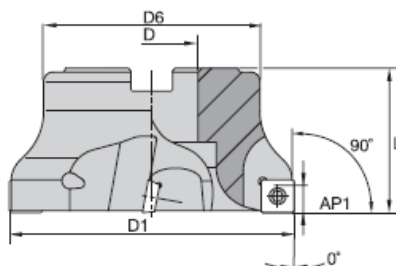


End Mills — Weldon Shank

D1	order number	catalog number	Z	D	L2	L	Ap1 max	kg	Max RPM
25	1981679	25A02R039B25SSP10G	2	25	39	96	6,6	0,3	37100
32	1981788	32A03R039B32SSP10G	3	32	39	100	6,6	0,5	33200
40	1981790	40A04R049B32SSP10G	4	32	49	110	6,6	0,7	30300

Spare Parts

D1	insert screw	Torx plus driver	torque (Nm)
25	MS2148	DT9IP	1,5
32	MS2148	DT9IP	1,5
40	MS2148	DT9IP	1,5



Shell Mills — Fine Pitch

D1	order number	catalog number	Z	D	D6	L	Ap1 max	kg	Max RPM
50	1981677	50A05RS90SP10DG	5	22	47	40	6,6	0,4	26300
63	1981678	63A06RS90SP10DG	6	22	50	40	6,6	0,5	23500
80	1981853	80A08RS90SP10DG	8	27	60	50	6,6	1,1	21450
100	1981854	100B10RS90SP10DG	10	32	80	50	6,6	1,7	18600

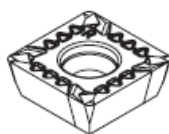
Spare Parts

D1	insert screw	Torx plus driver	torque (Nm)	mounting screw
50	MS2148	DT9IP	1,5	MS1234
63	MS2148	DT9IP	1,5	MS1234
80	MS2148	DT9IP	1,5	MS1556
100	MS2148	DT9IP	1,5	—

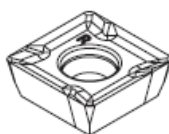
Indexable Inserts for KSSM SP.T10T3...



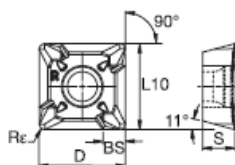
SPCT-LD2



SPET-GB2



SPCT-LE



H						
S						
N						
K						
M						
P						

● first choice
○ alternate choice

■ SPCT-LD2

catalog number	cutting edges	D	S	L10	BS	Re	hm	KC410M	KC520M	KC725M	KC915M	KC935M	KT530M
SPCT10T304PPELLD2	4	10,00	3,97	10,00	2,70	0,4	0,08			●			
SPCT10T304PPERLD2	4	10,00	3,97	10,00	2,70	0,4	0,08			●			
SPCT10T3PPELLD2	4	10,00	3,97	10,00	2,70	0,8	0,08			●			
SPCT10T3PPERLD2	4	10,00	3,97	10,00	2,70	0,8	0,08		●	●			
SPCT10T312PPELLD2	4	10,00	3,97	10,00	2,70	1,2	0,08			●			
SPCT10T312PPERLD2	4	10,00	3,97	10,00	2,70	1,2	0,08			●			
SPCT10T316ENLD2	4	10,00	3,97	10,00	—	1,6	0,08			●			
SPCT10T320ENLD2	4	10,00	3,97	10,00	—	2,0	0,08			●			

■ SPCT-LE

catalog number	cutting edges	D	S	L10	BS	Re	hm	KC410M	KC520M	KC725M	KC915M	KC935M	KT530M
SPCT10T304PPFLLE	4	10,00	3,97	10,00	2,70	0,4	0,05	●					
SPCT10T304PPFRLLE	4	10,00	3,97	10,00	2,70	0,4	0,05	●					
SPCT10T3PPFRLLE	4	10,00	3,97	10,00	2,70	0,8	0,05	●					
SPCT10T3PPFLLE	4	10,00	3,97	10,00	2,70	0,8	0,05	●					
SPCT10T312PPFRLLE	4	10,00	3,97	10,00	2,70	1,2	0,05	●					
SPCT10T312PPFLLE	4	10,00	3,97	10,00	2,70	1,2	0,05	●					
SPCT10T316FNLE	4	10,00	3,97	10,00	—	1,6	0,05	●					
SPCT10T320FNLE	4	10,00	3,97	10,00	—	2,0	0,05	●					

