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ISO TOOLS.....	507
QCMT (릭 세인지 고압용 TOOLS)....	516
KM (릭 체인지 TOOLS)	523
KX618 (6코! INSERTS).....	528



PRECISION SMALL PARTS
TURNING TOOLS CATALOG

ISO Inserts With Precision Lapping



JF INSERT Low Cutting Resistance, Good Chip Breaking Capability

Material	Recommended	Subsidiary	Applicable
P Soft steel	●	○	□
Carbon steel/alloy steel	●	○	□
M Martensitic	●	○	□
Austenitic	●	○	□
K Grey Cast Iron	●	○	□
Ductile Cast Iron	●	○	□
N Nonferrous	●	○	□
G Heat Resisting Alloy	●	○	□
Titanium Alloy	●	○	□
H Hardened Materials	●	○	□

Shape	Type	Coated				
		MB/BN	K/AlTiS	HA/SD	KH/ST	KO/NO
DCGT	0702005MPN-JF	●	●	●	●	●
	070201MPN-JF	●	●	●	●	●
	070202MPN-JF	●	●	●	●	●
VBGT	1103005MPN-JF	●	●	●	●	●
	110301MPN-JF	●	●	●	●	●
	110302MPN-JF	●	●	●	●	●
	110304MPN-JF	●	●	●	●	●
	110305MPN-JF	●	●	●	●	●
VCQT	110301MPN-JF	●	●	●	●	●
	110302MPN-JF	●	●	●	●	●
	110304MPN-JF	●	●	●	●	●
	110305MPN-JF	●	●	●	●	●
	110301MPN-JF	●	●	●	●	●
VPGT	110302MPN-JF	●	●	●	●	●
	110304MPN-JF	●	●	●	●	●

● Standard Stock

JF INSERT Low Cutting Resistance, Good Chip Breaking Capability

Material	Recommended	Subsidiary	Applicable
P Soft steel	●	○	□
Carbon steel/alloy steel	●	○	□
M Martensitic	●	○	□
Austenitic	●	○	□
K Grey Cast Iron	●	○	□
Ductile Cast Iron	●	○	□
N Nonferrous	●	○	□
G Heat Resisting Alloy	●	○	□
Titanium Alloy	●	○	□
H Hardened Materials	●	○	□

Shape	Type	Coated				
		MB/BN	K/AlTiS	HA/SD	KH/ST	KO/NO
DCGT	0702005MFN-JF	●	●	●	●	●
	070201MFN-JF	●	●	●	●	●
	070202MFN-JF	●	●	●	●	●
VBGT	1103005Mh-N-JF	●	●	●	●	●
	110301MFN-JF	●	●	●	●	●
	110302MFN-JF	●	●	●	●	●
	110304MFN-JF	●	●	●	●	●
	110305MFN-JF	●	●	●	●	●
VCQT	110301MFN-JF	●	●	●	●	●
	110302MFN-JF	●	●	●	●	●
	110304MFN-JF	●	●	●	●	●
	110305MFN-JF	●	●	●	●	●
	110301MFN-JF	●	●	●	●	●
VPGT	110302MFN-JF	●	●	●	●	●
	110304MFN-JF	●	●	●	●	●

● Standard Stock

RF INSERT High Rigidity, Big Cutting Depth, Outstanding Surface Finish

Material	Recommended	Subsidiary	Applicable
P Soft steel	●	○	□
Carbon steel/alloy steel	●	○	□
M Martensitic	●	○	□
Austenitic	●	○	□
K Grey Cast Iron	●	○	□
Ductile Cast Iron	●	○	□
N Nonferrous	●	○	□
G Heat Resisting Alloy	●	○	□
Titanium Alloy	●	○	□
H Hardened Materials	●	○	□

Shape	Type	Coated				
		MB/BN	K/AlTiS	HA/SD	KH/ST	KO/NO
VBGT	1103008MPR-RF	●	●	●	●	●
	110301MPR-RF	●	●	●	●	●
	110302MPR-RF	●	●	●	●	●
VCGT	1103008Mh-RF	●	●	●	●	●
	110301MPR-RF	●	●	●	●	●
	110302MPR-RF	●	●	●	●	●
	110308MPR-RF	●	●	●	●	●
	110302MPR-RF	●	●	●	●	●
VPGT	110301MPR-RF	●	●	●	●	●
	110302MPR-RF	●	●	●	●	●

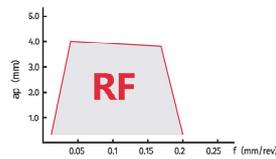
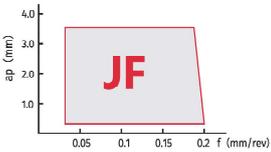
● Standard Stock

RF INSERT High Rigidity, Big Cutting Depth, Outstanding Surface Finish

Material	Recommended	Subsidiary	Applicable
P Soft steel	●	○	□
Carbon steel/alloy steel	●	○	□
M Martensitic	●	○	□
Austenitic	●	○	□
K Grey Cast Iron	●	○	□
Ductile Cast Iron	●	○	□
N Nonferrous	●	○	□
G Heat Resisting Alloy	●	○	□
Titanium Alloy	●	○	□
H Hardened Materials	●	○	□

