KX618

KX618 STABLE CLAMPING 6 EDGES SERIES

6 Cutting Edges
Much Economical

strengthened zero positioning slot
Stable Clamping Stable Cutting

Multiple tools for different purposes
meet different needs of processing

KX618

stable clamping 6 heads series

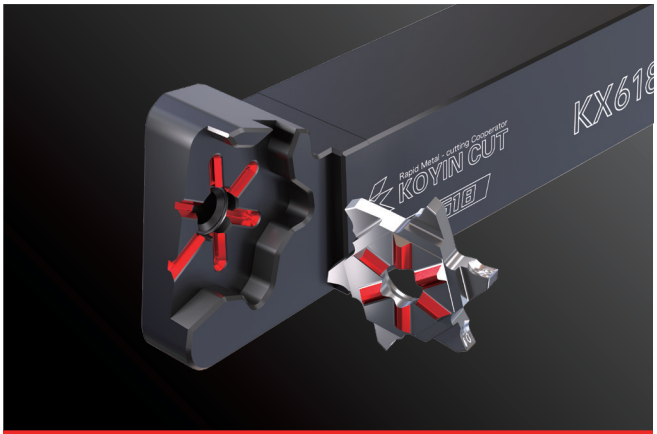
FEATURES AND ADVANTAGES

6 Cutting Edges

much economical as its cutting edges is as twice as triangular inserts

Multiple tools for different purposes

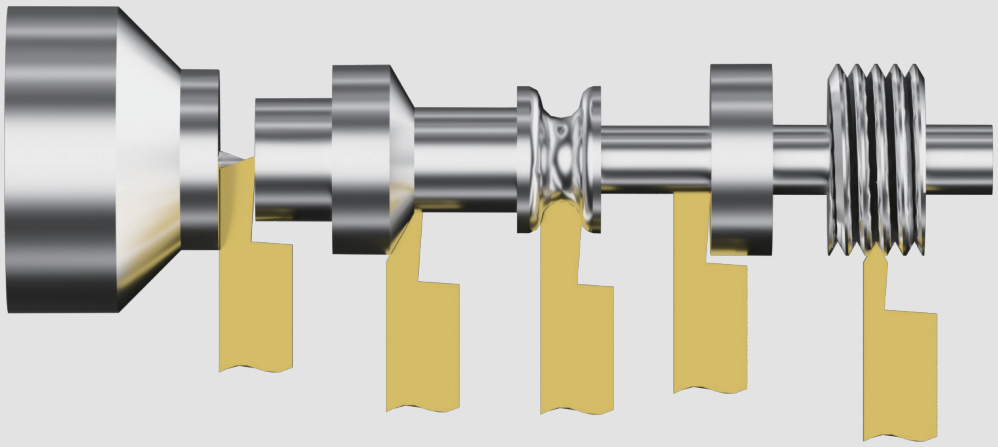
available with grooving, threading, back-turning, parting, circular grooving and etc



strengthened zero positioning slot

"*" shape clamping to make it stable

Processing Applications

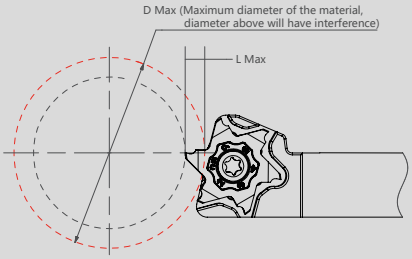


Parting | Back-turning | Profiling | Grooving | Threading

- **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

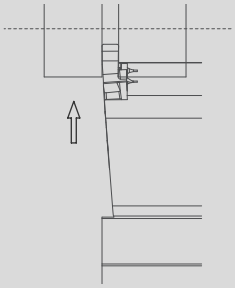


Symbols of KX618 Grooving Tools

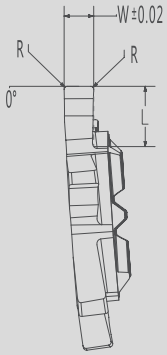
				025：0.25		250: 2.5		035: R0.35
KX618: KX618 Series	G: Grooving tools	R: right handed		125：1.25		300: 3.0		005: R0.05
Series	**Insert Type**	**Insert Direction**		**edge width**	**-**	**effective cutting depth**	**-**	**Nose Radius**
KX618	**G**	**R**		**125**	**-**	**300**	**-**	**005**

