	160	40	70,0	43,4	36,8	1,0	9,1	10	10	13650	2,00
2443493	200Y14LK90SP10N14K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

■ Spare Parts



D1	left-hand cartridge	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	TTP9	CP1416	THW3M	STCM11	MS1556
125	LK90SP1014	W14	MW25	MS2148	2	TTP9	CP1416	THW3M	STCM11	MS1559
160	LK90SP1014	W14	MW25	MS2148	2	TTP9	CP1416	THW3M	STCM11	—
200	LK90SP1014	W14	MW25	MS2148	2	TTP9	CP1416	THW3M	STCM11	—

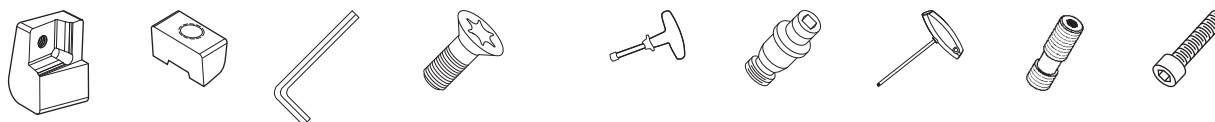
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■ Shell Mount • Half-Side Cutting • Left Hand

order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2443448	125Y08LK90SP10N16K	125	32	58,0	31,9	34,8	1,0	9,1	8	8	15450	1,60
2443472	160Y10LK90SP10N16K	160	40	70,0	43,4	34,8	1,0	9,1	10	10	13650	2,20
2443496	200Y14LK90SP10N16K	200	40	90,0	53,4	34,8	1,0	9,1	14	14	12200	4,10
2443514	250Y18LK90SP10N16K	250	60	130,0	58,4	34,8	1,0	9,1	18	18	10900	6,40
2443532	315Y20LK90SP10N16K	315	60	130,0	90,9	34,8	1,0	9,1	20	20	9700	9,50

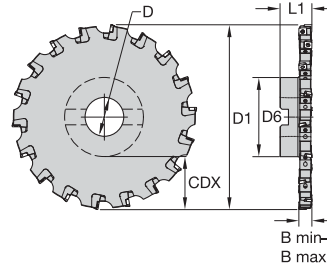
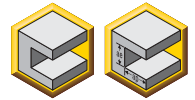
■ Spare Parts



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

Slotting Cutters

- Rapid adjustment and setting via unique cam adjustment mechanism.
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■ Shell Mount Slotting Cutters • 14–16mm Adjustment Range

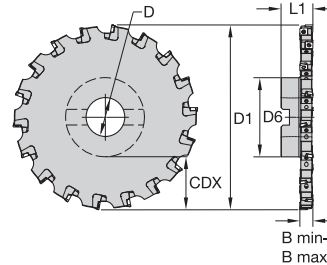
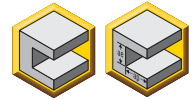
order number	catalogue number	D1	D	D6	CDX	L1	B min	B max	Z	Z S	max RPM	kg
2442598	100Y06NK90SP10N14K	100	27	48,0	24,4	50,8	14	16	6	3	17250	0,90
2443443	125Y08NK90SP10N14K	125	32	58,0	31,9	50,8	14	16	8	4	15450	1,40
2443467	160Y10NK90SP10N14K	160	40	70,0	43,4	50,8	14	16	10	5	13650	2,00
2443491	200Y14NK90SP10N14K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

■ Spare Parts



D1	left-hand cartridge	right-hand cartridge	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	TTP9	CP1416	THW3M	STCM11	MS1556
125	LK90SP1014	RK90SP1014	W14	MW25	MS2148	2	TTP9	CP1416	THW3M	STCM11	MS1559
160	LK90SP1014	RK90SP1014	W14	MW25	MS2148	2	TTP9	CP1416	THW3M	STCM11	—
200	LK90SP1014	RK90SP1014	W14	MW25	MS2148	2	TTP9	CP1416	THW3M	STCM11	—

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

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

■ Spare Parts



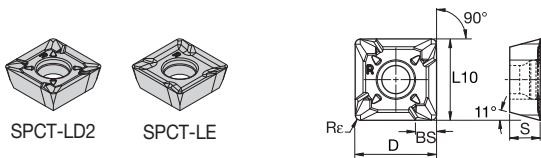
D1	left-hand cartridge	right-hand cartridge	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	LK90SP1016	RK90SP1016	W16	MW25	MS2148	2	TTP9	CP1416	THW3M	STCM11	MS1559
160	LK90SP1016	RK90SP1016	W16	MW25	MS2148	2	TTP9	CP1416	THW3M	STCM11	—
200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

Slotting Cutters

Insert Selection Guide

Material Group	Light Machining		General Purpose		Heavy Machining	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
P3-P4	.E..GB2	KC725M	.E..GB2	KCPK30	.S..GB2	KCPK30
P5-P6	.E..GB2	KCPK30	.E..GB2	KCPM20	.S..GB2	KCPM20
M1-M2	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
M3	.E..GB2	KC725M	.E..GB2	KCPK30	.S..GB2	KCPK30
K1-K2	.E..LD2	KC520M	.E..GB2	KCK15	.S..GB2	KCK15
K3	.E..GB2	KC520M	.E..GB2	KCPK30	.S..GB2	KCPK30
N1-N2	.F..LE	KC410M	.F..LE	KC410M	.F..LE	KC410M
N3	.F..LE	KC410M	.F..LE	KC410M	.F..LE	KC410M
S1-S2	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
S3	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
S4	.E..GB2	KC725M	.S..GB2	KC725M	-	-
H1	-	-	-	-	-	-

Indexable Inserts • KSSM SP.T10T3...