Shape	Type	Coated				
		MB/BN	K/AlTiS	HA/SD	KH/ST	KO/NO
VBGT	1103008MFR-RF	●	●	●	●	●
	110301MFR-RF	●	●	●	●	●
	110302MFR-RF	●	●	●	●	●
VCGT	1103008Mh-RF	●	●	●	●	●
	110301MFR-RF	●	●	●	●	●
	110302MFR-RF	●	●	●	●	●
	110308MFR-RF	●	●	●	●	●
	110302MFR-RF	●	●	●	●	●
VPGT	110301MFR-RF	●	●	●	●	●
	110302MFR-RF	●	●	●	●	●

● Standard Stock



Insert Grades

Grades	Symbols of Grades	machinable Materials
P-Type First Choice	KPM30N	Soft iron, Low Carbon Steel, Alloy Steel, Stainless Steel, Copper
M-Type First Choice	KXM15S	Stainless Steel, Titanium Alloy, Heat Resisting Alloy
All-Purpose Insert Series	KH1G10M	Soft iron, Low Carbon Steel, Alloy Steel, Stainless Steel, Titanium Alloy, Heat Resisting Alloy, Hardened Materials, Cast Iron
G-Type First Choice	KMG20	Titanium Alloy, Stainless Steel, Heat Resisting Alloy
N-Type First Choice	KCN10D (DLC Coated)	Copper, Aluminum, Magnesium, Zinc
N-Type First Choice	KCN10 (without Coating)	Copper, Aluminum, Magnesium, Zinc

Recommend Application Parameter

Precision Lapping Standard Inserts

Machined Materials	Carbon Steel/ Alloy Steel	Stainless Steel	Cast Iron	Heat Resisting Alloy/ Titanium Alloy	Nonferrous		
Insert Grades	KPM30N	KXM15S	KH1G10M	KXM15S	KMG20	KCN10D	KCN10
Cutting Speed Vc (m/min)	60-180	60-180	60-130	80-200	30-60	30-60	240-450 150-300

Precision Lapping Standard Inserts

Geometry	SF	PF	CF	JF	RF	KDC	AF
Cutting Depth Ap(mm)	0.05-3.5	0.05-2.5	0.02-3.0	0.05-3.5	0.05-4.0	0.05-5.0	0.2-3.0
Feeding Speed f (mm/rev)	0.02-0.2	0.02-0.18	0.02-0.15	0.02-0.2	0.02-0.2	0.1-0.2	0.05-0.2

QCMT SERIES

Quick Change Modular Turning Tools



Splitted Structure Design

V-shape Locating Slot Design

Precision Locating

Strong Inner Cooling System

Quick Change Modular Turning Tools

Symbols of QCMT and KM Tools

KM - KM Series	10 - 10 Handle				F: 80		JCT-With Inner Cooling
QCMT - QCMT Series	12 - 12 Handle				H: 100		Without Inner Cooling
Series	Tool Size	-	Tool Height	Tool Width	Tool Length	-	With Inner Cooling
QCMT	12	-	12	12	F	-	JCT

Symbols of ISO Standard Cutting Heads

KM - KM Series	10 - 10 Handle					B: 5'														
QCMT - QCMT Series	12 - 12 Handle																			
Series	Head Size	-	Screw Clamping	Insert Shape	Entering Angle	Clearance Angle	Insert Direction	Edge Length	-	With Inner Cooling	-	Others								
QCMT	12	-	S	V	J	C	R	11	-	JCT	-	P								

Symbols of ISO-Y axis Cutting Heads

KM - KM Series	10 - 10 Handle					B: 5'														
QCMT - QCMT Series	12 - 12 Handle																			
Series	Head Size	-	Y axis	-	Screw Clamping	Insert Shape	Entering Angle	Clearance Angle	Insert Direction	Edge Length	-	With Inner Cooling	-	Others						
QCMT	12	-	Y	-	S	V	J	C	R	11	-	JCT	-	P						

Symbols of KX618 Cutting Heads

KM - KM Series	10 - 10 Handle																			
QCMT - QCMT Series	12 - 12 Handle																			
Series	Head Size	-	Kx618 Insert		Cutting Heads Direction	-	With Inner Cooling	-	Others											
QCMT	12	-	KX618		R	-	JCT	-	P											

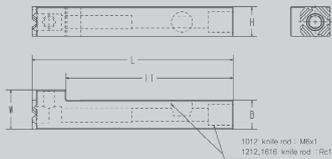
Symbols of KS12 Cutting Heads

KM - KM Series	10 - 10 Handle																			
QCMT - QCMT Series	12 - 12 Handle																			
Series	Head Size	-	Ks12 Insert		Cutting Heads Direction	-	With Inner Cooling	-	Others											
QCMT	12	-	KS12		R	-	JCT	-	P											

Symbols of KS1 Cutting Heads

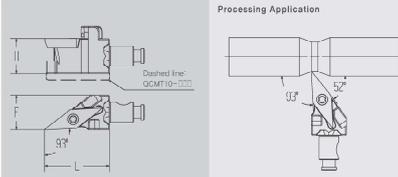
KM - KM Series	10 - 10 Handle																			
QCMT - QCMT Series	12 - 12 Handle																			
Series	Head Size	-	Ks16 Insert		Cutting Heads Direction	-	With Inner Cooling	-	Others											
QCMT	12	-	KST16		R	-	JCT	-	P											

