



MASTER CATALOG **2018**

VOLUME TWO | **ROTATING TOOLS**



HOLEMAKING | TAPPING | SOLID END MILLING | INDEXABLE MILLING

DUO-LOCK[®]

Corner Rounding and Chamfering Solid Carbide Tips

Primary Application

Duo-Lock[™] XRDA corner rounding and XADA chamfering tools perfectly complete the offering of high-performance end mills.

- Universal tools for almost all workpiece materials.
- Able to be reconditioned multiple times.

Features and Benefits

Advanced Technology

- Tailored amount of edges for each diameter.

Tailored Grades

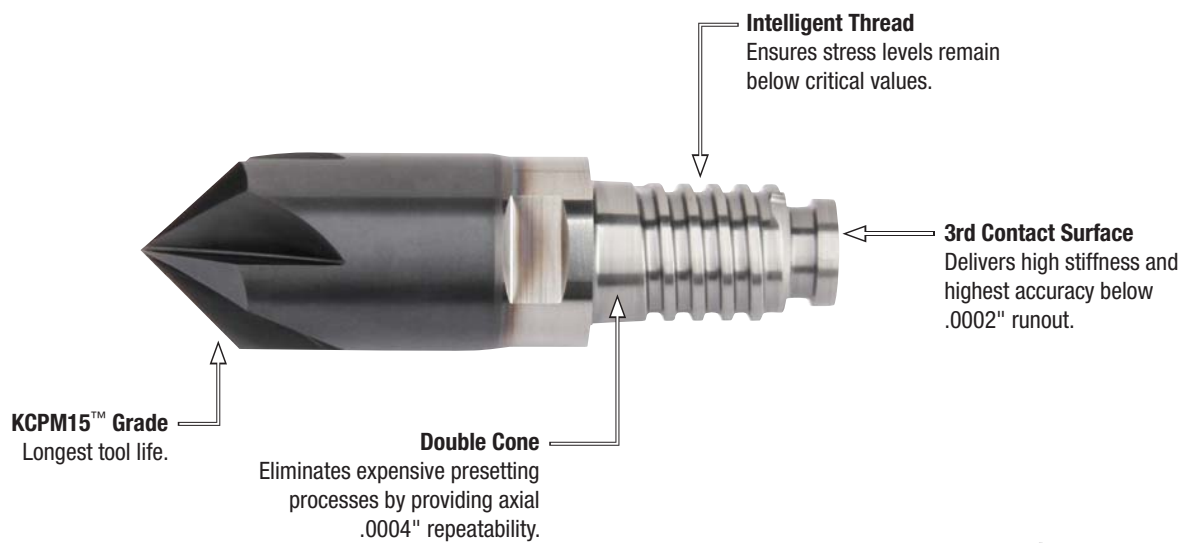
- KCPM15[™] Beyond[™] grade for outstanding wear protection in various materials to mitigate crater, depth-of-cut notching, and flank wear.

Customization

- Intermediate diameters are available between 3/8–1 1/4".
- Various angles and inverse radii possible.

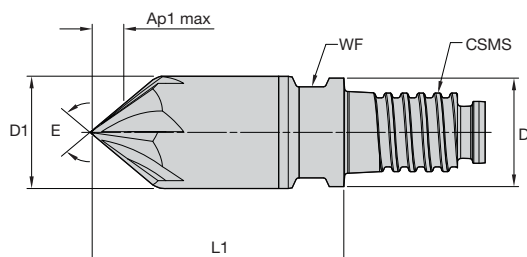
Extensive Standard Offering

- Diameter ranges 3/8–5/8".
- Integral adapters reduce the amount of interface for maximum accuracy. Steel extensions with Safe-Lock[™] by HAIMER shanks prevent pullout.
- Cut-to-size extra-long extensions available upon request off the shelf.



DUO-LOCK®
by HAIMER® and Kennametal

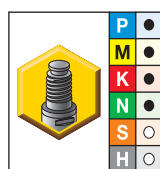
- Non-center cutting.
- Standard items listed. Additional styles and coatings made-to-order.



