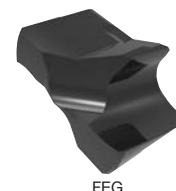
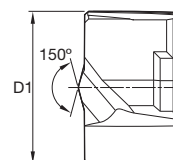
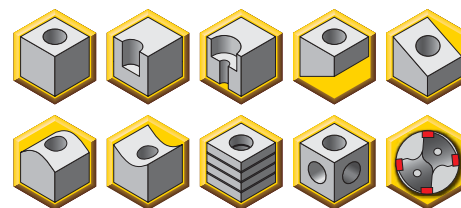
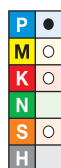


- KSEM FEG flat-bottom inserts create 180° flat holes — only a small cavity remains in the centre of the hole ground. KSEM offers an extraordinarily strong pocket seat for your demanding flat-bottom applications.
- Whether it is a blind hole, a through hole, or if you need to countersink, these inserts are focused on versatility and will support you in many essential drilling applications.
- KSEM FEG inserts feature a small centring point as well as double margin lands for improved guidance and hole straightness. A corner chamfer serves to reduce bur formation and to improve tool life.
- KCPM45™ combines a very tough, fine-grain carbide substrate with an advanced multilayer TiAlN coating. It is capable of machining steel even in the most demanding conditions.
- Use KSEM FEG KCPM45 cutting edges as an effective alternative in cast iron, stainless steel, and high-temp alloys.



FEG

KSEM Inserts • FEG KCPM45



KCPM45	D1		seat size
	mm	in	
KSEM1600FEGM	16,000	.6299	1
KSEM1650FEGM	16,500	.6496	1
KSEM1700FEGM	17,000	.6693	1
KSEM1750FEGM	17,500	.6890	1
KSEM1800FEGM	18,000	.7087	1
KSEM1850FEGM	18,500	.7283	2
KSEM1900FEGM	19,000	.7480	2
KSEM1905FEGM	19,050	.7500	2
KSEM1950FEGM	19,500	.7677	2
KSEM1984FEGM	19,840	.7811	2
KSEM2000FEGM	20,000	.7874	3
KSEM2050FEGM	20,500	.8071	3
KSEM2100FEGM	21,000	.8268	3
KSEM2150FEGM	21,500	.8465	3
KSEM2200FEGM	22,000	.8661	3
KSEM2250FEGM	22,500	.8858	4
KSEM2300FEGM	23,000	.9055	4
KSEM2350FEGM	23,500	.9252	4
KSEM2400FEGM	24,000	.9449	4
KSEM2450FEGM	24,500	.9646	5
KSEM2500FEGM	25,000	.9843	5
KSEM2540FEGM	25,400	1.0000	5
KSEM2550FEGM	25,500	1.0039	5
KSEM2580FEGM	25,800	1.0157	5



- first choice
- alternate choice

KCPM45	D1		seat size
	mm	in	
KSEM2581FEGM	25,810	1.0161	5
KSEM2600FEGM	26,000	1.0236	5
KSEM2619FEGM	26,190	1.0311	6
KSEM2650FEGM	26,500	1.0433	6
KSEM2670FEGM	26,700	1.0512	6
KSEM2700FEGM	27,000	1.0630	6
KSEM2750FEGM	27,500	1.0827	6
KSEM2800FEGM	28,000	1.1024	6
KSEM2850FEGM	28,500	1.1220	7
KSEM2900FEGM	29,000	1.1417	7
KSEM2950FEGM	29,500	1.1614	7
KSEM3000FEGM	30,000	1.1811	7
KSEM3050FEGM	30,500	1.2008	8
KSEM3100FEGM	31,000	1.2205	8
KSEM3150FEGM	31,500	1.2402	8
KSEM3175FEGM	31,750	1.2500	8
KSEM3200FEGM	32,000	1.2598	8
KSEM3250FEGM	32,500	1.2795	9
KSEM3300FEGM	33,000	1.2992	9
KSEM3350FEGM	33,500	1.3189	9
KSEM3400FEGM	34,000	1.3386	9
KSEM3450FEGM	34,500	1.3583	9
KSEM3500FEGM	35,000	1.3780	9
KSEM3550FEGM	35,500	1.3976	9

(continued)

(KSEM Inserts • FEG KCPM45™ — continued)



● first choice
○ alternate choice

KCPM45	D1		seat size
	mm	in	
KSEM3600FEGM	36,000	1.4173	9
KSEM3650FEGM	36,500	1.4370	10
KSEM3700FEGM	37,000	1.4567	10
KSEM3750FEGM	37,500	1.4764	10
KSEM3800FEGM	38,000	1.4961	10
KSEM3810FEGM	38,100	1.5000	10
KSEM3850FEGM	38,500	1.5157	10
KSEM3900FEGM	39,000	1.5354	10
KSEM3950FEGM	39,500	1.5551	10
KSEM4000FEGM	40,000	1.5748	10

Tolerance FEG • Metric

D1 metric	tolerance k7
12,5–18	+0,001/+ 0,019
>18–30	+0,002/+ 0,023
>30–40	+0,002/+ 0,027

Application Data

■ Modular Drill Carbide Insert Blades • KSEM™ • FEG Geometry • Grade KCPM45™ • Through Coolant • Metric

Material Group		Cutting Speed — vc			Metric						
		Range — m/min			Recommended Feed Rate (f) by Diameter						
		min	Starting Value	max		12,5	16,0	20,0	25,4	32,0	40,0
P	1	110	140	170	mm/r	0,14–0,23	0,17–0,25	0,19–0,29	0,23–0,38	0,26–0,43	0,33–0,76
	2	100	120	140	mm/r	0,17–0,23	0,19–0,25	0,22–0,29	0,29–0,38	0,32–0,43	0,33–0,76
	3	80	100	120	mm/r	0,14–0,20	0,15–0,23	0,17–0,25	0,23–0,34	0,26–0,38	0,33–0,66
	4	70	90	110	mm/r	0,11–0,20	0,13–0,23	0,14–0,25	0,18–0,34	0,21–0,38	0,26–0,66
M	1	40	60	80	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	2	35	55	70	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	3	20	40	60	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
K	1	90	135	175	mm/r	0,17–0,23	0,19–0,25	0,22–0,29	0,29–0,38	0,32–0,43	0,33–0,76
	2	80	120	140	mm/r	0,17–0,23	0,19–0,25	0,22–0,29	0,29–0,38	0,32–0,43	0,33–0,76
	3	70	110	125	mm/r	0,15–0,24	0,18–0,26	0,21–0,29	0,23–0,37	0,25–0,42	0,27–0,57
S	1	20	40	60	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	3	15	30	45	mm/r	0,09–0,14	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31