Turning-Inner Cooling Modular Tools



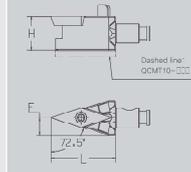
Type	Size					Accessories	
	H	B	W	L	L1	Screw	Wrench
QCMT10-1012F-JCT	10	12	16	80	67	KS-6006-HS-P0.5	KW-LH2
QCMT12-1212F-JCT	12	12	10	60	07	KG 5007 TO IP	KW IP10
QCMT12-1212H-JCT	12	12	16	100	87		
QCMT16-1616F-JCT	16	16	18	80	67	KS-R030-HS-H1 / 2	KW-LH3
QCMT16-1616H-JCT	16	16	18	100	87		

V-shape Cutting Heads



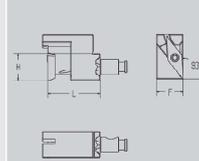
Type	Size			Accessories		Corresponding Insert
	L	H	F	Screw	Wrench	
UCM110-SVJB %/11-JCT-P	22	10	16	KS-2503-T	KW-T8	VB□□1103□□
QCMT12-SVJB %/11-JCT-P	22	12	16			
QCMT10-SVJD %/11-JCT-P	23	10	10	KS-2503-T	KW-T8	VC□□1103□□
QCMT10-SVIC %/11-JCT-P	22	10	16			
QCMT12-SVIC %/11-JCT-P	22	12	16	KS-2503-T	KW-T8	VC□□1103□□
QCMT16-SVIC %/11-JCT-P	23	16	16			
QCMT10-SVIP %/11-JCT-P	22	10	16	KS-2503-I	KW-I8	VP□□1103□□
QCMT12-SVIP %/11-JCT-P	22	12	16			
QCMT16-SVIP %/11-JCT-P	23	16	16			

V-shape Cutting Heads



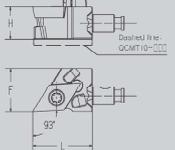
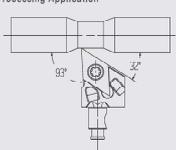
Type	Size			Accessories		Corresponding Insert
	L	H	F	Screw	Wrench	
QCMT10-SVBN11-JCT-P	22	10	5	KS-2503-T	KW-T8	VB□□1103□□
QCMT12-SVBN11-JCT-P	22	12	0			
QCMT16-SVBN11-JCP-P	23	16	8	KS-2503-T	KW-T8	VC□□1103□□
QCMT10-SVVCN11-JCT-P	22	10	5			
QCMT12-SVVCN11-JCT-P	22	12	6	KS-2503-T	KW-T8	VC□□1103□□
QCMT16-SVVCN11-JCP-P	23	16	8			

V-shape Y-axis Cutting Heads

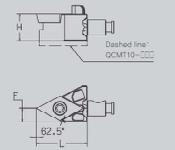
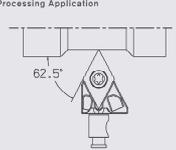


Type	Size			Accessories		Corresponding Insert
	L	H	F	Screw	Wrench	
QCMT10-Y-SVJCR11-JCT-P	23	10	16	KS-2503-I	KW-I8	VC□□1103□□
QCMT12-Y-SVJCR11-JCT-P	23	12	16			
QCMT16-Y-SVJCR11-JCT-P	23	16	16			

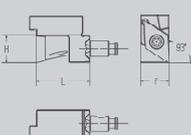
D-shape Cutting Heads

						
	Size			Accessories		
Type	L	H	F	Screw	Wrench	Corresponding Insert
QCMT10-SDJC%/L11-JCT-P	22	10	16	KS-4008-T	KW-T15	DC□□11T3□□
QCMT12-SDJC%/L11-JCT-P	22	12	16			
QCMT16-SDJC%/L11-JCT-P	23	16	16			

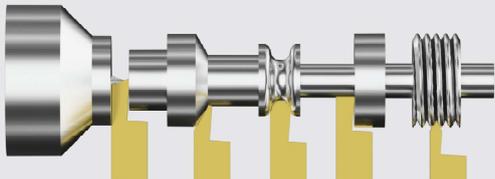
D-shape Cutting Heads

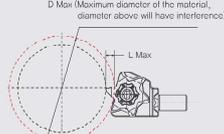
						
	Size			Accessories		
Type	L	H	F	Screw	Wrench	Corresponding Insert
QCMT10-SDNCN11-JCT-P	22	10	5	KS-4008-T	KW-T15	DC□□11T3□□
QCMT12-SDNCN11-JCT-P	22	12	6			
QCMT16-SDNCN11-JCT-P	23	16	8			

D-shape Y-axis Cutting Heads

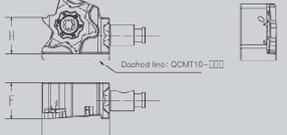
						
	Size			Accessories		
Type	L	H	F	Screw	Wrench	Corresponding Insert
QCMT10-Y-SDJCR11-JCT-P	23	10	16	KS-4008-T	KW-T15	DC□□11T3□□
QCMT12-Y-SDJCR11-JCT-P		12	16			
QCMT16-Y-SDJCR11-JCT-P		16	16			

KDC Cutting Heads

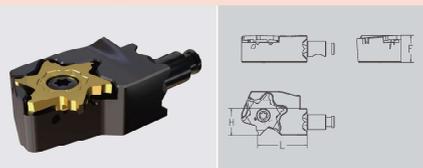
					
<p>Parting Back-turning Profiling Grooving Threading</p>					
<p>■ Notice</p> <p>1. Maximum Diameter of parting is 7mm</p> <p>2. Maximum Diameter of parting is 3.5MM, Groove depth varies according to the diameter of the material, please refer to the figure below</p>					