 ● first choice
 ○ alternate choice

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

SPCT-LD2

catalogue number	D	S	L10	BS	Re	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPM20	KCPK30
SPCT10T304PPPELLD2	10,00	3,97	10,00	2,70	0,4	0,04	4			●			
SPCT10T304PPERLD2	10,00	3,97	10,00	2,70	0,4	0,04	4			●			
SPCT10T304PPERLD2	10,00	3,97	10,00	2,70	0,8	0,04	4		●	●		●	
SPCT10T304PPPELLD2	10,00	3,97	10,00	2,70	0,8	0,04	4			●			
SPCT10T312PPERLD2	10,00	3,97	10,00	2,70	1,2	0,04	4			●			
SPCT10T312PPPELLD2	10,00	3,97	10,00	2,70	1,2	0,04	4			●			
SPCT10T316ENLD2	10,00	3,97	10,00	-	1,6	0,04	4			●			
SPCT10T320ENLD2	10,00	3,97	10,00	-	2,0	0,04	4			●			

SPCT-LE

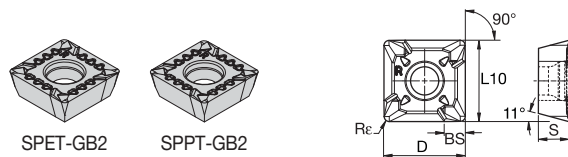
catalogue number	D	S	L10	BS	Re	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPM20	KCPK30
SPCT10T304PPFLE	10,00	3,97	10,00	2,70	0,4	0,02	4	●					
SPCT10T304PPFRLE	10,00	3,97	10,00	2,70	0,4	0,02	4	●					
SPCT10T304PPFRLE	10,00	3,97	10,00	2,70	0,8	0,02	4	●					
SPCT10T304PPFLE	10,00	3,97	10,00	2,70	0,8	0,02	4	●					
SPCT10T312PPFRLE	10,00	3,97	10,00	2,70	1,2	0,02	4	●					
SPCT10T312PPFLE	10,00	3,97	10,00	2,70	1,2	0,02	4	●					
SPCT10T316FNLE	10,00	3,97	10,00	-	1,6	0,02	4	●					
SPCT10T320FNLE	10,00	3,97	10,00	-	2,0	0,02	4	●					

Slotting Cutters

Insert Selection Guide

Material Group	Light Machining		General Purpose		Heavy Machining	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
P3-P4	.E..GB2	KC725M	.E..GB2	KCPK30	.S..GB2	KCPK30
P5-P6	.E..GB2	KCPK30	.E..GB2	KCPM20	.S..GB2	KCPM20
M1-M2	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
M3	.E..GB2	KC725M	.E..GB2	KCPK30	.S..GB2	KCPK30
K1-K2	.E..LD2	KC520M	.E..GB2	KCK15	.S..GB2	KCK15
K3	.E..GB2	KC520M	.E..GB2	KCPK30	.S..GB2	KCPK30
N1-N2	.F..LE	KC410M	.F..LE	KC410M	.F..LE	KC410M
N3	.F..LE	KC410M	.F..LE	KC410M	.F..LE	KC410M
S1-S2	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
S3	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
S4	.E..GB2	KC725M	.S..GB2	KC725M	-	-
H1	-	-	-	-	-	-

Indexable Inserts • KSSM SP.T10T3...



● first choice
○ alternate choice

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

SPET-GB2

catalogue number	D	S	L10	BS	Re	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPM20	KCPK30
SPET10T304PPERGB2	10,00	3,97	10,00	2,70	0,4	0,08	4	○	○	○	○	○	○
SPET10T304PPELGB2	10,00	3,97	10,00	2,70	0,4	0,08	4	○	○	○	○	○	○
SPET10T3PPERGB2	10,00	3,97	10,00	2,70	0,8	0,08	4	○	○	○	○	○	○
SPET10T3PPELGB2	10,00	3,97	10,00	2,70	0,8	0,08	4	○	○	○	○	○	○
SPET10T3PPSLGB2	10,00	3,97	10,00	2,70	0,8	0,13	4	○	○	○	○	○	○
SPET10T3PPSRGB2	10,00	3,97	10,00	2,70	0,8	0,13	4	○	○	○	○	○	○

SPPT-GB2

catalogue number	D	S	L10	BS	Re	hm	cutting edges	KC410M	KC520M	KC725M	KCK15	KCPM20	KCPK30
SPPT10T3PPERGB2	10,00	3,97	10,00	2,70	0,8	0,08	4	○	○	○	○	○	○
SPPT10T3PPSRGB2	10,00	3,97	10,00	2,70	0,8	0,13	4	○	○	○	○	○	○

Slotting Cutters

■ Recommended Starting Speeds [m/min]

Material Group		KC410M			KC520M			KC725M		
P	1	—	—	—	—	—	—	260	230	215
	2	—	—	—	—	—	—	220	190	160
	3	—	—	—	—	—	—	200	170	140
	4	—	—	—	—	—	—	180	150	120
	5	—	—	—	—	—	—	150	135	120
	6	—	—	—	—	—	—	130	100	80
M	1	—	—	—	—	—	—	170	150	135
	2	—	—	—	—	—	—	155	130	110
	3	—	—	—	—	—	—	115	100	80
K	1	—	—	—	270	245	215	—	—	—
	2	—	—	—	210	190	175	—	—	—
	3	—	—	—	175	160	145	—	—	—
N	1-2	1215	1080	995	—	—	—	—	—	—
	3	1080	995	915	—	—	—	—	—	—
S	1	—	—	—	—	—	—	35	30	25
	2	—	—	—	—	—	—	35	30	25
	3	—	—	—	—	—	—	45	35	25
	4	—	—	—	—	—	—	60	45	30
H	1	—	—	—	—	—	—	—	—	—

Material Group		KCK15			KCPM20			KCPK30		
P	1	—	—	—	550	485	450	455	395	370
	2	—	—	—	340	310	275	280	255	230
	3	—	—	—	310	275	255	255	230	205
	4	—	—	—	230	215	190	190	175	160
	5	—	—	—	275	250	230	260	230	210
	6	—	—	—	190	170	145	160	135	—
M	1	—	—	—	225	200	175	205	185	155
	2	—	—	—	205	175	160	185	160	140
	3	—	—	—	160	145	125	145	130	115
K	1	420	385	340	360	325	295	295	265	240
	2	335	295	275	285	255	235	235	210	190
	3	280	250	230	240	215	200	195	175	160
N	1-2	—	—	—	—	—	—	—	—	—
	3	—	—	—	—	—	—	—	—	—
S	1	—	—	—	—	—	—	—	—	—
	2	—	—	—	—	—	—	—	—	—
	3	—	—	—	—	—	—	—	—	—
	4	—	—	—	—	—	—	—	—	—
H	1	—	—	—	—	—	—	—	—	—

