



TOOL HOLDERS

BORING BAR FOR CNC MACHINE

MILLING AND CHUCKS

THREADING TOOLS AND CARBIDE INSERTS

SOLID CARBIDE TOOLS

Turning Tool Holders

Multi lock system

MCLNR/L



1616-H12 4040-S25
2020-K12
2525-M12
3232-P12
2525-M16
3232-P16
3232-P19
4040-R19

MCKNR/L



2020-K12
2525-M12
3232-P12
3232-P19

MCBNR/L



2020-K12
2525-M12
3232-P12
3232-P16
3232-P19

MCLNR/L



1616-H11
2020-K11
2525-M11
2020-K15
2525-M15
3225-P15
3232-P15

MDPNN



1616-H11
2020-K11
2525-M11
2020-K15
2525-M15
3232-P15

MTGNR/L



1616-H16
2020-K16
2525-M16
2525-M22

MTFNR/L



1616-H16
2020-K16
2525-M16
3232-P16
2525-M22
3232-P22

MTENN



2020-K16
2525-M16
3232-P16
4040-S16
2525-M22
3232-P22

MSSNR/L



2020-K12
2525-M12
3232-P12
2525-M15
3232-P15

MSDNN



1616-H12
2020-K12
2525-M12
3232-P12
2525-M15
3232-P15
3232-P19
4040-S19

MWLNR/L



1616-H06
2020-K06
2525-M06
1616-H08
2020-K08
2525-M08
3232-P08

MVJNR/L



1616-H16
2020-K16
2525-M16
3232-P16

Screw on system

SCLCR/L



1010-E06
1212-F09
1616-H09
2020-K09
2525-M09
2020-K12
2525-M12
3232-P12

SDQCR/L



1010-E07
1212-F07
1616-H07
1616-H11
2020-K11
2525-M11

SDNCN



0808-E07
1010-E07
1212-F07
1212-H11
1616-H11
2020-K11
2525-M11

SSSCR/L



1212-F09
1616-H09
2020-K09
2525-M09
2525-M12

SRDCN



1616-H08
2020-K08
2525-M08
1616-H10
2020-K10
2525-M10

SRGCR/L



1616-H08
2020-K08
2525-M08
1616-H10
2020-K10
2525-M10

Turning Tool Holders

SVJBR/L



1616-H11
2020-K11
1616-H16
2020-K16
2525-M16
3232-P16

SVQBR/L



1616-H16
2020-K16
2525-M16
3232-P16

SVVBN



1212-F11
1616-H11
2020-K11
2525-M11
1616-H16
2020-K16
2525-M16
3232-P16

Wedge clamp on system

WTJNR/L



1316-K16
1616-K16
2020-K16
2525-M16
3232-P16

WWLNR/L



2020-K08
2525-M08
3232-P08

Boring Bars

Multi lock system

MCLNR/L



S20Q-MCLNR/L12
S25R-MCLNR/L12
S32S-MCLNR/L12
S40T-MCLNR/L12
S45U-MCLNR/L12
S50U-MCLNR/L12
S60V-MCLNR/L12
S50U-MCLNR/L19

