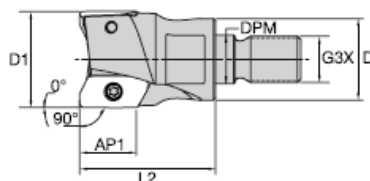


NEW!

- 14 mm depth-of-cut capability.
- Aggressive ramping rates.
- Generates superior surface finish.
- Mill true 90° walls.
- High rpm capabilities.



End Mills - Screw-On

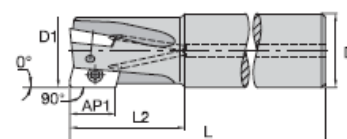
D1	order number	catalog number	Z	G3X	D	L2	DPM	Ap1 max	Max Ramp Angle	kg	Max RPM
20	2968370	20A02R035M10SED14	2	M10	18	35	10,5	14,7	16.8°	0,1	47500
25	2968371	25A02R035M12SED14	2	M12	21	35	12,5	14,6	10.7°	0,1	39700
32	2968372	32A03R040M16SED14	3	M16	29	40	17,0	14,6	7.0°	0,2	33300
40	2968373	40A04R040M16SED14	4	M16	29	40	17,0	14,4	5.1°	0,2	28700

Spare Parts

D1	insert screw	torque (Nm)	Torx plus driver
20	MS2167	2,3	DT9IP
25	MS2166	2,3	DT9IP
32	MS2166	2,3	DT9IP
40	MS2166	2,3	DT9IP

NEW!

- 14 mm depth-of-cut capability.
- Aggressive ramping rates.
- Generates superior surface finish.
- Mill true 90° walls.
- High rpm capabilities.



End Mills — Cylindrical Shank — Long Length

D1	order number	catalog number	Z	D	L2	L	Ap1 max	Max Ramp Angle	kg	Max RPM
20	2968363	20A02R050A20SED14-170	2	20	50	170	14,7	16.8°	0,3	47500
25	2968367	25A02R050A25SED14-170	2	25	50	170	14,6	10.7°	0,6	39700
25	2968364	25A03R050A25SED14-170	3	25	50	170	14,6	10.7°	0,6	39700
32	2968368	32A03R050A32SED14-200	3	32	50	200	14,6	7.0°	1,1	33300
32	2968365	32A04R050A32SED14-200	4	32	50	200	14,6	7.0°	1,1	33300
40	2968369	40A04R050A32SED14-200	4	32	50	200	14,4	5.1°	1,2	28700
40	2968366	40A05R050A32SED14-200	5	32	50	200	14,4	5.1°	1,3	28700

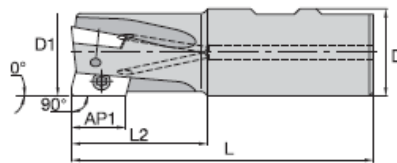
Spare Parts

D1	insert screw	torque (Nm)	Torx plus driver
20	MS2167	2,3	DT9IP
25	MS2166	2,3	DT9IP
32	MS2166	2,3	DT9IP
40	MS2166	2,3	DT9IP

Indexable End Mills – Mill 1-14



- 14 mm depth-of-cut capability.
- Aggressive ramping rates.
- Generates superior surface finish.
- Mill true 90° walls.
- High rpm capabilities.



■ End Mills – Weldon Shank

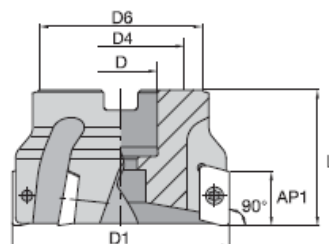
D1	order number	catalog number	Z	D	L2	L	Ap1 max	Max Ramp Angle	kgs	Max RPM
20	2622232	20A02R039B20SED14	2	20	39	90	14,7	16.8°	0,2	47500
25	2623937	25A02R044B25SED14	2	25	44	100	14,6	10.7°	0,3	39700
25	2478640	25A03R044B25SED14	3	25	44	101	14,6	10.7°	0,3	39700
32	2623938	32A03R050B32SED14	3	32	50	110	14,5	7.0°	0,6	33300
32	2478642	32A04R050B32SED14	4	32	50	110	14,5	7.0°	0,6	33300
40	2623939	40A04R050B32SED14	4	32	50	110	14,4	5.1°	0,7	28700
40	2623933	40A05R050B32SED14	5	32	50	110	14,4	5.1°	0,7	28700

■ Spare Parts

D1	insert screw	torque (Nm)	Torx plus driver
20	MS2167	2,3	DT9IP
25	MS2166	2,3	DT9IP
32	MS2166	2,3	DT9IP
40	MS2166	2,3	DT9IP



- 14 mm depth-of-cut capability.
- Aggressive ramping rates.
- Generates superior surface finish.
- Mill true 90° walls.
- High rpm capabilities.



