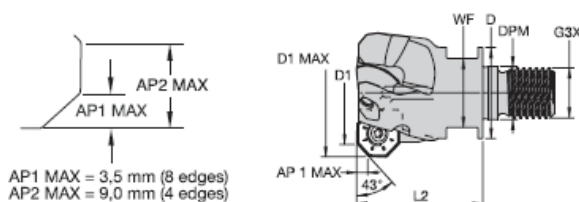


NEW!

- Available in diameters of 32 mm and 40 mm.
- Three geometries and six grades for use in most workpiece materials.
- Eight cutting edges.



End Mills — Screw-On

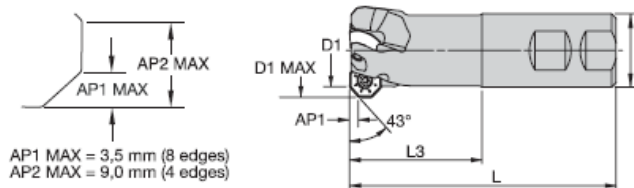
D1	order number	catalog number	Z	D	D1 max	L2	DPM	G3X	WF	Ap1 max	Max Ramp Angle	Max RPM
32	3115896	KSOM32R02M16OF06	2	29	41	40	17	M16	22	3,5	11.0°	19890
32	3115895	KSOM32R03M16OF06	3	29	41	40	17	M16	22	3,5	11.0°	19890
40	3115901	KSOM40R03M16OF06	3	29	49	40	17	M16	22	3,5	7.5°	15920
40	3115900	KSOM40R04M16OF06	4	29	49	40	17	M16	22	3,5	7.5°	15920

Spare Parts

D1	insert screw	Nm	Torx plus wrench
32	193.433	6	TTP15
40	193.433	6	TTP15

NEW!

- Available in diameters of 32 mm and 40 mm.
- Three geometries and six grades for use in most workpiece materials.
- Eight cutting edges.



End Mills — Medium Pitch

D1	order number	catalog number	Z	D	D1 max	L3	L	Ap1 max	Max Ramp Angle	Max RPM
32	3115894	KSOM32R02B20OF06	2	20	41	25	76	3,5	11.0°	19890
40	3115899	KSOM40R03B25OF06	3	25	49	25	82	3,5	7.5°	15920

End Mills — Fine Pitch

D1	order number	catalog number	Z	D	D1 max	L3	L	Ap1 max	Max Ramp Angle	Max RPM
32	3115893	KSOM32R03B20OF06	3	20	41	25	76	3,5	11.0°	19890
32	3115882	KSOM32R03B25OF06	3	25	41	25	82	3,5	11.0°	19890
40	3115898	KSOM40R04B25OF06	4	25	49	25	82	3,5	7.5°	15920
40	3115897	KSOM40R04B32OF06	4	32	49	49	110	3,5	7.5°	15920

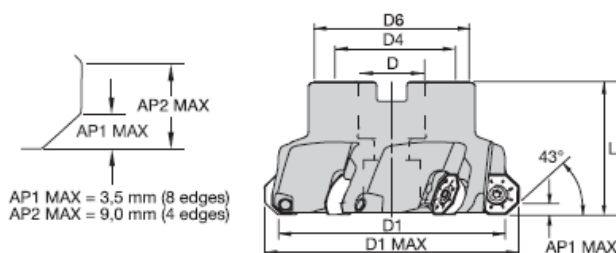
Spare Parts

D1	insert screw	Nm	Torx plus wrench
32	193.433	6	TTP15
40	193.433	6	TTP15

Indexable Shell Mills



- Available in diameters of 50 mm to 160 mm.
- Three geometries and six grades for use in most workpiece materials.
- Eight insert cutting edges.