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

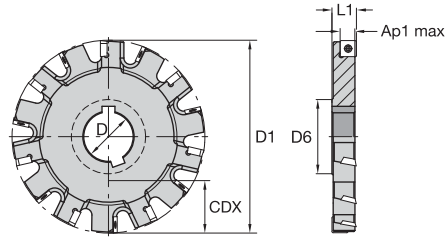
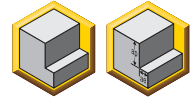
■ Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50-100%			
.F..LE	0,08	0,17	0,33	0,06	0,13	0,25	0,06	0,11	0,22	0,05	0,10	0,20	0,05	0,10	0,20	.F..LE
.E..LD2	0,09	0,25	0,49	0,07	0,19	0,37	0,06	0,17	0,32	0,05	0,16	0,30	0,05	0,15	0,29	.E..LD2
.E..GB2	0,17	0,36	0,61	0,13	0,27	0,46	0,11	0,23	0,40	0,10	0,22	0,37	0,10	0,21	0,36	.E..GB2
.S..GB2	0,17	0,43	0,68	0,13	0,32	0,51	0,11	0,28	0,44	0,10	0,26	0,41	0,10	0,25	0,41	.S..GB2

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

- 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.



■ Arbor 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	11,70	12	12	9170	1,95
3330987	200J14RP90SD12	200	50	68,8	65,6	20,0	11,70	14	14	8210	3,18
3330990	250J16RP90SD12	250	50	68,8	90,6	20,0	11,70	16	16	7300	5,29

■ Spare Parts



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

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

■ Arbor Mount • 12mm IC • Left Hand

Slotting Cutters

order number	catalogue number	D1	D	D6	CDX	L1	Ap1 max	Z	Z S	max RPM	kg
3330985	160H12LP90SD12	160	40	54,8	55,6	20,0	11,7	12	12	9170	1,95
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

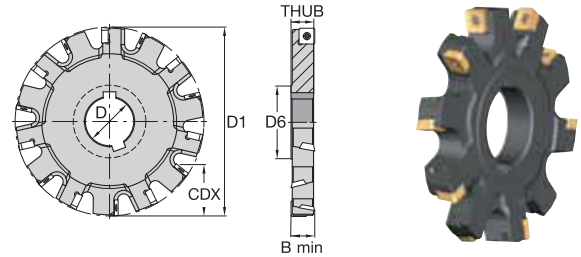
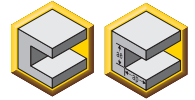
■ Spare Parts



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



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

order number	catalog 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	1,84
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

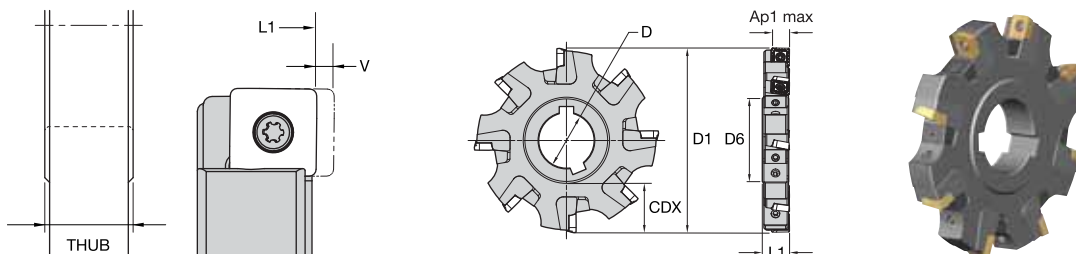
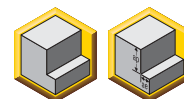


D1	insert screw	Nm	Torx Plus driver
160	MS2078	4	DT15IP
200	MS2078	4	DT15IP
250	MS2078	4	DT15IP

NOTE: For superior surface finish, use right-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.



■ Arbor 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
2443486	200J14RK90SD12N18K	200	50	68,8	64,5	18,1	18,2	1,3	11,7	14	14	8200	3,00
2443507	250J16RK90SD12N18K	250	50	68,8	89,5	18,1	18,2	1,3	11,7	16	16	7350	5,00
2443525	315K18RK90SD12N18K	315	60	83,8	114,5	18,1	18,2	1,3	11,7	18	18	6500	8,40

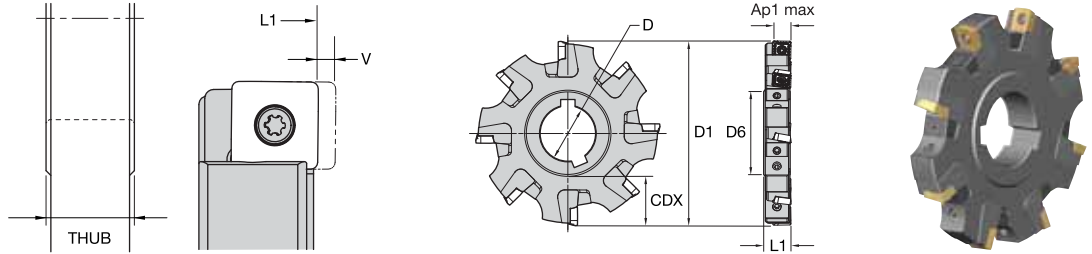
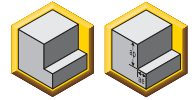
■ Spare Parts



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

Slotting Cutters

- Rapid adjustment and setting via unique cam adjustment mechanism.
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- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