■ Shell Mills — Coarse Pitch

D1	order number	catalog number	Z	D	D4	D6	L	Ap1 max	Max Ramp Angle	kgs	Max RPM
40	2623940	40A04RS90ED14D	4	16	—	37	40	14,4	5.1°	0,2	28700
50	2623941	50A05RS90ED14D	5	22	—	45	40	14,3	3.8°	0,3	25000
63	2623942	63A06RS90ED14D	6	22	—	50	40	14,3	2.8°	0,5	21800
80	2623963	80A07RS90ED14D	7	27	—	60	50	14,2	2.1°	1,0	19000
100	2623964	100A08RS90ED14D	8	32	—	80	50	14,2	1.7°	1,8	16800
125	2510390	125B09RS90ED14D	9	40	—	90	63	14,2	1.3°	2,9	14900
160	2623965	160C11RS90ED14D	11	40	66,70	100	63	14,2	1.0°	4,0	13100

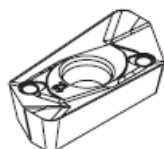
■ Shell Mills — Fine Pitch

D1	order number	catalog number	Z	D	D4	D6	L	Ap1 max	Max Ramp Angle	kgs	Max RPM
40	2623934	40A05RS90ED14D	5	16	—	37	40	14,4	5.1°	0,20	28700
50	2478686	50A06RS90ED14D	6	22	—	45	40	14,3	3.8°	0,29	25000
63	2478689	63A07RS90ED14D	7	22	—	50	40	14,3	2.8°	0,53	21800
80	2478690	80A09RS90ED14D	9	27	—	60	50	14,2	2.1°	1,08	19000
100	2623935	100A10RS90ED14D	10	32	—	80	50	14,2	1.7°	1,86	16800
125	2623936	125B12RS90ED14D	12	40	—	90	63	14,2	1.3°	3,01	14900
160	2510391	160C15RS90ED14D	15	40	67	100	63	14,2	1.0°	4,20	13100

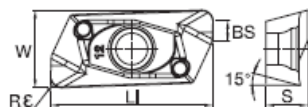
■ Spare Parts

D1	insert screw	Torx plus driver	torque (Nm)	mounting screw	coolant screw	coolant cap
40	MS2166	DT9IP	2,3	MS1294	MS1294CG	—
50	MS2166	DT9IP	2,3	—	MS2072CG	—
63	MS2166	DT9IP	2,3	—	MS2072CG	—
80	MS2166	DT9IP	2,3	—	MS2038CG	—
100	MS2166	DT9IP	2,3	—	MS1254CG	—
125	MS2166	DT9IP	2,3	—	420.200	470.232
160	MS2166	DT9IP	2,3	—	420.200	470.233

Indexable Inserts for Mill 1-14 ED.T1404



EDCT14-LD



NEW!

● first choice
○ alternate choice

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

catalog number	cutting edges	LI	W	S	BS	Rε	hm	KC410M	KC520M	KC522M	KC725M	KC915M	KC935M
EDCT140404PDERGD	2	17,46	8,49	4,50	2,95	0,4	0,08				●		
EDCT140404PDERLD	2	17,46	8,49	4,50	2,95	0,4	0,06			●			
EDCT140404PDFRLDJ	2	17,46	8,49	4,50	2,95	0,4	0,05	●					
EDCT140408PDERGD	2	17,47	8,48	4,50	2,56	0,8	0,08				●		
EDCT140408PDERLD	2	17,47	8,48	4,50	2,56	0,8	0,06			●			
EDCT140408PDFRLDJ	2	17,47	8,48	4,50	2,56	0,8	0,05	●					
EDCT140412PDERGD	2	17,48	8,46	4,50	2,17	1,2	0,08				●		
EDCT140412PDERLD	2	17,48	8,46	4,50	2,17	1,2	0,06			●			
EDCT140412PDFRLDJ	2	17,47	8,46	4,50	2,17	1,2	0,05	●					
EDCT140416PDERGD	2	17,49	8,45	4,50	1,77	1,6	0,08				●		
EDCT140416PDERLD	2	17,49	8,45	4,50	1,77	1,6	0,06			●			
EDCT140416PDFRLDJ	2	17,49	8,45	4,50	1,77	1,6	0,05	●					
EDCT140431PDERGD	2	17,50	8,40	4,50	0,26	3,1	0,08				●		
EDCT140431PDERLD	2	17,50	8,40	4,50	0,26	3,1	0,06			●			
EDCT140431PDFRLDJ	2	17,50	8,40	4,50	0,26	3,1	0,05	●					
EDPT140404PDERHD	2	17,46	8,39	4,50	2,95	0,4	0,12		●	●	●	●	●
EDPT140408PDERHD	2	17,47	8,38	4,50	2,56	0,8	0,12		●	●	●	●	●
EDPT140408PDSRGD	2	17,47	8,37	4,50	2,55	0,8	0,15		●		●		●
EDPT140412PDERHD	2	17,48	8,36	4,50	2,16	1,2	0,12		●	●	●	●	●
EDPT140412PDSRGD	2	17,48	8,35	4,50	2,17	1,2	0,15		●		●		●
EDPT140416PDERHD	2	17,49	8,36	4,50	1,77	1,6	0,12		●	●	●	●	●
EDPT140416PDSRGD	2	17,49	8,35	4,50	1,77	1,6	0,15		●		●		●
EDPT140420PDERHD	2	17,49	8,35	4,50	1,37	2,0	0,12			●	●	●	●
EDPT140424PDERHD	2	17,50	8,32	4,50	0,99	2,4	0,12				●	●	●
EDPT140431PDERHD	2	17,51	8,30	4,50	0,26	3,1	0,12				●	●	●
EDPT140440PDERHD	2	16,53	8,26	4,50	—	4,0	0,12				●	●	●