End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"

XADA • Inch

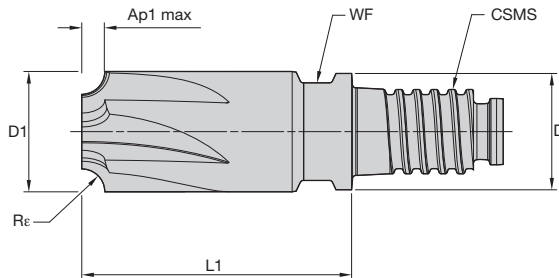


- first choice
- alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	E	Z U
XADA0375Y4CU60	3/8	.359	.075	.847	DL10	.315	60	4
XADA0375Y4CU45	3/8	.359	.178	.847	DL10	.315	90	4
XADA0500Y5CU60	1/2	.480	.100	1.126	DL12	.374	60	5
XADA0500Y5CU45	1/2	.480	.100	1.130	DL12	.374	90	5
XADA0625Y6CU45	5/8	.605	.125	1.402	DL16	.512	90	6
XADA0625Y6CU60	5/8	.605	.125	1.406	DL16	.512	60	6

NOTE: For application data, please see page O50.

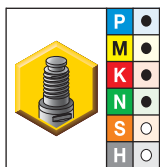
- Non-center cutting.
- Standard items listed. Additional styles and coatings made-to-order.



End Mill Tolerances

D1	tolerance e8
13/32–23/32"	-0,00126"/-0,00232"
23/32–1-3/16"	-0,00157"/-0,00287"

■ XRDA • Inch



- first choice
- alternate choice

KCPM15	D1	D	Ap1 max	L1	CSMS system size	WF	Rε	Z U
XRDA0375Y4CUC	3/8	.359	.060	.843	DL10	.315	.060	4
XRDA0375Y4CUE	3/8	.359	.120	.852	DL10	.315	.120	4
XRDA0500Y5CUB	1/2	.480	.030	1.126	DL12	.374	.030	5
XRDA0500Y5CUC	1/2	.480	.060	1.131	DL12	.374	.060	5
XRDA0500Y5CUE	1/2	.480	.120	1.136	DL12	.374	.120	5
XRDA0625Y6CUC	5/8	.605	.060	1.406	DL16	.512	.060	6
XRDA0625Y6CUE	5/8	.605	.120	1.406	DL16	.512	.120	6

NOTE: For application data, please see page O51.

XADA • Inch

Material Group																	
		Chamfering		short			medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A).				
		A		adapter reach										D1 – Diameter			
				KCPM15			KCPM15			KCPM15							
				Cutting Speed – vc SFM			Cutting Speed – vc SFM			Cutting Speed – vc SFM			frac.	3/8	1/2	5/8	
		ap	ae	min		max	min		max	min		max	dec.	.375	.500	.625	
P	0	0.35 x D	0.35 x D	490	–	660	441	–	594	441	–	594	IPT	.0022	.0027	.0032	
	1	0.35 x D	0.35 x D	490	–	660	441	–	594	441	–	594	IPT	.0022	.0027	.0032	
	2	0.35 x D	0.35 x D	460	–	620	414	–	558	414	–	558	IPT	.0022	.0027	.0032	
	3	0.35 x D	0.35 x D	390	–	520	351	–	468	351	–	468	IPT	.0018	.0023	.0027	
	4	0.35 x D	0.35 x D	300	–	490	270	–	441	270	–	441	IPT	.0016	.0021	.0024	
	5	0.35 x D	0.35 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0015	.0018	.0022	
M	6	0.35 x D	0.35 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0012	.0015	.0018	
	1	0.35 x D	0.35 x D	300	–	380	240	–	304	210	–	266	IPT	.0018	.0023	.0027	
	2	0.35 x D	0.35 x D	200	–	260	160	–	208	140	–	182	IPT	.0015	.0018	.0022	
K	3	0.35 x D	0.35 x D	200	–	230	160	–	184	140	–	161	IPT	.0012	.0015	.0018	
	1	0.35 x D	0.35 x D	390	–	490	351	–	441	351	–	441	IPT	.0022	.0027	.0032	
	2	0.35 x D	0.35 x D	360	–	460	324	–	414	324	–	414	IPT	.0018	.0023	.0027	
N	3	0.35 x D	0.35 x D	360	–	430	324	–	387	324	–	387	IPT	.0015	.0018	.0022	
	1	0.35 x D	0.35 x D	1640	–	6560	1312	–	5248	984	–	3936	IPT	.0030	.0040	.0050	
	2	0.35 x D	0.35 x D	1640	–	4920	1312	–	3936	984	–	2952	IPT	.0024	.0032	.0040	
	3	0.35 x D	0.35 x D	1640	–	4920	1312	–	3936	984	–	2952	IPT	.0021	.0028	.0035	
	4	0.35 x D	0.35 x D	1310	–	2460	1048	–	1968	786	–	1476	IPT	.0021	.0028	.0035	
	5	0.35 x D	0.35 x D	820	–	3280	656	–	2624	492	–	1968	IPT	.0027	.0036	.0045	
	6	0.35 x D	0.35 x D	330	–	2460	264	–	1968	198	–	1476	IPT	.0030	.0040	.0050	
S	7	0.35 x D	0.35 x D	330	–	2460	264	–	1968	198	–	1476	IPT	.0021	.0028	.0035	
	1	0.35 x D	0.35 x D	160	–	300	128	–	240	96	–	180	IPT	.0018	.0023	.0027	
	2	0.35 x D	0.35 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0012	.0015	
	3	0.35 x D	0.35 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0012	.0015	
H	4	0.35 x D	0.35 x D	160	–	200	128	–	160	96	–	120	IPT	.0013	.0017	.0020	
	1	0.35 x D	0.35 x D	260	–	460	208	–	368	156	–	276	IPT	.0016	.0021	.0024	