■ Arbor Mount • Half-Side Cutting • Right Hand

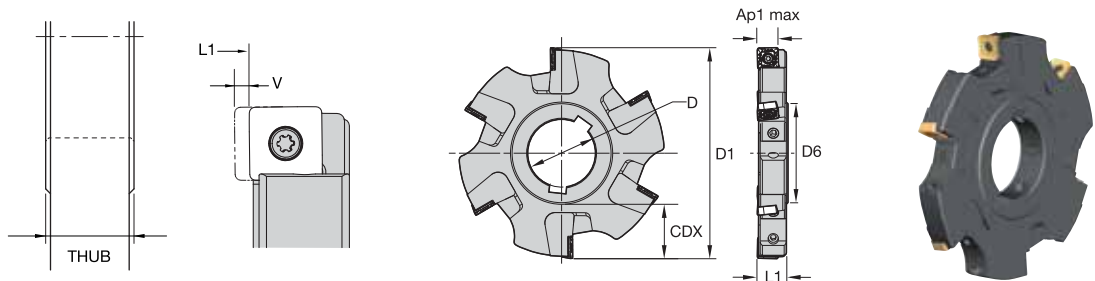
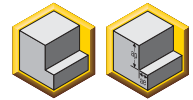
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2443441	125H08RK90SD12N20K	125	40	54,8	34,0	20,7	20,8	1,3	11,7	8	8	10350	1,20
2443465	160H10RK90SD12N20K	160	40	54,8	51,5	20,7	20,8	1,3	11,7	10	10	9150	2,10
2443489	200J14RK90SD12N20K	200	50	68,8	64,5	20,7	20,8	1,3	11,7	14	14	8200	3,50
2443510	250J16RK90SD12N20K	250	50	68,8	89,5	20,7	20,8	1,3	11,7	16	16	7350	5,90
2443528	315K18RK90SD12N20K	315	60	83,8	114,5	20,7	20,8	1,3	11,7	18	18	6500	9,70

■ Spare Parts



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

- Rapid adjustment and setting via unique cam adjustment mechanism.
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■ Arbor 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
2443487	200J14LK90SD12N18K	200	50	68,8	64,5	18,1	18,2	1,3	11,7	14	14	8200	3,00
2443508	250J16LK90SD12N18K	250	50	68,8	89,5	18,1	18,2	1,3	11,7	16	16	7350	5,00
2443526	315K18LK90SD12N18K	315	60	83,8	114,5	18,1	18,2	1,3	11,7	18	18	6500	8,40

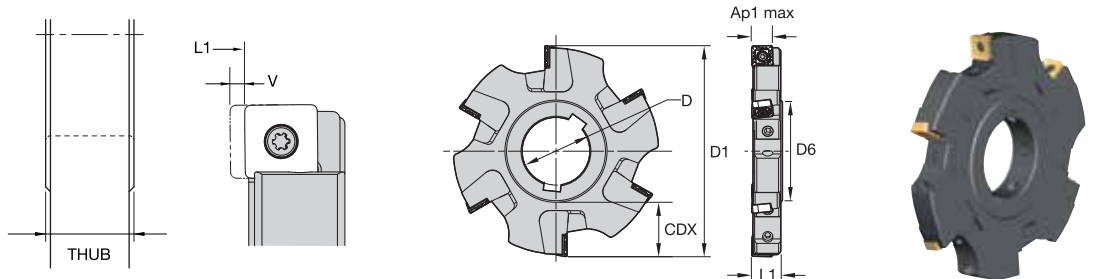
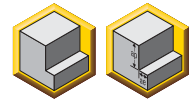
■ Spare Parts



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

Slotting Cutters

- Rapid adjustment and setting via unique cam adjustment mechanism.
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■ Arbor Mount • Half-Side Cutting • Left Hand

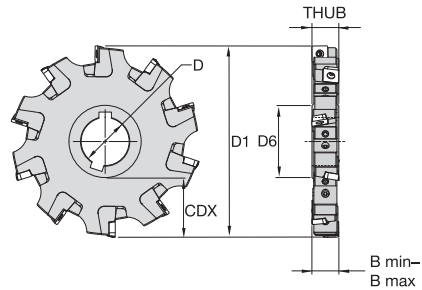
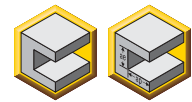
order number	catalogue number	D1	D	D6	CDX	L1	THUB	V	Ap1 max	Z	Z S	max RPM	kg
2443442	125H08LK90SD12N20K	125	40	54,8	34,0	20,7	20,8	1,3	11,7	8	8	10350	1,20
2443466	160H10LK90SD12N20K	160	40	54,8	51,5	20,7	20,8	1,3	11,7	10	10	9150	2,10
2443490	200J14LK90SD12N20K	200	50	68,8	64,5	20,7	20,8	1,3	11,7	14	14	8200	3,50
2443511	250J16LK90SD12N20K	250	50	68,8	89,5	20,7	20,8	1,3	11,7	16	16	7350	5,90
2443529	315K18LK90SD12N20K	315	60	83,8	114,5	20,7	20,8	1,3	11,7	18	18	6500	9,70

■ Spare Parts



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

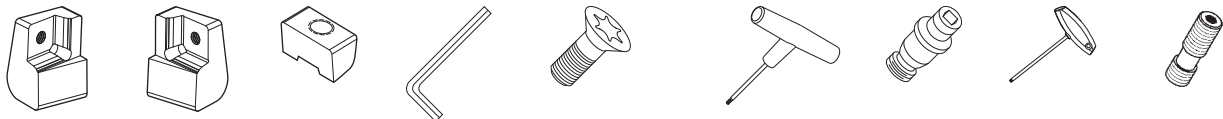
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



■ Arbor 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

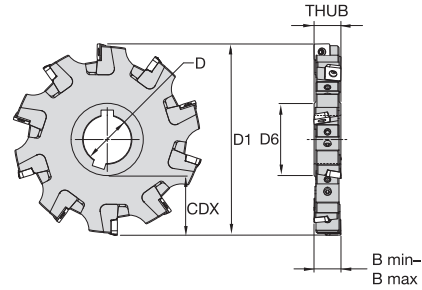
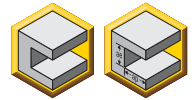
■ Spare Parts



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

Slotting Cutters

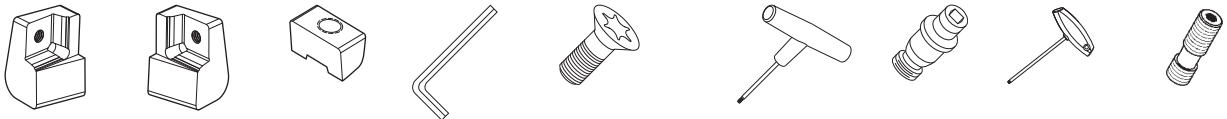
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Two keyways for staggered mounting.
- Wiper insert facets for superior surface finishes.