MCKNR/L



S20Q-MCKNR/L12
S25R-MCKNR/L12
S32S-MCKNR/L12
S40T-MCKNR/L12
S50U-MCKNR/L12

MDUNR/L



S25R-MDUNR/L15
S32S-MDUNR/L15
S40T-MDUNR/L15
S50U-MDUNR/L15

MDZNR/L



S25R-MDZNR/L15
S32S-MDZNR/L15
S40T-MDZNR/L15
S50U-MDZNR/L15

MTFNR/L



S20Q-MTFNR/L16
S25R-MTFNR/L16
S32S-MTFNR/L16
S40T-MTFNR/L16
S50U-MTFNR/L16
S40T-MTFNR/L22
S50U-MTFNR/L22

MTQNR/L



S20Q-MTQNR/L16
S25R-MTQNR/L16
S32S-MTQNR/L16
S40T-MTQNR/L16
S50U-MTQNR/L16

MSKNR/L



S20Q-MSKNR/L12
S25R-MSKNR/L12
S32S-MSKNR/L12
S40T-MSKNR/L12
S45U-MSKNR/L12
S50U-MSKNR/L12

MWLNR/L



S16N-MWLNR/L06
S20Q-MWLNR/L06
S25R-MWLNR/L06
S20Q-MWLNR/L08
S25R-MWLNR/L08
S32S-MWLNR/L08
S40T-MWLNR/L08

■ **Boring Bars**

MVUNR/L



S25R-MVUNR/L16
S32S-MVUNR/L16
S40T-MVUNR/L16
S50U-MVUNR/L16

MVQNR/L



S25R-MVQNR/L16
S32S-MVQNR/L16
S40T-MVQNR/L16
S50U-MVQNR/L16

Screw on system

SCLCR/L



S07K-SCLCR/L06 S16N-SCLCR/L09
S08K-SCLCR/L06 S20Q-SCLCR/L09
S08K-SCLCR/L06-A16 S25R-SCLCR/L09
S09K-SCLCR/L06-A16 S32S-SCLCR/L09
S10K-SCLCR/L06 S20Q-SCLCR/L12
S10K-SCLCR/L06-A16 S25R-SCLCR/L12
S12M-SCLCR/L06 S32S-SCLCR/L12
S12M-SCLCR/L09 S40T-SCLCR/L12
S14M-SCLCR/L09-A16

SCKCR/L



S08K-SCKCR/L06
S10K-SCKCR/L06
S12M-SCKCR/L06
S12M-SCKCR/L09
S16N-SCKCR/L09
S20Q-SCKCR/L09
S25R-SCKCR/L09

SDUCR/L



S10K-SDUCR/L07
S12M-SDUCR/L07
S16N-SDUCR/L07
S20Q-SDUCR/L11
S25R-SDUCR/L11
S32S-SDUCR/L11
S40T-SDUCR/L11
S50U-SDUCR/L11

SDQCR/L



S10K-SDQCR/L07
S12M-SDQCR/L07
S16N-SDQCR/L07
S20Q-SDQCR/L11
S25R-SDQCR/L11
S32S-SDQCR/L11

SDWCR/L



S12M-SDWCR/L07
S16N-SDWCR/L07
S20Q-SDWCR/L07
S20Q-SDWCR/L11
S25R-SDWCR/L11
S32S-SDWCR/L11

SDLCR/L



S08K-SDLCR/L07
S10K-SDLCR/L07
S12M-SDLCR/L07
S16N-SDLCR/L07
S20Q-SDLCR/L11
S25R-SDLCR/L11

STFCR/L



S08K-STFCR/L09 S25R-STFCR/L16
S10K-STFCR/L09 S32S-STFCR/L16
S12M-STFCR/L09 S40T-STFCR/L16
S10K-STFCR/L11 S50U-STFCR/L16
S12M-STFCR/L11
S16N-STFCR/L11
S20Q-STFCR/L11
S20Q-STFCR/L16