Recommended Starting Speeds [m/min]

90° approach angle

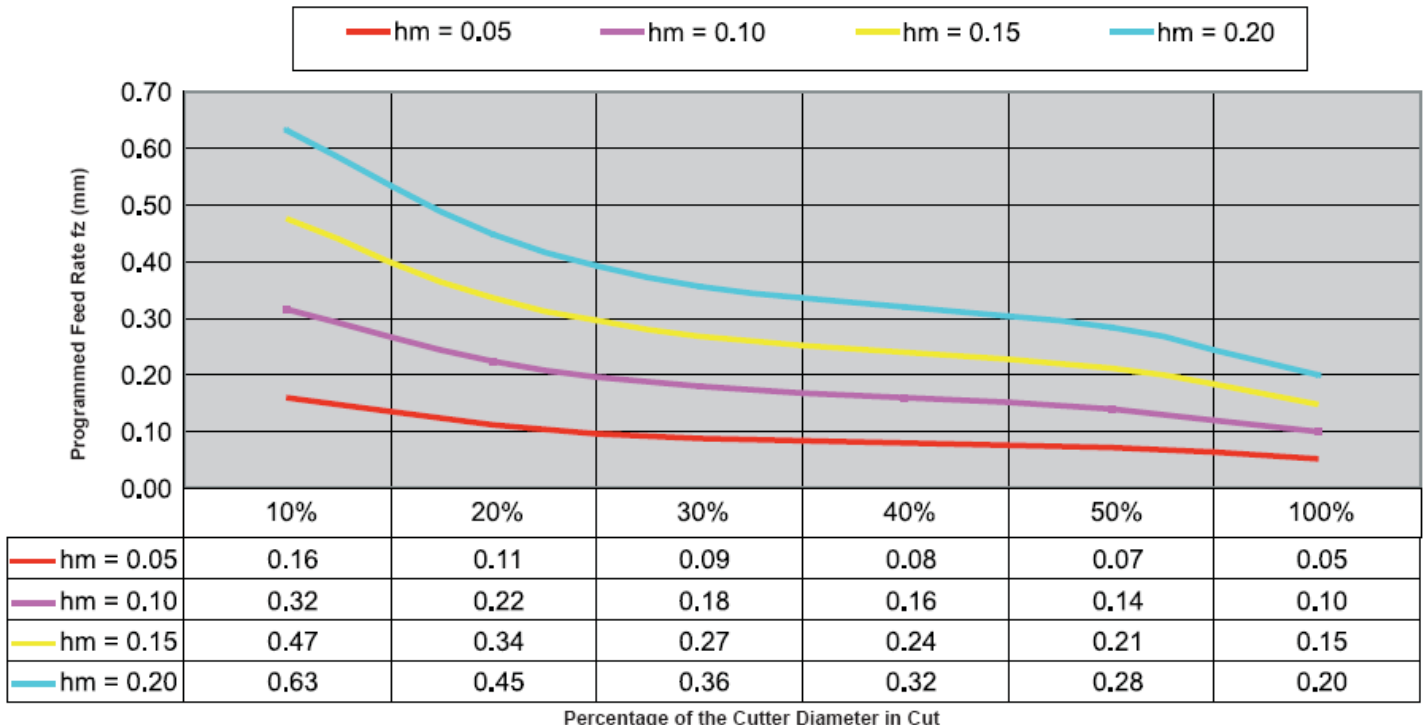
Material Group	KC410M			KC520M			KC522M			KC725M			KC915M			KC935M		
P1										260	230	210				390	340	320
P2										160	150	130				240	220	200
P3										150	130	120				220	200	180
P4							100	90	80	110	100	90				160	150	140
P5							130	125	105	125	110	100				225	200	180
P6							80	70		90	80					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
K2				210	190	180	200	180	170	130	120	110	290	260	240	200	180	170
K3				180	160	140	170	150	140	110	100	90	240	220	200	170	150	140
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																		

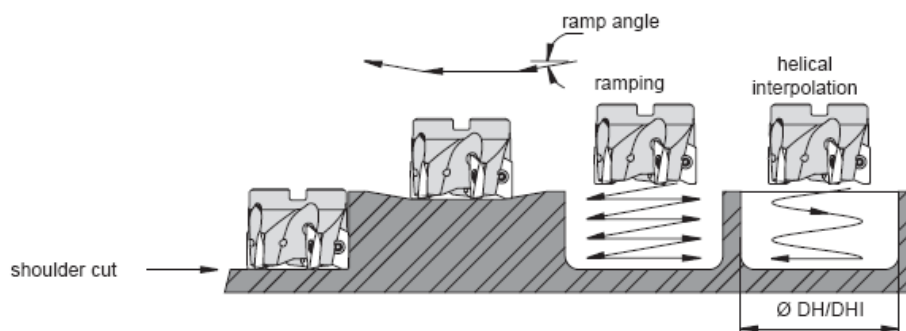
FIRST choice starting speeds are in bold type.

