



MASTER CATALOG **2018**

VOLUME TWO | **ROTATING TOOLS**



HOLEMAKING | TAPPING | SOLID END MILLING | INDEXABLE MILLING

➤ RHR™ Disc Reaming

Primary Application

The RHR modular disc reaming system combines the productivity of disc reamers with the idea of interchangeable reaming heads. Only five coupling sizes cover the whole diameter range, a comfortable interchange mechanism, and no need for setting fixtures or repeat measurements makes this system very attractive. Combine RHR disc reamers with the Kennametal SIF™ steerable holder for the best results.

Features and Benefits

- Solid carbide disc at front instead of single-tipped carbide blanks.
- Unique coating specifically for reaming applications.
- Unique patented coupling system enables same runout accuracy as monoblock systems (<3 microns), eliminating repeat runout checking.
- Quick radial clamping change-outs, even in narrow situations.
- No fixture for clamping or dismounting necessary.
- Helical and straight flutes for chip control in through and blind holes.
- Bodies available with straight shank, HSK back end, and SIF connection.



Customization

- All diameters between 14–42,5mm (.5512–1.6732").
- Variation of leads and cylindrical margin for application-specific optimization.

➤ RHM™ Modular Cermet-Tipped System

Primary Application

RHM modular reamers are tipped with cermet blanks and available in diameters from 14–42,5mm (.5512–1.6732") as standards, and up to 50mm (1.968") as custom solutions. Cermet reamers provide excellent tool life and surface finishes in steel applications. Combine RHM module reamers with the Kennametal SIF™ steerable holder for best results.

Use SIF steerable hydraulic chucks or SIF adapters for easy compensation of radial runout and angular inaccuracies of the spindle to achieve the highest possible hole straightness and surface quality. Radial or axial tool bodies are available at diameter 20mm.

Features and Benefits

Taper-Face Contact with KST Coupling

- Symmetrical torque transmission near head.
- Higher feed rate than conventional reaming tools.
- Better surface quality and tool life due to less tendency to vibrate.
- No need for head to body orientation.

Customization

- Diameters up to 50mm (1.968") available with and without internal coolant in 0,001mm (.00004") steps.
- Intermediate diameters from standard offering available with short delivery time.
- RHM tooling for machining heat-resistant materials, as well as different lengths and couplings or shanks, available on request.

Higher productivity and profitability

- Longer tool life with increased hole and surface quality due to lapped ground leads.
- Cermet enables highest metal removal rates at higher speeds and feeds in steel.
- Improved straightness and cylindrical form compared to competitive tools and reduced vibration tendency due to unequal flutes.



➤ RHM-E™ Expandable Reamers

Primary Application

The original idea behind an expansion reamer is to achieve more regrinds. The expansion mechanism is designed for this purpose only.

The Kennametal expandable reaming system is different. Over an expansion range of 48 microns, it comes with a completely linear expansion rate of 2 microns per 30° turn. The micron-adjustability of this system eliminates manufacturing tolerances and thus allows for machining tightest tolerances, usually only achievable by using an uncoated tool or guide pad reaming. No pre-setting equipment is required.



Features and Benefits

Precision and Productivity

- Use with SIF™ steerable chucks for KST toolholders for easy compensation of radial runout and angular inaccuracies.
- Tools are preadjusted to hit IT6 tolerance.
- Expansion range of 48 microns.
- Completely linear expansion.
- 2 microns per 30° turn.

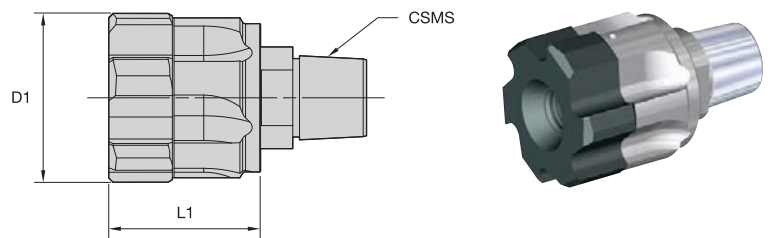
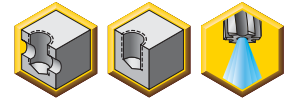
Increased Tool Life

- Longer tool life at smaller tolerances.

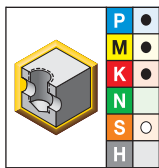
Customization

- Diameters up to 42mm (1.65") available with helical and straight flutes in 0,001mm (.00004") increments.

- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Please order lock screw and retention knob separately.



■ RHR • Disc Style Reamer Head • Straight Fluted for Blind Holes with Internal Coolant

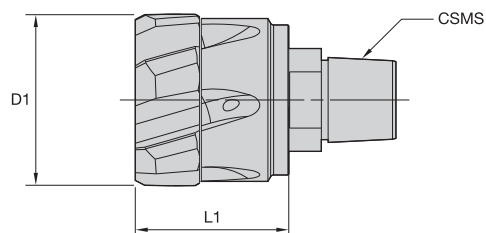
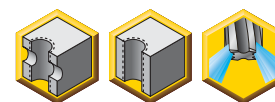


- first choice
- alternate choice

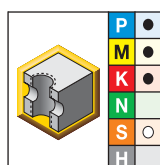
KCU05	CSMS system size	D1		L1		Z
		mm	in	mm	in	
RHR14000KST115H7SF	KST115	14,00	.551	17,90	.705	6
RHR15000KST115H7SF	KST115	15,00	.591	17,90	.705	6
RHR16000KST135H7SF	KST135	16,00	.630	17,90	.705	6
RHR17000KST135H7SF	KST135	17,00	.669	17,90	.705	6
RHR18000KST155H7SF	KST155	18,00	.709	17,90	.705	6
RHR19000KST155H7SF	KST155	19,00	.748	17,90	.705	6
RHR20000KST175H7SF	KST175	20,00	.787	17,90	.705	6
RHR21000KST175H7SF	KST175	21,00	.827	17,90	.705	6
RHR22000KST175H7SF	KST175	22,00	.866	17,90	.705	6
RHR23000KST200H7SF	KST200	23,00	.906	18,90	.744	6
RHR24000KST200H7SF	KST200	24,00	.945	18,90	.744	6
RHR25000KST200H7SF	KST200	25,00	.984	18,90	.744	8
RHR26000KST200H7SF	KST200	26,00	1.024	18,90	.744	8
RHR27000KST200H7SF	KST200	27,00	1.063	18,90	.744	8
RHR28000KST250H7SF	KST250	28,00	1.102	18,90	.744	8
RHR29000KST250H7SF	KST250	29,00	1.142	18,90	.744	8
RHR30000KST250H7SF	KST250	30,00	1.181	18,90	.744	8
RHR31000KST250H7SF	KST250	31,00	1.221	18,90	.744	8
RHR32000KST250H7SF	KST250	32,00	1.260	18,90	.744	8
RHR33000KST300H7SF	KST300	33,00	1.299	20,40	.803	8
RHR34000KST300H7SF	KST300	34,00	1.339	20,40	.803	8
RHR35000KST300H7SF	KST300	35,00	1.378	20,40	.803	8
RHR36000KST300H7SF	KST300	36,00	1.417	20,40	.803	8
RHR37000KST300H7SF	KST300	37,00	1.457	20,40	.803	8
RHR38000KST350H7SF	KST350	38,00	1.496	20,40	.803	8
RHR39000KST350H7SF	KST350	39,00	1.535	20,40	.803	8
RHR40000KST350H7SF	KST350	40,00	1.575	20,40	.803	8
RHR41000KST350H7SF	KST350	41,00	1.614	20,40	.803	8
RHR42000KST350H7SF	KST350	42,00	1.654	20,40	.803	8

Hole Finishing

- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Please order lock screw and retention knob separately.