Shell Mills — Medium Pitch

D1	order number	catalog number	Z	D	D1 max	D4	D6	L	Ap1 max	Max Ramp Angle	Max RPM
50	3115903	KSOM50R04OF06	4	22	59	—	38	43	3,5	5.0°	12730
63	3115905	KSOM63R05OF06	5	22	72	—	50	43	3,5	3.9°	10110
80	3115907	KSOM80R06OF06	6	27	89	—	60	50	3,5	2.9°	7960
100	3115909	KSOM100R07OF06	7	32	109	—	80	50	3,5	2.2°	6370
125	3115911	KSOM125R08OF06	8	40	134	—	94	63	3,5	1.7°	5090
160	3115913	KSOM160R10OF06	10	40	169	67	114	63	3,5	1.3°	3980

Spare Parts

D1	insert screw	torque (Nm)	wrench	mounting screw	coolant screw	coolant cap
50	193.433	6	TTP15	129.025	MS2072CG	—
63	193.433	6	TTP15	125.025	MS1234CG	—
80	193.433	6	TTP15	125.230	MS2038CG	—
100	193.433	6	TTP15	—	MS2189CG	—
125	193.433	6	TTP15	—	420.200	470.232
160	193.433	6	TTP15	—	420.200	470.233

Shell Mills — Fine Pitch

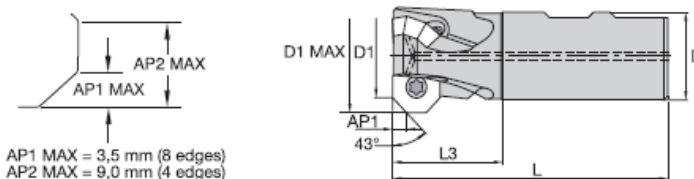
D1	order number	catalog number	Z	D	D1 max	D4	D6	L	Ap1 max	Max Ramp Angle	Max RPM
50	3115902	KSOM50R06OF06	6	22	59	—	38	43	3,5	5.0°	12730
63	3115904	KSOM63R07OF06	7	22	72	—	50	43	3,5	3.9°	10110
80	3115906	KSOM80R09OF06	9	27	89	—	60	50	3,5	2.9°	7960
100	3115908	KSOM100R10OF06	10	32	109	—	80	50	3,5	2.2°	6370
125	3115910	KSOM125R12OF06	12	40	134	—	94	63	3,5	1.7°	5090
160	3115912	KSOM160R16OF06	16	40	169	67	114	63	3,5	1.3°	3980

Spare Parts

D1	insert screw	torque (Nm)	wrench	mounting screw	coolant screw	coolant cap
50	193.433	6	TTP15	129.025	MS2072CG	—
63	193.433	6	TTP15	125.025	MS1234CG	—
80	193.433	6	TTP15	125.230	MS2038CG	—
100	193.433	6	TTP15	—	MS2189CG	—
125	193.433	6	TTP15	—	420.200	470.232
160	193.433	6	TTP15	—	420.200	470.233

NEW!

- Cutting diameters are 32 mm and 40 mm.
- Three insert geometries and six grades to cut most workpiece materials.
- Eight insert cutting edges.



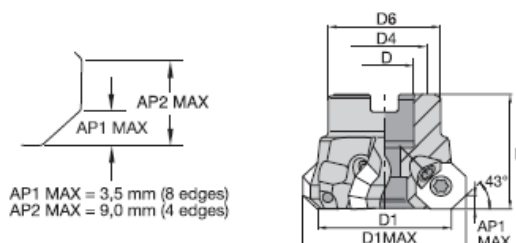
■ End Mills — Wedge Clamping

D1	order number	catalog number	Z	D	D1 max	L3	L	Ap1 max	Ap2 max	kg	Max RPM
32	2462846	32D03R040B32SOF04	3	32	41	40	100	3,5	9,0	0,6	19890
40	2488093	40D04R050B32SOF04	4	32	49	50	110	3,5	9,0	0,7	15920

■ Spare Parts

D1	insert screw	torque (Nm)	wedge	wedge screw	torque (Nm)	Torx plus wrench
32	193.433	6	470.264	193.434	6	TTP15
40	193.433	6	470.264	193.434	6	TTP15

- Cutting diameter ranges from 50 mm to 160 mm.
- Three insert geometries and six grades to cut most workpiece materials.
- Eight insert cutting edges.