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)





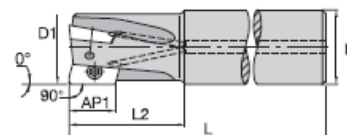
DH min. = Min. blind hole diameter with helical interpolation
DHI max. = Max. blind hole diameter with flat bottom

Insert Style	Cutting Diameter	Max. Ramp. Angle	Minimum Hole Diameter (DH min)	Maximum Flat-bottomed Hole Diameter, (DHI max)	Max Dia with <u>No</u> flat bottom
Mill 1-14	20	16°	23,74	35,62	40
Mill 1-14	25	11°	33,75	44,44	50
Mill 1-14	32	7°	47,80	59,79	64
Mill 1-14	40	5°	63,76	75,22	80
Mill 1-14	40	5°	64,00	75,47	80
Mill 1-14	50	4°	83,96	96,05	100
Mill 1-14	63	3°	109,93	121,47	126
Mill 1-14	80	2°	143,91	155,47	160
Mill 1-14	100	1°	183,89	199,47	200
Mill 1-14	125	1°	233,88	245,47	250
Mill 1-14	160	1°	303,88	315,47	320

Note: Max. ramp angle decreases as nose radius increases.

NEW!

- 18 mm depth-of-cut capability.
- Aggressive ramping rates.
- Generates superior surface finish.
- Mill true 90° walls.
- High rpm capabilities.

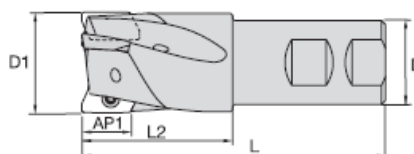


■ End Mills – Cylindrical Shank - Long Length

D1	order number	catalog number	Z	D	L2	L	Ap1 max	Max Ramp Angle	kg	Max RPM
25	2613785	25A02R050A25SED18-170	2	25	50	170	18,0	17.0°	0,5	37380
32	2613786	32A03R050A32SED18-200	3	32	50	200	18,0	10.5°	1,1	32140
32	2613788	32A02R050A32SED18-200	2	32	50	200	18,0	10.5°	1,1	32140
40	2613787	40A04R050A32SED18-200	4	32	50	200	17,8	7.5°	1,2	28220
40	2613789	40A03R050A32SED18-200	3	32	50	200	17,8	7.5°	1,2	28220

■ Spare Parts

D1	insert screw	Torx plus driver	torque (Nm)
25	MS2126	DT15IP	4,0
32	MS2126	DT15IP	4,0
40	MS2126	DT15IP	4,0

NEW!


■ End Mills – Weldon Shank

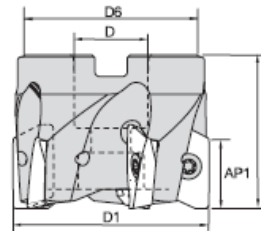
D1	order number	catalog number	Z	D	L2	L	Ap1 max	Max Ramp Angle	kg	Max RPM
25	2390446	25A02R044B25SED18	2	25	44	100	18,0	17.0°	0,3	37380
32	2390448	32A03R050B32SED18	3	32	50	110	18,0	10.5°	0,5	32140
40	2417191	40A03R050B32SED18	3	32	50	110	17,8	7.5°	0,7	28220
40	2390450	40A04R050B32SED18	4	32	50	110	17,8	7.5°	0,6	28220

■ Spare Parts

D1	insert screw	Torx plus wrench	torque (Nm)
25	MS2126	DT15IP	4,0
32	MS2126	DT15IP	4,0
40	MS2126	DT15IP	4,0

Indexable Shell Mills – Mill 1-18

- 18 mm depth-of-cut capability.
- Aggressive ramping rates.
- Generates superior surface finish.
- Mill true 90° walls.
- High rpm capabilities.