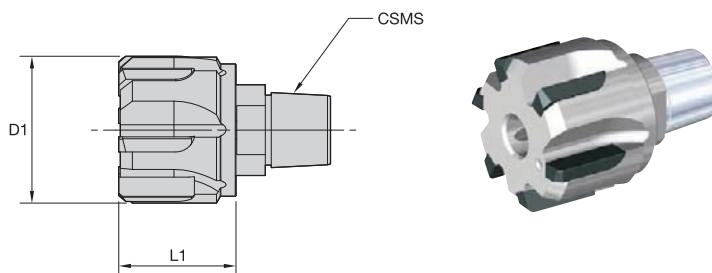
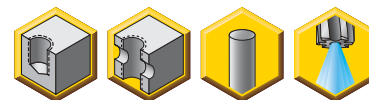
■ RHR • Disc Style Reamer Head • Helical Fluted for Through Holes with Internal Coolant



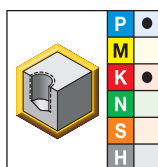
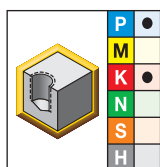
- first choice
- alternate choice

KCU05	CSMS system size	D1		L1		Z
		mm	in	mm	in	
RHR14000KST115H7HF	KST115	14,00	.551	17,90	.705	6
RHR15000KST115H7HF	KST115	15,00	.591	17,90	.705	6
RHR16000KST135H7HF	KST135	16,00	.630	17,90	.705	6
RHR17000KST135H7HF	KST135	17,00	.669	17,90	.705	6
RHR18000KST155H7HF	KST155	18,00	.709	17,90	.705	6
RHR19000KST155H7HF	KST155	19,00	.748	17,90	.705	6
RHR20000KST175H7HF	KST175	20,00	.787	17,90	.705	6
RHR21000KST175H7HF	KST175	21,00	.827	17,90	.705	6
RHR22000KST175H7HF	KST175	22,00	.866	17,90	.705	6
RHR23000KST200H7HF	KST200	23,00	.906	18,90	.744	6
RHR24000KST200H7HF	KST200	24,00	.945	18,90	.744	6
RHR25000KST200H7HF	KST200	25,00	.984	18,90	.744	8
RHR26000KST200H7HF	KST200	26,00	1.024	18,90	.744	8
RHR27000KST200H7HF	KST200	27,00	1.063	18,90	.744	8
RHR28000KST250H7HF	KST250	28,00	1.102	18,90	.744	8
RHR29000KST250H7HF	KST250	29,00	1.142	18,90	.744	8
RHR30000KST250H7HF	KST250	30,00	1.181	18,90	.744	8
RHR31000KST250H7HF	KST250	31,00	1.221	18,90	.744	8
RHR32000KST250H7HF	KST250	32,00	1.260	18,90	.744	8
RHR33000KST300H7HF	KST300	33,00	1.299	20,40	.803	8
RHR34000KST300H7HF	KST300	34,00	1.339	20,40	.803	8
RHR35000KST300H7HF	KST300	35,00	1.378	20,40	.803	8
RHR36000KST300H7HF	KST300	36,00	1.417	20,40	.803	8
RHR37000KST300H7HF	KST300	37,00	1.457	20,40	.803	8
RHR38000KST350H7HF	KST350	38,00	1.496	20,40	.803	8
RHR39000KST350H7HF	KST350	39,00	1.535	20,40	.803	8
RHR40000KST350H7HF	KST350	40,00	1.575	20,40	.803	8
RHR41000KST350H7HF	KST350	41,00	1.614	20,40	.803	8
RHR42000KST350H7HF	KST350	42,00	1.654	20,40	.803	8

- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Please order lock screw for axial use or retention knob separately.



■ RHM • Blind Hole Cermet Tipped Reamer

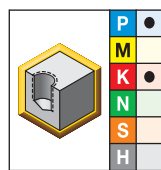
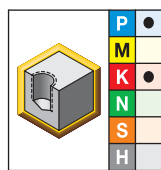


- first choice
- alternate choice

		D1		L1			
KT325	KT6215	CSMS system size	mm	in	mm	in	Z
RHM14000KST115H7SF *	RHM14000KST115H7SF	KST115	14,00	.551	13,50	.531	6
RHM14288KST115H7SF *	RHM14288KST115H7SF	KST115	14,29	.563	13,50	.531	6
RHM15000KST115H7SF *	—	KST115	15,00	.591	13,50	.531	6
RHM15875KST115H7SF *	RHM15875KST115H7SF	KST115	15,88	.625	13,50	.531	6
RHM16000KST135H7SF *	RHM16000KST135H7SF	KST135	16,00	.630	13,50	.531	6
RHM17000KST135H7SF *	RHM17000KST135H7SF *	KST135	17,00	.669	15,50	.610	6
RHM17463KST135H7SF *	—	KST135	17,46	.688	15,50	.610	6
RHM18000KST155H7SF	RHM18000KST155H7SF	KST155	18,00	.709	15,50	.610	6
RHM19000KST155H7SF *	—	KST155	19,00	.748	15,50	.610	6
—	RHM19050KST155H7SF *	KST155	19,05	.750	15,50	.610	6
RHM20000KST175H7SF	RHM20000KST175H7SF	KST175	20,00	.787	15,50	.610	6
RHM20640KST175H7SF *	RHM20640KST175H7SF *	KST175	20,64	.813	15,50	.610	6
RHM21000KST175H7SF *	RHM21000KST175H7SF	KST175	21,00	.827	15,50	.610	6
—	RHM22000KST175H7SF *	KST175	22,00	.866	15,50	.610	6
RHM22230KST175H7SF *	RHM22230KST175H7SF *	KST175	22,23	.875	15,50	.610	6
RHM22500KST200H7SF *	RHM22500KST200H7SF *	KST200	22,50	.886	16,50	.650	6
RHM23000KST200H7SF *	RHM23000KST200H7SF *	KST200	23,00	.906	16,50	.650	6
RHM23810KST200H7SF *	RHM23810KST200H7SF *	KST200	23,81	.937	16,50	.650	6
RHM24000KST200H7SF *	RHM24000KST200H7SF *	KST200	24,00	.945	16,50	.650	6
RHM25000KST200H7SF *	RHM25000KST200H7SF	KST200	25,00	.984	16,50	.650	6
RHM25400KST200H7SF *	RHM25400KST200H7SF *	KST200	25,40	1.000	16,50	.650	6
RHM26000KST200H7SF *	—	KST200	26,00	1.024	16,50	.650	8
RHM26990KST200H7SF *	RHM26990KST200H7SF *	KST200	26,99	1.063	16,50	.650	8
RHM27000KST200H7SF	RHM27000KST200H7SF *	KST200	27,00	1.063	16,50	.650	8

(continued)

(RHM • Blind Hole Cermet Tipped Reamer — continued)



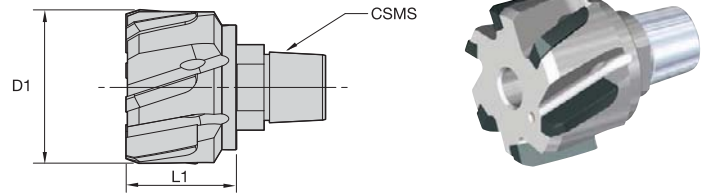
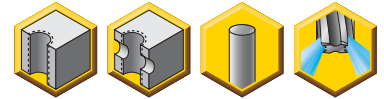
● first choice
○ alternate choice