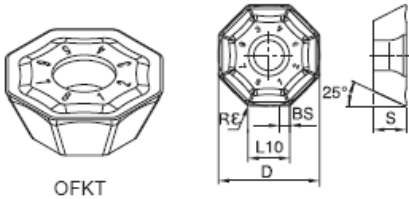
■ Shell Mills — Wedge Clamping

D1	order number	catalog number	Z	D	D1 max	D4	D6	L	Ap1 max	Ap2 max	kgs	Max RPM
50	2487015	50A06RS45OF06A	6	22	59	—	42	43	3,5	9,0	0,4	12730
63	2462847	63A07RS45OF06A	7	22	72	—	54	43	3,5	9,0	0,7	10110
80	2465247	80A09RS45OF06A	9	27	89	—	64	50	3,5	9,0	1,2	7960
100	2462848	100B10RS45OF06A	10	32	109	—	84	50	3,5	9,0	2,1	6370
125	2488094	125B12RS45OF06A	12	40	134	—	94	63	3,5	9,0	3,0	5090
160	2488095	160C16RS45OF06A	16	40	169	67	114	63	3,5	9,0	4,7	3980

■ Spare Parts

D1	insert screw	torque (Nm)	wedge	wedge screw	torque (Nm)	wrench	mounting screw	coolant clamping screw	coolant cap
50	193.433	6	470.264	193.434	6	TTP15	129.025	MS2072CG	—
63	193.433	6	470.264	193.434	6	TTP15	125.025	420.100	—
80	193.433	6	470.264	193.434	6	TTP15	125.230	420.120	—
100	193.433	6	470.264	193.434	6	TTP15	—	420.160	—
125	193.433	6	470.264	193.434	6	TTP15	—	420.200	470.232
160	193.433	6	470.264	193.434	6	TTP15	—	420.200	470.233

Indexable Inserts for KSOM Mini OF.T06L5...



● first choice
○ alternate choice

H							
S							
N							
K							
M							
P							

catalog number	cutting edges	D	S	L10	BS	Re	hm	KC410M	KC520M	KC522M	KC725M	KC915M	KC935M
OFKT06L5AFENGB	8	14,70	5,00	6,00	—	0,80	0,10						
OFKT06L5AFENLB	8	14,70	5,00	6,00	1,23	0,80	0,05						
OFKT06L5AFFNLNJ	8	14,70	5,00	6,00	—	0,80	0,05						
OFKT06L5AFSNHB	8	14,70	5,00	6,00	—	0,80	0,20						
OFKT06L5AFSNLB	8	14,70	5,00	6,00	1,21	0,80	0,20						
OFPT06L5AFENGB	8	14,70	5,00	6,00	—	0,80	0,10						
OFPT06L5AFSNHB	8	14,70	5,00	6,00	—	0,80	0,20						

Recommended Starting Speeds [m/min]

