

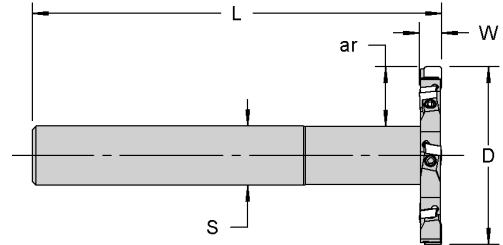
INDEXABLE KEYSEAT CUTTERS




KS Series



- Designed for narrow width slotting, grooving, keyseat cutting, and back facing
- Staggered teeth and positive rakes
- Precision ground inserts with wiper flats
- Tool can be offset to increase the width of the slot
- Two indexes per insert
- Special sizes can be quoted
- Cutter bodies and inserts made in the USA

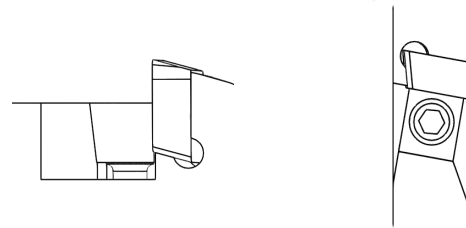


Diameter D	Part Number	Dimensions (inches)				No. of Inserts		Insert	Standard Components	
		W	S	L	ar	Total	Eff.		Wedge	Screw
0.88	KS-010	0.188	0.50	3.25	0.19	4	2	KDC-010	3W000	3DS312
	KS-020	0.250	0.50	3.25	0.19	4	2			
1.00	KS-030	0.188	0.50	3.50	0.25	4	2			
	KS-040	0.250	0.50	3.50	0.25	4	2			
1.25	KS-050	0.188	0.50	3.50	0.38	6	3			
	KS-060	0.250	0.50	3.50	0.38	6	3			
1.50	KS-070	0.188	0.50	3.50	0.50	8	4			
	KS-080	0.250	0.50	3.50	0.50	8	4			
2.00	KS-090	0.188	0.50	3.50	0.75	8	4			
	KS-100	0.250	0.50	3.50	0.75	8	4			

Size	Part Number	Thickness	Clearance Angle	Corner Radius	Coatings				Image
					None	TiCN	TiN	TiAlN	
KDC	KDC-010	0.078	15°	0.010	•	○	○	•	

Loading Inserts

- Make sure all surfaces are clean.
- Insert the indexable insert into the pocket as shown in the diagram. The wedge must be loose for the insert to fit. If necessary, loosen the wedge using the differential screw.
- Before tightening the wedge, press on the insert to make sure that its bottom and sides are in contact with their seating surfaces.
- Continue to press on the insert while tightening the wedge screw.



Indexing Inserts

- Inserts can be indexed to opposite hand stations. They cannot be indexed in the same pocket.
- Index the inserts before excessive wear occurs. Excessive wear or chipping can cause poor positioning of the insert when indexing.