Shell Mills – Coarse Pitch

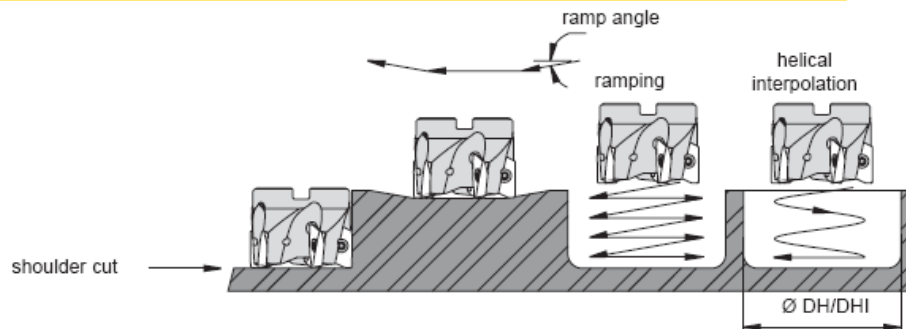
D1	order number	catalog number	Z	D	L	D6	Ap1 max	Max Ramp Angle	kgs	Max RPM
50	2417185	50A04RS90ED18D	4	22	40	45	17,7	5.0°	0,28	24890
63	2417186	63A05RS90ED18D	5	22	40	50	17,6	4.0°	0,51	21910
80	2417187	80A06RS90ED18D	6	27	50	60	17,5	3.0°	1,03	19270
100	2417188	100A07RS90ED18D	7	32	50	80	17,5	2.0°	1,77	17120
125	2417189	125B08RS90ED18D	8	40	63	90	17,5	1.5°	3,08	15230
160	2417190	160C10RS90ED18D	10	40	63	100	17,5	1.2°	4,15	13400

Shell Mills – Fine Pitch

D1	order number	catalog number	Z	D	L	D6	Ap1 max	Max Ramp Angle	kgs	Max RPM
50	2417183	50A05RS90ED18D	5	22	40	45	17,7	5.0°	0,3	24890
63	2390483	63A06RS90ED18D	6	22	40	50	17,6	4.0°	0,5	21910
80	2417184	80A07RS90ED18D	7	27	50	60	17,5	3.0°	1,1	19270
100	2390485	100A08RS90ED18D	8	32	50	80	18,0	2.0°	1,8	17120
125	2390486	125B09RS90ED18D	9	40	63	90	17,5	1.5°	3,2	15230
160	2390487	160C12RS90ED18D	12	40	63	100	17,5	1.2°	4,4	13400

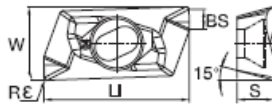
Spare Parts

D1	insert screw	Torx plus wrench	torque (Nm)	mounting screw	coolant screw	coolant cap
50	MS2126	DT15IP	4,0	129.025	MS2072CG	—
63	MS2126	DT15IP	4,0	129.025	MS2072CG	—
80	MS2126	DT15IP	4,0	MS2038	MS2038CG	—
100	MS2126	DT15IP	4,0	MS1254	MS1254CG	—
125	MS2126	DT15IP	4,0	—	420.200	470.232
160	MS2126	DT15IP	4,0	—	420.200	470.233



DH min. = Min. blind hole diameter with helical interpolation
DHI max. = Max. blind hole diameter with flat bottom

Insert Style	Cutting Diameter	Max. Ramp Angle	Minimum Hole Diameter (DH min)	Maximum Flat-bottomed Hole Diameter, (DHI max)	Max Dia with No flat bottom
Mill 1-18	25	17°	29,24	45,84	50
Mill 1-18	32	10°	42,98	59,84	64
Mill 1-18	40	7°	58,92	75,84	80
Mill 1-18	50	5°	78,88	95,84	100
Mill 1-18	63	4°	104,86	121,84	126
Mill 1-18	80	3°	139,02	156,50	160
Mill 1-18	100	2°	179,00	196,50	200
Mill 1-18	125	1°	228,98	246,50	250
Mill 1-18	160	1°	298,98	316,50	320