Grooving tools

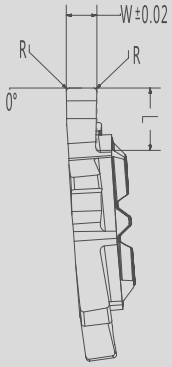
Processing Application



		KPM30N	KXM15S	KHS10M	KMS20	KCN10D	KCN10
P	Soft steel	◆	◇	◆/◇			
	Carbon steel/alloy steel	◆	◇	◆/◇			
M	Martensitic	◇	◆	◆	◆		
	Austenitic	◆	◆	◆	◆		
K	Grey Cast Iron			◇			
	Ductile Cast Iron			◇			
N	Nonferrous					◆	◆
S	Heat Resisting Alloy		◆	◆/◇	◆		
	Titanium Alloy		◆	◆/◇	◆		
H	Hardened Materials			◆/◇			



shape Right Handed Tool	Type	Size W	Size L	Size R	PVD Coated Cemented Carbide KPM30N	KXM15S	KHS10M	KMS20	KCN10D	cemented carbide KCN10
	KX618GR 050-150-005	0.5	1.5	0.05		●	●			
	KX618GR 060-150-005	0.6				●	●			
	KX618GR 070-150-005	0.7				●	●			
	KX618GR 075-150-005	0.75				●	●			
	KX618GR 070-200-005	0.7	2.0	0.05		●	●			
	KX618GR 075-200-005	0.75		0.05		●	●			
	KX618GR 080-200-005	0.8		0.05		●	●			
	KX618GR 090-200-005	0.9		0.05		●	●			
	KX618GR 100-200-005	1.0		0.05		●	●			
	KX618GR 100-200-010			0.1		●	●			
	KX618GR 110-200-005	1.1		0.05		●	●			
	KX618GR 110-200-010			0.1		●	●			
	KX618GR 120-200-005	1.2		0.05		●	●			
	KX618GR 120-200-010			0.1		●	●			
	KX618GR 125-200-005	1.25		0.05		●	●			
	KX618GR 125-200-010			0.1		●	●			
	KX618GR 130-200-010	1.3		0.1		●	●			
	KX618GR 130-200-020			0.2		●	●			
	KX618GR 140-200-010	1.4		0.1		●	●			
	KX618GR 140-200-020			0.2		●	●			
	KX618GR 150-200-010	1.5		0.1		●	●			
	KX618GR 150-200-020			0.2		●	●			
	KX618GR 160-200-010	1.6		0.1		●	●			
	KX618GR 160-200-020			0.2		●	●			
	KX618GR 170-200-010	1.7		0.1		●	●			
	KX618GR 170-200-020			0.2		●	●			
	KX618GR 175-200-010	1.75		0.1		●	●			
	KX618GR 175-200-020			0.2		●	●			
	KX618GR 100-300-005	1.0	3.0	0.05		●	●			
	KX618GR 100-300-010			0.1		●	●			
	KX618GR 110-300-005	1.1		0.05		●	●			
	KX618GR 110-300-010			0.1		●	●			
	KX618GR 120-300-005	1.2		0.05		●	●			
	KX618GR 120-300-010			0.1		●	●			
	KX618GR 125-300-005	1.25		0.05		●	●			
	KX618GR 125-300-010			0.1		●	●			
	KX618GR 130-300-010	1.3		0.1		●	●			
	KX618GR 130-300-020			0.2		●	●			
	KX618GR 140-300-010	1.4		0.1		●	●			
	KX618GR 140-300-020			0.2		●	●			
	KX618GR 150-300-010	1.5		0.1		●	●			
	KX618GR 150-300-020			0.2		●	●			
	KX618GR 160-300-010	1.6		0.1		●	●			
	KX618GR 160-300-020			0.2		●	●			