		CSMS system size	D1		L1		Z
KT325	KT6215		mm	in	mm	in	
RHM27500KST250H7SF *	RHM27500KST250H7SF *	KST250	27,50	1.083	16,50	.650	8
RHM28000KST250H7SF *	RHM28000KST250H7SF	KST250	28,00	1.102	16,50	.650	8
RHM28580KST250H7SF *	RHM28580KST250H7SF *	KST250	28,58	1.125	16,50	.650	8
RHM29000KST250H7SF	RHM29000KST250H7SF *	KST250	29,00	1.142	16,50	.650	8
RHM30000KST250H7SF	RHM30000KST250H7SF *	KST250	30,00	1.181	16,50	.650	8
RHM30160KST250H7SF *	—	KST250	30,16	1.187	16,50	.650	8
RHM31000KST250H7SF *	RHM31000KST250H7SF *	KST250	31,00	1.221	16,50	.650	8
RHM31750KST250H7SF *	RHM31750KST250H7SF *	KST250	31,75	1.250	16,50	.650	8
RHM32000KST250H7SF *	—	KST250	32,00	1.260	16,50	.650	8
RHM32500KST300H7SF *	RHM32500KST300H7SF *	KST300	32,50	1.280	18,00	.709	8
RHM33000KST300H7SF *	RHM33000KST300H7SF *	KST300	33,00	1.299	18,00	.709	8
RHM33340KST300H7SF *	RHM33340KST300H7SF *	KST300	33,34	1.313	18,00	.709	8
RHM34000KST300H7SF *	—	KST300	34,00	1.339	18,00	.709	8
RHM34930KST300H7SF *	RHM34930KST300H7SF *	KST300	34,93	1.375	18,00	.709	8
RHM35000KST300H7SF *	RHM35000KST300H7SF *	KST300	35,00	1.378	18,00	.709	8
RHM36000KST300H7SF *	RHM36000KST300H7SF *	KST300	36,00	1.417	18,00	.709	8
RHM36510KST300H7SF *	RHM36510KST300H7SF *	KST300	36,51	1.437	18,00	.709	8
RHM37000KST300H7SF *	—	KST300	37,00	1.457	18,00	.709	8
RHM37500KST350H7SF *	RHM37500KST350H7SF *	KST350	37,50	1.476	18,00	.709	8
RHM38000KST350H7SF *	RHM38000KST350H7SF *	KST350	38,00	1.496	18,00	.709	8
RHM38100KST350H7SF *	RHM38100KST350H7SF *	KST350	38,10	1.500	18,00	.709	8
RHM39000KST350H7SF *	RHM39000KST350H7SF *	KST350	39,00	1.535	18,00	.709	8
RHM39690KST350H7SF *	RHM39690KST350H7SF *	KST350	39,69	1.563	18,00	.709	8
—	RHM40000KST350H7SF *	KST350	40,00	1.575	18,00	.709	8
RHM41000KST350H7SF *	RHM41000KST350H7SF *	KST350	41,00	1.614	18,00	.709	8
RHM41280KST350H7SF *	RHM41280KST350H7SF *	KST350	41,28	1.625	18,00	.709	8
RHM42000KST350H7SF	RHM42000KST350H7SF *	KST350	42,00	1.654	18,00	.709	8

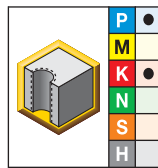
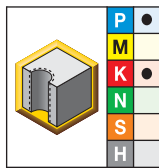
NOTE: *Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

Hole Finishing

- For hole tolerance H7.
- Intermediate sizes ground to achieve IT6 or IT7 hole tolerance class available.
- Please order lock screw for axial use or retention knob separately.



■ RHM • Through Hole Cermet Tipped Reamer

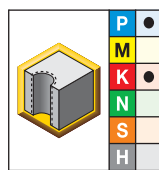
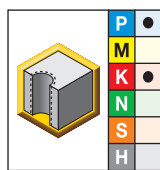


- first choice
- alternate choice

		D1		L1		Z
KT325	KT6215	CSMS system size	mm	in	mm	
RHM14000KST115H7HF *	RHM14000KST115H7HF	KST115	14,00	.551	13,50	6
RHM14288KST115H7HF *	RHM14288KST115H7HF *	KST115	14,29	.563	13,50	6
RHM15875KST115H7HF *	—	KST115	15,88	.625	13,50	6
RHM16000KST135H7HF	RHM16000KST135H7HF	KST135	16,00	.630	13,50	6
RHM17000KST135H7HF *	RHM17000KST135H7HF	KST135	17,00	.669	15,50	6
RHM17463KST135H7HF *	RHM17463KST135H7HF *	KST135	17,46	.688	15,50	6
RHM18000KST155H7HF *	RHM18000KST155H7HF	KST155	18,00	.709	15,50	6
RHM19000KST155H7HF *	RHM19000KST155H7HF	KST155	19,00	.748	15,50	6
RHM19050KST155H7HF *	RHM19050KST155H7HF	KST155	19,05	.750	15,50	6
RHM20000KST175H7HF	RHM20000KST175H7HF	KST175	20,00	.787	15,50	6
RHM20640KST175H7HF *	RHM20640KST175H7HF	KST175	20,64	.813	15,50	6
RHM21000KST175H7HF	RHM21000KST175H7HF	KST175	21,00	.827	15,50	6
RHM22000KST175H7HF	RHM22000KST175H7HF *	KST175	22,00	.866	15,50	6
RHM22230KST175H7HF *	RHM22230KST175H7HF *	KST175	22,23	.875	15,50	6
RHM22500KST200H7HF *	RHM22500KST200H7HF *	KST200	22,50	.886	16,50	6
RHM23000KST200H7HF *	RHM23000KST200H7HF *	KST200	23,00	.906	16,50	6
RHM23810KST200H7HF *	RHM23810KST200H7HF *	KST200	23,81	.937	16,50	6
RHM24000KST200H7HF	RHM24000KST200H7HF *	KST200	24,00	.945	16,50	6
RHM25000KST200H7HF	RHM25000KST200H7HF	KST200	25,00	.984	16,50	6
RHM25400KST200H7HF *	RHM25400KST200H7HF	KST200	25,40	1.000	16,50	6
RHM26000KST200H7HF *	—	KST200	26,00	1.024	16,50	8
RHM26990KST200H7HF *	RHM26990KST200H7HF *	KST200	26,99	1.063	16,50	8
RHM27000KST200H7HF *	RHM27000KST200H7HF *	KST200	27,00	1.063	16,50	8
RHM27500KST250H7HF *	RHM27500KST250H7HF *	KST250	27,50	1.083	16,50	8

(continued)

(RHM • Through Hole Cermet Tipped Reamer — continued)



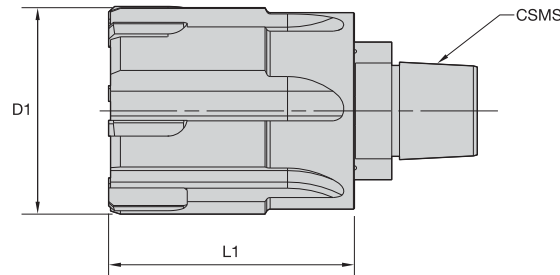
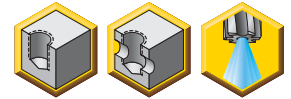
- first choice
- alternate choice