- first choice
- alternate choice

H									
S									
N									
K									
M									
P									

catalog number	cutting edges	LI	W	S	BS	Re	hm	KC410M	KC520M	KC522M	KC525M	KC715M	KC725M	KC915M	KC935M
EDCT180504PDERGD	2	21,75	10,98	5,50	3,07	0,4	0,10						●		
EDCT180504PDFRLDJ	2	21,75	10,98	5,50	3,07	0,4	0,05	●							
EDCT180508PDERGD	2	21,76	10,97	5,50	2,69	0,8	0,10						●		
EDCT180508PDERLD	2	21,76	10,97	5,50	2,69	0,8	0,08			●					
EDCT180508PDFRLDJ	2	21,76	10,97	5,50	2,69	0,8	0,05	●							
EDCT180512PDERGD	2	21,77	10,97	5,50	2,29	1,2	0,10						●		
EDCT180512PDFRLDJ	2	21,77	10,97	5,50	2,29	1,2	0,05	●							
EDCT180516PDERLD	2	21,78	10,96	5,50	1,90	1,6	0,08			●					
EDCT180516PDFRLDJ	2	21,78	10,96	5,50	1,90	1,6	0,05	●							
EDCT180520PDFRLDJ	2	21,79	10,95	5,50	1,49	2,0	0,05	●							
EDCT180524PDFRLDJ	2	21,79	10,93	5,50	1,11	2,4	0,05	●							
EDCT180532PDERLD	2	21,79	10,91	5,50	0,32	3,2	0,08			●					
EDCT180532PDFRLDJ	2	21,79	10,91	5,50	0,32	3,2	0,05	●							
EDCT180540PDERLD	2	20,78	10,87	5,50	—	4,0	0,08			●					
EDCT180540PDFRLDJ	2	20,78	10,87	5,50	—	4,0	0,05	●							
EDCT180548PDERLD	2	20,20	10,83	5,50	—	4,8	0,08			●					
EDCT180548PDFRLDJ	2	20,20	10,83	5,50	—	4,8	0,05	●							
EDCT180564PDERLD	2	18,72	10,73	5,50	—	6,4	0,08			●					
EDCT180564PDFRLDJ	2	18,72	10,73	5,50	—	6,4	0,05	●							
EDPT180508PDERGD	2	21,76	10,97	5,50	2,69	0,8	0,10		●		●	●	●		●
EDPT180508PDERHD	2	21,77	10,89	5,50	2,69	0,8	0,12						●		●
EDPT180508PDSRGD	2	21,76	10,90	5,50	2,69	0,8	0,18						●	●	●
EDPT180512PDERGD	2	21,77	11,00	5,50	2,29	1,2	0,10						●		
EDPT180512PDERHD	2	21,77	10,88	5,50	2,29	1,2	0,12						●		●
EDPT180512PDSRGD	2	21,77	10,89	5,50	2,29	1,2	0,18						●	●	●
EDPT180516PDERGD	2	21,78	10,94	5,50	1,90	1,6	0,10		●	●	●		●		●
EDPT180516PDERHD	2	21,78	10,87	5,50	1,90	1,6	0,12						●		●
EDPT180516PDSRGD	2	21,78	10,88	5,50	1,90	1,6	0,18						●	●	●
EDPT180524PDERGD	2	21,79	10,93	5,50	1,11	2,4	0,10						●		
EDPT180532PDERGD	2	21,79	10,91	5,50	0,32	3,2	0,10		●	●	●		●		●
EDPT180532PDERHD	2	21,79	10,83	5,50	0,31	3,2	0,12						●		●
EDPT180532PDSRGD	2	21,79	10,83	5,50	0,32	3,2	0,18						●		●
EDPT180548PDERGD	2	20,20	10,83	5,50	—	4,8	0,10			●	●		●		
EDPT180548PDERHD	2	20,16	10,75	5,50	—	4,8	0,12						●		●
EDPT180564PDERGD	2	18,79	10,73	5,50	—	6,4	0,10			●	●		●		●

Recommended Starting Speeds [m/min]

90° approach angle

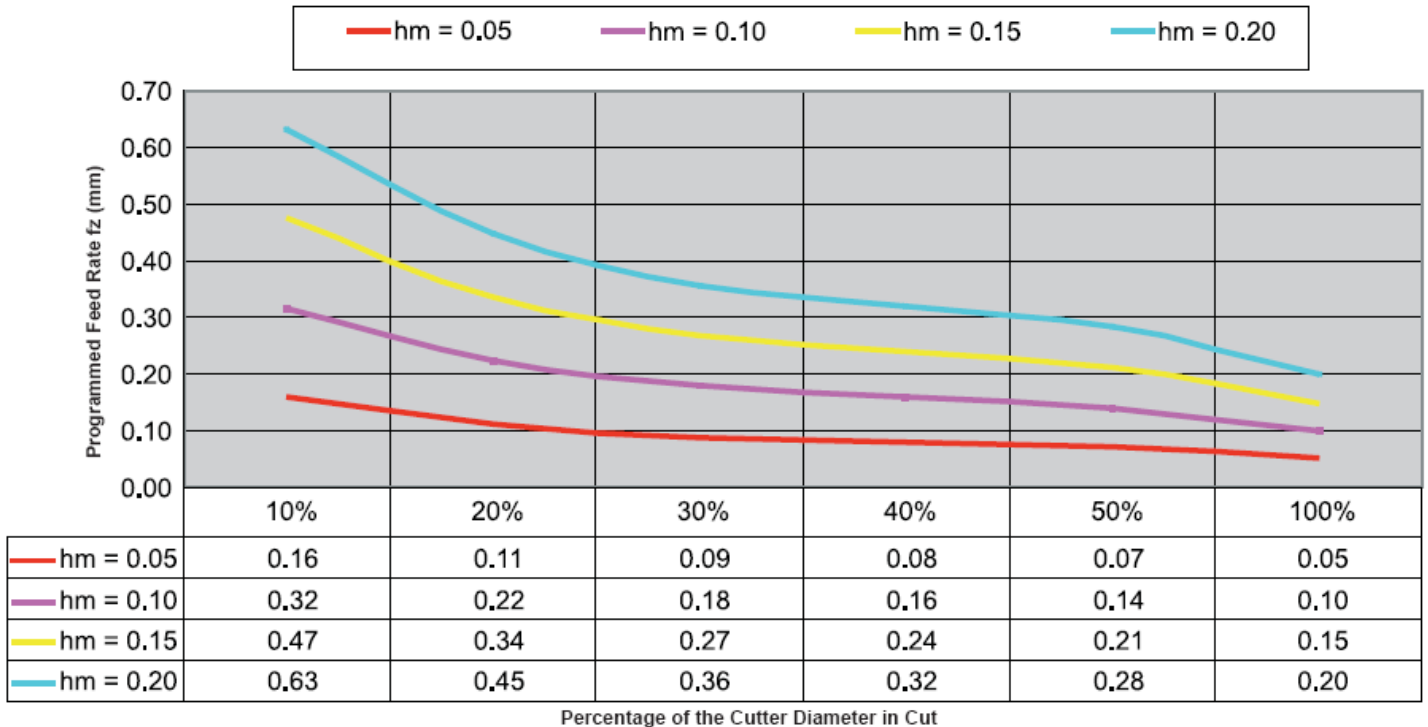
Material Group	KC410M			KC520M			KC522M			KC525M			KC715M			KC725M			KC915M			KC935M		
P1													340	300	280	260	230	210				390	340	320
P2													210	190	170	160	150	130				240	220	200
P3													190	170	150	150	130	120				220	200	180
P4							100	90	80				140	130	120	110	100	90				160	150	140
P5							130	125	105				190	175	155	125	110	100				225	200	180
P6							80	70					120	100		90	80					140	120	
M1							150	130	120	200	180	165	220	190	180	170	150	140				250	220	210
M2							140	120	120	170	155	140				150	140	130				230	210	190
M3							100	90		140	125	105				120	100					170	150	
K1				270	240	220										160	150	130	360	330	290	250	230	210
K2				210	190	180	200	180	170							130	120	110	290	260	240	200	180	170
K3				180	160	140	170	150	140							110	100	90	240	220	200	170	150	140
N1	1210	1080	990																					
N2																								
S1							30	30		65	55	45				40	30							
S2							30	30		45	35	30				30	30							
S3							40	40		40	35	30				40	40							
S4							50	40		50	45	35				50	50							
H1																								