SSKCR/L



S12M-SSKCR/L09
S16N-SSKCR/L09
S20Q-SSKCR/L09
S25R-SSKCR/L09

SSSCR/L



S12M-SSSCR/L09
S16N-SSSCR/L09
S20Q-SSSCR/L09
S25R-SSSCR/L09
S32S-SSSCR/L09

SVUCR/L



S16N-SVUCR/L11
S20Q-SVUCR/L11
S20Q-SVUCR/L16
S25R-SVUCR/L16
S32S-SVUCR/L16
S40T-SVUCR/L16
S50U-SVUCR/L16

■ **Boring Bars**

SVQCR/L



S16N-SVQCR/L11
S20Q-SVQCR/L11
S20Q-SVQCR/L16
S25R-SVQCR/L16
S32S-SVQCR/L16
S40T-SVQCR/L16
S50U-SVQCR/L16

SVZBR/L



S16N-SVZBR/L11
S20Q-SVZBR/L11
S25R-SVZBR/L16
S32S-SVZBR/L16
S40T-SVZBR/L16
S50U-SVZBR/L16

■ **Threading Tool Holders**

SER/L



1010-H11	3232-P22
1212-H16	4040-S22
1616-H16	2525-M27
2020-K16	3232-P27
2525-M16	4040-S27
3232-P16	5050-T27
2525-M22	

SNR/L



0010K11	0020R16	0032S22
0012K11	0025R16	0040T22
0010K11-A16	0032S16	0050U22
0012K11-A16	0040T16	0040T27
0013M16	0050U16	
0016M16	0020Q22	
0020Q16	0025R22	

■ **Tool Holders For Grooving**

MGEHR/L



1616-1.5	1616-2.5	2020-4
2020-1.5	2020-2.5	2525-3
2525-1.5	2525-2.5	3232-4
1212-2	1616-3	2525-5
1616-2	2020-3	3232-5
2020-2	2525-3	
2525-2	3232-3	

MGIVR/L



2016-1.5	2520-2.5	3732-4
2520-1.5	2925-2.5	3125-5
2925-1.5	2520-3	3732-5
2016-2	3125-3	
2520-2	3732-3	
2925-2	2520-4	
2016-2.5	3125-4	

SGTR/L



1212H16C
1616H16C
2020K16C
2525M16C
2020K22C
2525M22C

ZQ



1616R/L-03
2020R/L-03
2525R/L-03
2020R/L-04
2525R/L-04

SMBB



1626
2026
2032
2526
2532
3232

SPB



226 532
326
426
526
232
332
432

INDEXABLE END MILL

AKT20S/30S



($\phi 10\sim\phi 63\text{mm}$)
($\phi 0.4\sim\phi 2.52\text{inch}$)
-insert
APXT11T3PDSR
APXT11312R
APXT1604PDSR
APKT1604PDFR

AMS20S/30S



($\phi 10\sim\phi 35\text{mm}$)
($\phi 0.4\sim\phi 1.375\text{inch}$)
-insert
APMT1135PDER
APMT1604PDER

FMRS4R/5R



($\phi 16\sim 35\text{mm}$)
($\phi 0.625\sim\phi 1.375\text{inch}$)
-insert
RPMT08T2
RPMT1003
RPMW1003

INDEXABLE MILLING CUTTER

AMC30S



($\phi 50\sim\phi 125\text{mm}$)
($\phi 2\sim\phi 5\text{inch}$)
-insert
APMT1604PDER
APKT1604PDFR
APXT1604PDSR

KM12



($\phi 50\sim\phi 125\text{mm}$)
($\phi 2\sim\phi 5\text{inch}$)
-insert
SEHT1204AFSN

FMRC5R/6R



($\phi 50\sim\phi 125$)
($\phi 2\sim\phi 5\text{inch}$)
-insert
RPMT10T3
RPMT1204

MICRO BORING BAR

BT40-SMH



Boring range
($\phi 6\sim\phi 20$)

BORING BITE



BB16-5S
BB16-7S
BB16-9S
BB16-11S
BB16-15S
BB16-19S

BT40-BKA



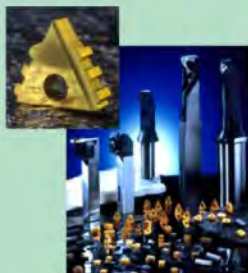
-Boring range
BT30 ($\phi 23\sim\phi 68$)
Bt40 ($\phi 23\sim\phi 140$)
Bt50 ($\phi 23\sim\phi 175$)