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

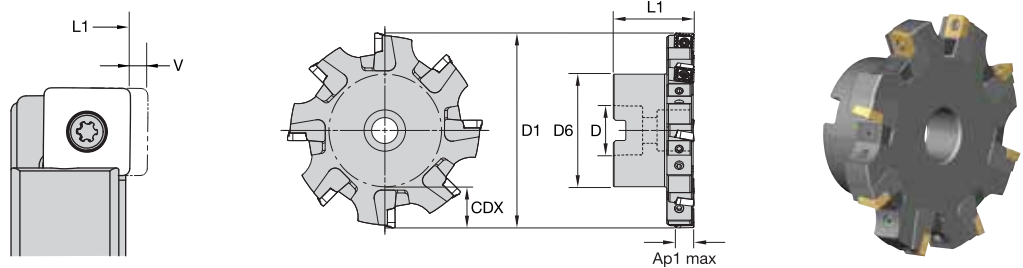
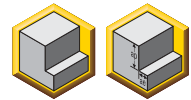
order number	catalogue number	D1	D	D6	B min	B max	CDX	THUB	Z	Z S	max RPM	kg
2443440	125H08NK90SD12N20K	125	40	54,8	20,7	23,3	34,0	20,8	8	4	10350	1,20
2443464	160H10NK90SD12N20K	160	40	54,8	20,7	23,3	51,5	20,8	10	5	9150	2,10
2443488	200J14NK90SD12N20K	200	50	68,8	20,7	23,3	64,5	20,8	14	7	8200	3,50
2443509	250J16NK90SD12N20K	250	50	68,8	20,7	23,3	89,5	20,8	16	8	7350	5,90
2443527	315K18NK90SD12N20K	315	60	83,8	20,7	23,3	114,5	20,8	18	9	6500	9,70

■ Spare Parts



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

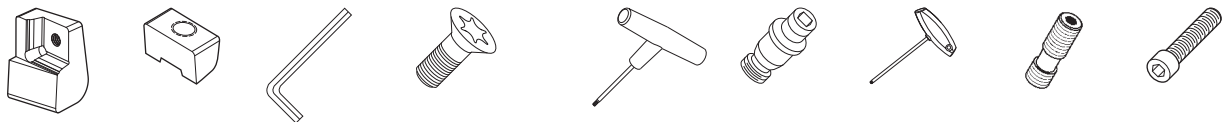
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ 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
2443474	160Y10RK90SD12N18K	160	40	70,0	43,4	51,0	1,3	11,7	10	10	9150	2,30
2443498	200Y14RK90SD12N18K	200	40	90,0	53,4	51,0	1,3	11,7	14	14	8200	4,20
2443516	250Y16RK90SD12N18K	250	60	130,0	58,4	51,0	1,3	11,7	16	16	7350	6,70
2443537	315Y18RK90SD12N18K	315	60	130,0	90,9	51,0	1,3	11,7	18	18	6500	10,10

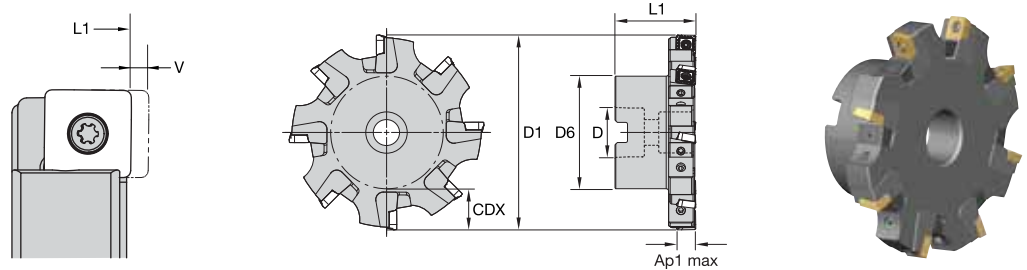
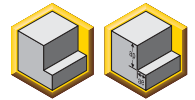
■ Spare Parts



D1	right-hand cartridge	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	TTP15	CP1820	THW3M	STCM11	MS1559
160	RK90SD1218	W18	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
200	RK90SD1218	W18	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
250	RK90SD1218	W18	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
315	RK90SD1218	W18	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—

Slotting Cutters

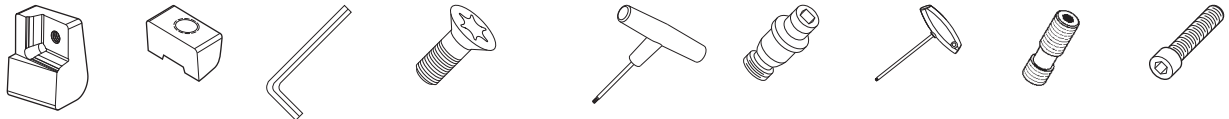
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ Shell Mount • Half-Side Cutting • Right Hand