		D1			L1		
KT325	KT6215	CSMS system size	mm	in	mm	in	Z
RHM28000KST250H7HF	RHM28000KST250H7HF	KST250	28,00	1.102	16,50	.650	8
RHM28580KST250H7HF *	—	KST250	28,58	1.125	16,50	.650	8
RHM29000KST250H7HF *	RHM29000KST250H7HF *	KST250	29,00	1.142	16,50	.650	8
RHM30000KST250H7HF	RHM30000KST250H7HF	KST250	30,00	1.181	16,50	.650	8
RHM30160KST250H7HF *	RHM30160KST250H7HF *	KST250	30,16	1.187	16,50	.650	8
RHM31000KST250H7HF *	RHM31000KST250H7HF *	KST250	31,00	1.221	16,50	.650	8
RHM31750KST250H7HF *	RHM31750KST250H7HF *	KST250	31,75	1.250	16,50	.650	8
RHM32000KST250H7HF *	RHM32000KST250H7HF *	KST250	32,00	1.260	16,50	.650	8
RHM32500KST300H7HF *	RHM32500KST300H7HF *	KST300	32,50	1.280	18,00	.709	8
RHM33000KST300H7HF *	RHM33000KST300H7HF *	KST300	33,00	1.299	18,00	.709	8
RHM33340KST300H7HF *	RHM33340KST300H7HF *	KST300	33,34	1.313	18,00	.709	8
—	RHM34000KST300H7HF	KST300	34,00	1.339	18,00	.709	8
RHM34930KST300H7HF *	RHM34930KST300H7HF *	KST300	34,93	1.375	18,00	.709	8
RHM35000KST300H7HF	RHM35000KST300H7HF	KST300	35,00	1.378	18,00	.709	8
RHM36000KST300H7HF	—	KST300	36,00	1.417	18,00	.709	8
RHM36510KST300H7HF *	RHM36510KST300H7HF *	KST300	36,51	1.437	18,00	.709	8
RHM37000KST300H7HF *	RHM37000KST300H7HF	KST300	37,00	1.457	18,00	.709	8
RHM37500KST350H7HF *	RHM37500KST350H7HF *	KST350	37,50	1.476	18,00	.709	8
RHM38100KST350H7HF *	—	KST350	38,10	1.500	18,00	.709	8
RHM39000KST350H7HF *	RHM39000KST350H7HF *	KST350	39,00	1.535	18,00	.709	8
RHM39690KST350H7HF *	RHM39690KST350H7HF *	KST350	39,69	1.563	18,00	.709	8
RHM40000KST350H7HF	RHM40000KST350H7HF	KST350	40,00	1.575	18,00	.709	8
RHM41000KST350H7HF *	RHM41000KST350H7HF *	KST350	41,00	1.614	18,00	.709	8
RHM41280KST350H7HF *	RHM41280KST350H7HF *	KST350	41,28	1.625	18,00	.709	8
RHM42000KST350H7HF	RHM42000KST350H7HF *	KST350	42,00	1.654	18,00	.709	8

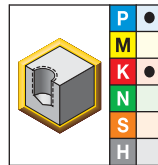
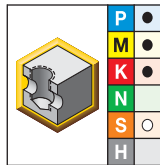
NOTE: Uncoated carbide grade K605™ is available on request.

*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

- For hole tolerance H6.
- Intermediate sizes available.
- Lock screw for axial use or retention knob comes with holder.
- Allen expansion screw.



RHM-E • Blind Hole Expansion Reamer



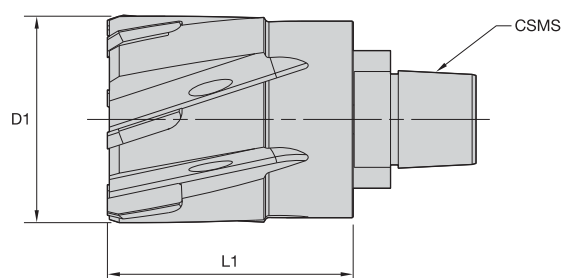
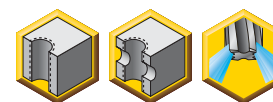
- first choice
- alternate choice

		CSMS system size	D1		L1		Z
KC6005	KC6305		mm	in	mm	in	
RHME14000KST115H6SF *	RHME14000KST115H6SF	KST115	14,00	.551	25,00	.984	6
RHME14288KST115H6SF *	RHME14288KST115H6SF *	KST115	14,29	.563	25,00	.984	6
RHME15000KST115H6SF *	RHME15000KST115H6SF	KST115	15,00	.591	25,00	.984	6
RHME16000KST135H6SF	RHME16000KST135H6SF	KST135	16,00	.630	25,00	.984	6
RHME17000KST135H6SF *	RHME17000KST135H6SF	KST135	17,00	.669	25,00	.984	6
RHME17463KST135H6SF *	RHME17463KST135H6SF *	KST135	17,46	.688	25,00	.984	6
RHME18000KST155H6SF *	RHME18000KST155H6SF *	KST155	18,00	.709	25,00	.984	6
RHME19000KST155H6SF *	RHME19000KST155H6SF *	KST155	19,00	.748	25,00	.984	6
RHME19050KST155H6SF *	RHME19050KST155H6SF *	KST155	19,05	.750	25,00	.984	6
RHME20000KST175H6SF *	RHME20000KST175H6SF	KST175	20,00	.787	25,00	.984	6
RHME21000KST175H6SF	RHME21000KST175H6SF *	KST175	21,00	.827	25,00	.984	6
RHME22000KST175H6SF *	RHME22000KST175H6SF *	KST175	22,00	.866	25,00	.984	6
RHME22225KST175H6SF *	RHME22225KST175H6SF	KST175	22,23	.875	25,00	.984	6
RHME23000KST200H6SF *	RHME23000KST200H6SF *	KST200	23,00	.906	25,00	.984	6
RHME23813KST200H6SF *	RHME23813KST200H6SF *	KST200	23,81	.938	25,00	.984	6
RHME24000KST200H6SF	RHME24000KST200H6SF *	KST200	24,00	.945	25,00	.984	6
RHME25000KST200H6SF	RHME25000KST200H6SF	KST200	25,00	.984	30,00	1.181	6
RHME25400KST200H6SF *	RHME25400KST200H6SF *	KST200	25,40	1.000	30,00	1.181	6
RHME26000KST200H6SF *	RHME26000KST200H6SF *	KST200	26,00	1.024	30,00	1.181	8
RHME27000KST200H6SF *	RHME27000KST200H6SF	KST200	27,00	1.063	30,00	1.181	8
RHME28000KST250H6SF	RHME28000KST250H6SF	KST250	28,00	1.102	36,00	1.417	8
RHME30000KST250H6SF	RHME30000KST250H6SF	KST250	30,00	1.181	36,00	1.417	8
RHME31750KST250H6SF *	RHME31750KST250H6SF *	KST250	31,75	1.250	36,00	1.417	8
RHME32000KST250H6SF *	RHME32000KST250H6SF *	KST250	32,00	1.260	36,00	1.417	8
RHME34000KST300H6SF *	RHME34000KST300H6SF *	KST300	34,00	1.339	36,00	1.417	8
RHME36000KST300H6SF *	RHME36000KST300H6SF *	KST300	36,00	1.417	36,00	1.417	8
RHME38000KST350H6SF *	RHME38000KST350H6SF *	KST350	38,00	1.496	36,00	1.417	8
RHME40000KST350H6SF *	RHME40000KST350H6SF *	KST350	40,00	1.575	36,00	1.417	8
RHME42000KST350H6SF	RHME42000KST350H6SF *	KST350	42,00	1.654	36,00	1.417	8

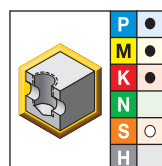
NOTE: Uncoated carbide grade K605™ is available on request.

*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

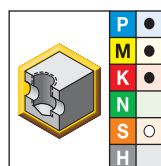
- For hole tolerance H6.
- Intermediate sizes available.
- Lock screw for axial use or retention knob comes with holder.
- Allen expansion screw.