shape Right Handed Tool	Type	Size			PVD Coated Cemented Carbide					cemented carbide
		W	L	R	KPM30N	KXM15S	KHS10M	KMS20	KCN10D	KCN10
 	KX618GR 170-300-010	1.7	3.0	0.1		●	●			
	KX618GR 170-300-020			0.2		●	●			
	KX618GR 175-300-010	1.75		0.1		●	●			
	KX618GR 175-300-020			0.2		●	●			
	KX618GR 180-300-010	1.8		0.1		●	●			
	KX618GR 180-300-020			0.2		●	●			
	KX618GR 190-300-010	1.9		0.1		●	●			
	KX618GR 190-300-020			0.2		●	●			
	KX618GR 200-300-010	2.0		0.1		●	●			
	KX618GR 200-300-020			0.2		●	●			
	KX618GR 210-300-010	2.1		0.1		●	●			
	KX618GR 210-300-020			0.2		●	●			
	KX618GR 220-300-010	2.2		0.1		●	●			
	KX618GR 220-300-020			0.2		●	●			
	KX618GR 230-300-010	2.3		0.1		●	●			
	KX618GR 230-300-020			0.2		●	●			
	KX618GR 240-300-010	2.4		0.1		●	●			
	KX618GR 240-300-020			0.2		●	●			
	KX618GR 250-300-010	2.5		0.1		●	●			
	KX618GR 250-300-020			0.2		●	●			
	KX618GR 150-350-010	1.5	3.5	0.1		●	●			
	KX618GR 150-350-020			0.2		●	●			
	KX618GR 160-350-010	1.6		0.1		●	●			
	KX618GR 160-350-020			0.2		●	●			
	KX618GR 170-350-010	1.7		0.1		●	●			
	KX618GR 170-350-020			0.2		●	●			
	KX618GR 175-350-010	1.75		0.1		●	●			
	KX618GR 175-350-020			0.2		●	●			
	KX618GR 180-350-010	1.8		0.1		●	●			
	KX618GR 180-350-020			0.2		●	●			
	KX618GR 190-350-010	1.9		0.1		●	●			
	KX618GR 190-350-020			0.2		●	●			
	KX618GR 200-350-010	2.0		0.1		●	●			
	KX618GR 200-350-020			0.2		●	●			
	KX618GR 210-350-010	2.1		0.1		●	●			
	KX618GR 210-350-020			0.2		●	●			
	KX618GR 220-350-010	2.2		0.1		●	●			
	KX618GR 220-350-020			0.2		●	●			
	KX618GR 230-350-010	2.3		0.1		●	●			
	KX618GR 230-350-020			0.2		●	●			
	KX618GR 240-350-010	2.4		0.1		●	●			
	KX618GR 240-350-020			0.2		●	●			
	KX618GR 250-350-010	2.5		0.1		●	●			
	KX618GR 250-350-020			0.2		●	●			

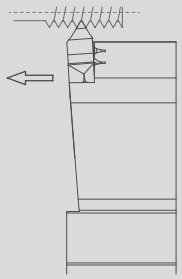
Grades: ◆Recommended ⬙Suitable ◇Applicable ● Standard Stock

Symbols of KX618 Threading Tools

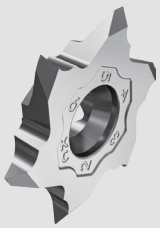
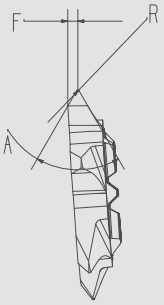
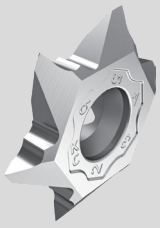
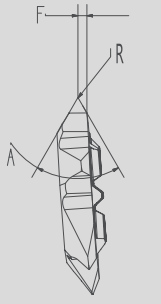
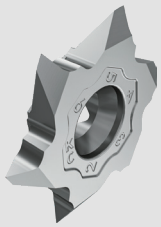
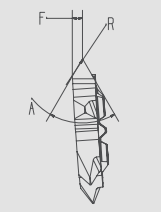
			040: 0.4		A: left
			080: 0.8		B: right
KX618: KX618 Series	T: Threading Tools	R: Right Handed	125: 1.25		N: central
Series	**Insert Type**	**Insert Direction**	**Tip Width**	**-**	**Edge Position**
KX618	T	R	125	-	A