<p>Dmax</p>	32	42	51	65	100	
	Lmax	3.5	3.3	3.2	3.0	

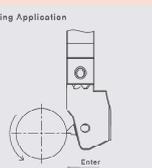
KX618 Cutting Heads

						
	Size			Accessories		
Type	L	H	F	Screw	Wrench	Corresponding Insert
QCMT10-KX618R-JCT-P	22	10	16	KS-4008-T	KW-T15	KX618L/R□□
QCMT12-KX618R-JCT-P		12	16			
QCMT16-KX618R-JCT-P		16	16			

KX618-Y axis Cutting heads



Processing Application



Type	Size			Accessories		Corresponding Insert
	L	H	F	Screw	Wrench	
QCMT12-Y-KX618R-ICKT-P	18.5	12	16	K5-008-T	KW-T15	KX618R/RTT



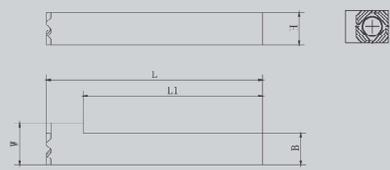
KM
Economical quick change modular turning tools

FEATURES AND ADVANTAGES



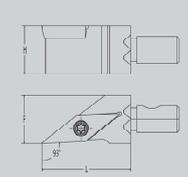
- By splitting the head and holder, one holder for multiple cutting heads according to need becomes possible
- Standardized and located once assembled, making the operation quick and easy

Turning-Modular tool holders

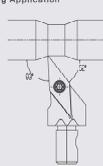


Type	Size					Accessories	
	H	B	W	L	L1	Screw	Wrench
KM10-1012F	10	12	10	00	07	KG-4000-1G-P0.5	KW-LI2
KM12-1212H	12	12	16	80	67	KS-5007-TS-IP	KW-IP10
KM12-1212H	12	12	16	100	87		
KM16-1616F	16	16	18	80	67	KS-0009-IG-P0.75	KW-LI3
KM16-1616H	16	16	18	100	87		

V-shape Cutting Heads

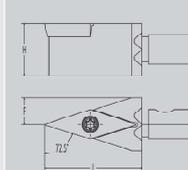


Processing Application

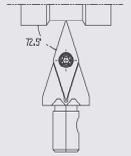


Type	Size			Accessories		Corresponding Insert
	L	H	F	Screw	Wrench	
KM10-SVJB 9/11	22	10	12	KS-2503-T	KW-T0	V□□110□□
KM12-SVJD 9/11		12	12			
KM16-SVJB 9/11	23	16	16	KS-2503-T	KW-T8	V□□110□□
KM10-SVJC 9/11	22	10	12			
KM12-SVJC 9/11	23	12	12	KS-2503-T	KW-T8	V□□110□□
KM16-SVJC 9/11		16	16			
KM10-SVJP 9/11	22	10	12	KS-2503-T	KW-T8	V□□110□□
KM12-SVJP 9/11		12	12			
KM16-SVJP 9/11	23	16	16	KS-2503-T	KW-T8	V□□110□□
KM10-SVJP 9/11	22	10	12			

Turning-Modular tool holders

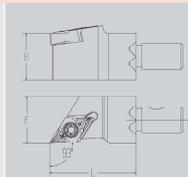


Processing Application

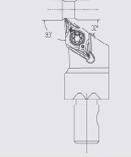


Type	Size			Accessories		Corresponding Insert
	L	H	F	Screw	Wrench	
KM10-SVVDN-11	22	10	0	KS-2503-T	KW-T8	V□□110□□
KM12-SVVDN-11		12	6			
KM16-SVVDN-11	23	16	8	KS-2503-T	KW-TR	V□□110□□
KM10-SVVCN-11	22	10	6			
KM12-SVVCN-11	23	12	6	KS-2503-T	KW-TR	V□□110□□
KM16-SVVCN-11		16	0			

KDC Cutting Heads

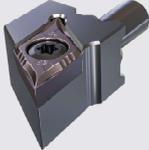
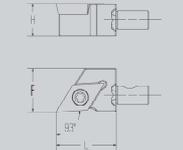
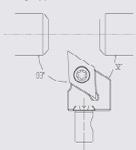


Processing Application

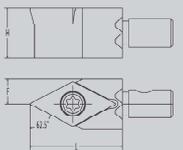
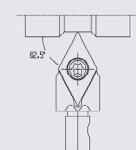


Type	Size			Accessories		Corresponding Insert
	L	H	F	Screw	Wrench	
KM10-SDJXR-07	22	10	12	KG-2504-T	KW-T0	DXGJ 0700 □□□□
KM12-SDJXR-07		12	12			
KM16-SDJXR-07	23	16	16	KS-4008-T	KW-T15	DXGJ 1104 □□□□
KM10-SDJXR-11	22	10	10			
KM12-SDJXR-11	23	12	16	KS-4008-T	KW-T15	DXGJ 1104 □□□□
KM16-SDJXR-11		16	16			

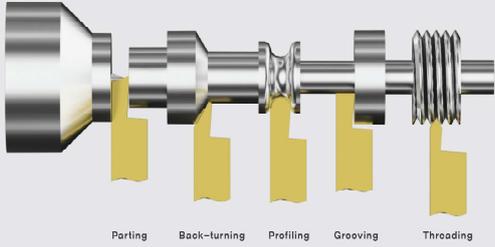
D-shape Cutting Heads

						
	Type	Size			Accessories	
KM10-SDJC ϕ _L -11	L	H	F	Screw	Wrench	DC□□11T□□□
KM12 ODJC ϕ _L 11	22	10	16	KS-4008-T	KW-T15	
KM16-SDJC ϕ _L -11	23	12	16			

