

BEYOND EVOLUTION™



Make The Cut

Experience the unequaled precision of Beyond Evolution KCU25B PVD-coated grade inserts. Engineered with a Triple-V design for secure positioning and enhanced rigidity, these inserts are perfect for fine cut-off applications. They deliver exceptional chip control, reduced cutting forces across all material groups and achieves up to 30% higher speeds for unmatched productivity.



MACHINISTS CAN EXPECT:

KCU25B Grade

- Precision and power
- Increased speed
- Longer tool life
- Excellent across material groups

CF – Cut-off Fine Geometry

- Lower cutting forces
- Excellent surface finish
- Superior chip control

Featured Material Master Numbers

32 MM Blades	32 MM Inserts
3MM - 5941725	3MM - 7167430
4MM - 5941726	4MM - 7167439

**ARE YOU READY TO MAKE THE CUT?
LEVEL UP WITH BEYOND EVOLUTION TODAY!**



**VIEW THE
FULL CUT-OFF
PORTFOLIO**

Cut-Off Speed Range • Beyond Evolution - KCU25B

Material Group		KCU25B			
		SFM		m/min	
		Min	Max	Min	Max
P	0-1	443	1181	135	360
	2	410	722	125	220
	3	394	722	120	220
	4	115	312	35	95
	5	197	476	60	145
	6	164	394	50	120
M	1	328	869	100	265
	2	295	820	90	250
	3	295	722	90	220
K	1	443	1312	135	400
	2	377	1230	115	375
	3	328	1115	100	340
N	1-2	377	2690	115	820
	3	-	-	-	-
	4	377	2083	115	635
	5	295	1050	90	320
	6	295	1345	90	410
	S	1	33	213	10
2		33	279	10	85
3		49	279	15	85
4		33	377	10	115
H	1	-	-	-	-
	2	-	-	-	-
	3	-	-	-	-

NOTE:
As the average chip thickness increases, the speed should be decreased.

Cut-Off Plunge Feed Rates • Beyond Evolution - KCU25B

KCU25B							
Geometry	Seat Size	Corner Radius		fn (in/rev)		fn (mm/rev)	
		Inch	MM	Min	Max	Min	Max
CF	3	0.000	0,00	0.002	0.005	0,04	0,12
		0.008	0,20	0.002	0.007	0,05	0,18
	4	0.000	0,00	0.002	0.005	0,04	0,12
		0.008	0,20	0.002	0.008	0,05	0,20

