

ALUMINUM ALLOY
PROCESSING TOOL SERIES

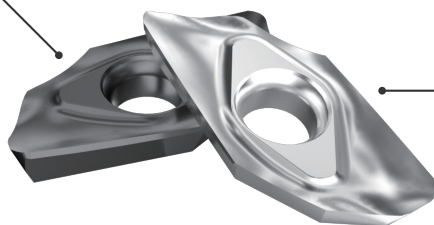
EcoCut



K290A SERIES

K290A-15 SERIES FEATURES AND ADVANTAGES

Diamond-like carbon coating



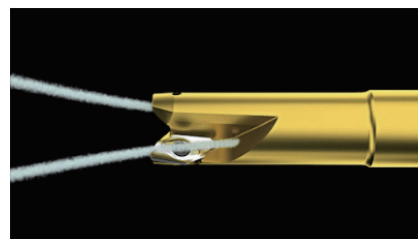
Mirror polished



Big rake angle



Wide spiral angle

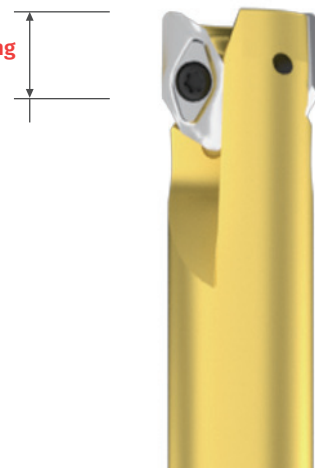


Inner cooling system

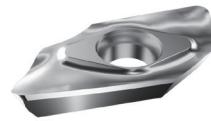
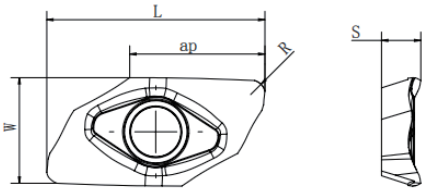
FEATURES AND ADVANTAGES

- Easier and faster machining, bigger cutting depth
- Outstanding chip control and cooling effect through inner cooling system
- Excellent chip removal capability
- Significantly improve tool life
- Suitable for different aluminum alloys

Maximum cutting
depth 15MM



K290A-15 Insert



K290A-15 (Mirror polished)
K290A AXGT 1505..R KCN10

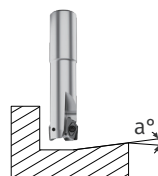
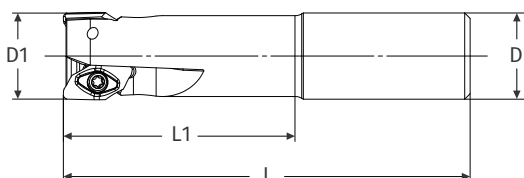


K290A-15 (Diamond-like carbon coating)
K290A AXGT 1505..R KCN10D

Type	Grade		Size (mm)				
	KCN10	KCN10D	W	ap	L	R	S
K290A AXGT 150502R	○		12.9	15	23.95	0.2	4.9
K290A AXGT 150504R	●		12.9	15	24.39	0.4	4.9
K290A AXGT 150508R	●		12.97	15.8	24.4	0.8	4.73
K290A AXGT 150512R	●		12.55	15.8	23.5	1.2	4.72
K290A AXGT 150516R	●		12.55	15.7	23.3	1.6	4.70
K290A AXGT 150520R	●		12.55	15.2	22.3	2.0	4.64
K290A AXGT 150525R	●		12.55	15.1	22.1	2.5	4.60
K290A AXGT 150530R	●		12.55	15.0	21.9	3.0	4.50
K290A AXGT 150532R	●		12.55	15.0	21.9	3.2	4.51
K290A AXGT 150540R			12.55	14.5	20.9	4.0	4.41
K290A AXGT 150502R		○	12.9	15	23.95	0.2	4.9
K290A AXGT 150504R		●	12.9	15	24.39	0.4	4.9
K290A AXGT 150508R		●	12.97	15.8	24.4	0.8	4.73
K290A AXGT 150512R		●	12.55	15.8	23.5	1.2	4.72
K290A AXGT 150516R		●	12.55	15.7	23.3	1.6	4.70
K290A AXGT 150520R		●	12.55	15.2	22.3	2.0	4.64
K290A AXGT 150525R		●	12.55	15.1	22.1	2.5	4.60
K290A AXGT 150530R		●	12.55	15.0	21.9	3.0	4.50
K290A AXGT 150532R		●	12.55	15.0	21.9	3.2	4.51
K290A AXGT 150540R		○	12.55	14.5	20.9	4.0	4.41

