

ROTATING TOOLS

SLOT MILLING



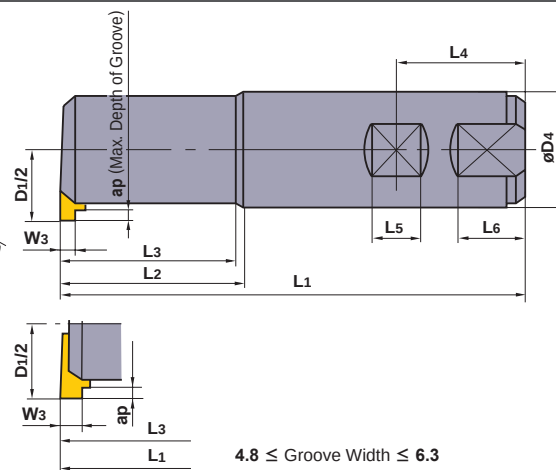
Roughing



KSMG



- Side face grooving tool for machining centres.
- The minimum cutting diameter is $\phi 25\text{mm}$ for internal grooving.
- For groove widths of 1.25mm – 6.30mm.



Right hand tool holder only.

Order Number	Stock	Number of Teeth	Dimensions (mm)								Geometry of Groove		Minimum Cutting Diameter	Insert Number
			L1	D4	L2	L3	L4	L5	L6		W3	ap		
KSMGR25S25	●	1	115	25	40	36.5	32	12	17		1.25	1.2	25	MGT L330000
											1.45	1.5		
											$1.5 \leq W3 \leq 4.0$	3.0		
KSMGR40S32	●	1	130	32	50	49	36	14	19		1.25	1.2	40	MGT L430000
											1.45	1.5		
											$1.5 \leq W3 \leq 2.3$	3.0		
											$2.5 \leq W3 \leq 4.7$	4.5		
KSMGR40S32L	●	1	180	32	100	99	36	14	19		1.25	1.2	40	MGT L430000
											1.45	1.5		
											$1.5 \leq W3 \leq 2.3$	3.0		
											$2.5 \leq W3 \leq 4.7$	4.5		
											$4.8 \leq W3 \leq 6.0$	4.5		
			181.6	32	101.6	100.6	36	14	19		$4.8 \leq W3 \leq 6.0$	4.5	40	MGT L440000

SPARE PARTS

Tool Holder Number					
	Clamp Lever	Spring	Lever Pin	Clamp Screw	Wrench
KSMGR25S25	LLCL13S	HLS2	—	LLCS105	①HKY20F
40S32	LLCL24	—	LLP14	LLCS108	②HKY30R
40S32L	LLCL24	—	LLP14	LLCS108	②HKY30R

* Clamp Torque (N • m) : LLCS105=1.5, LLCS108=3.3

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/tooth)
P Mild Steel	$\leq 180\text{HB}$	NX2525 UTi20T	130 (120–150)	0.225 (0.1–0.35)
		VP20MF	160 (120–200)	0.225 (0.1–0.35)
		NX2525 UTi20T	110 (100–120)	0.2 (0.1–0.30)
		VP20MF	120 (100–140)	0.2 (0.1–0.30)
K Cast Iron	Tensile Strength $\leq 450\text{MPa}$	UTi20T	110 (100–120)	0.175 (0.1–0.25)
		UTi20T	100 (80–125)	0.225 (0.1–0.35)

● Revolution (min^{-1}) = $(1000 \times \text{Cutting Speed}) \div (3.14 \times \phi D1)$ ● Table Feed (mm/min) = Feed per Tooth $\times$ Number of Teeth $\times$ Cutter Revolution

● : Inventory maintained. ★ : Inventory maintained in Japan.

HONING OF CUTTING EDGE

Supplementary honing when steel cutting, gives longer tool life. Use a diamond file for best results.