■ SPET-GB2

catalog number	cutting edges	D	S	L10	BS	Re	hm	KC410M	KC520M	KC725M	KC915M	KC935M	KT530M
SPET10T3PPELGB2	4	10,00	3,97	10,00	2,70	0,8	0,10	●	●	●	●	●	
SPET10T3PPERGB2	4	10,00	3,97	10,00	2,70	0,8	0,10	●	●	●	●	●	
SPET10T3PPSLGB2	4	10,00	3,97	10,00	2,70	0,8	0,15	●	●	●	●	●	
SPET10T3PPSRGB2	4	10,00	3,97	10,00	2,70	0,8	0,15	●	●	●	●	●	

■ SPPT-GB2

catalog number	cutting edges	D	S	L10	BS	Re	hm	KC410M	KC520M	KC725M	KC915M	KC935M	KT530M
SPPT10T3PPERGB2	4	10,00	3,97	10,00	2,70	0,8	0,10				●	●	
SPPT10T3PPSRGB2	4	10,00	3,97	10,00	2,70	0,8	0,15				●	●	●

Recommended Starting Speeds [m/min]

90° approach angle

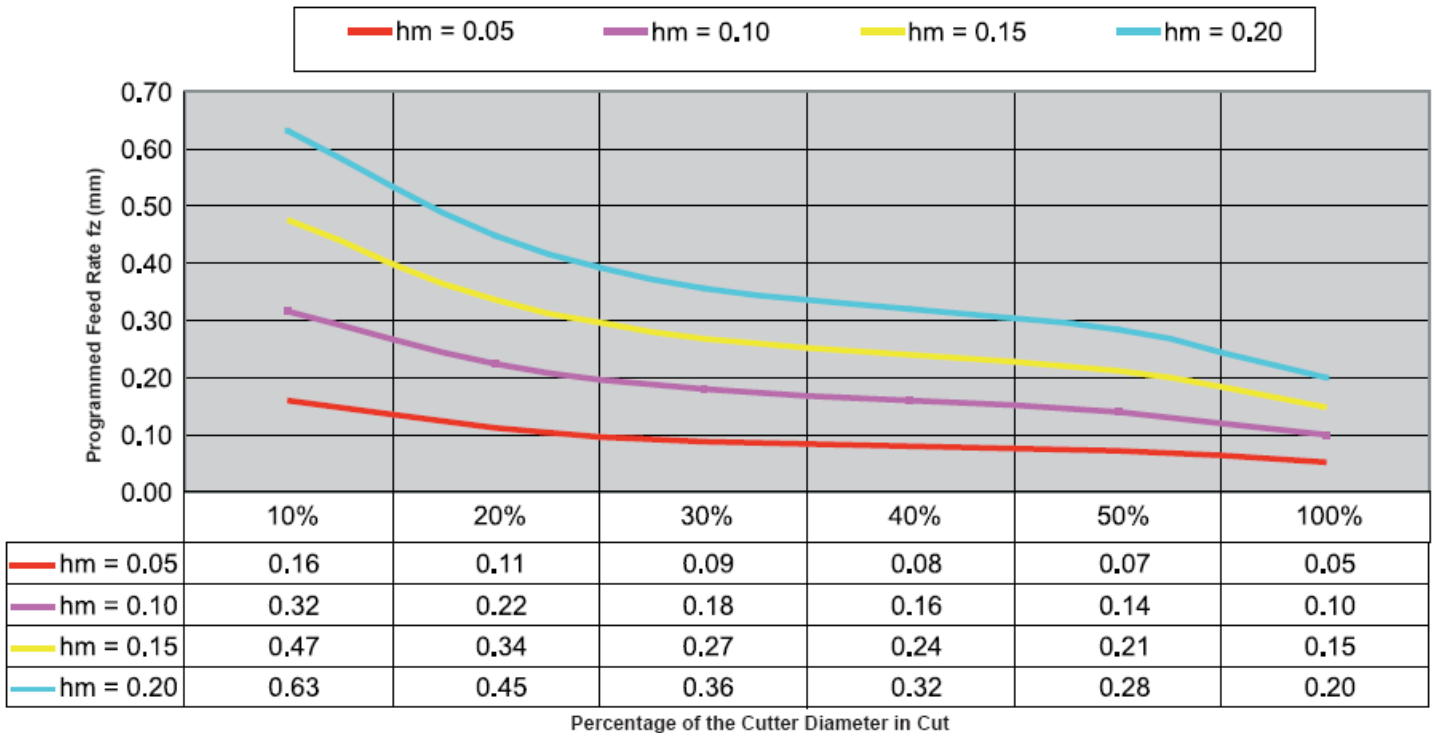
Material Group	KC410M			KC520M			KC725M			KC915M			KC935M			KT530M		
P1							260	230	210				390	340	320	290	250	230
P2							160	150	130				240	220	200	180	160	140
P3							150	130	120				220	200	180	160	140	130
P4							110	100	90				160	150	140	120	110	100
P5							125	110	100				225	200	180	165	149	130
P6							90	80					140	120		100	90	
M1							170	150	140				250	220	210	190	160	150
M2							150	140	130				230	210	190	170	150	140
M3							120	100					170	150		130	110	
K1				270	240	220	160	150	130	360	330	290	250	230	210			
K2				210	190	180	130	120	110	290	260	240	200	180	170			
K3				180	160	140	110	100	90	240	220	200	170	150	140			
N1	1210	1080	990															
N2																		
S1							40	30										
S2							30	30										
S3							40	40										
S4							50	50										
H1																		