BT40-BCF



-Boring range
BT30 ($\phi 29.5\sim\phi 83$)
Bt40 ($\phi 29.5\sim\phi 141$)
Bt50 ($\phi 29.5\sim\phi 141$)

THREADING INSERTS



THE GROOVING INSERTS AS EXCLUSIVE USE

MGMN



1.5mm
2.0mm
2.5mm
3.0mm
4.0mm
5.0mm

SP



2.0mm
3.0mm
4.0mm
5.0mm

JTGR



0.50mm 1.95mm
0.75mm 2.00mm
1.00mm 2.20mm
1.15mm 2.50mm
1.20mm 2.75mm
1.25mm 3.00mm
1.50mm
1.75mm

■ CHATTER RESISTANT BORING BAR



Characteristic:

- A. The lightweight head with it's large dimple reduce chatter.
- B. Chip disposal properties are improved by having 2 channels for chip evacuation.
- C. Stable coolant is supplied even is in deep holes.

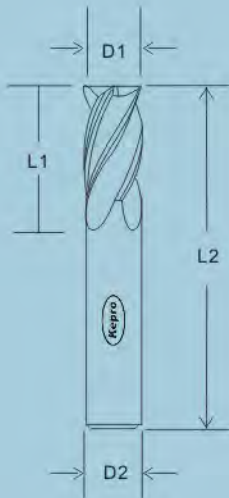
■ SINGLE ACTION TYPE



Characteristic:

- A. A simple, secure clamping system provides enhanced stability and clamping forces, ensures stable machining.
- B. This new clamping system prevents unexpected breakages to provide exceptional tool life.

2/3/4 Flutes
centre cutting
30° RHS/RHS



STANDARD SERIES

Tool No	Cutting Dia	Cutting Length	Over all Length	Shank dia
EMSD0100	1	4	38	3
EMSD0150	1.5	4	38	3
EMSD0200	2	4	38	3
EMSD0250	2.5	4	38	3
EMSD0300	3	14	38	3
EMSD0350	3.5	14	50	4
EMSD0400	4	14	50	4
EMSD0450	4.5	15	63	5
EMSD0500	5	19	63	5
EMSD0600	6	19	63	6
EMSD0700	7	19	63	7
EMSD0800	8	20	63	8
EMSD0900	9	22	63	9
EMSD0100	10	25	70	10
EMSD0110	11	25	76	11
EMSD0120	12	25	76	12
EMSD0140	14	31	89	14
EMSD0160	16	31	89	16
EMSD0180	18	38	101	18
EMSD0200	20	38	101	20
EMSD0220	22	38	101	22
EMSD0250	25	38	101	25

LONG SERIES

Long Series,	Square End Mill			
EMLS0300	3	25	76	3
EMLS0400	4	25	76	4
EMLS0500	5	25	76	5
EMLS0600	6	25	76	6
EMXL0600	6	38	101	6
EMLS0800	8	41	101	8
EMLS0100	10	45	101	10
EMLS0120	12	51	101	12

EXTRA LONG SERIES

Extra Long Series	Square End Mill			
EMXXLS0600	6	60	150	6
EMXLS 0800	8	60	150	8
EMXLS 0100	10	60	150	10
EMXLS 0120	12	75	150	12
EMXLS 0140	14	75	150	14
EMXLS 0160	16	75	150	16
EMXLS 0180	18	75	150	18
EMXLS 0200	20	75	150	20
EMXLS 0250	25	75	150	25

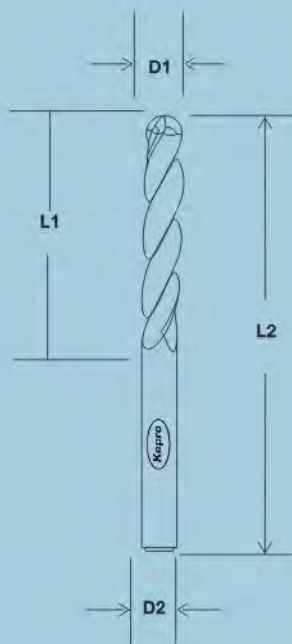
TOLERANCES FRACTION

ØD1	+0.0 -0.002"
ØD2	+0.0 -0.0001"/-0.0005"