RHM-E • Through Hole Expansion Reamer



KC6005



KC6305

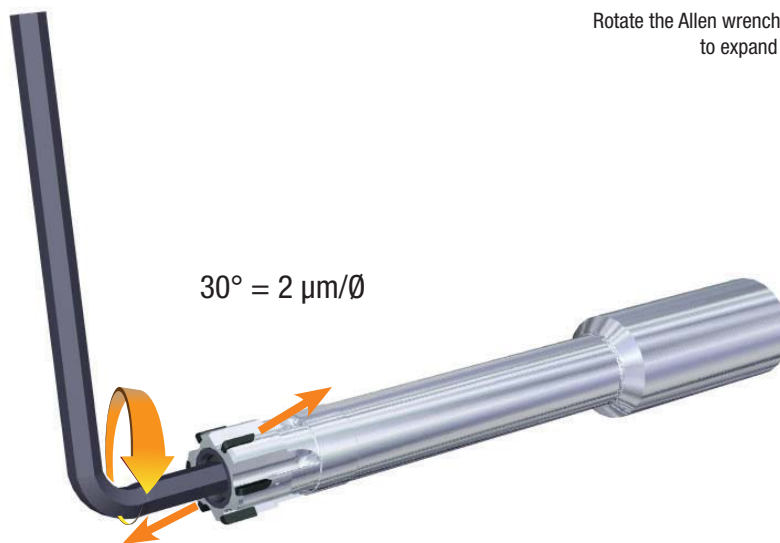
		CSMS system size	D1		L1		Z
			mm	in	mm	in	
RHME14000KST115H6HF *	RHME14000KST115H6HF *	KST115	14,00	.551	25,00	.984	6
RHME14288KST115H6HF *	RHME14288KST115H6HF *	KST115	14,29	.563	25,00	.984	6
RHME15000KST115H6HF *	RHME15000KST115H6HF *	KST115	15,00	.591	25,00	.984	6
RHME16000KST135H6HF	RHME16000KST135H6HF	KST135	16,00	.630	25,00	.984	6
RHME17000KST135H6HF	RHME17000KST135H6HF *	KST135	17,00	.669	25,00	.984	6
RHME17463KST135H6HF	RHME17463KST135H6HF *	KST135	17,46	.688	25,00	.984	6
RHME18000KST155H6HF *	RHME18000KST155H6HF	KST155	18,00	.709	25,00	.984	6
RHME19000KST155H6HF *	RHME19000KST155H6HF *	KST155	19,00	.748	25,00	.984	6
RHME19050KST155H6HF *	RHME19050KST155H6HF	KST155	19,05	.750	25,00	.984	6
RHME20000KST175H6HF	RHME20000KST175H6HF	KST175	20,00	.787	25,00	.984	6
RHME21000KST175H6HF *	RHME21000KST175H6HF *	KST175	21,00	.827	25,00	.984	6
RHME22000KST175H6HF	RHME22000KST175H6HF	KST175	22,00	.866	25,00	.984	6
RHME22225KST175H6HF *	RHME22225KST175H6HF	KST175	22,23	.875	25,00	.984	6
RHME23000KST200H6HF *	RHME23000KST200H6HF *	KST200	23,00	.906	25,00	.984	6
RHME23813KST200H6HF *	RHME23813KST200H6HF *	KST200	23,81	.938	25,00	.984	6
RHME24000KST200H6HF *	RHME24000KST200H6HF *	KST200	24,00	.945	25,00	.984	6
RHME25000KST200H6HF *	RHME25000KST200H6HF	KST200	25,00	.984	30,00	1.181	6
RHME25400KST200H6HF	RHME25400KST200H6HF	KST200	25,40	1.000	30,00	1.181	6
RHME26000KST200H6HF *	RHME26000KST200H6HF	KST200	26,00	1.024	30,00	1.181	8
RHME27000KST200H6HF *	RHME27000KST200H6HF *	KST200	27,00	1.063	30,00	1.181	8
RHME28000KST250H6HF	RHME28000KST250H6HF	KST250	28,00	1.102	36,00	1.417	8
RHME30000KST250H6HF	RHME30000KST250H6HF	KST250	30,00	1.181	36,00	1.417	8
RHME31750KST250H6HF *	RHME31750KST250H6HF	KST250	31,75	1.250	36,00	1.417	8
RHME32000KST250H6HF *	RHME32000KST250H6HF *	KST250	32,00	1.260	36,00	1.417	8
RHME34000KST300H6HF *	RHME34000KST300H6HF *	KST300	34,00	1.339	36,00	1.417	8
RHME36000KST300H6HF *	RHME36000KST300H6HF *	KST300	36,00	1.417	36,00	1.417	8
RHME38000KST350H6HF *	RHME38000KST350H6HF *	KST350	38,00	1.496	36,00	1.417	8
RHME40000KST350H6HF *	—	KST350	39,99	1.574	36,00	1.417	8
—	RHME40000KST350H6HF *	KST350	40,00	1.575	36,00	1.417	8
RHME42000KST350H6HF *	RHME42000KST350H6HF *	KST350	42,00	1.654	36,00	1.417	8

NOTE: Uncoated carbide grade K605™ is available on request.

*Made-to-order standard item. Standard pricing, manufacturing lead time, and minimum order quantity applies.

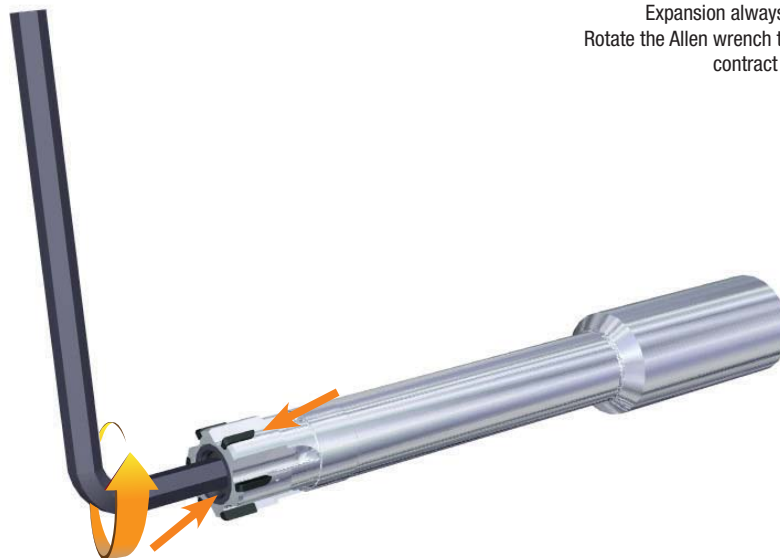
To Expand

Rotate the Allen wrench to the right to expand the reamer.



To Contract

Expansion always reversible:
Rotate the Allen wrench to the left to contract the reamer.



- 30° = 2 μm linear expansion.
- 720° = 2 revolutions; = 48 μm maximum expansion.
- Hard stop after 720° expansion. You cannot over expand!
- The expansion occurs in the elastic material behavior.
- You cannot reduce the diameter below D1.

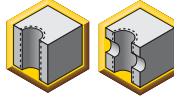
■ RHR • Metric

Material Group		KCU05			Metric						
		Cutting Speed — vc			Recommended Feed Rate per Tooth						
		Range — m/min			Tool Diameter (mm)	14,00–19,99mm		20,00–32,00mm		32,50–42,00mm	
		min	Starting Value	max	Feed/Tooth	min	max	min	max	min	max
P	1	90	120	155	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	2	90	120	155	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	3	75	100	130	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	4	50	80	105	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	5	30	40	60	mm/z	0,08	0,18	0,08	0,20	0,08	0,22
	6	30	40	60	mm/z	0,08	0,18	0,08	0,20	0,08	0,22
M	1	15	20	40	mm/z	0,08	0,15	0,08	0,18	0,08	0,20
	2	15	20	30	mm/z	0,08	0,15	0,08	0,18	0,08	0,20
	3	15	20	30	mm/z	0,08	0,15	0,08	0,18	0,08	0,20
K	1	80	110	130	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	2	65	90	110	mm/z	0,10	0,20	0,10	0,22	0,10	0,25
	3	50	70	90	mm/z	0,10	0,18	0,10	0,20	0,10	0,22
S	1	15	20	30	mm/z	0,06	0,15	0,10	0,18	0,10	0,20
	2	15	20	30	mm/z	0,06	0,15	0,10	0,18	0,10	0,20
	3	20	30	40	mm/z	0,08	0,18	0,10	0,20	0,10	0,20
	4	20	30	40	mm/z	0,08	0,18	0,10	0,20	0,10	0,20