43° approach angle

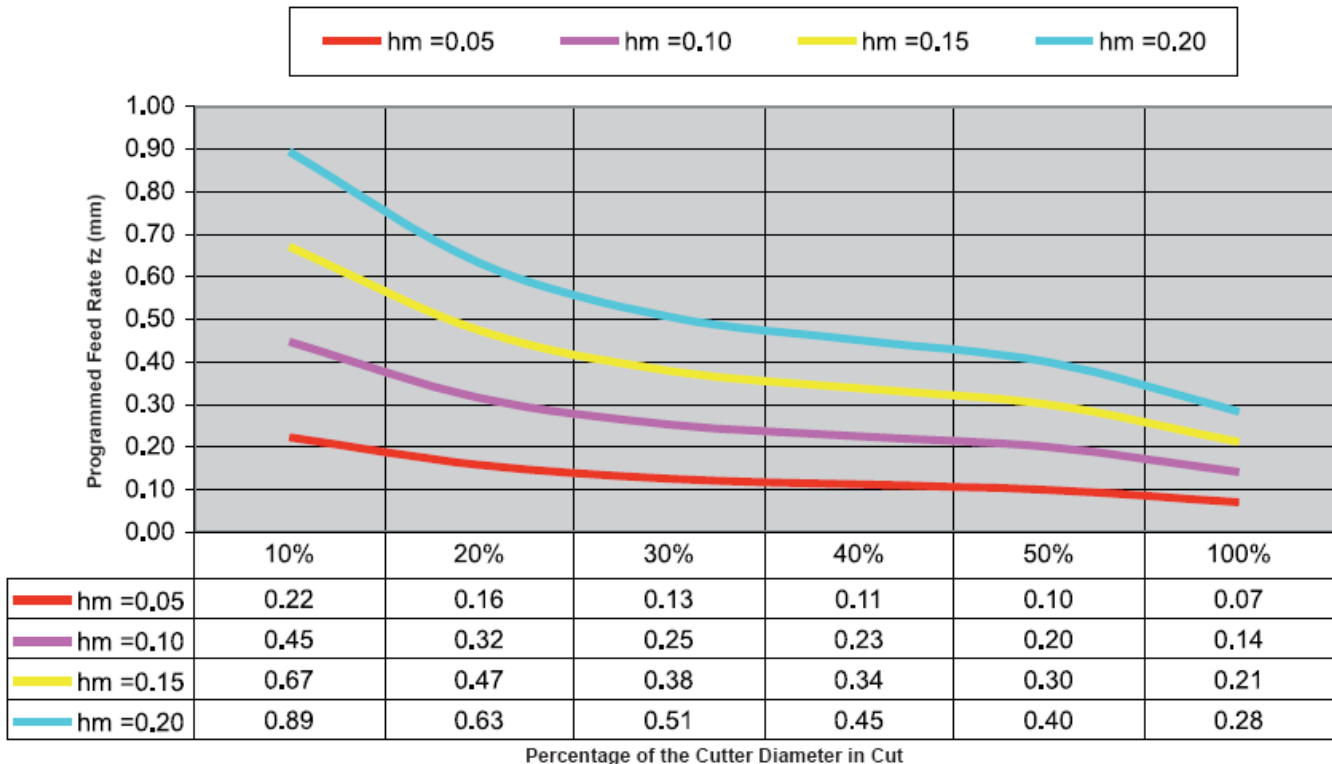
Material Group	KC410M			KC520M			KC522M			KC725M			KC915M			KC935M		
P1										310	270	250				470	410	380
P2										190	180	160				290	260	240
P3										180	160	140				260	240	220
P4							120	110	100	130	120	110				200	180	160
P5							155	150	135	180	160	150				265	240	215
P6							100	80		110	90					160	140	
M1							180	160	150	200	180	160				310	270	250
M2							170	150	140	180	170	150				280	250	230
M3							120	110		140	120					210	180	
K1				320	290	260				200	180	160	440	400	350	310	280	250
K2				250	220	210	240	220	200	160	140	130	350	310	290	240	220	200
K3				210	190	170	200	180	170	130	120	110	290	260	240	200	180	170
N1	1450	1290	1190															
N2																		
S1							40	30		40	40							
S2							30	30		40	40							
S3							40	40		50	50							
S4							50	50		60	50							
H1																		

FIRST choice starting speeds are in bold type.