D-shape Cutting Heads

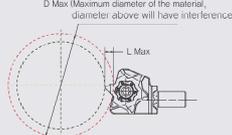
						
	Type	Size			Accessories	
KM10-SDNCN-11	L	H	F	Screw	Wrench	DC□□11T□□□
KM12-SDNCN-11	22	10	6	KS-4008-T	KW-T15	
KM16-SDNCN-11	23	12	8			

Processing Application of KX618

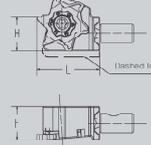


Notice

- Maximum Diameter of parting is 7mm
- Maximum Diameter of parting is 3.5MM, Groove depth varies according to the diameter of the material, please refer to the figure below

Dmax	32	42	51	65	100	
Lmax	3.5	3.3	3.2	3.0	2.5	

KX618 Cutting Heads

						
	Type	Size			Accessories	
KM10-KX618K	L	H	F	Screw	Wrench	KX618□R□□
KM12-KX618R	22	10	12	KS-4008-T	KW-T15	
KM16-KX618R	23	12	12			

KX618

KX618 STABLE CLAMPING 6 EGES SERIES



6 Cutting Edges

Much Economical



strengthened zero positioning slot

Stable clamping Stable Cutting



Multiple tools for different purposes

meet different needs of processing

Stable Clamping 6 Heads Tools

KX618

stable clamping 6 heads series



KOYIN CUT

FEATURES AND ADVANTAGES



6 Cutting Edges

Each insert has 6 cutting edges, its cutting edges is as twice as triangular inserts



Multiple tools for different purposes

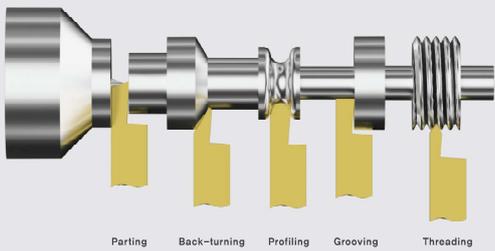
available with: grooving, threading, back-turning, parting, circular grooving and etc.



strengthened zero positioning slot

*** Shape clamping to make it stable

Processing Applications



Parting Back-turning Profiling Grooving Threading

Notice

1. Maximum Diameter of parting is 7mm
2. Maximum Diameter of parting is 3.5MM, Groove depth varies according to the diameter of the material, please refer to the figure below

Dmax	32	42	51	65	100
Lmax	3.5	3.3	3.2	3.0	2.5

Symbols of KX618 Grooving Tools

Series	Insert Type	Insert Direction	edge width	effective cutting depth	Nose Radius
KX618	G	R	125	300	005

Grooving tools

Processing Application	Shape	Type	Size		PVD Coated Cemented Carbide						
			W	L	NP	KXV158	KH101M	KH320	KCN100	KCN10	
P Soft steel Carbon steel/alloy steel	[Diagram]	KX618GR 050-150-005	0.5	1.5	0.05	◆	◇	◆	◆	◆	◆
			KX618GR 070-150-005			0.7	◆	◇	◆	◆	◆
M Martensitic Austenitic	[Diagram]	KX618GR 075-150-005	0.75	2.0	0.05	◆	◇	◆	◆	◆	◆
			KX618GR 070-200-005			0.7	◆	◇	◆	◆	◆
K Grey Cast Iron Ductile Cast Iron	[Diagram]	KX618GR 075-200-005	0.75	2.0	0.05	◆	◇	◆	◆	◆	◆
			KX618GR 080-200-005			0.8	◆	◇	◆	◆	◆
N Nonferrous	[Diagram]	KX618GR 090-200-005	0.9	2.0	0.05	◆	◇	◆	◆	◆	◆
			KX618GR 100-200-005			1.0	◆	◇	◆	◆	◆
S Heat-Resisting Alloy Titanium Alloy	[Diagram]	KX618GR 100-200-010	1.0	2.0	0.1	◆	◇	◆	◆	◆	◆
			KX618GR 110-200-005			1.1	◆	◇	◆	◆	◆
H Hardened Materials	[Diagram]	KX618GR 110-200-010	1.1	2.0	0.1	◆	◇	◆	◆	◆	◆
			KX618GR 120-200-005			1.2	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 125-200-005	1.25	2.0	0.1	◆	◇	◆	◆	◆	◆
			KX618GR 130-200-010			1.3	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 140-200-010	1.4	2.0	0.1	◆	◇	◆	◆	◆	◆
			KX618GR 140-200-020			1.4	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 150-200-010	1.5	2.0	0.1	◆	◇	◆	◆	◆	◆
			KX618GR 150-200-020			1.5	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 160-200-010	1.6	2.0	0.1	◆	◇	◆	◆	◆	◆
			KX618GR 160-200-020			1.6	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 170-200-010	1.7	2.0	0.1	◆	◇	◆	◆	◆	◆
			KX618GR 170-200-020			1.7	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 175-200-010	1.75	2.0	0.1	◆	◇	◆	◆	◆	◆
			KX618GR 175-200-020			1.75	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 100-300-005	1.0	3.0	0.05	◆	◇	◆	◆	◆	◆
			KX618GR 100-300-010			1.0	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 110-300-005	1.1	3.0	0.05	◆	◇	◆	◆	◆	◆
			KX618GR 110-300-010			1.1	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 120-300-005	1.2	3.0	0.05	◆	◇	◆	◆	◆	◆
			KX618GR 120-300-010			1.2	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 125-300-005	1.25	3.0	0.05	◆	◇	◆	◆	◆	◆
			KX618GR 125-300-010			1.25	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 130-300-010	1.3	3.0	0.1	◆	◇	◆	◆	◆	◆
			KX618GR 130-300-020			1.3	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 140-300-010	1.4	3.0	0.1	◆	◇	◆	◆	◆	◆
			KX618GR 140-300-020			1.4	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 150-300-010	1.5	3.0	0.1	◆	◇	◆	◆	◆	◆
			KX618GR 150-300-020			1.5	◆	◇	◆	◆	◆
[Diagram]	[Diagram]	KX618GR 160-300-010	1.6	3.0	0.1	◆	◇	◆	◆	◆	◆
			KX618GR 160-300-020			1.6	◆	◇	◆	◆	◆