Duo-Lock Modular Milling

■ XRDA • Inch

Material Group																		
		Corner Rounding		short		medium			long			Recommended feed per tooth (IPT = inch/th) for side milling (A).						
												D1 – Diameter						
				A		adapter reach												
						KCPM15			KCPM15							KCPM15		
Cutting Speed – vc SFM			Cutting Speed – vc SFM			Cutting Speed – vc SFM			frac.	3/8	1/2	5/8						
ap	ae	min		max	min		max	min		max	dec.	.375	.500	.625				
P	0	0.35 x D	0.35 x D	490	–	660	441	–	594	441	–	594	IPT	.0022	.0027	.0032		
	1	0.35 x D	0.35 x D	490	–	660	441	–	594	441	–	594	IPT	.0022	.0027	.0032		
	2	0.35 x D	0.35 x D	460	–	620	414	–	558	414	–	558	IPT	.0022	.0027	.0032		
	3	0.35 x D	0.35 x D	390	–	520	351	–	468	351	–	468	IPT	.0018	.0023	.0027		
	4	0.35 x D	0.35 x D	300	–	490	270	–	441	270	–	441	IPT	.0016	.0021	.0024		
	5	0.35 x D	0.35 x D	200	–	330	170	–	280.5	160	–	264	IPT	.0015	.0018	.0022		
M	6	0.35 x D	0.35 x D	160	–	250	136	–	212.5	128	–	200	IPT	.0012	.0015	.0018		
	1	0.35 x D	0.35 x D	300	–	380	240	–	304	210	–	266	IPT	.0018	.0023	.0027		
	2	0.35 x D	0.35 x D	200	–	260	160	–	208	140	–	182	IPT	.0015	.0018	.0022		
K	3	0.35 x D	0.35 x D	200	–	230	160	–	184	140	–	161	IPT	.0012	.0015	.0018		
	1	0.35 x D	0.35 x D	390	–	490	351	–	441	351	–	441	IPT	.0022	.0027	.0032		
	2	0.35 x D	0.35 x D	360	–	460	324	–	414	324	–	414	IPT	.0018	.0023	.0027		
N	3	0.35 x D	0.35 x D	360	–	430	324	–	387	324	–	387	IPT	.0015	.0018	.0022		
	1	0.35 x D	0.35 x D	1640	–	6560	1312	–	5248	984	–	3936	IPT	.0030	.0040	.0050		
	2	0.35 x D	0.35 x D	1640	–	4920	1312	–	3936	984	–	2952	IPT	.0024	.0032	.0040		
	3	0.35 x D	0.35 x D	1640	–	4920	1312	–	3936	984	–	2952	IPT	.0021	.0028	.0035		
	4	0.35 x D	0.35 x D	1310	–	2460	1048	–	1968	786	–	1476	IPT	.0021	.0028	.0035		
	5	0.35 x D	0.35 x D	820	–	3280	656	–	2624	492	–	1968	IPT	.0027	.0036	.0045		
S	6	0.35 x D	0.35 x D	330	–	2460	264	–	1968	198	–	1476	IPT	.0030	.0040	.0050		
	7	0.35 x D	0.35 x D	330	–	2460	264	–	1968	198	–	1476	IPT	.0021	.0028	.0035		
	1	0.35 x D	0.35 x D	160	–	300	128	–	240	96	–	180	IPT	.0018	.0023	.0027		
	2	0.35 x D	0.35 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0012	.0015		
H	3	0.35 x D	0.35 x D	80	–	130	64	–	104	48	–	78	IPT	.0010	.0012	.0015		
	4	0.35 x D	0.35 x D	160	–	200	128	–	160	96	–	120	IPT	.0013	.0017	.0020		
	1	0.35 x D	0.35 x D	260	–	460	208	–	368	156	–	276	IPT	.0016	.0021	.0024		