TOLERANCES METRIC

Ø	D1 (h10) µm	D2 (h6) µm
3.6	+0/-48	+0/-8
6-10	+0/-58	+0/-9
10-18	+0/-70	+0/-11
18-30	+0/-84	+0/-13

2/3/4 Flutes
centre cutting
30° RHS/RHS



STANDARD SERIES

Tool No	Cutting Dia	Cutting Length	Over all Length	Shank dia
EMSD0100	1	4	38	3
EMSD0150	1.5	4	38	3
EMSD0200	2	4	38	3
EMSD0250	2.5	4	38	3
EMSD0300	3	14	38	3
EMSD0350	3.5	14	50	4
EMSD0400	4	14	50	4
EMSD0450	4.5	15	63	5
EMSD0500	5	19	63	5
EMSD0600	6	19	63	6
EMSD0700	7	19	63	7
EMSD0800	8	20	63	8
EMSD0900	9	22	63	9
EMSD0100	10	25	70	10
EMSD0110	11	25	76	11
EMSD0120	12	25	76	12
EMSD0140	14	31	89	14
EMSD0160	16	31	89	16
EMSD0180	18	38	101	18
EMSD0200	20	38	101	20
EMSD0220	22	38	101	22
EMSD0250	25	38	101	25

LONG SERIES

Long Series,	Ball Nose End Mill			
EMLS0300	3	25	76	3
EMLS0400	4	25	76	4
EMLS0500	5	25	76	5
EMLS0600	6	25	76	6
EMXL0600	6	38	101	6
EMLS0800	8	41	101	8
EMLS0100	10	45	101	10
EMLS0120	12	51	101	12

EXTRA LONG SERIES

Extra Long Series	Ball Nose End Mill			
EMXXLS0600	6	60	150	6
EMXLS 0800	8	60	150	8
EMXLS 0100	10	60	150	10
EMXLS 0120	12	75	150	12
EMXLS 0140	14	75	150	14
EMXLS 0160	16	75	150	16
EMXLS 0180	18	75	150	18
EMXLS 0200	20	75	150	20
EMXLS 0250	25	75	150	25

TOLERANCES FRACTION

ØD1 +0.0
-0.002"

ØD2 +0.0
-0.0001"/-0.0005"