shape Right Handed Tool	Type	Size			PVD Coated Cemented Carbide					
		W	L	R	KX618N	KX618S	KX618M	KX618K	KX618N	KX618S
	KX618GR 170-300-010	1.7	0.0	0.1	•	•	•	•	•	•
	KX618GR 170-300-020			0.2	•	•	•	•	•	•
	KX618GR 175-300-010			0.1	•	•	•	•	•	•
	KX618GR 175-300-020	1.75	0.0	0.2	•	•	•	•	•	•
	KX618GR 180-300-010			0.1	•	•	•	•	•	•
	KX618GR 180-300-020	1.8	0.0	0.2	•	•	•	•	•	•
	KX618GR 190-300-010			0.1	•	•	•	•	•	•
	KX618GR 190-300-020	1.9	0.0	0.2	•	•	•	•	•	•
	KX618GR 200-300-010			0.1	•	•	•	•	•	•
	KX618GR 200-300-020	2.0	0.0	0.2	•	•	•	•	•	•
	KX618GR 210-300-010			0.1	•	•	•	•	•	•
	KX618GR 210-300-020	2.1	0.0	0.2	•	•	•	•	•	•
	KX618GR 220-300-010			0.1	•	•	•	•	•	•
	KX618GR 220-300-020	2.2	0.0	0.2	•	•	•	•	•	•
	KX618GR 230-300-010			0.1	•	•	•	•	•	•
	KX618GR 230-300-020	2.3	0.0	0.2	•	•	•	•	•	•
	KX618GR 240-300-010			0.1	•	•	•	•	•	•
	KX618GR 240-300-020	2.4	0.0	0.2	•	•	•	•	•	•
	KX618GR 250-300-010			0.1	•	•	•	•	•	•
	KX618GR 250-300-020	2.5	0.0	0.2	•	•	•	•	•	•
	KX618GR 150-350-010			1.5	3.5	0.1	•	•	•	•
	KX618GR 150-350-020	0.2	•			•	•	•	•	•
	KX618GR 160-350-010	1.6	3.5	0.1	•	•	•	•	•	•
	KX618GR 160-350-020			0.2	•	•	•	•	•	•
	KX618GR 170-350-010	1.7	3.5	0.1	•	•	•	•	•	•
	KX618GR 170-350-020			0.2	•	•	•	•	•	•
	KX618GR 175-350-010	1.75	3.5	0.1	•	•	•	•	•	•
	KX618GR 175-350-020			0.2	•	•	•	•	•	•
	KX618GR 180-350-010	1.8	3.5	0.1	•	•	•	•	•	•
	KX618GR 180-350-020			0.2	•	•	•	•	•	•
KX618GR 190-350-010	1.9	3.5	0.1	•	•	•	•	•	•	
KX618GR 190-350-020			0.2	•	•	•	•	•	•	
KX618GR 200-350-010	2.0	3.5	0.1	•	•	•	•	•	•	
KX618GR 200-350-020			0.2	•	•	•	•	•	•	
KX618GR 210-350-010	2.1	3.5	0.1	•	•	•	•	•	•	
KX618GR 210-350-020			0.2	•	•	•	•	•	•	
KX618GR 220-350-010	2.2	3.5	0.1	•	•	•	•	•	•	
KX618GR 220-350-020			0.2	•	•	•	•	•	•	
KX618GR 230-350-010	2.3	3.5	0.1	•	•	•	•	•	•	
KX618GR 230-350-020			0.2	•	•	•	•	•	•	
KX618GR 240-350-010	2.4	3.5	0.1	•	•	•	•	•	•	
KX618GR 240-350-020			0.2	•	•	•	•	•	•	
KX618GR 250-350-010	2.5	3.5	0.1	•	•	•	•	•	•	
KX618GR 250-350-020			0.2	•	•	•	•	•	•	

Grades: ♦ Recommended ◊ Suitable ◊ Applicable ● Standard Stock

Symbols of KX618 Threading Tools

Series	Insert Type	Insert Direction	Tip Width	Edge Position
KX618	T	R	125	A

Threading Tools

shape Right Handed Tool	Type	Size				PVD Coated Cemented Carbide							
		F	A	R	Pitch (MM)	Teeth per inch (TPI)	KX618N	KX618S	KX618M	KX618K	KX618N	KX618S	
	KX618TR 040-A	0.4	60°	0.05	0.2-0.75	127-34	•	•					
		KX618TR 080-A	0.8	60°	0.05	0.4-1.25	63-21	•	•				
	KX618TR 040-D		0.4	60°	0.05	0.2-0.75	127-34	•	•				
		KX618TR 080-B	0.8	60°	0.05	0.4-1.25	63-21	•	•				
	KX618TR 125-N		1.25	60°	0.1	1.0-1.5	25-17	•	•				