FIRST choice starting speeds are in bold type.

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

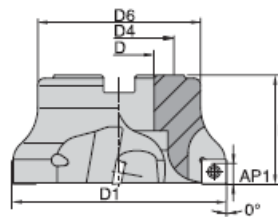
Recommended Starting Feeds

90° Approach Angle Feed-Per-Tooth Compensation
(Radial Width-of-Cut Dependent)



Indexable Shell Mills

- Thicker inserts for heavy-duty applications.
- Excellent for square shoulder milling in wide range of applications.
- Various insert nose radii available for workpiece requirements.



Shell Mills — Coarse Pitch

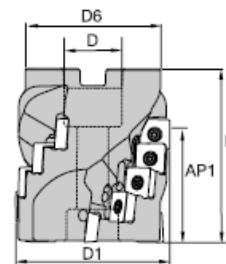
D1	order number	catalog number	Z	D	D4	D6	L	Ap1 max	kgs	Max RPM
50	1926939	50A03RS90SD12DG	3	22	—	45	40	9,2	0,3	20600
63	1926936	63A04RS90SD12DG	4	22	—	50	40	9,2	0,5	18300
80	1926901	80A05RS90SD12DG	5	27	—	60	50	9,2	1,0	16300
100	1926841	100B06RS90SD12DG	6	32	—	80	50	9,2	1,6	14600
125	1926839	125B07RS90SD12DG	7	40	—	90	63	9,2	2,8	13000
160	1926836	160C08RS90SD12DG	8	40	67	100	63	9,2	4,3	11500

Shell Mills — Fine Pitch

D1	order number	catalog number	Z	D	D4	D6	L	Ap1 max	kgs	Max RPM
50	1926938	50A04RS90SD12DG	4	22	—	46	40	9,2	0,3	20600
63	1926933	63A05RS90SD12DG	5	22	—	50	40	9,2	0,5	18300
80	1926898	80A06RS90SD12DG	6	27	—	60	50	9,2	1,0	16300
100	1926840	100B08RS90SD12DG	8	32	—	80	50	9,2	1,7	14600
125	1926837	125B10RS90SD12DG	10	40	—	90	63	9,2	2,9	13000
160	1926983	160C12RS90SD12DG	12	40	67	100	63	9,2	4,4	11500
200	1926941	200C14RS90SD12DG	14	60	102	130	63	9,2	6,8	10300

