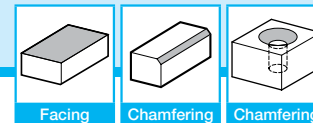
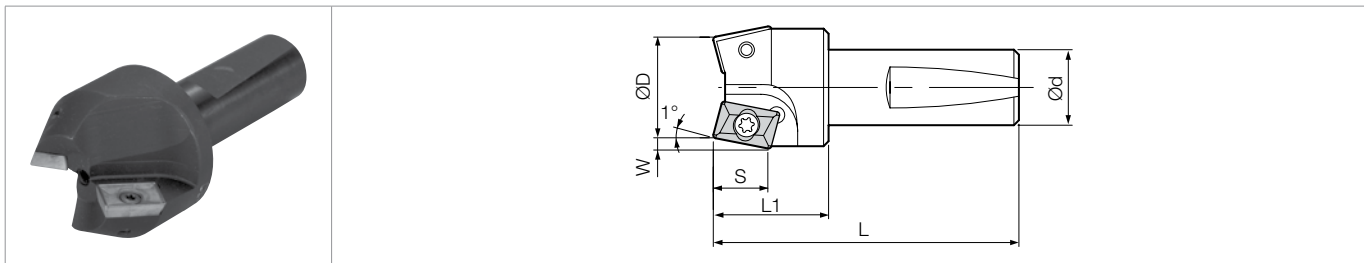


CM / CM-AL CHAMFERING END MILL



CM / CM-AL (For Aluminum Cutting)



Toolholder Dimensions

Part Number	Stock	No. of Inserts	Dimensions (in)						Spare Parts		Applicable Inserts ● B25	
			ØD	Ød	L	L1	S	W	α	Clamp Screw		Wrench
CM 0563-15-09	●	2	0.563	0.500	2.780	1.000	0.340	0.089	15.0°	SCR-04	T7	XPMT090208
0563-20-09	●						0.330	0.116	20.0°			
0563-25-09	●						0.310	0.143	25.0°			
0563-30-09	●		0.563	0.625	2.910	1.000	0.300	0.169	30.0°	SCR-04	T7	
0563-35-09	●						0.280	0.194	35.0°			
0563-45-09	●		0.563	0.625	2.910	1.000	0.240	0.239	45.0°	SCR-01	T7	
0563-60-09	●						0.160	0.301	60.0°			
0563-75-09	●						0.080	0.327	75.0°			
CM 1000-03	●	2	1.000	0.750	3.150	1.250	0.589	0.031	3.0°	SCR-16	T10	XPMT15T3...
1000-05	●						0.586	0.052	5.0°			
1000-10	●						0.577	0.103	10.0°			
1000-15	●						0.564	0.154	15.0°			
1000-20	●		1.000	0.750	3.150	1.250	0.547	0.204	20.0°	SCR-30	T10	
1000-25	●						0.526	0.252	25.0°			
1000-30	●						0.501	0.298	30.0°			
1000-35	●		1.000	0.750	3.150	1.250	0.472	0.343	35.0°	SCR-30	T10	
1000-37.5	●						0.456	0.372	37.5°			
1000-41	●						0.433	0.393	41.0°			
1000-45	●						0.400	0.400	45.0°			
1000-50	●						0.376	0.454	50.0°			
1000-55	●						0.327	0.507	55.0°			
1000-60	●						0.284	0.521	60.0°			
1000-70	●						0.193	0.547	70.0°			
1000-75	●		0.146	0.584	75.0°							
CM 1000-15-AL	●	2	1.000	0.750	3.250	1.350	0.613	0.158	15.0°	SCR-02	T15	APET1604...
1000-20-AL	●						0.595	0.208	20.0°			
1000-30-AL	●						0.544	0.304	30.0°			
0800-45-AL	●		0.800	0.750	3.250	1.350	0.440	0.430	45.0°	SCR-02	T15	
0800-60-AL	●						0.308	0.528	60.0°			
0690-75-AL	●						0.158	0.591	75.0°			

Recommended Cutting Conditions

Workpiece Material	Feed Rate fz (ipt)	Recommended Insert Grades (Cutting Speed Vc: sfm)						
		Cermet		MEGACOAT NANO	PVD Coated Carbide			Carbide
		TN100M	TC60	PR1525	PR930	PR905	PR830	KW10
Low Carbon Steel	0.003-0.006	☆ 800-1400	★ 800-1400	★ 400-800	☆ 350-750	-	-	-
Carbon Steel	0.003-0.006	☆ 600-1200	★ 600-1200	★ 300-700	☆ 250-650	-	-	-
Mold Steel	0.003-0.006	☆ 400-700	★ 400-700	★ 250-600	☆ 250-600	-	-	-
Stainless Steel	0.002-0.006	☆ 300-800	☆ 300-800	★ 300-600	☆ 300-500	-	☆ 300-800	-
Cast Iron	0.003-0.008	☆ 400-1200	★ 400-1200	-	-	★ 400-800	-	☆ 300-500
Non-ferrous Metals	0.005-0.007	☆ 1500-1800	☆ 1500-1800	-	-	-	-	★ 2000-4000

* Apply sufficient amount of coolant

★: 1st Recommendation ☆: 2nd Recommendation

● : U.S. Stock Standard
○ : World Express (Shipping: 7-10 Business Days)

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K5

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75° LEAD D
90° LEAD E
HIGH FEED F
MULTI-FUNCTION G
SLOT MILLS H
RADIUS / BALL-NOSE J
OTHER APPLICATIONS K
TOOL HOLDING O
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