FIRST choice starting speeds are in bold type.

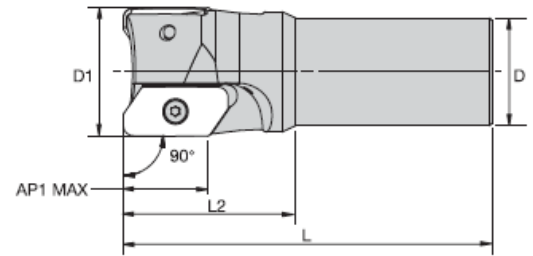
As the average chip thickness goes higher the speed should be decreased.

Recommended Starting Feeds

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



- 25 mm axial depth of cut, straight wall, true 90° cutting capability.
- High-speed capability: 40 mm cutting diameter = 24,300 max rpm.
- Rigid 5 mm thick insert, periphery ground for accuracy and consistency.
- Insert screws should be changed when inserts are changed.



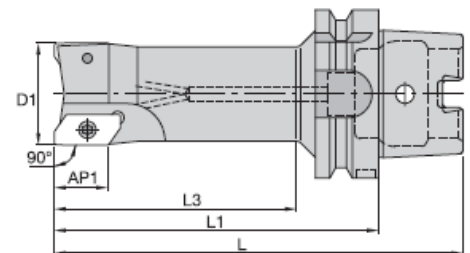
End Mills — Cylindrical Shank

D1	order number	catalog number	Z	D	L2	L	Ap1 max	Max Ramp Angle	kgs	Max RPM
40	2649569	40A02R50A32SKE25	2	32	50	111	25,0	15.0°	0,6	24300
40	2479504	40A02R80A32SKE25	2	32	80	141	25,0	15.0°	0,9	24300
50	2649570	50A02R80A32SKE25	2	32	80	141	24,9	10.0°	1,2	20600
50	2500741	50A03R80A32SKE25	3	32	80	141	24,9	10.0°	1,1	20600
50	2649571	50A02R100A32SKE25	2	32	100	161	24,9	10.0°	1,4	20600
50	2649572	50A03R100A32SKE25	3	32	100	161	24,9	10.0°	1,4	20600

Spare Parts

D1	insert screw	Torx driver	torque (Nm)
40	MS1374	DT15	3,9
50	MS1374	DT15	3,9

- 25 mm axial depth of cut, straight wall, true 90° cutting capability.
- High-speed capability: 40 mm cutting diameter = 24,300 max rpm.
- Ramping up to 15°.
- All integral shank tools are balanced to G2.5 at 10.000 rpm.
- Insert screws should be changed when inserts are changed.



