

# KSNF Series

## General Use Endmill



General Engineering



Mold&Die



Automotive



Finish



Rough

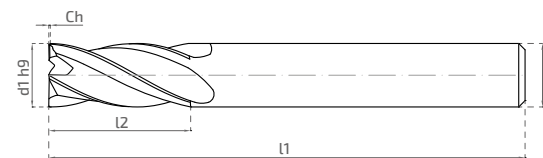
Brand-New Original Geometry, Unique Edge-Preparation, And Advanced Coating Technology,

Unrivalled To Machine Workpieces Till 55HRC Hardness In Price-Performance Ratio.

new *product*

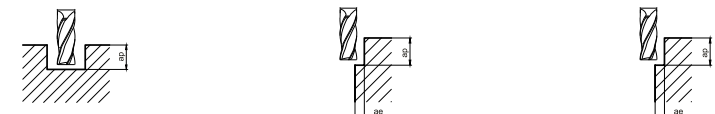
Meet The New Generation Of Eco+ Series!

Available from stock in all sizes **%100**



Stock	Code	d1h9	d2h6	l1	l2	Ch
*	KSNF401050	1	4	50	3	-
*	KSNF401550	1,5	4	50	6	-
*	KSNF402050	2	4	50	7	-
*	KSNF402550	2,5	4	50	9	-
*	KSNF403038	3	3	38	9	-
*	KSNF403050	3	4	50	9	-
*	KSNF404051	4	4	51	14	0,1
*	KSNF405051	5	5	51	15	0,1
*	KSNF406058	6	6	58	15	0,1
*	KSNF407064	7	8	64	15	0,1
*	KSNF408064	8	8	64	20	0,1
*	KSNF409073	9	10	73	21	0,1
*	KSNF410073	10	10	73	21	0,1
*	KSNF411082	11	12	82	25	0,1
*	KSNF412082	12	12	82	25	0,15
*	KSNF414082	14	14	82	30	0,15
*	KSNF416093	16	16	93	35	0,1
*	KSNF418093	18	18	93	38	0,1
*	KSNF420105	20	20	105	38	0,15

Material	Cutting Parameters		
	Slotting ap=0,5x0 Vc (m/min)	Shoulder Milling ae=0,5x0 ap=1x0 Vc (m/min)	Shoulder Milling ae=0,1x0 ap=1,5x0 Vc (m/min)

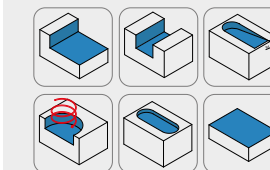
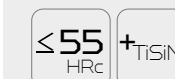


Material	Slotting ap=0,5x0 Vc (m/min)	Shoulder Milling ae=0,5x0 ap=1x0 Vc (m/min)	Shoulder Milling ae=0,1x0 ap=1,5x0 Vc (m/min)
Unalloyed Steel	145	175	290
Steel	110	135	200
Tempered Steel	105	100	170
Cold Work Tool Steel	80	90	130
Hot Work Tool Steel	80	90	130
AISI 304 - 416 - 420	65	80	150
AISI 316 - 440	60	75	120
17-4 PH 15-5 PH	60	75	120
Chrome-Cobalt Alloy	50	60	80
Duplex F51	55	70	90
Super Duplex F55	55	70	90
Gray Cast Iron	140	165	150
Alloyed Cast Iron	130	150	200
Precision Cast Iron	125	145	155
Iron-Based Super Alloys	30	40	50
Nickel-Based Super Alloys	30	40	60
Titanium-Based Super Alloys	40	50	100

Feed Per Tooth (mm/tooth)			
0	ap=0,5x0	ae=0,5x0 ap=1x0	ae=0,1x0 ap=1,5x0
4	0,013-0,02	0,08-0,012	0,016-0,025
6	0,02-0,03	0,02-0,03	0,027-0,041
8	0,023-0,04	0,02-0,03	0,041-0,062
10	0,035-0,05	0,027-0,04	0,055-0,082
12	0,04-0,06	0,035-0,05	0,072-0,103
14	0,05-0,07	0,04-0,06	0,082-0,123
16	0,055-0,08	0,05-0,07	0,103-0,144
18	0,06-0,09	0,055-0,08	0,113-0,164
20	0,07-0,1	0,06-0,09	0,123-0,185

# KSNF

General Use Endmill



Steel	●
Stainless Steel	○
Hardened Steel ≤54 HRC	●
Hardened Steel >54 HRC	○
Cast Iron	●
Graphite	○
Non Ferrous Material	○
HRSA	○
Titanium	○

● Recommended ○ Acceptable ○ Not Recommended

\* Marked products can be delivered quickly from stock.