TOLERANCES METRIC

Ø mm D1 (h10) D2 (h6)
µm µm

3.6 +0/-48 +0/-8

6-10 +0/-58 +0/-9

10-18 +0/-70 +0/-11

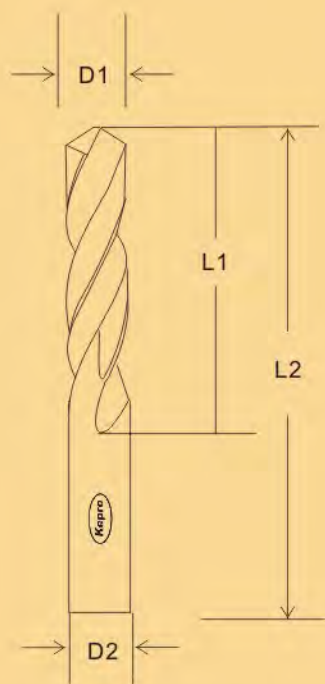
18-30 +0/-84 +0/-13

Drills

Tool No	D1	D2	L1	L2
DR 02 0300	3	16	46	3
DR 02 0310	3.1	18	49	3.1
DR 02 0320	3.2	18	49	3.2
DR 02 0330	3.3	18	49	3.3
DR 02 0340	3.4	20	52	3.4
DR 02 0350	3.5	20	52	3.5
DR 02 0360	3.6	20	52	3.6
DR 02 0370	3.7	20	52	3.7
DR 02 0380	3.8	22	55	3.8
DR 02 0390	3.9	22	55	3.9
DR 02 0400	4	22	55	4
DR 02 0410	4.1	22	55	4.1
DR 02 0420	4.2	22	55	4.2
DR 02 0430	4.3	24	58	4.3
DR 02 0440	4.4	24	58	4.4
DR 02 0450	4.5	24	58	4.5
DR 02 0460	4.6	24	58	4.6
DR 02 0470	4.7	24	58	4.7
DR 02 0480	4.8	26	62	4.8
DR 02 0490	4.9	26	62	4.9
DR 02 0500	5	26	62	5
DR 02 0510	5.1	26	62	5.1
DR 02 0520	5.2	26	62	5.2
DR 02 0530	5.3	28	66	5.3
DR 02 0540	5.4	28	66	5.4
DR 02 0550	5.5	28	66	5.5
DR 02 0560	5.6	28	66	5.6
DR 02 0570	5.7	28	66	5.7
DR 02 0580	5.8	28	66	5.8
DR 02 0590	5.9	28	66	5.9
DR 02 0600	6	28	66	6
DR 02 0610	6.1	31	70	6.1
DR 02 0620	6.2	31	70	6.2
DR 02 0630	6.3	31	70	6.3
DR 02 0640	6.4	31	70	6.4
DR 02 0650	6.5	31	70	6.5
DR 02 0660	6.6	31	70	6.6
DR 02 0670	6.7	31	70	6.7
DR 02 0680	6.8	34	74	6.8
DR 02 0690	6.9	34	74	6.9
DR 02 0700	7	34	74	7
DR 02 0710	7.1	34	74	7.1
DR 02 0720	7.2	34	74	7.2
DR 02 0730	7.3	34	74	7.3
DR 02 0740	7.4	34	74	7.4
DR 02 0750	7.5	34	74	7.5
DR 02 0760	7.6	37	79	7.6
DR 02 0770	7.7	37	79	7.7
DR 02 0780	7.8	37	79	7.8
DR 02 0790	7.9	37	79	7.9

Tool No	D1	D2	L1	L2
DR 02 0800	8	37	79	8
DR 02 0810	8.1	37	79	8.1
DR 02 0820	8.2	37	79	8.2
DR 02 0830	8.3	37	79	8.3
DR 02 0840	8.4	37	79	8.4
DR 02 0850	8.5	37	79	8.5
DR 02 0860	8.6	40	84	8.6
DR 02 0870	8.7	40	84	8.7
DR 02 0880	8.8	40	84	8.8
DR 02 0890	8.9	40	84	8.9
DR 02 0900	9	40	84	9
DR 02 0910	9.1	40	84	9.1
DR 02 0920	9.2	40	84	9.2
DR 02 0930	9.3	40	84	9.3
DR 02 0940	9.4	40	84	9.4
DR 02 0950	9.5	40	84	9.5
DR 02 0960	9.6	43	89	9.6
DR 02 0970	9.7	43	89	9.7
DR 02 0980	9.8	43	89	9.8
DR 02 0990	9.9	43	89	9.9
DR 02 0100	10	43	89	10
DR 02 0101	10	43	89	10
DR 02 0102	10	43	89	10
DR 02 0103	10	43	89	10
DR 02 0104	10	43	89	10
DR 02 0105	11	43	89	11
DR 02 0106	11	43	89	11
DR 02 0107	11	43	89	11
DR 02 0108	11	43	89	11
DR 02 0110	11	47	95	11
DR 02 0112	11	47	95	11
DR 02 0115	12	47	95	12
DR 02 0118	12	47	95	12
DR 02 0120	12	51	102	12
DR 02 0125	13	51	102	13
DR 02 0130	13	51	102	13
DR 02 0135	14	51	102	14
DR 02 0140	14	54	107	14
DR 02 0145	15	56	111	15
DR 02 0150	15	56	111	15
DR 02 0155	16	58	115	16
DR 02 0160	16	58	115	16
DR 02 0165	17	60	119	17
DR 02 0170	17	60	119	17
DR 02 0175	18	62	123	18
DR 02 0180	18	62	123	18
DR 02 0185	19	64	127	19
DR 02 0190	19	64	127	19
DR 02 0195	20	66	131	20
DR 02 0200	20	66	131	20