Threading Tools

processing diagram



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

shape Right Handed Tool		Type	Size					PVD Coated Cemented Carbide					cemented carbide
			F	A	R	Pitch (MM)	Teeth per inch (TPI)	KPM30N	KXM15S	KHS10M	KMS20	KCN10D	KCN10
	Type A 	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		●	●			
	Type B 	KX618TR 040-B	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		●	●			
	Type N 	KX618TR 125-N	1.25	60°	0.1	1.0~1.5	25~17		●	●			

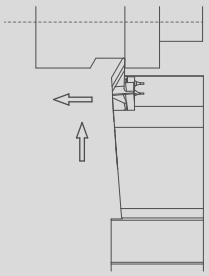
Grades: ◆Recommended ⬙Suitable ◇Applicable ●Standard Stock

Symbols of KX618 Back-turning tools

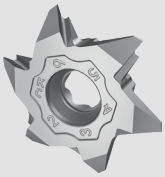
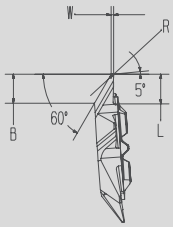
			005: R0.05 010: R0.1 015: R0.15		
KX618: KX618 Series	B: Back-turning	R: right handed			
Series	**Insert Type**	**Insert Direction**	**Nose Radius**	**-**	**with chipbreaking slot**
KX618	B	R	005	-	S

Back-turning tools

processing diagram



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

shape Right Handed Tool		Type	Size				PVD Coated Cemented Carbide					cemented carbide
			W	L	R	B	KPM30N	KXM15S	KHS10M	KMS20	KCN10D	KCN10
		KX618BR 005-S	0.3	3.5	<0.05	3.5		●	●			
		KX618BR 010-S			<0.1			●	●			
		KX618BR 015-S			<0.15			●	●			

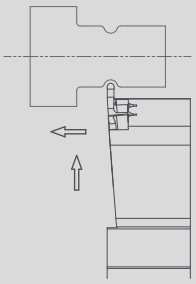
Grades: ◆Recommended ⬙Suitable ◇Applicable ● Standard Stock

Symbols of KX618 Circular Grooving Tools

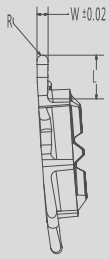
				050: R0.5 125: R1.25		150: 1.5 200: 2.0 350: 3.5
KX618: KX618 Series	R: Circular Grooving Tools	R: right handed				
Series	**Insert Type**	**Insert Direction**		**Nose Radius**	**-**	**Effective cutting depth**
KX618	R	R		050	-	200

Circular Grooving Tools

processing diagram



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

shape Right Handed Tool	Type	Size			PVD Coated Cemented Carbide					cemented carbide
		W	L	R	KPM30N	KXM15S	KHS10M	KMS20	KCN10D	KCN10
										
	KX618RR 035-150	0.7	1.5	0.35		●	●			
	KX618RR 050-200	1.0	2.0	0.5		●	●			
	KX618RR 060-200	1.2		0.6		●	●			
	KX618RR 075-350	1.5	3.5	0.75		●	●			
	KX618RR 100-350	2.0		1.0		●	●			
	KX618RR 125-350	2.5		1.25		●	●			

