

RAISE **YOUR** **STANDARDS**

JOB SHOP EDITION

**SPECIAL PROMOTIONAL
PRICING STARTING AT \$99.00**

**BEYOND™ EVOLUTION™
CUT-OFF**



VERSATILITY AND PERFORMANCE

Valid until June 30, 2022
All pricing is shown in USD



Materials



Applications



Cut-Off

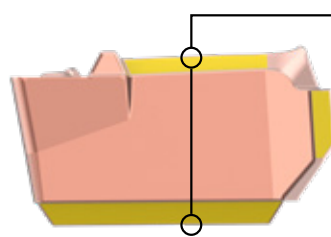
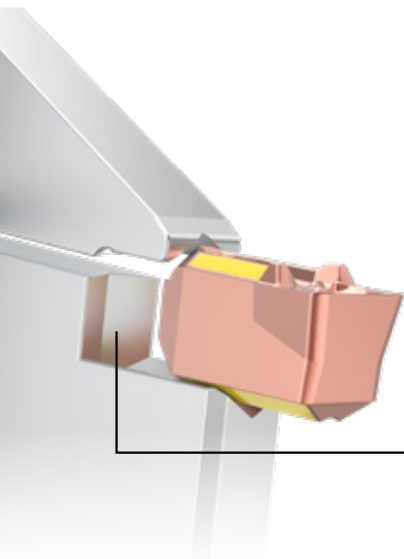


O.D. Deep Grooving

BEYOND™ EVOLUTION™ CUT-OFF \$99.00

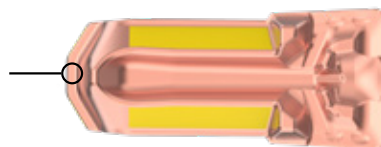


****Buy a Beyond Evolution cut-off blade and 10 inserts for \$99***



Top and Bottom-V
Precise and secure insert positioning for increased rigidity and dimensional accuracy.

V-Back Design
Unsurpassed grooving, cut-off, and multi-directional turning load stability.



Beyond Evolution

PROMOTION		BLADE INCLUDED					INSERTS INCLUDED					PRICE
Order #	Catalog #	Qty	MM#	Cat #	Width	Height	Qty	MM#	Cat #	Grade	USD	
6960197	BE01 PROMO	1	5941709	EVBSN26J0230	2	26	10	5533082	EC020M02N00CF02	KCU25	\$99.00	
6960198	BE02 PROMO	1	5941709	EVBSN26J0230	2	26	10	5533151	EC020M02R06CF02	KCU25	\$99.00	
6960199	BE03 PROMO	1	5941721	EVBSN26J0340	3	26	10	5941073	EC030M03N00CF02	KCU25	\$99.00	
6960200	BE04 PROMO	1	5941721	EVBSN26J0340	3	26	10	5941075	EC030M03R06CF02	KCU25	\$99.00	
6960321	BE05 PROMO	1	5941723	EVBSN26J0440	4	26	10	5941076	EC040M04N00CF02	KCU25	\$99.00	
6960322	BE06 PROMO	1	5941723	EVBSN26J0440	4	26	10	5941078	EC040M04R06CF02	KCU25	\$99.00	
6960323	BE07 PROMO	1	5941724	EVBSN32M0250	2	32	10	5533082	EC020M02N00CF02	KCU25	\$99.00	
6960324	BE08 PROMO	1	5941724	EVBSN32M0250	2	32	10	5533151	EC020M02R06CF02	KCU25	\$99.00	
6960325	BE09 PROMO	1	5941725	EVBSN32M0350	3	32	10	5941073	EC030M03N00CF02	KCU25	\$99.00	
6960326	BE10 PROMO	1	5941725	EVBSN32M0350	3	32	10	5941075	EC030M03R06CF02	KCU25	\$99.00	
6960327	BE11 PROMO	1	5941726	EVBSN32M0450	4	32	10	5941076	EC040M04N00CF02	KCU25	\$99.00	
6960328	BE12 PROMO	1	5941726	EVBSN32M0450	4	32	10	5941078	EC040M04R06CF02	KCU25	\$99.00	

* Returns will be refunded at promotional order price.

Application Data • Plunge Feed Rates									
Geometry	Seat Size (SSC)	Corner Radius		fn (mm/rev)			fn (in/rev)		
		mm	in	Low	High	Starting	Low	High	Starting
CF	1B	0	0.000	0.04	0.08	0.05	0.002	0.003	0.002
		0,1	0.004	0.05	0.10	0.06	0.002	0.004	0.002
	02	0	0.000	0.04	0.08	0.06	0.002	0.003	0.002
		0,2	0.008	0.05	0.13	0.07	0.002	0.005	0.003
	03	0	0.000	0.04	0.12	0.08	0.002	0.005	0.003
		0,2	0.008	0.05	0.18	0.09	0.002	0.007	0.004
	04	0	0.000	0.04	0.12	0.08	0.002	0.005	0.003
		0,2	0.008	0.05	0.20	0.11	0.002	0.008	0.004
	05	0	0.000	0.04	0.14	0.09	0.002	0.006	0.004
		0,3	0.012	0.05	0.23	0.13	0.002	0.009	0.005

Application Data • Recommended Starting Speeds (m/min)				
Material Group	KCU25	KCU25		
		1	2	3
P	0-1	110	225	270
	2	110	160	260
	3	110	125	235
	4	60	90	160
	5	100	160	210
	6	85	120	185
M	1	90	170	245
	2	90	150	245
	3	90	140	210
K	1	100	145	225
	2	70	120	170
	3	50	85	120
N	1-2	120	440	780
	3	-	-	-
	4	100	290	490
	5	70	135	195
	6	100	170	245
	S	1	8	40
2		8	30	75
3		15	40	75
4		8	50	110
H	1	-	-	-
	2	-	-	-
	3	-	-	-

Application Data • Recommended Starting Speeds (SFM)				
Material Group	KCU25	KCU25		
		1	2	3
P	0-1	360	740	880
	2	360	520	880
	3	360	410	800
	4	200	290	540
	5	320	530	680
	6	280	400	600
M	1	300	550	800
	2	300	500	800
	3	300	450	700
K	1	320	480	760
	2	240	400	560
	3	160	280	400
N	1-2	400	1440	2560
	3	-	-	-
	4	320	960	1600
	5	240	440	640
	6	320	560	800
	S	1	25	125
2		25	100	250
3		50	125	250
4		25	175	350
H	1	-	-	-
	2	-	-	-
	3	-	-	-

“JOB SHOP MACHINING IS EXTREMELY COMPETITIVE. IT’S CRITICAL THAT WE CONSISTENTLY USE STANDARD TOOLS THAT NOT ONLY CUT A WIDE VARIETY OF MATERIALS, BUT ALSO PERFORM AT THE HIGHEST LEVELS THROUGHOUT ALL INDUSTRIES. THESE KENNAMETAL TOOLS ARE MY SHOP’S STANDARDS.”

– Titan





To Place Your Order:
Contact Your Local
Authorized Distributor

***KENNAMETAL WILL DONATE A PORTION
OF EACH PROMOTIONAL ITEM SOLD
TO WORKSHOPS FOR WARRIORS®***



WORKSHOPS FOR WARRIORS IS A NONPROFIT ORGANIZATION THAT TRAINS AND CERTIFIES VETERANS AND
TRANSITIONING SERVICE MEMBERS FOR CAREERS IN ADVANCED MANUFACTURING.

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