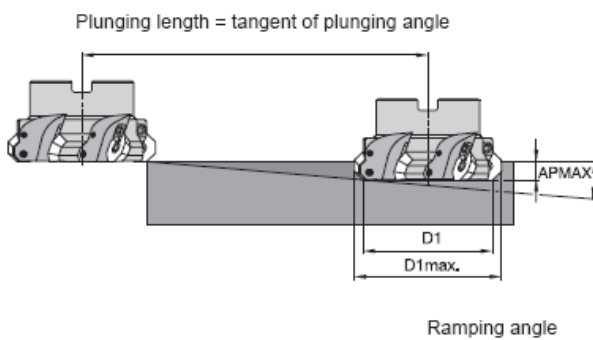
As the average chip thickness value goes higher the speed should be decreased.

Recommended Starting Feeds

43° Approach Angle Feed-Per-Tooth Compensation
(Radial Width-of-Cut Dependent)



Ramping



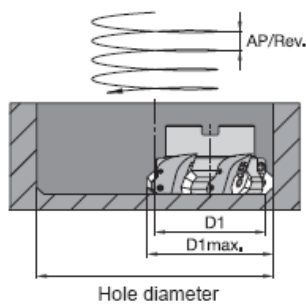
Metric version

D1 mm	D1 max. mm	max. ap mm	Ramping Angle (°)	Ramping Length mm
32	41,1	9	11,0	46,3
40	49,0	9	7,5	68,4
50	58,9	9	5,0	102,9
63	71,8	9	3,9	132,0
80	88,7	9	2,9	177,7
100	108,6	9	2,2	234,3
125	133,6	9	1,7	303,2
160	168,5	9	1,3	396,6

Inch version

D1 inch	D1 max. inch	max. ap inch	Ramping Angle (°)	Ramping Length inch
1.25	1.61	.354	11,0	1.82
1.50	1.85	.354	8,0	2.52
2.00	2.35	.354	5,2	3.89
2.50	2.85	.354	3,8	5.34
3.00	3.34	.354	3,0	6.76
4.00	4.34	.354	2,1	9.66
5.00	5.34	.354	1,6	12.69
6.00	6.34	.354	1,3	15.61

Helical Interpolation



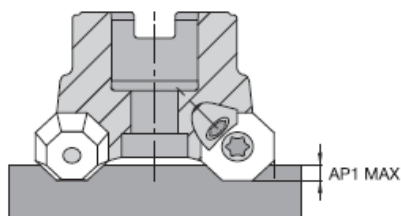
Metric version

D1 mm	D1 max. mm	Hole Diameter		AP/Rev. mm
		min. mm	max. mm	
32	41,1	61,7	81,7	4,7
40	49,0	77,5	97,6	4,7
50	58,9	97,4	117,4	4,7
63	71,8	123,3	143,3	4,7
80	88,7	157,2	177,2	4,7
100	108,6	197,2	217,1	4,7
125	133,6	247,1	267,0	4,7
160	168,5	317,1	377,0	4,7

Inch version

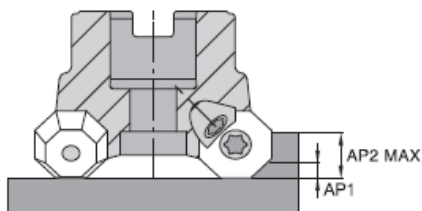
D1 inch	D1 max. inch	Hole Diameter		AP/Rev. inch
		min. inch	max. inch	
1.25	1.61	2.41	3.20	.185
1.50	1.85	2.91	3.69	.185
2.00	2.35	3.90	4.68	.185
2.50	2.85	4.93	5.68	.185
3.00	3.34	5.89	6.68	.185
4.00	4.34	7.89	8.67	.185
5.00	5.34	9.89	10.67	.185
6.00	6.34	11.89	12.67	.185

Plunging



Max. Plunging Depth	mm	inch
AP1 MAX	3,2	.13

Face Milling



Max. DOC AP	mm	inch	Chipload (fz)
AP1 MAX	3,5	.14	1 x fz
AP2 MAX	9,0	.35	0,6 x fz