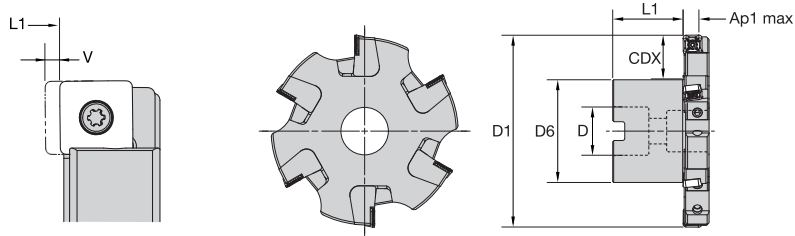
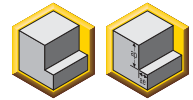
order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2443453	125Y08RK90SD12N20K	125	32	58,0	31,9	51,0	1,3	11,7	8	8	10350	1,70
2443477	160Y10RK90SD12N20K	160	40	70,0	43,4	51,0	1,3	11,7	10	10	9150	2,50
2443501	200Y14RK90SD12N20K	200	40	90,0	53,4	51,0	1,3	11,7	14	14	8200	4,60
2443519	250Y16RK90SD12N20K	250	60	130,0	58,4	51,0	1,3	11,7	16	16	7350	7,30
2443534	315Y18RK90SD12N20K	315	60	130,0	90,9	51,0	1,3	11,7	18	18	6500	11,30

■ Spare Parts



D1	right-hand cartridge	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	TTP15	CP1820	THW3M	STCM11	MS1559
160	RK90SD1220	W20	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
200	RK90SD1220	W20	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
250	RK90SD1220	W20	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
315	RK90SD1220	W20	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—

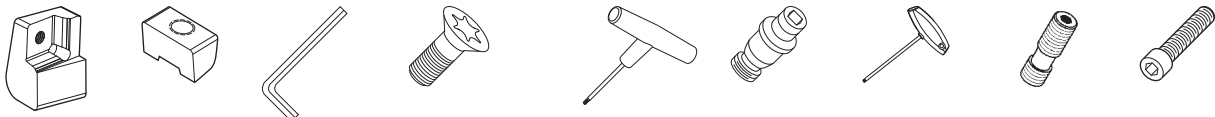
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ 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
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
2443499	200Y14LK90SD12N18K	200	40	90,0	53,4	33,0	1,3	11,7	14	14	8200	4,20
2443517	250Y16LK90SD12N18K	250	60	130,0	58,4	33,0	1,3	11,7	16	16	7350	6,70
2443538	315Y18LK90SD12N18K	315	60	130,0	90,9	33,0	1,3	11,7	18	18	6500	10,10

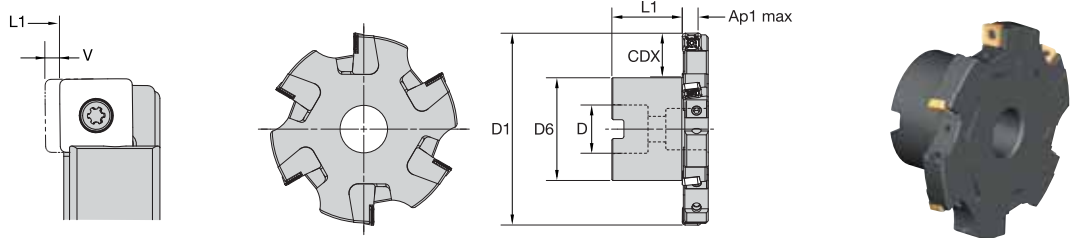
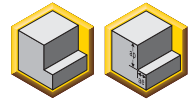
■ Spare Parts



D1	left-hand cartridge	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	TTP15	CP1820	THW3M	STCM11	MS1559
160	LK90SD1218	W18	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
200	LK90SD1218	W18	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
250	LK90SD1218	W18	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
315	LK90SD1218	W18	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—

Slotting Cutters

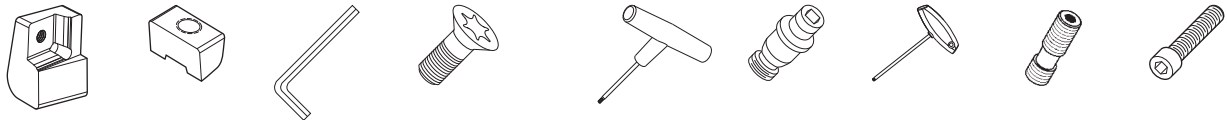
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ Shell Mount • Half-Side Cutting • Left Hand

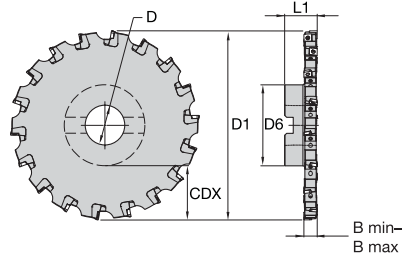
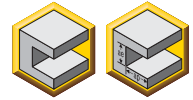
order number	catalogue number	D1	D	D6	CDX	L1	V	Ap1 max	Z	Z S	max RPM	kg
2443454	125Y08LK90SD12N20K	125	32	58,0	31,9	30,4	1,3	11,7	8	8	10350	1,70
2443478	160Y10LK90SD12N20K	160	40	70,0	43,4	30,4	1,3	11,7	10	10	9150	2,50
2443502	200Y14LK90SD12N20K	200	40	90,0	53,4	30,4	1,3	11,7	14	14	8200	4,60
2443520	250Y16LK90SD12N20K	250	60	130,0	58,4	30,4	1,3	11,7	16	16	7350	7,30
2443535	315Y18LK90SD12N20K	315	60	130,0	90,9	30,4	1,3	11,7	18	18	6500	11,30

■ Spare Parts



D1	left-hand cartridge	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	TTP15	CP1820	THW3M	STCM11	MS1559
160	LK90SD1220	W20	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
200	LK90SD1220	W20	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
250	LK90SD1220	W20	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
315	LK90SD1220	W20	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—

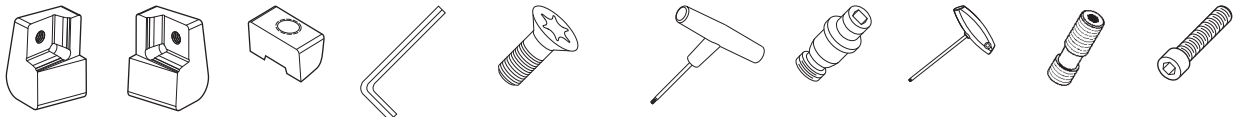
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ 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
2443497	200Y14NK90SD12N18K	200	40	90,0	18	20,7	53,4	51,0	14	7	8200	4,20
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	10,10