Grades: ◆Recommended ⬙Suitable ◇Applicable ●Standard Stock

Symbols of KX618 flat parting tools

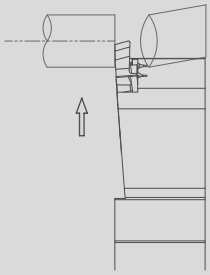
				050: 0.5 125: 1.25		S: R0.03-R0.05 P: R0.08
KX618: KX618 Series	C: parting tools	R: right handed				
Series	**Insert Type**	**Insert Direction**		**Edge width**	**-**	**Nose Radius**
KX618	C	R		125	-	S

symbols of KX618 parting tools with lead angle

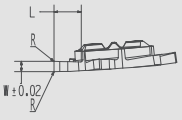
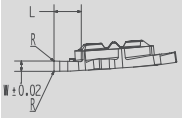
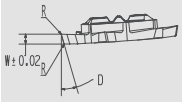
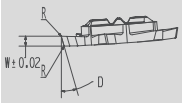
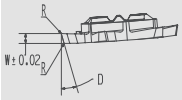
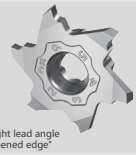
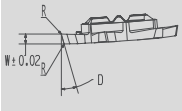
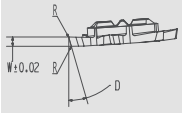
				050: 0.5 125: 1.25		20D: 20° 16D: 16° 11D: 11°	R: with right lead angle L: with left lead angle		N: without chipbreaking slot and nose radius S: R0.03-R0.05 P: R0.08	
KX618: KX618 Series	C: parting tools	R: right handed								
Series	**Insert Type**	**Insert Direction**		**edge width**	**-**	**lead angle**	**lead direction**	**-**	**Nose Radius/other**	
KX618	C	R		125	-	16D	R	-	S	

parting tools

processing diagram



		KPM30N	KXM15S	KHS10M	KMS20	KCN10D	KCN10
P	Soft steel	◆	◇	⬙			
	Carbon steel/alloy steel	◆	◇	⬙			
M	Martensitic	◇	◆	◆	◆		
	Austenitic	◆	◆	◆	◆		
K	Grey Cast Iron			◇			
	Ductile Cast Iron			◇			
N	Nonferrous					◆	◆
S	Heat Resisting Alloy		◆	⬙	◆		
	Titanium Alloy		◆	⬙	◆		
H	Hardened Materials			⬙			

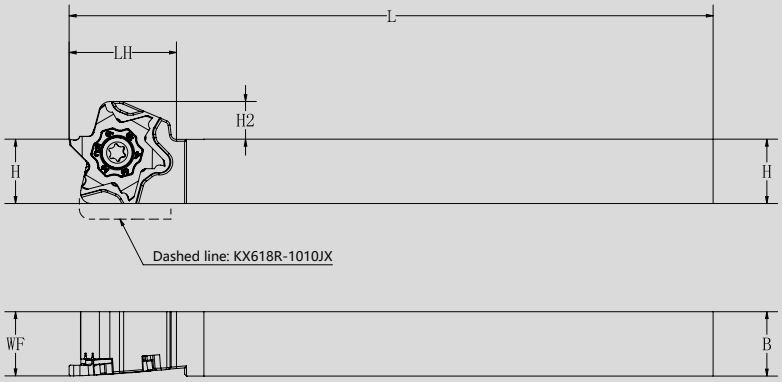
shape Right Handed Tool		Type	Size W	Maximum Diameter of parting DMax	R	D	PVD Coated Cemented Carbide KPM30N	KXM15S	KHS10M	KMS20	KCN10D	cemented carbide KCN10
 flat		KX618CR 050-S	0.5	3	0.03 I 0.05	0°		●	●			
		KX618CR 070-S	0.7					●	●			
		KX618CR 100-S	1					●	●			
		KX618CR 125-S	1.25	7				●	●			
		KX618CR 150-S	1.5					●	●			
 "flat strengthened edge"		KX618CR 100-P	1.0	3	0.08 ±0.01	0°		●	●			
		KX618CR 125-P	1.25	7				●	●			
		KX618CR 150-P	1.5					●	●			
 with right lead angle		KX618CR 100-11DR-S	1.0	3	0.03 I 0.05	11°		●	●			
		KX618CR 125-11DR-S	1.25	7				●	●			
		KX618CR 150-11DR-S	1.5					●	●			
 "with right lead angle strengthened edge"		KX618CR 100-11DR-P	1.0	3	0.08 ±0.01	11°		●	●			
		KX618CR 125-11DR-P	1.25	7				●	●			
		KX618CR 150-11DR-P	1.5					●	●			
 with right lead angle		KX618CR 050-16DR-S	0.5	3	0.03 I 0.05	16°		●	●			
		KX618CR 070-16DR-S	0.7					●	●			
		KX618CR 100-16DR-S	1					●	●			
		KX618CR 125-16DR-S	1.25	7				●	●			
		KX618CR 150-16DR-S	1.5					●	●			
 "with right lead angle strengthened edge"		KX618CR 100-16DR-P	1.0	3	0.08 ±0.01	16°		●	●			
		KX618CR 125-16DR-P	1.25	7				●	●			
		KX618CR 150-16DR-P	1.5					●	●			
 "with right lead angle without chipbreaking slot"		KX618CR 070-20DR-N	0.7	3	0	20°		●	●			
		KX618CR 100-20DR-N	1.0	7				●	●			
		KX618CR 125-20DR-N	1.25					●	●			
		KX618CR 150-20DR-N	1.5					●	●			