●: Standard stock ○: Customized products

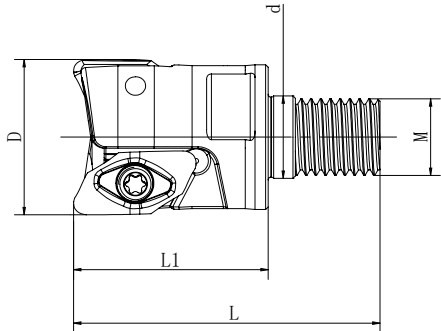
K290A-15 Tool holder



Type		Size (mm)						Accessories	
		D1	D	L	L1	Z	a° max	Screw	Wrench
K290A EAL-D32-C32-160L-15	●	32	32	160	80	2	22.0	KSM500110	KWT-20
K290A EAL-D32-C32-200L-15	○	32	32	200	90	2	22.0		
K290A EAL-D40-C32-160L-15	○	40	32	160	50	2	16.0		

●: Standard stock ○: Customized products

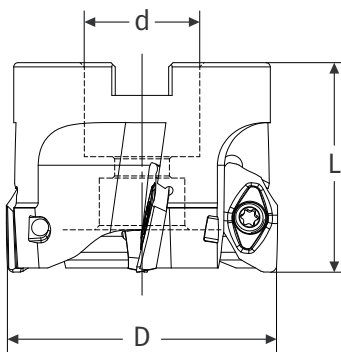
K290A-15 Threading head



Type		Size (mm)						Accessories	
		D	M	d	L	L1	Z	Screw	Wrench
K290A-2032-M16-15	●	32	M16	17	63	42	2	KSM500110	KWT-20

●:Standard stock ○:Customized products Z:Numbers of edge

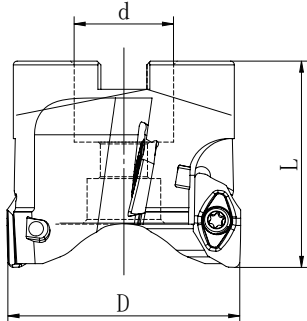
K290A-15 Cutter head



Type		Size (mm)					Accessories	
		D	L	d	Z	a° max	Screw	Wrench
K290A FAL-D50-22-3T-15	●	50	45	22	3	10.0	KSM500110	KWT-20
K290A FAL-D63-22-4T-15	●	63	50	22	4	7.0		
K290A FAL-D63-27-4T-15	●	63	50	27	4	7.0		
K290A FAL-D80-27-5T-15	●	80	50	27	5	6.0		
K290A FAL-D100-32-6T-15	●	100	50	32	6	4.0		
K290A FAL-D125-40-7T-15	○	125	63	40	7	3.0		

●:Standard stock ○:Customized products

SM-29 Ultra deep cutter head

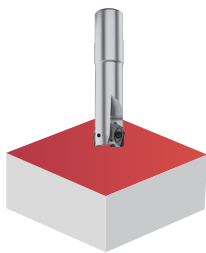


Type		Size (mm)						Accessories	
		D	L	ap	d	Z	a° max	Screw	Wrench
K290A SM D50-29-22-4T-15	○	50	55	29	22	4	11.0	KSM500110	KWT-20
K290A SM D63-29-22-4T-15	○	63	55	29	22	4	10.0		

●: Standard stock ○: Customized products

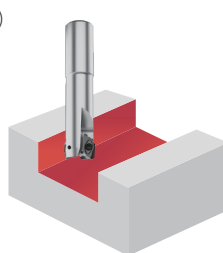
Application scenarios

①



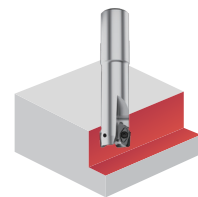
End-milling

②



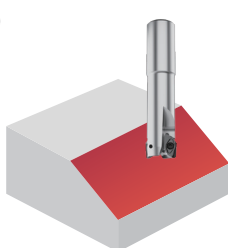
Plunge milling

③



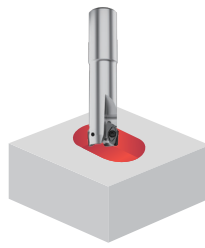
Shoulder milling

④



Slope milling

⑤



Cavity milling

K290A SERIES

K290A-10 SERIES

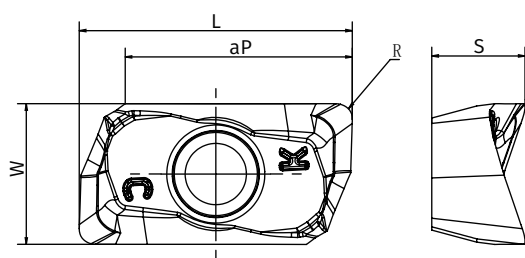
FEATURES AND ADVANTAGES

FEATURES AND ADVANTAGES

- Combines big rake angle and wide spiral angle to lower the cutting resistance, making the machining process easier and faster
- Has the chip space mirror polished to achieve better chip control, mitigating the built-up edge
- Suitable for different aluminum alloys



