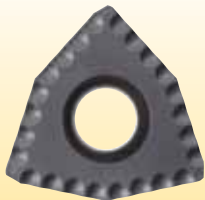


■ KSEM PLUS Carbide Insert Recommendations

Modular Drills

Material Group	Outboard/ Inboard	Insert Style	Grade	Page(s)	Comments
P	O	DFR-GD	KCU25, KCU40	H89	Recommended outboard insert style for working in all P-materials. Start with KCU40™ and use KCU25™ in stable conditions to achieve higher tool life.
		DFC-/DFT-HP		H90, H88	
	I	DFC-/DFT-DS	KCU40	H90, H88	Reduce feed rate by 10% to further improve chip formation in long-chipping steels and low carbon steel.
M	O	KSEMP-HPG	KC7315	H87	Must use KSEMP centre inserts in P-materials to avoid excessive wear on head & inserts.
		DFR-MD	KC7140	H89	Recommended outboard insert style for working in all M-materials.
		DFC-/DFT-MD		H90, H89	
	I	DFC-/DFT-DS	KCU40	H90, H88	Reduce feed rate by 20% to further improve chip formation and/or run with lower power consumption.
		KSEMP-HPG	KC7315	H87	Recommended inboard insert style for working in all M-materials.
K	O	KSEM-PC	KC7135	H56, H87	For unstable conditions in stainless steel, use KSEM PC inserts.
		KSEM-HPL	KC7320	H50	If chip control issue resulting from centre insert occurs in M-materials, use KSEM HPL insert inboard. Reduction of feed rate up to 20% is recommended.
	I	DFR-LD	KCU25	H89	Recommended insert styles for working in all K-Materials.
I	DFC-/DFT-HP	H90, H88			
	N	O	KSEM-HPCCCL	KC7410	
DFR-GD			KC7225	H89	Recommended outboard insert styles for working in all non-ferrous materials.
DFC-/DFT-HP			KCU40	H90, H88	
DFC-/DFT-DS			KCU40	H90, H88	Reduce feed rate by 15% for diameters <56mm and up to 50% for larger diameters to improve chip formation.
I		DFR/DFT-ST	KD1425	J85	Use PCD tipped outboard when working with CFRP, CFRP/metal stacks and plastics (N3, N5, and N6).
	KSEMP-HPG	KC7315	H87	Recommended inboard insert style for working in all non-ferrous materials.	
S	O	KSEM-HPS	K715	—	This is a made-to-order item (uncoated/sharp) — use it to improve your results in N3, N5, and N6, if required.
		DFR-GD	KC7140	H89	Recommended outboard insert style for working in all S-materials.
		DFC-/DFT-HP	KCU40	H90, H88	
	I	DFC-/DFT-DS	KCU40	H90, H88	Reduce feed rate by 20% to further improve chip formation and/or run with lower power consumption.
S	I	KSEM-PC	KC7135	H56, H87	If centre breakage is an issue in S-materials, use KSEM PC insert inboard.



Need help with bad chip formation?

Our new DS geometry for DFT™ and DFC™ inserts on KSEM PLUS helps you to improve your performance in long chipping materials.

If chip formation is an issue, you may use our new DFT and DFC DS style inserts with the recommendations for feed rate adjustments given as indicated.