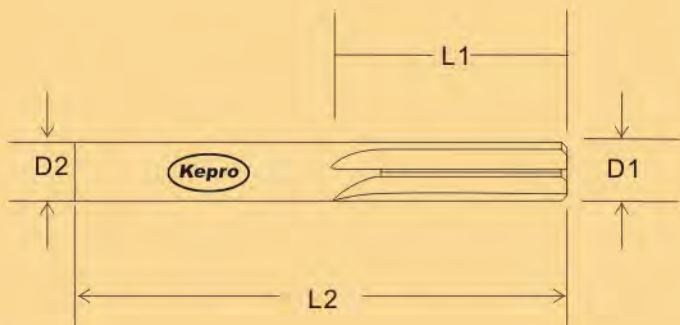
2 Flutes
30° RHS/RHS
self centering
140° point angle



TOLERANCES

Ø mm	D1(h8) µm	D2(h7) µm
3-6	+0/-18	+0/-12
6-10	+0/-22	+0/-15
10-18	+0/-27	+0/-18
18-30	+0/-33	+0/-21

Straight flutes / 10 degree RHS/RHS
right hand cutting
suitable for H7 tolerance



Tool No.	Cutting Dia	Cutting Length	Oval All Length
RM01 0300	3	12	57
RM01 0400	4	18	63
RM01 0500	5	22	63
RM01 0600	6	25	75
RM01 0700	7	25	75
RM01 0800	8	28	82
RM01 0900	9	35	100
RM01 0100	10	35	100
RM01 0110	11	35	100
RM01 0120	12	35	100

TOLERANCES

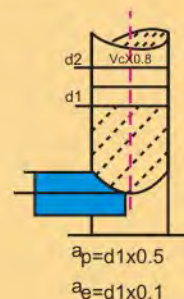
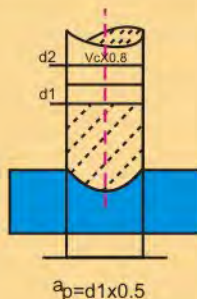
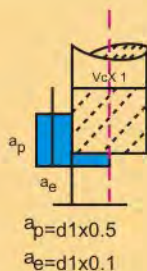
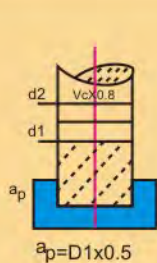
Ø mm	D1 µm
3-6	+1/+8
6-10	+1/+11
10-18	+1/+13