Grades: ♦ Recommended ◊ Suitable ◊ Applicable ● Standard Stock

ISO TOOLS

QCMT(릭 체인저 고압용 TOOLS)

KM(릭 체인저 TOOLS)

KX618(고하 INSERTS)

Stable Clamping 6 Heads Tools

Symbols of KX618 Back-turning tools

KX618: KX618 Series	B: Back-turning	R: right handed	005: R0.05 010: R0.1 015: R0.15	-	with chipbreaking slot
Series	Insert Type	Insert Direction	Nose Radius		
KX618	B	R	005	-	S

Back-turning tools

processing diagram	Material	PVD Coated Cemented Carbide						
		KM100N	KM135	KH104	HM20	KCN100	KCN10	
shape Right Handed Tool	Type	Size			W	L	R	B
	KX618BR 005-S	0.3	3.5	<0.05	3.5			
	KX618BR 010-S			<0.1				
	KX618BR 015-S			<0.15				

Grades: ◆ Recommended ◇ Suitable ◊ Applicable ● Standard Stock

Symbols of KX618 Circular Grooving Tools

KX618: KX618 Series	R: Circular Grooving Tools	R: right handed	050: R0.5 125: R1.25	-	150: 1.5 200: 2.0 350: 3.5
Series	Insert Type	Insert Direction	Nose Radius		Effective cutting depth
KX618	R	R	050	-	200

Circular Grooving Tools

processing diagram	Material	PVD Coated Cemented Carbide					
		KM100N	KM135	KH104	HM20	KCN100	KCN10
shape Right Handed Tool	Type	Size			W	L	R
	KX618RR 035-150	0.7	1.5	0.35			
	KX618RR 050-200	1.0	2.0	0.5			
	KX618R-URU-ZUU	1.2		0.6			
	KX618RR 075-350	1.5		0.75			
	KX618RR 100-350	2.0	3.5	1.0			
	KX618RR 125-350	2.5		1.25			

Grades: ◆ Recommended ◇ Suitable ◊ Applicable ● Standard Stock

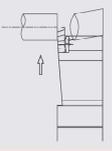
Symbols of KX618 flat parting tools

KX610: KX610 Series	C: parting tools	R: right handed	090: 0.5 125: 1.25	-	S: R0.03-R0.05 P: R0.00
Series	Insert Type	Insert Direction	Edge width		Nose Radius
KX618	C	R	125	-	S

symbols of KX618 parting tools with lead angle

KX618: KX618 Series	C: parting tools	R: right handed	090: 0.5 125: 1.25	200: 2.0 160: 1.6	R: with right lead angle	110: 1.1 L: with left lead angle	-	N: without chipbreaking slot and nose radius S: R0.03-R0.05 P: R0.00
Series	Insert Type	Insert Direction	edge width	lead angle	insert direction			Nose Radius/nose
KX618	C	R	125	-	16D	R	-	S

parting tools



P	Soft steel	◆	◇	◇	◇	◇	◇	◇	◇	◇
	Carbon steel/alloy steel	◆	◇	◇	◇	◇	◇	◇	◇	◇
M	Martensitic	◆	◇	◇	◇	◇	◇	◇	◇	◇
	Austenitic	◆	◇	◇	◇	◇	◇	◇	◇	◇
K	Gray Cast Iron	◆	◇	◇	◇	◇	◇	◇	◇	◇
	Ductile Cast Iron	◆	◇	◇	◇	◇	◇	◇	◇	◇
N	Nonferrous	◆	◇	◇	◇	◇	◇	◇	◇	◇
	Heat Resisting Alloy	◆	◇	◇	◇	◇	◇	◇	◇	◇
S	Titanium Alloy	◆	◇	◇	◇	◇	◇	◇	◇	◇
	Titanium Alloy	◆	◇	◇	◇	◇	◇	◇	◇	◇
H	Hardened Materials	◆	◇	◇	◇	◇	◇	◇	◇	◇