K290A-10 Insert



K290A-10 (Mirror polished)
K290A AXGT 1043..R KCN10

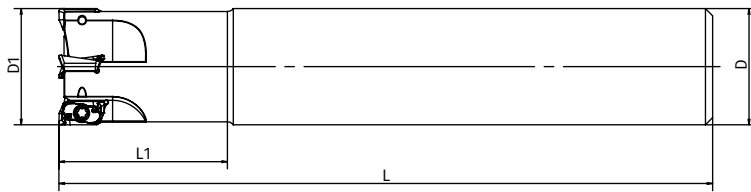


K290A-10 (Diamond-like carbon coating)
K290A AXGT 1043..R KCN10D

Type	Size (mm)						
	KCN10	KCN10D	W	ap	L	R	S
K290A AXGT 104304R	●		6.4	10	12.5	0.4	4.3
K290A AXGT 104308R	●		6.4	10	12.48	0.8	4.26
K290A AXGT 104316R	●		6.4	10	12.44	1.6	4.15
K290A AXGT 104304R		●	6.4	10	12.5	0.4	4.3
K290A AXGT 104308R		●	6.4	10	12.48	0.8	4.26
K290A AXGT 104316R		●	6.4	10	12.44	1.6	4.15

●:Standard stock ○:Customized products

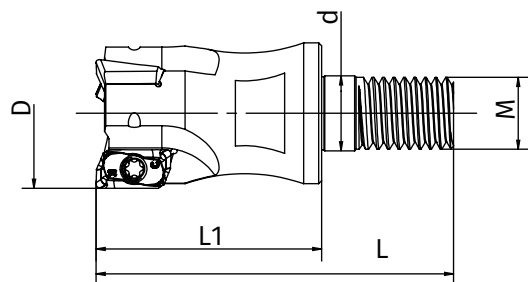
K290A-10 Tool holder



Type		Size (mm)					Accessories	
		D1	D	L	L1	Z	Screw	Wrench
K290A 2016-C16-L120-10	●	16	16	120	25	2	KSM250060	KWT-8
K290A 2017-C16-L120-10	●	17	16	120	25	2		
K290A 3020-C20-L165-10	●	20	20	165	30	3		
K290A 3021-C20-L165-10	●	21	20	165	30	3		
K290A 4025-C25-L180-10	●	25	25	180	35	4		
K290A 4026-C25-L180-10	●	26	25	180	38	4		
K290A 5032-C32-L180-10	●	32	32	180	48	5		

●: Standard stock ○: Customized products Z: Numbers of edge

K290A-10 Threading head



Type			Size (mm)						Accessories	
			D	M	d	L	L1	Z	Screw	Wrench
K290A 2016-M8-10	●	16	M8	8.5	46	23	2	KSM250060	KWT-8	
K290A 2017-M8-10	●	17								
K290A 3020-M10-10	●	20	M10	10.5	49	30	3			
K290A 3021-M10-10	●	21								
K290A 3025-M12-10	●	25	M12	12.5	57	35	3			
K290A 4025-M12-10	●	25	M12	12.5	57	35	4			
K290A 4026-M12-10	●	26								
K290A 5032-M16-10	●	32	M16	17	63	43	5			

●: Standard stock ○: Customized products Z: Numbers of edge

Recommend Application Parameter

ISO	Machined material	Hardness HB	Grade	Cutting speed Vc(m/min)	Feed per teeth fz(mm/t)
N	Aluminum alloy	60	KCN10	300-3000	0.15-0.35
			KCN10D	420-5000	0.15-0.45
		100	KCN10	200-2000	0.1-0.25
			KCN10D	280-2800	0.1-0.35
	Cast aluminum alloy Si≤12%	75	KCN10	200-2000	0.15-0.3
			KCN10D	280-2800	0.15-0.45
		90	KCN10	200-1500	0.1-0.25
			KCN10D	280-2100	0.1-0.35
	cast aluminum alloy Si>12%	130	KCN10	200-1000	0.07-0.15
			KCN10D	280-1400	0.07-0.25
	Copper alloy Pb>1%	110	KCN10	200-800	0.07-0.15
			KCN10D	280-1100	0.07-0.25
	Copper alloy	90	KCN10	300-1000	0.1-0.15
			KCN10D	420-1400	0.1-0.35
		100	KCN10	300-800	0.1-0.15
			KCN10D	420-1100	0.1-0.3
	Rigid plastics, Fber reinforcedplastics	—	KCN10	100-500	0.1-0.15
			KCN10D	140-700	0.1-0.3
	Ebonite	—	KCN10	100-300	0.1-0.15
			KCN10D	140-420	0.1-0.3