■ RHR • Inch

Material Group		KCU05			Inch						
		Cutting Speed — vc			Recommended Feed Rate per Tooth						
		Range — SFM			Tool Diameter (inch)	.551–.787"		.787–1.260"		1.260–1.654"	
		min	Starting Value	max	Feed/Tooth	min	max	min	max	min	max
P	1	295	394	509	inch/z	.004	.008	.004	.009	.004	.010
	2	295	394	509	inch/z	.004	.008	.004	.009	.004	.010
	3	246	328	427	inch/z	.004	.008	.004	.009	.004	.010
	4	164	262	344	inch/z	.004	.008	.004	.009	.004	.010
	5	98	131	197	inch/z	.003	.007	.004	.008	.004	.009
	6	98	131	197	inch/z	.003	.007	.003	.008	.003	.009
M	1	49	66	131	inch/z	.003	.006	.003	.007	.003	.008
	2	49	66	98	inch/z	.003	.006	.003	.007	.003	.008
	3	49	66	98	inch/z	.003	.006	.003	.007	.003	.008
K	1	262	361	427	inch/z	.004	.008	.004	.009	.004	.010
	2	213	295	361	inch/z	.004	.008	.004	.009	.004	.010
	3	164	230	295	inch/z	.004	.007	.004	.008	.004	.009
S	1	49	66	98	inch/z	.002	.006	.004	.007	.004	.008
	2	49	66	98	inch/z	.002	.006	.004	.007	.004	.008
	3	66	98	131	inch/z	.003	.007	.004	.008	.004	.008
	4	66	98	131	inch/z	.003	.007	.004	.008	.004	.008

■ RHM™ and RHM-E™ • Metric

Material Group	Cermet Tipped												Carbide Tipped												Metric							
																																
	straight flute						helical flute						straight flute						helical flute													
	KT325						KT6215						K605						KC6305													
	Cutting Speed — vc														Recommended Feed Rate per Tooth																	
	Range — m/min														Tool Diameter (mm)																	
		min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	Feed/Tooth	14,00–19,99mm		20,00–32,00mm		32,50–42,00mm													
P	1	150	180	210	180	210	240	40	60	70	90	120	155	mm/z	0,10	0,20	0,10	0,22	0,10	0,25												
	2	150	180	210	180	210	240	40	60	70	90	120	155	mm/z	0,10	0,20	0,10	0,22	0,10	0,25												
	3	130	160	180	150	180	210	30	40	50	75	100	130	mm/z	0,10	0,20	0,10	0,22	0,10	0,25												
	4	100	130	150	120	150	170	25	40	45	50	80	105	mm/z	0,10	0,20	0,10	0,22	0,10	0,25												
	5	80	100	120	100	130	150	10	20	30	30	40	55	mm/z	0,08	0,18	0,08	0,20	0,08	0,22												
	6	80	100	120	100	130	150	10	20	30	30	40	55	mm/z	0,08	0,18	0,08	0,20	0,08	0,22												
M	1	–	–	–	–	–	–	8	10	15	15	20	28	mm/z	0,08	0,15	0,08	0,18	0,08	0,20												
	2	–	–	–	–	–	–	8	10	15	15	20	28	mm/z	0,08	0,15	0,08	0,18	0,08	0,20												
	3	–	–	–	–	–	–	8	10	15	15	20	28	mm/z	0,08	0,15	0,08	0,18	0,08	0,20												
K	1	150	180	200	180	210	240	30	50	60	80	110	130	mm/z	0,10	0,20	0,10	0,22	0,10	0,25												
	2	130	160	180	150	180	210	25	40	45	65	90	110	mm/z	0,10	0,20	0,10	0,22	0,10	0,25												
	3	100	130	160	120	150	170	20	30	40	50	70	90	mm/z	0,10	0,18	0,10	0,20	0,10	0,22												
N	1	–	–	–	–	–	–	110	150	195	–	–	–	mm/z	0,10	0,30	0,10	0,30	0,10	0,30												
	2	–	–	–	–	–	–	110	150	195	–	–	–	mm/z	0,10	0,30	0,10	0,30	0,10	0,30												
	3	–	–	–	–	–	–	110	150	195	–	–	–	mm/z	0,10	0,30	0,10	0,30	0,10	0,30												
	4	–	–	–	–	–	–	110	150	195	–	–	–	mm/z	0,10	0,30	0,10	0,30	0,10	0,30												
	5	–	–	–	–	–	–	105	140	180	–	–	–	mm/z	0,10	0,30	0,10	0,30	0,10	0,30												
S	1	–	–	–	–	–	–	8	10	15	15	20	28	mm/z	0,06	0,15	0,10	0,18	0,10	0,20												
	2	–	–	–	–	–	–	8	10	15	15	20	28	mm/z	0,06	0,15	0,10	0,18	0,10	0,20												
	3	–	–	–	–	–	–	15	20	30	20	30	40	mm/z	0,08	0,18	0,10	0,20	0,10	0,20												
	4	–	–	–	–	–	–	15	20	30	20	30	40	mm/z	0,08	0,18	0,10	0,20	0,10	0,20												

Hole Finishing

 RHM[™] and RHM-E[™] • Inch

Material Group	Cermet Tipped						Carbide Tipped						Inch							
																				
	straight flute			helical flute			straight flute			helical flute										
	KT325			KT6215			K605			KC6305										
	Cutting Speed — vc													Recommended Feed Rate per Tooth						
	Range — SFM													Tool Diameter (inch)	.551–.787"		.787–1.260"		1.280–1.654"	
	min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	Feed/Tooth	min	max	min	max	min	max	
P	1	492	590	689	590	689	787	131	197	230	295	394	508	inch/z	.004	.008	.004	.009	.004	.010
	2	492	590	689	590	689	787	131	197	230	295	394	508	inch/z	.004	.008	.004	.009	.004	.010
	3	426	525	590	492	590	689	98	131	164	246	328	426	inch/z	.004	.008	.004	.009	.004	.010
	4	328	426	492	394	492	558	82	131	148	164	262	344	inch/z	.004	.008	.004	.009	.004	.010
	5	262	328	394	328	426	492	33	66	98	98	131	180	inch/z	.003	.007	.003	.008	.003	.009
	6	262	328	394	328	426	492	33	66	98	98	131	180	inch/z	.003	.007	.003	.008	.003	.009
M	1	–	–	–	–	–	–	26	33	49	49	66	92	inch/z	.003	.006	.003	.007	.003	.008
	2	–	–	–	–	–	–	26	33	49	49	66	92	inch/z	.003	.006	.003	.007	.003	.008
	3	–	–	–	–	–	–	26	33	49	49	66	92	inch/z	.003	.006	.003	.007	.003	.008
K	1	492	590	656	590	689	787	98	164	197	262	361	426	inch/z	.004	.008	.004	.009	.004	.010
	2	426	525	590	492	590	689	82	131	148	213	295	361	inch/z	.004	.008	.004	.009	.004	.010
	3	328	426	525	394	492	558	66	98	131	164	230	295	inch/z	.004	.007	.004	.008	.004	.009
N	1	–	–	–	–	–	–	361	492	640	–	–	–	inch/z	.004	.012	.004	.012	.004	.012
	2	–	–	–	–	–	–	361	492	640	–	–	–	inch/z	.004	.012	.004	.012	.004	.012
	3	–	–	–	–	–	–	361	492	640	–	–	–	inch/z	.004	.012	.004	.012	.004	.012
	4	–	–	–	–	–	–	361	492	640	–	–	–	inch/z	.004	.012	.004	.012	.004	.012
	5	–	–	–	–	–	–	344	459	590	–	–	–	inch/z	.004	.012	.004	.012	.004	.012
S	1	–	–	–	–	–	–	26	33	49	49	66	92	inch/z	.002	.006	.004	.007	.004	.008
	2	–	–	–	–	–	–	26	33	49	49	66	92	inch/z	.002	.006	.004	.007	.004	.008
	3	–	–	–	–	–	–	49	66	98	66	98	131	inch/z	.003	.007	.004	.008	.004	.008
	4	–	–	–	–	–	–	49	66	98	66	98	131	inch/z	.003	.007	.004	.008	.004	.008