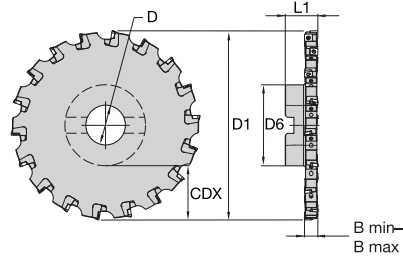
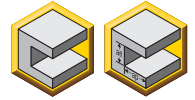
■ Spare Parts



D1	left-hand cartridge	right-hand cartridge	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	TTP15	CP1820	THW3M	STCM11	MS1559
160	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
200	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
250	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
315	LK90SD1218	RK90SD1218	W18	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—

Slotting Cutters

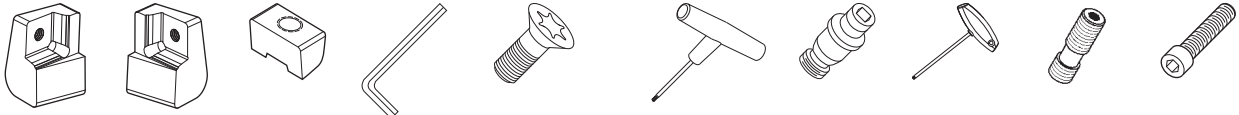
- Rapid adjustment and setting via unique cam adjustment mechanism.
- Large selection of insert geometries and grades to cut most workpiece materials.
- Four insert cutting edges.
- Wide choice of insert radii.
- Wiper insert facets for superior surface finishes.



■ 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



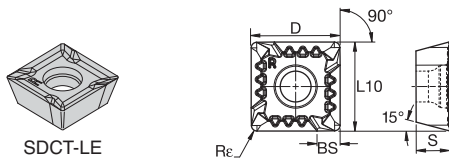
D1	left-hand cartridge	right-hand cartridge	wedge	cam pin wrench	insert screw	Nm	Torx Plus wrench	cam pin	wedge wrench	wedge screw	socket-head cap screw
125	LK90SD1220	RK90SD1220	W20	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	MS1559
160	LK90SD1220	RK90SD1220	W20	MW3	MS2077	4	TTP15	CP1820	THW3M	STCM11	—
200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



Insert Selection Guide

Material Group	Light Machining		General Purpose		Heavy Machining	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
P3-P4	.E..GB2	KCPK30	.S..GB2	KCPK30	.S..GB	KCPK30
P5-P6	.E..GB2	KCPM20	.S..GB2	KCPM20	.S..GB	KCPK30
M1-M2	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
M3	.E..GB2	KCPK30	.S..GB2	KCPK30	.S..GB	KCPK30
K1-K2	.E..LD	KCK15	.E..GB2	KCK15	.S..GB2	KCK15
K3	.E..GB2	KCPK30	.S..GB2	KCPK30	.S..GB	KCPK30
N1-N2	.F..LE	KC410M	.F..LE	KC410M	.F..LE	KC410M
N3	.F..LE	KC410M	.F..LE	KC410M	.F..LE	KC410M
S1-S2	.E..LD2	KC725M	.E..GB2	KC725M	.S..GB2	KC725M
S3	.E..GB2	KC725M	.S..GB2	KC725M	.S..GB	KC725M
S4	.S..GB2	KC725M	.S..GB	KC725M	—	—
H1	—	—	—	—	—	—

Indexable Inserts • KSSM SD.T1204...



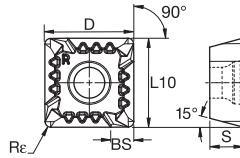
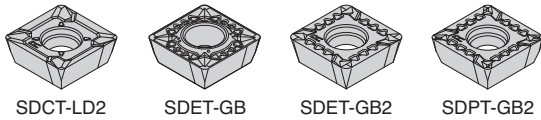
● first choice
○ alternate choice

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

SDCT-LE

Slotting Cutters

catalogue number	D	S	L10	BS	Re	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM20
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	●						



● first choice
○ alternate choice

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

■ SDCT-LD2

catalogue number	D	S	L10	BS	Re	hm	cutting edges
SDCT120404PDELDD2	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
SDCT1204PDERLD2	12,70	4,76	12,70	3,32	0,8	0,04	4
SDCT1204PDELDD2	12,70	4,76	12,70	3,32	0,8	0,04	4
SDCT120412PDERLD2	12,70	4,76	12,70	3,05	1,2	0,04	4
SDCT120412PDELDD2	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
SDET1204PDERGB	12,70	4,76	12,70	3,36	0,8	0,07	4
SDET1204PDSRGB	12,70	4,76	12,70	3,36	0,8	0,16	4
SDET120412PDERGB	12,70	4,76	12,70	3,36	1,2	0,07	4
SDET120464SNGB	12,70	4,76	12,70	—	6,4	0,15	2

■ SDET-GB2

catalogue number	D	S	L10	BS	Re	hm	cutting edges
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

■ SDPT-GB2

catalogue number	D	S	L10	BS	Re	hm	cutting edges
SDPT1204PDERGB2	12,70	4,76	12,70	2,70	0,8	0,08	4
SDPT1204PDSRGB2	12,70	4,76	12,70	2,70	0,8	0,13	4

	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM20
SDCT-LD2				●			●
SDET-GB		●				●	
SDET-GB2		●		●	●	●	●
SDPT-GB2				●		●	●



■ Recommended Starting Speeds [m/min]