Spare Parts

D1	insert screw	Torx plus driver	torque (Nm)	shim	shim screw	hex driver	mounting screw
50	MS2078	DT15IP	4	—	—	—	MS1234
63	MS2078	DT15IP	4	—	—	—	129.025
80	MS2078	DT15IP	4	SM449	SRS3	DH35M	MS2038
100	MS2078	DT15IP	4	SM449	SRS3	DH35M	—
125	MS2078	DT15IP	4	SM449	SRS3	DH35M	—
160	MS2078	DT15IP	4	SM449	SRS3	DH35M	—
200	MS2078	DT15IP	4	SM449	SRS3	DH35M	—

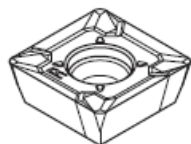


■ Shell Mills — Standard Pitch

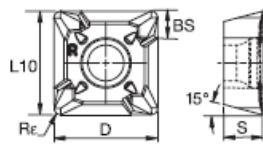
D1	order number	catalog number	Z	Z U	D	D6	L	Ap1 max	kg	Max RPM
50	2400693	50A3RS90SD12L32	9	3	22	44	55	32,4	0,4	16400
63	2400694	63A3RS90SD12L50	15	3	27	55	70	51,2	0,9	14600
80	2400695	80A4RS90SD12L61	24	4	32	70	80	61,6	1,8	12950

■ Spare Parts

D1	insert screw	Torx wrench	torque (Nm)	coolant screw
50	MS1273	TT15	4	MS1235CG
63	MS1273	TT15	4	MS1238CG
80	MS1273	TT15	4	MS1241CG



SDCT-PDE-LD2

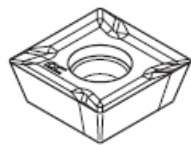


LD2 (Ground) 15° Rake Face

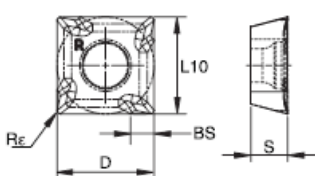
● first choice
○ alternate choice

H				
S				
N				
K				
M				
P				

catalog number	cutting edges	D	S	L10	BS	Re	hm	KC520M	KC522M	KC725M
SDCT120404PDERLD2	4	12,70	4,76	12,70	2,93	0,4	0,08			
SDCT1204PDERLD2	4	12,70	4,76	12,70	3,32	0,8	0,08			
SDCT120412PDERLD2	4	12,70	4,76	12,70	3,05	1,2	0,08			
SDCT120416ENLD2	4	12,70	4,76	12,70	—	1,6	0,08			
SDCT120420ENLD2	4	12,70	4,76	12,70	—	2,0	0,08			
SDCT120424ENLD2	4	12,70	4,76	12,70	—	2,4	0,08			
SDCT120432ENLD2	4	12,70	4,76	12,70	—	3,2	0,08			



SDCT-PDF-LE

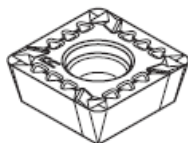


LE (Ground) 20° Rake Face

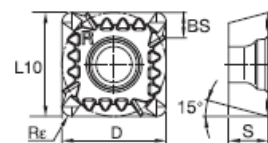
● first choice
○ alternate choice

H				
S				
N				
K				
M				
P				

catalog number	cutting edges	D	S	L10	BS	Re	hm	KC410M
SDCT120404PDFRLE	4	12,70	4,76	12,70	2,93	0,4	0,05	
SDCT1204PDFRLE	4	12,70	4,76	12,70	3,32	0,8	0,05	
SDCT120412PDFRLE	4	12,70	4,76	12,70	3,05	1,2	0,05	
SDCT120416FNLE	4	12,70	4,76	12,70	—	1,6	0,05	
SDCT120420FNLE	4	12,70	4,76	12,70	—	2,0	0,05	
SDCT120424FNLE	4	12,70	4,76	12,70	—	2,4	0,05	
SDCT120432FNLE	4	12,70	4,76	12,70	—	3,2	0,05	