Hole Finishing

■ Reaming Allowances for Multi-Blade Reaming

mm	in	reaming allowances in diameter					
		min	mm middle	max	min	in middle	max
1,40–4,80	.055–.189	0,08	0,12	0,20	.003	.005	.008
4,81–9,59	.189–.378	0,10	0,15	0,25	.004	.006	.010
9,60–15,00	.378–.591	0,15	0,20	0,30	.006	.008	.012
15,00–20,00	.591–.787	0,15	0,25	0,35	.006	.010	.014
20,00–50,00	.787–1.969	0,20	0,30	0,40	.008	.012	.016

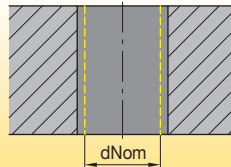
■ Troubleshooting

Problem

Cause

Possible Remedy

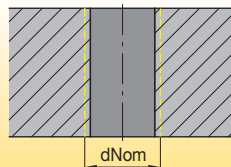
Hole diameter too large.



- Reaming tool running out-of-center.
- Concentricity of pilot hole and ream machining unsatisfactory.
- Built-up edge.
- Unsuitable cooling lubricant.
- Reaming tool diameter too large.

- Use equalizing adapter.
- Re-align, use floating head.
- Change cooling lubricant.
- Change cutting speed.
- Measure reamers and send for repairs.

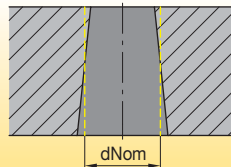
Hole diameter too small.



- Reamer worn.
- Unsuitable cooling lubricant.
- Reaming allowance too small.

- Replace and refit tool.
- Change cooling lubricant.
- Increase reaming allowance.

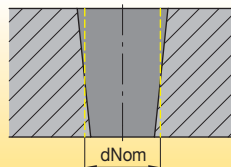
Conical hole profile wider towards drill runoff.



- Concentricity of pilot hole and reaming unsatisfactory.
- Positioning accuracy of pilot hole to reaming.

- Re-align, use equalizing adapter.
- Correct positioning accuracy.

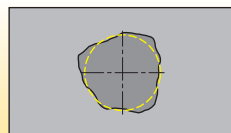
Conical hole profile wider at drill entry point.



- Concentricity of pilot hole and reaming unsatisfactory.
- Reaming tool skim cutting with ledger.

- Re-align, use floating head.
- Securely clamp reaming tool axially.

Hole out-of-center and/or showing chatter marks.



- Reaming tool running out-of-center.
- Slanted cutting surface/asymmetrical cutting.
- Workpiece twisted.

- Use equalizing adapter.
- Spot face as drilling preparation.
- Take the direction of impact into account when clamping the workpiece.

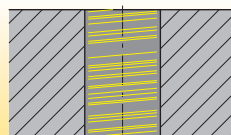
Surface quality does not meet specification.



- Tool cutters worn.
- Reaming tool running out-of-center.
- Incorrect technology data (cutting parameters).
- Inadequate chip evacuation.

- Use equalizing adapter.
- Re-align, use floating head.
- Change cooling lubricant.
- Change cutting speed.
- Measure reamers and send for repairs.

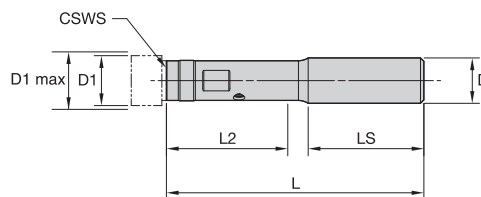
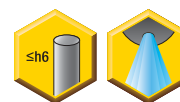
Feed grooves



- Built-up edge.

- Change cooling lubricant.
- Change cutting speed.

- Tool body shipped with lock screw and wrench.
- Order reamer head separately.

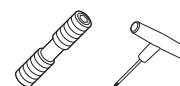


■ Straight Shank • Axial Clamping • 3 x D

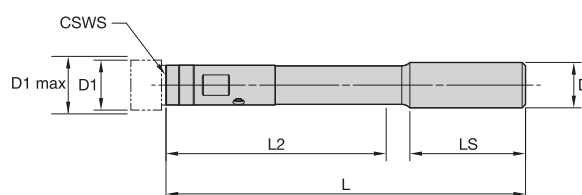
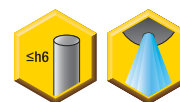


Hole Finishing

order number	catalog number	CSWS system size	D1		D1 max		D		L		L2		LS		central lock screw	Torx wrench	Nm	ft. lbs.
			mm	in	mm	in	mm	in	mm	in	mm	in	mm	in				
4056174	SS16KST115AR3M	KST115	14,00	.551	15,999	.630	16,00	.630	91,00	3.583	36,00	1.420	48,00	1.89	KST115115AS	FT8	3,0	2.2
4056175	SS20KST135AR3M	KST135	16,00	.630	17,999	.709	20,00	.787	99,00	3.898	39,00	1.540	51,00	2.01	KST135155AS	FT10	4,0	3.0
4056176	SS20KST155AR3M	KST155	18,00	.709	19,999	.787	20,00	.787	106,00	4.173	45,00	1.770	51,00	2.01	KST135155AS	FT10	4,0	3.0
3861185	SS20KST175AR3M	KST175	20,00	.787	22,499	.886	20,00	.787	113,50	4.469	51,50	2.028	51,00	2.01	KST175200AS	TT15	5,0	3.7
3861186	SS20KST200AR3M	KST200	22,50	.886	27,499	1.083	20,00	.787	130,50	5.138	65,50	2.579	51,00	2.01	KST175200AS	TT15	5,0	3.7
3861187	SS25KST250AR3M	KST250	27,50	1.083	32,499	1.280	25,00	.984	152,50	6.004	80,50	3.169	56,00	2.20	KST250250AS	TT25	9,0	6.7
3861188	SS32KST300AR3M	KST300	32,50	1.280	37,499	1.476	32,00	1.260	174,00	6.850	94,00	3.701	61,00	2.40	KST300350AS	TT30	13,0	9.7
3861189	SS32KST350AR3M	KST350	37,50	1.476	42,000	1.654	32,00	1.260	190,00	7.480	108,00	4.252	61,00	2.40	KST300350AS	TT30	13,0	9.7

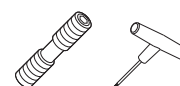


- Tool body shipped with lock screw and wrench.
- Order reamer head separately.