Grades: ◆Recommended ⬙Suitable ◇Applicable ●Standard Stock

Symbols of KX618 tool holders

					M: 150
					JX: 120
					J: 110
KX618: KX618 Series	R: Right handed				H: 100
Series	**Direction**	**-**	**Tool Height**	**Tool Width**	**Tool Length**
KX618	R	-	12	12	JX

KX618 Tool holders



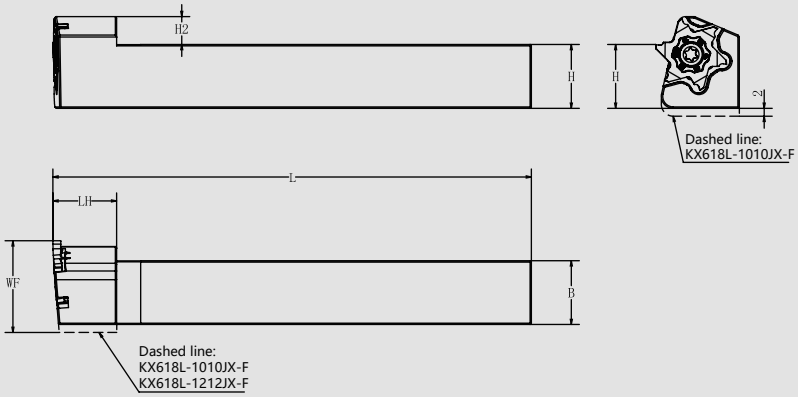
• Right Handed Tool holder

Type	Size(mm)						Accessaries		Corresponding Insert
	H	B	L	LH	WF	H2	Screw	Wrenth	
KX618R -1010JX	10	10	120	20	10	7	KS-4008-T	KW-T15	KX618□R □□□
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			

Symbols of KX618-F

					M: 150 JX: 120 J: 110 H: 100		
KX618: KX618 Series	L: Left handed						F: For Row Tools
Series	**Holder Direction**	**-**	**Holder Heigh**	**Holder Width**	**Tool Length**	**-**	**Other**
KX618	L	-	12	12	JX	-	F

Tool holder for KX618-F



• "left handed holders
left handed holders are for roght hand inserts"

Type	Size(mm)							Accessaries		Corresponding Insert
	H	B	L	LH	H1	H2	WF	Screw	Wrenth	
KX618L-1010JX-F	10	10	120	16	6	9	19	KS-4008-T	KW-T15	KX618□R □□□
KX618L-1212JX-F	12	12	120	16	4	9	19			
KX618L-1616JX-F	16	16	120	16	0	9	21			