SDET-PD-GB2

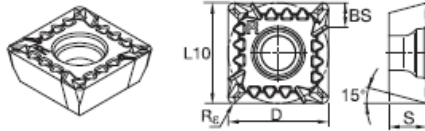


GB2 (Ground) 5° Rake Face

● first choice
○ alternate choice

H				
S				
N				
K				
M				
P				

catalog number	cutting edges	D	S	L10	BS	Re	hm	KC520M	KC725M	KC915M	KC935M
SDET1204PDERGB2	4	12,70	4,76	12,70	3,32	0,8	0,10				
SDET1204PDSRGB2	4	12,70	4,76	12,70	3,32	0,8	0,15				
SDET120412PDERGB2	4	12,70	4,76	12,70	3,05	1,2	0,10				
SDET120416SNGB2	4	12,70	4,76	12,70	—	1,6	0,15				
SDET120420SNGB2	4	12,70	4,76	12,70	—	2,0	0,15				
SDET120424SNGB2	4	12,70	4,76	12,70	—	2,4	0,15				
SDET120432SNGB2	4	12,70	4,76	12,70	—	3,2	0,15				



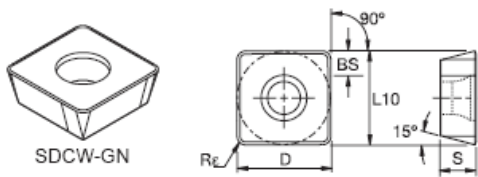
SDPT-PD-GB2

■ GB2 (Precision Sintered) 5° Rake Face

● first choice
○ alternate choice

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

catalog number	cutting edges	D	S	L10	BS	Re	hm	KC725M	KC915M	KC985M
SDPT1204PDERGB2	4	12,70	4,76	12,70	3,32	0,8	0,10	●	●	●
SDPT1204PDSRGB2	4	12,70	4,76	12,70	3,32	0,8	0,15	●	●	●



SDCW-GN

■ GN (Ground) Flat Top

● first choice
○ alternate choice

H				
S				
N				
K		●		
M				
P				

catalog number	cutting edges	D	S	L10	BS	Re	hm	KY3500
SDCW1204PDSRGN	4	12,70	4,76	12,70	3,32	0,8	0,08	●
SDCW120412PDSRGN	4	12,70	4,76	12,70	3,05	1,2	0,08	●

Recommended Starting Speeds [m/min]

90° approach angle

Material Group	KC410M			KC520M			KC522M			KC725M			KC915M			KC935M			KY3500		
P1										260	230	210				390	340	320			
P2										160	150	130				240	220	200			
P3										150	130	120				220	200	180			
P4							100	90	80	110	100	90				160	150	140			
P5							130	125	105	125	110	100				225	200	180			
P6							80	70		90	80					140	120				
M1							150	130	120	170	150	140				250	220	210			
M2							140	120	120	150	140	130				230	210	190			
M3							100	90		120	100					170	150				
K1				270	240	220				160	150	130	360	330	290	250	230	210	800	730	650
K2				210	190	180	200	180	170	130	120	110	290	260	240	200	180	170	630	570	530
K3				180	160	140	170	150	140	110	100	90	240	220	200	170	150	140	530	470	430
N1	1210	1080	990																		
N2																					
S1							30	30		40	30										
S2							30	30		30	30										
S3							40	40		40	40										
S4							50	40		50	50										
H1																					

FIRST choice starting speeds are in bold type.

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

Recommended Starting Feeds

90° Approach Angle Feed-Per-Tooth Compensation
(Radial Width-of-Cut Dependent)