SUGGESTED PARAMETERS

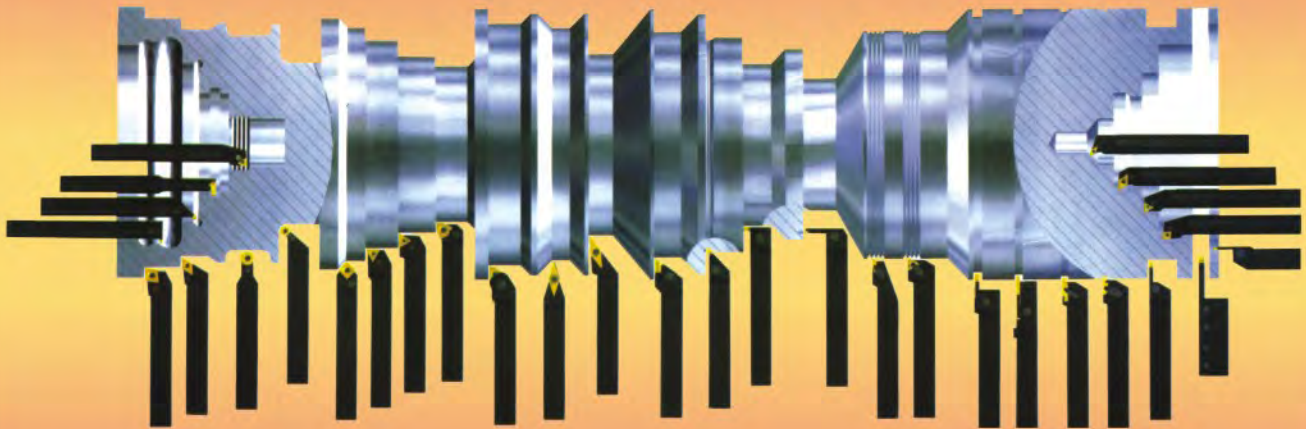
END MILLS - GENERAL APPLICATION SERIES

MATERIAL	SPEED (M / MIN)	FEED (MM / TOOTH)		
		d ₁ ≤ 6mm	d ₁ ≤ 12mm	d ₁ ≤ 25mm
CARBON & ALLOY STEEL UPTO 30 HRC	50 - 190	0.005 - 0.040	0.025 - 0.076	0.076 - 0.179
CARBON & ALLOY STEEL < 38 - 70 HRC	20 - 60	0.005 - 0.013	0.013 - 0.025	0.025 - 0.076
DIE & MOULD STEEL	20 - 80	0.005 - 0.025	0.025 - 0.050	0.050 - 0.152
STAINLESS STEELS - 300 SERIES	40 - 80	0.005 - 0.025	0.025 - 0.050	0.050 - 0.152
STAINLESS STEELS - 400 SERIES	30 - 60	0.005 - 0.013	0.025 - 0.050	0.050 - 0.152
GREY CAST IRON	50 - 180	0.005 - 0.025	0.025 - 0.050	0.050 - 1.152
DUCTILE CAST IRON	30 - 120	0.005 - 0.025	0.025 - 0.050	0.050 - 0.152
MALLEABLE CAST IRON	40 - 150	0.005 - 0.020	0.020 - 0.050	0.050 - 0.102
NICKEL BASED ALLOYS	5 - 40	0.008 - 0.020	0.020 - 0.025	0.025 - 0.050
TITANIUM ALLOYS	10 - 60	0.005 - 0.020	0.020 - 0.025	0.025 - 0.050
COBALT BASED ALLOYS	5 - 30	0.005 - 0.020	0.020 - 0.025	0.025 - 0.050
ALLUMINIUM	180 - 400	0.005 - 0.050	0.050 - 0.102	0.102 - 0.203
MAGNESIUM	300 - 400	0.013 - 0.050	0.050 - 0.076	0.076 - 0.152
COPPER / BRASS	80 - 280	0.0143 - 0.050	0.050 - 0.076	0.076 - 0.152
PLASTIC	180 - 400	0.015 - 0.076	0.076 - 0.152	0.152 - 0.381
FIBREGLASS	90 - 240	0.015 - 0.076	0.076 - 0.102	0.102 - 0.254
GRAPHITE	180 - 300	0.076 - 0.130	0.130 - 0.203	0.203 - 0.254
WOOD*	15,000 - 25,000RPM*	0.038 - 0.076	0.076 - 0.130	0.130 - 0.176

CONVERSION FORMULAS
Cutting Speed: RPM X M / MIN (3.14 X TOOL DIA) X RPM / 1000
Cutting Speed: M / MIN RPM 1000 X M / MIN / (3.14 X TOOL DIA)
Feed: RPM x FEED x NOS OF TEETH



Turning tool shown for how to cut



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