Material Group		KC410M			KC520M			KC522M			KC725M		
P	1	—	—	—	—	—	—	330	285	270	260	230	215
	2	—	—	—	—	—	—	275	240	200	220	190	160
	3	—	—	—	—	—	—	255	215	175	200	170	140
	4	—	—	—	—	—	—	225	185	150	180	150	120
	5	—	—	—	—	—	—	185	170	150	150	135	120
	6	—	—	—	—	—	—	165	125	100	130	100	80
M	1	—	—	—	—	—	—	205	180	165	170	150	135
	2	—	—	—	—	—	—	185	160	130	155	130	110
	3	—	—	—	—	—	—	140	120	95	115	100	80
K	1	—	—	—	270	245	215	230	205	185	—	—	—
	2	—	—	—	210	190	175	180	160	150	—	—	—
	3	—	—	—	175	160	145	150	135	120	—	—	—
N	1-2	1215	1080	995	—	—	—	—	—	—	—	—	—
	3	1080	995	915	—	—	—	—	—	—	—	—	—
S	1	—	—	—	—	—	—	40	35	25	35	30	25
	2	—	—	—	—	—	—	40	35	25	35	30	25
	3	—	—	—	—	—	—	50	40	25	45	35	25
	4	—	—	—	—	—	—	70	50	35	60	45	30
H	1	—	—	—	—	—	—	—	—	—	—	—	—

Material Group		KCK15			KCPK30			KCPM20		
P	1	—	—	—	455	395	370	550	485	450
	2	—	—	—	280	255	230	340	310	275
	3	—	—	—	255	230	205	310	275	255
	4	—	—	—	190	175	160	230	215	190
	5	—	—	—	260	230	210	275	250	230
	6	—	—	—	160	135	—	190	170	145
M	1	—	—	—	205	185	155	225	200	175
	2	—	—	—	185	160	140	205	175	160
	3	—	—	—	145	130	115	160	145	125
K	1	420	385	340	295	265	240	360	325	295
	2	335	295	275	235	210	190	285	255	235
	3	280	250	230	195	175	160	240	215	200
N	1-2	—	—	—	—	—	—	—	—	—
	3	—	—	—	—	—	—	—	—	—
S	1	—	—	—	—	—	—	—	—	—
	2	—	—	—	—	—	—	—	—	—
	3	—	—	—	—	—	—	—	—	—
	4	—	—	—	—	—	—	—	—	—
H	1	—	—	—	—	—	—	—	—	—

NOTE: FIRST choice starting speeds are in **bold** type.
As the average chip thickness increases, the speed should be decreased.

■ Recommended Starting Feeds [mm]

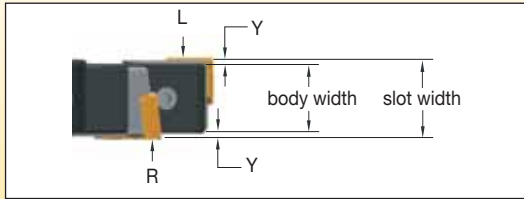
Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	10%			20%			30%			40%			50-100%			
.F..LE	0,08	0,17	0,33	0,06	0,13	0,25	0,06	0,11	0,22	0,05	0,10	0,20	0,05	0,10	0,20	.F..LE
.E..LD	0,09	0,24	0,51	0,07	0,18	0,38	0,06	0,16	0,33	0,05	0,15	0,31	0,05	0,14	0,30	.E..LD
.E..LD2	0,09	0,24	0,51	0,07	0,18	0,38	0,06	0,16	0,33	0,05	0,15	0,31	0,05	0,14	0,30	.E..LD2
.E..GB	0,17	0,35	0,59	0,12	0,26	0,44	0,11	0,23	0,38	0,10	0,21	0,36	0,10	0,21	0,35	.E..GB
.E..GB2	0,17	0,36	0,60	0,13	0,27	0,45	0,11	0,23	0,39	0,10	0,22	0,36	0,10	0,21	0,36	.E..GB2
.S..GB	0,17	0,43	0,63	0,13	0,32	0,47	0,11	0,28	0,41	0,10	0,26	0,38	0,10	0,25	0,37	.S..GB
.S..GB2	0,17	0,43	0,62	0,13	0,32	0,47	0,11	0,28	0,41	0,10	0,26	0,38	0,10	0,25	0,37	.S..GB2

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

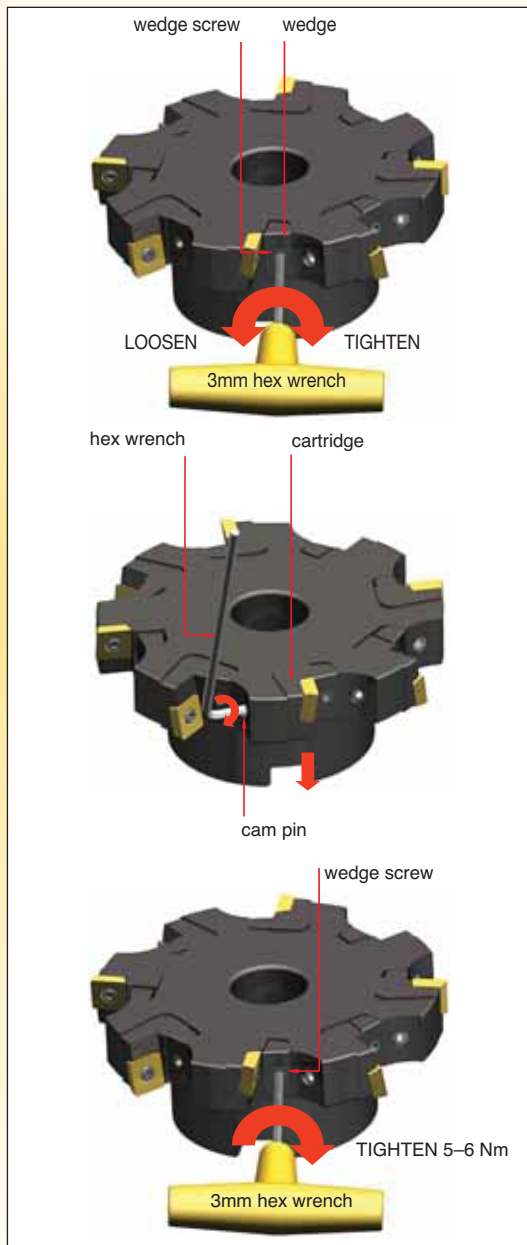
Slotting Cutters

■ 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 1 Nm, 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 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.