Monoblocks — HSK63A

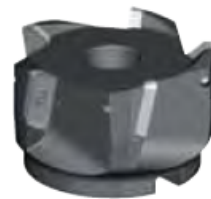
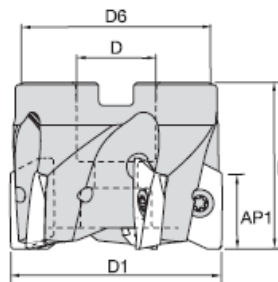
D1	order number	catalog number	Z	system size back	L3	L1	L	Ap1 max	Max Ramp Angle	kgs	Max RPM
40	2880434	40A02R110S63SKE25	2	HSK63	78	110	142	25	15.0°	1,2	24300
40	2880433	40A02R121S63SKE25	2	HSK63	89	121	153	25	15.0°	1,3	24300
40	2880435	40A02R140S63SKE25	2	HSK63	108	140	172	25	15.0°	1,2	24300
50	2880436	50A02R110S63SKE25	2	HSK63	84	110	142	25	10.0°	1,5	20600
50	2880437	50A02R140S63SKE25	2	HSK63	114	140	172	25	10.0°	1,9	20600
50	2880438	50A03R110S63SKE25	3	HSK63	84	110	142	25	10.0°	1,4	20600
50	2880439	50A03R140S63SKE25	3	HSK63	114	140	172	25	10.0°	1,8	20600

Spare Parts

D1	insert screw	Torx driver	torque (Nm)	balancing screw
40	MS1374	DT15	3,9	KUAM27
50	MS1374	DT15	3,9	KUAM27



- 25 mm axial depth of cut, straight wall, true 90° cutting capability.
- High-speed capability.
- Insert screws should be changed when inserts are changed.



■ Shell Mills

D1	order number	catalog number	Z	D	D6	L	Ap1 max	Max Ramp Angle	kgs	Max RPM
52	2878139	52A02RS90KE25	2	22	49	58	24,8	9.5°	0,5	20000
63	2954527	63A02RS90KE25	2	22	50	55	24,7	7.0°	0,7	17600
63	2954528	63A03RS90KE25	3	22	50	55	24,7	7.0°	0,6	17600
80	2496538	80A03RS90KE25	3	27	60	60	24,7	5.0°	1,2	15100
100	2954529	100B04RS90KE25	4	32	78	60	24,7	3.5°	1,8	13200

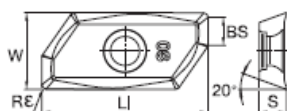
■ Spare Parts

D1	insert screw	Torx driver	torque (Nm)	coolant screw
52	MS1374	DT15	4,0	MS1235CG
63	MS1374	DT15	4,0	MS1242CG
80	MS1374	DT15	4,0	MS2038CG
100	MS1374	DT15	4,0	MS2169C

Indexable Inserts for Mill 1-25 KE..25L5..



KEGT-LDJ



NEW!

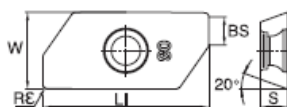
- first choice
- alternate choice

H	
S	
N	●
K	
M	
P	

catalog number	cutting edges	LI	W	S	BS	Re	hm	KC410M
KEGT25L508PEERLDJ	2	31,47	14,60	5,21	5,34	0,8	0,13	●
KEGT25L512PEERLDJ	2	31,47	14,60	5,21	4,94	1,2	0,13	●
KEGT25L516PEERLDJ	2	31,47	14,60	5,21	4,55	1,6	0,13	●
KEGT25L520PEERLDJ	2	31,47	14,60	5,21	4,15	2,0	0,13	●
KEGT25L524PEERLDJ	2	31,47	14,60	5,21	3,78	2,4	0,13	●
KEGT25L531PEERLDJ	2	31,47	14,60	5,21	3,06	3,1	0,13	●
KEGT25L540PEERLDJ	2	31,47	14,60	5,21	2,16	4,0	0,13	●
KEGT25L547PEERLDJ	2	31,47	14,60	5,21	1,40	4,8	0,13	●
KEGT25L550PEERLDJ	2	31,47	14,60	5,21	1,14	5,0	0,13	●
KEGT25L560PEERLDJ	2	31,47	14,60	5,21	0,13	6,0	0,13	●
KEGT25L564PEERLDJ	2	29,99	14,60	5,21	—	6,4	0,13	●



KEEW-LNJ



NEW!

- first choice
- alternate choice

H	
S	
N	●
K	
M	
P	

catalog number	cutting edges	LI	W	S	BS	Re	hm	K313
KEEW25L508PEFRLNJ	2	31,47	14,60	5,21	5,34	0,8	0,05	●
KEEW25L516PEFRLNJ	2	31,47	14,60	5,21	4,55	1,6	0,05	●
KEEW25L531PEFRLNJ	2	31,47	14,60	5,21	3,06	3,1	0,05	●
KEEW25L547PEFRLNJ	2	31,47	14,60	5,21	1,39	4,8	0,05	●

Recommended Starting Speeds [m/min]

90° approach angle

Material Group	K313			KC410M		
P1						
P2						
P3						
P4						
P5						
P6						
M1						
M2						
M3						
K1						
K2						
K3						
N1	800	700	600	1210	1080	990
N2	600	500	400			
S1						
S2						
S3						
S4						
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)

