

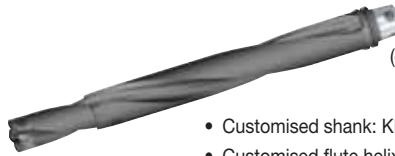


Application	Workpiece Shape	A1 Head	B1 Head
Flat Face		✓	✓
Cored Hole		✗	✓
Stacked Plates		✗	✓
Angled Exit (exit only!)		✓ <3°	✓ max 15°
Angled Entrance		✓ <3°	✓ <3°
Cross Holes		✗	✓ max 50% of D1

KSEM PLUS Customised Solution Capabilities:

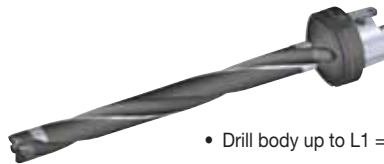


- Intermediate head Ø.
- Custom head to use reground KSEM™ inserts.
- Heads for cross holes Ø = d1.



(example)

- Customised shank: KM™, HSK, VDI, ISO taper, etc.
- Customised flute helix.
- Step drill.



- Drill body up to L1 = 20 x D and total length of 1250mm.

Mounting DPA Guiding Pads on B1 Heads

All B1 heads are delivered with preset guiding pads.

Measure radial undersize "A" of pad to cutting edge for both sides and adjust using shim set that comes with each head.

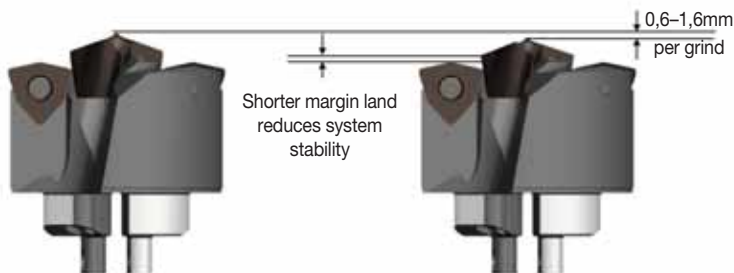
NOTE: For best results with slanted exits and in cross hole drilling, we recommend guiding pads adjustment results in an undersize of A = 30 µm (edge of guiding pads to cutting edges).

Coolant Recommendations



Internal coolant is recommended for optimum chip flow and tool life.

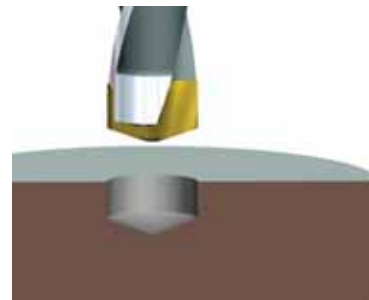
KSEM PLUS Piloting Insert SHOULD NOT Be Reground:



Only new KSEM PLUS inserts will provide consistency and process security on a KSEM PLUS modular drill system. If you want to reground, refer to our custom solution A1 and B1 heads.

NOTE: Reground KSEM PLUS inserts can be used in KSEM™ drills.

Piloting Instructions:



1. KSEM...PC Pilot drill Ø equal KSEMP Ø PDD
2. Drill 1mm deep from full diameter