

● Toolholder Dimensions

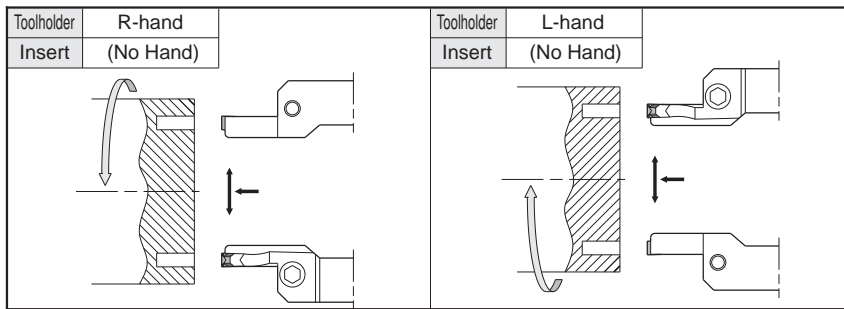
Description	Std.		Dimension (mm)									Width (mm)	Face Grooving Dia. øD		Spare Parts			
	R	L	H1-h	H2	H3	B	L1	L2	F	S	T		W	MIN.	MAX.	Screw	Wrench	
	KFMS^{R/L} 2020K2535-5	●							39				20	25	35			
2020K3550-5	●			-	10								35	50				
2020K5075-5	●												50	75				
2020K75115-5	●		20			20	125				-	25	75	115				
2020K115180-5	●			5	10			44					115	180				
2020K180235-5	●												180	235				
2020K235800-5	●												235	∞				
2525M2535-5	●	●						39				20	25	35	HH5X25	LW-4		
2525M3550-5	●	●											35	50				
2525M5075-5	●	●						44				25	50	75				
2525M75115-5	●	●	25		-	10	25	150			-	32	75	115				
2525M115180-5	●	●											115	180				
2525M180235-5	●	●						51					180	235				
2525M235800-5	●	●											235	∞				

• Dimension T shows available grooving depth.

• Face Grooving Dia.øD: The diameter range of the initial groove.

• For KFMS^{R/L}...-5 Toolholder can hold a 6mm width insert. () value shows the dimension of a 6mm width insert.

◆ Selection of Toolholder & Insert



■ Applicable Inserts (mm)

Description	L	H
FMM30-03 } FMM60-04	12	3.5
FMN3 } FMN6	12	3.5

P	M	K	N	S	H	Classification of usage												
Carbon Steel / Alloy Steel	Stainless Steel	Cast Iron	Non-ferrous Metals	Titanium Alloy	Hard materials (under 40HRC)													
					Hard materials (over 40HRC)													

● : Continuous-Light Interruption / 1st Choice
 ○ : Continuous-Light Interruption / 2nd Choice
 ● : Continuous / 1st Choice
 ○ : Continuous / 2nd Choice

Insert	Description	Dimension (mm)			Cermet	CVD Coated Carbide	PVD Coated Carbide			Carbide	Applicable Toolholder
		W	rε	M			TN90	CR9025	PR915		
	FMM 30-03	3.0	0.3	2.0	●	●	●	●	●	●	KFMS^{R/L}... 3
	40-04	4.0	0.4	2.6	●	●	●	●	●	●	KFMS^{R/L}... 4
	50-04	5.0		3.4	●	●	●	●	●	●	KFMS^{R/L}... 5
	60-04	6.0		4.0	●	●	●	●	●	●	KFMS^{R/L}... 5
	FMN 3	3.0		0.25	2.0	●	●	●	●	●	●
	4	4.0	2.6		●	●	●	●	●	●	KFMS^{R/L}... 4
	5	5.0	3.4		●	●	●	●	●	●	KFMS^{R/L}... 4
	6	6.0	4.0		●	●	●	●	●	●	KFMS^{R/L}... 5
							●	●	●	●	●

• FMN type inserts are only for Deep Grooving and not applicable for Longitudinal turning.

Recommended Cutting Conditions ● G91

◆ Limit of Longitudinal turning toward Center It causes the toolholder to interfere with the groove wall depending on the initial cut's diameter.

Description	øD			
	25	26	27	28 and over
KFMS^{R/L} 2020K2530-3				
KFMS^{R/L} 2525M2530-3	4	2	0	0
KFMS^{R/L} 2020K2535-4				
KFMS^{R/L} 2525M2535-4	6	3	0	
KFMS^{R/L} 2020K2535-5	7	4	1	(No remaining Boss)
KFMS^{R/L} 2525M2535-5	*(5)	*(2)	*(0)	

e.g.) KFMSR 2525M2530-3 with ø25 as first cut towards the center, it will cause a rubbing with the holder cartridge if ød is 4.0mm.

*() value shows the Dimension using FMM60-04 Insert.

● : Std. Item □ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)

Inserts are sold in 10 piece boxes.