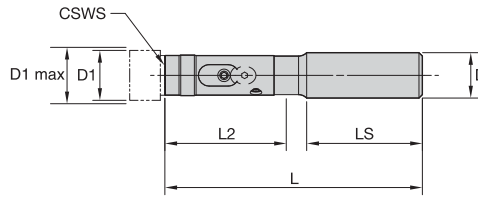


■ Straight Shank • Axial Clamping • 5 x D

order number	catalog number	CSWS system size	D1		D1 max		D		L		L2		LS		central lock screw	Torx wrench	Nm	ft. lbs.
			mm	in	mm	in	mm	in	mm	in	mm	in	mm	in				
4056177	SS16KST115AR5M	KST115	14,00	.551	15,999	.630	16,00	.630	123,00	4.843	68,00	2.680	48,00	1.89	KST115115AS	FT8	3,0	2.2
4056178	SS20KST135AR5M	KST135	16,00	.630	17,999	.709	20,00	.787	135,00	5.315	75,00	2.950	51,00	2.01	KST135155AS	FT10	4,0	3.0
4056179	SS20KST155AR5M	KST155	18,00	.709	19,999	.787	20,00	.787	146,00	5.748	85,00	3.350	51,00	2.01	KST135155AS	FT10	4,0	3.0
3861190	SS20KST175AR5M	KST175	20,00	.787	22,499	.886	20,00	.787	158,50	6.240	96,50	3.799	51,00	2.01	KST175200AS	TT15	5,0	3.7
3861191	SS20KST200AR5M	KST200	22,50	.886	27,499	1.083	20,00	.787	185,50	7.303	120,50	4.744	51,00	2.01	KST175200AS	TT15	5,0	3.7
3861192	SS25KST250AR5M	KST250	27,50	1.083	32,499	1.280	25,00	.984	217,50	8.563	145,50	5.728	56,00	2.20	KST250250AS	TT25	9,0	6.7
3861193	SS32KST300AR5M	KST300	32,50	1.280	37,499	1.476	32,00	1.260	249,00	9.803	169,00	6.654	61,00	2.40	KST300350AS	TT30	13,0	9.7
3861194	SS32KST350AR5M	KST350	37,50	1.476	42,000	1.654	32,00	1.260	274,00	10.787	192,00	7.559	61,00	2.40	KST300350AS	TT30	13,0	9.7



- Tool body shipped with retention knob, clamp set, and wrench.
- Order reamer head separately.

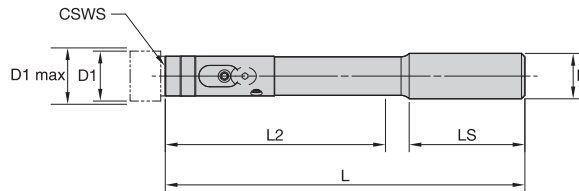


■ Straight Shank • Radial Clamping • 3 x D

order number	catalog number	CSWS system size	D1		D1 max		D		L		L2		LS		retention knob	clamp set	Torx wrench	ft. lbs.	
			mm	in	mm	in	mm	in	mm	in	mm	in	mm	in					
3861195	SS20KST175RR3M	KST175	20,00	.787	22,499	.886	20,00	.787	113,50	4.469	51,50	2.028	51,00	2.01	KST175200RK	KST175CS	TT15	5,0	3.7
3861196	SS20KST200RR3M	KST200	22,50	.886	27,499	1.083	20,00	.787	130,50	5.138	65,50	2.579	51,00	2.01	KST175200RK	KST200CS	TT15	5,0	3.7
3861197	SS25KST250RR3M	KST250	27,50	1.083	32,499	1.280	25,00	.984	152,50	6.004	80,50	3.169	56,00	2.21	KST250250RK	KST250CS	TT25	9,0	6.7
3861198	SS32KST300RR3M	KST300	32,50	1.280	37,499	1.476	32,00	1.259	174,00	6.850	94,00	3.701	61,00	2.40	KST300350RK	KST300CS	TT30	13,0	9.7
3861199	SS32KST350RR3M	KST350	37,50	1.476	42,000	1.654	32,00	1.259	190,00	7.480	108,00	4.252	61,00	2.40	KST300350RK	KST350CS	TT30	13,0	9.7



- Tool body shipped with retention knob, clamp set, and wrench.
- Order reamer head separately.



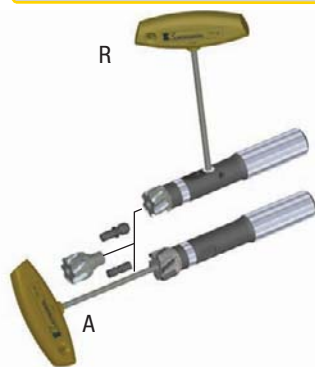
■ Straight Shank • Radial Clamping • 5 x D

order number	catalog number	CSWS system size	D1		D1 max		D		L		L2		LS		retention knob	clamp set	Torx wrench	ft. lbs.	
			mm	in	mm	in	mm	in	mm	in	mm	in	mm	in					
3861200	SS20KST175RR5M	KST175	20,00	.787	22,499	.886	20,00	.787	158,50	6.24	96,50	3.80	51,00	2.01	KST175200RK	KST175CS	TT15	5,0	3.7
3861201	SS20KST200RR5M	KST200	22,50	.886	27,499	1.083	20,00	.787	185,50	7.30	120,50	4.74	51,00	2.01	KST175200RK	KST200CS	TT15	5,0	3.7
3861202	SS25KST250RR5M	KST250	27,50	1.083	32,499	1.280	25,00	.984	217,50	8.56	145,50	5.73	56,00	2.21	KST250250RK	KST250CS	TT25	9,0	6.7
3861203	SS32KST300RR5M	KST300	32,50	1.280	37,499	1.476	32,00	1.259	249,00	9.80	169,00	6.65	61,00	2.40	KST300350RK	KST300CS	TT30	13,0	9.7
3861204	SS32KST350RR5M	KST350	37,50	1.476	42,000	1.654	32,00	1.259	274,00	10.79	192,00	7.56	61,00	2.40	KST300350RK	KST350CS	TT30	13,0	9.7

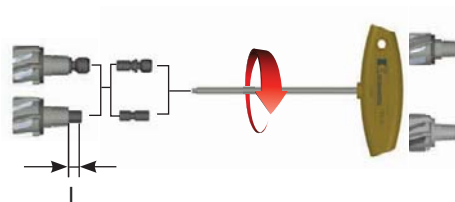


Assemble

1

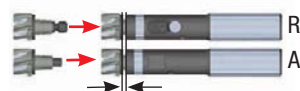


2

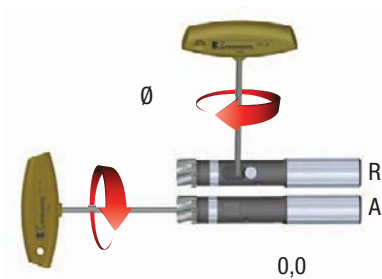


$\varnothing$ (mm)		$\varnothing$ (in)		L (mm)
14,000	27,499	0.549	1.078	5-5,5
27,500	42,000	1.078	1.647	5,5-6

3



4



$\varnothing$ (mm)		$\varnothing$ (in)			 (Nm)	 (ft. lbs.)
14,000	15,999	0.549	0.627	DT - 8	2	1.5
16,000	19,999	0.627	0.784	DT - 10	3	2.2
20,000	27,499	0.784	1.078	TT - 15	4	3.7
27,500	32,499	1.078	1.274	TT - 25	5	6.7
32,500	42,000	1.275	1.647	TT - 30	13	9.7

Disassemble

4

→

3

→

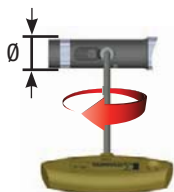
2

→

1

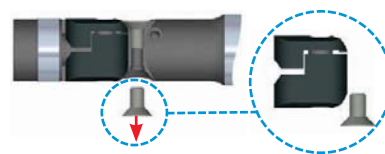
Disassemble

1

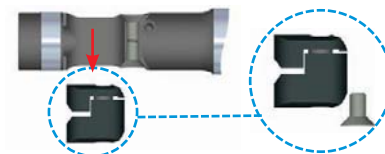


Ø (mm)	Ø (in)			(Nm)	(ft. lbs.)
17,5	0.686	KST175CS	2,5	2,5	1.9
20	0.784	KST200CS	2,5	2,5	1.9
25	0.980	KST250CS	3	5	3.7
30	1.176	KST300CS	4	9	6.7
35	1.373	KST350CS	4	9	9.7

2



3



Assemble 3 → 2 → 1

SIF™



Coolant flow



Application