shape Right Handed Tool	Type	Size				PVD Coated Cemented Carbide					
		W	Maximum Diameter of parting DMax	R	D	KX618CR	KX618S	KX618DR	KX618P	KX618DR	KX618N
	KX618CR 050-S	0.5				◆	◆	◆	◆	◆	◆
	KX618CR 070-S	0.7	3			◆	◆	◆	◆	◆	
	KX618CR 100-S	1.0	0.03		0°	◆	◆	◆	◆	◆	
	KX618CR 125-G	1.25	0.05			◆	◆	◆	◆	◆	
	KX618CR 150-S	1.5	7			◆	◆	◆	◆	◆	
	KX618CR 100-P	1.0	3		0°	◆	◆	◆	◆	◆	
	KX618CR 125-P	1.25	0.08 ±0.01		0°	◆	◆	◆	◆	◆	
	KX618CR 150-P	1.5	7			◆	◆	◆	◆	◆	
	KX618CR 100-11DR-S	1.0	3		11°	◆	◆	◆	◆	◆	
	KX618CR 125-11DR-S	1.25	0.03		11°	◆	◆	◆	◆	◆	
	KX618CR 150-11DR-S	1.5	0.05			◆	◆	◆	◆	◆	
	KX618CR 100-11DR-P	1.0	3		16°	◆	◆	◆	◆	◆	
	KX618CR 125-11DR-P	1.25	0.08 ±0.01		16°	◆	◆	◆	◆	◆	
	KX618CR 150-11DR-P	1.5	7			◆	◆	◆	◆	◆	
	KX618CR 050-16DR-S	0.5				◆	◆	◆	◆	◆	
	KX618CR 070-16DR-S	0.7	3			◆	◆	◆	◆	◆	
	KX618CR 100-16DR-S	1.0	0.03		16°	◆	◆	◆	◆	◆	
	KX618CR 125-16DR-S	1.25	0.05			◆	◆	◆	◆	◆	
	KX618CR 150-16DR-S	1.5	7			◆	◆	◆	◆	◆	
	KX618CR 100-16DR-P	1.0	3		16°	◆	◆	◆	◆	◆	
	KX618CR 125-16DR-P	1.25	0.08 ±0.01		16°	◆	◆	◆	◆	◆	
	KX618CR 150-16DR-P	1.5	7			◆	◆	◆	◆	◆	
	KX618CR 070-20DR-N	0.7	3			◆	◆	◆	◆	◆	
	KX618CR 100-20DR-N	1.0			20°	◆	◆	◆	◆	◆	
	KX618CR 125-20DR-N	1.25	7			◆	◆	◆	◆	◆	
	KX618CR 150-20DR-N	1.5				◆	◆	◆	◆	◆	

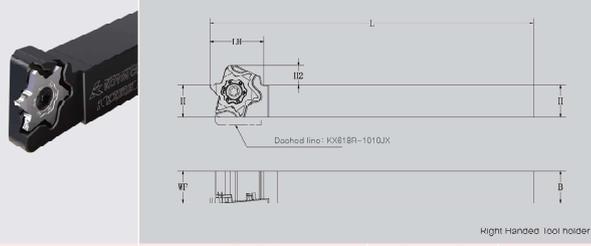
Grades: ◆ Recommended ◇ Suitable ◇ Applicable ◆ Standard Stock

Symbols of KX618 tool holders

KX618	R	-	12	12	JX
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M: 150
JK: 120
J: 110
H: 110

KX618 Tool holders

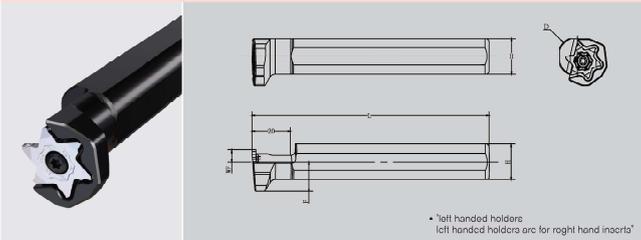


Type	Size(mm)						Accessories		Corresponding Insert
	H	B	L	LH	WF	H2	Secrw	Wrenth	
KX618R-1010JX	10	10	120	20	10	7	KS-4008-T	KW-T15	KX618DR □□□
KX618R-1212JX	12	12	120	20	12	7			
KX618R-1616JX	16	16	120	20	16	7			
KX618R-2020JX	20	20	120	20	20	7			
KX618R-2525M	25	25	150	20	25	7			

Tool holder for S-KX618-F

14: Diameter 14									
15: Diameter 15.875									
16: Diameter 16									
19: Diameter 19.125									
20: Diameter 20	M: 150								
22: Diameter 22	JX120								
25: Diameter 25	J: 110								
25.4: Diameter 25.4	H: 100								
S: Screw locking method				KX618: KX618 Series	L: Left handed			F: Used for cutting machine	
Locking method	Knife diameter	Tool Length	-	Series	Direction	-		Other	
S	20	JX	-	KX618	L	-		F	

Tool holder for S-KX618-F (socket holder for external machining)



Type	Size(mm)					Accessories		Corresponding insert
	D	H	WF	L	F	Screw	Wrench	
S14H-KX618L-F	14	13		100				
S16C-KX618L-F	16	15	6	95	15			
S19JX-KX618L-F	19.05	18		120				
S20JX-KX618L-F	20	19		120		KS-4008-T	KW-T15	KX618LJR LLLL
S22JX-KX618L-F	22	21		120				
S25H-KX618L-F	25	24	10	100	11			
S25.4JX-KX618L-F	25.4	24		120				

Recommend Application Parameter

KX618 SERIES								
Machined Materials	Carbon Steel Alloy Steel	Stainless Steel	Cast Iron	Heat Resisting Alloy/ Titanium Alloy	Nonferrous			
Insert Grades	KPMS0N	KXM1G3	KI-B10M	KI-B10M	KXM1G3	KMG20	KCN10D	KCN10
Cutting Speed Vc(m/min)	60-180	60-180	60-130	80-200	30-60	30-80	240-450	150-300
Edge Width of Grooving Tools	0.5-1.2	1.25-2.5						
Feeding Speedf(mm/rev)	0.02-0.06	0.03-0.07						
Threading Tools	Type A	Type B	Type N					
Cutting Depth Ap(mm)	0.02-0.05	0.02-0.05	0.03-0.08					
Back-turning tools								
Cutting Depth Ap(mm)	0.05-3.3							
Threading Tools f(mm/rev)	0.02-0.08							
parting tools								
edge width	0.5 1.0	1.25 1.5						
Feeding Speed f(mm/rev)	0.008-0.04	0.015-0.06						