

# **RAISE** **YOUR** **STANDARDS**

**JOB SHOP EDITION**

**SPECIAL PROMOTIONAL  
PRICING STARTING AT \$249.00**

**DODEKA™ MINI  
FACE MILL**



**VERSATILITY AND PERFORMANCE**

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



## Materials



## Applications



Face Milling



Shell Mill



Shoulder Milling



Through Coolant

# DODEKA™ MINI

# \$249.00

Maximum number of teeth per diameter.

Productivity booster in all materials.



Twelve cutting edges per insert.

**\*Buy a Dodeka Mini cutter and 10 inserts for \$249**

### Dodeka Mini

PROMOTION		CUTTER INCLUDED					INSERTS INCLUDED				PRICE
Order #	Catalog #	Qty	MM#	Cat #	Dia (in)	Pockets	Qty	MM#	Cat #	Grade	USD
6967596	DM01 PROMO	1	4130429	KSHR200HN4345M3	2	5	10	6165759	HNPJ43ANSNGD	KCSM40	\$249.00
6967597	DM02 PROMO	1	4130429	KSHR200HN4345M3	2	5	10	5550703	HNPJ43ANSNGD	KCPM40	\$249.00
6967598	DM03 PROMO	1	4130429	KSHR200HN4345M3	2	5	10	4119700	HNPJ43ANSNGD	KCPK30	\$249.00
6967599	DM04 PROMO	1	4130429	KSHR200HN4345M3	2	5	10	4121575	HNGJ43ANFNLDJ	KC410M	\$249.00
6967600	DM05 PROMO	1	4130432	KSHR250HN4345M3	2.5	6	10	6165759	HNPJ43ANSNGD	KCSM40	\$249.00
6967631	DM06 PROMO	1	4130432	KSHR250HN4345M3	2.5	6	10	5550703	HNPJ43ANSNGD	KCPM40	\$249.00
6967632	DM07 PROMO	1	4130432	KSHR250HN4345M3	2.5	6	10	4119700	HNPJ43ANSNGD	KCPK30	\$249.00
6967633	DM08 PROMO	1	4130432	KSHR250HN4345M3	2.5	6	10	4121575	HNGJ43ANFNLDJ	KC410M	\$249.00
6967634	DM09 PROMO	1	4130494	KSHR300HN4345C4	3	5	10	6165759	HNPJ43ANSNGD	KCSM40	\$249.00
6967635	DM10 PROMO	1	4130494	KSHR300HN4345C4	3	5	10	5550703	HNPJ43ANSNGD	KCPM40	\$249.00
6967636	DM11 PROMO	1	4130494	KSHR300HN4345C4	3	5	10	4119700	HNPJ43ANSNGD	KCPK30	\$249.00
6967637	DM12 PROMO	1	4130494	KSHR300HN4345C4	3	5	10	4121575	HNGJ43ANFNLDJ	KC410M	\$249.00

\* Returns will be refunded at promotional order price.

## Recommended Starting Feeds [IPT]

Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40-100%			
.F.LDJ	.007	.018	.032	.005	.013	.023	.004	.010	.017	.003	.009	.015	.003	.008	.014	.F.LDJ
.S.GD	.013	.031	.046	.009	.022	.033	.007	.016	.025	.006	.014	.022	.006	.013	.020	.S.GD

NOTE: Use "Light Machining" values as starting feed rate.



## ■ Recommended Starting Speeds for Dry Machining • Inch

Material Group		KC410M *			KCPK30			KCPM40			KCSM40		
P	1	-	-	-	1790	<b>1560</b>	1460	1165	<b>1015</b>	970	-	-	-
	2	-	-	-	1100	<b>1000</b>	900	985	<b>855</b>	705	-	-	-
	3	-	-	-	1000	<b>900</b>	805	900	<b>770</b>	625	-	-	-
	4	-	-	-	755	<b>690</b>	625	805	<b>675</b>	525	-	-	-
	5	-	-	-	1015	<b>900</b>	820	675	<b>605</b>	525	675	<b>575</b>	475
	6	-	-	-	625	<b>525</b>	475	590	<b>460</b>	360	590	<b>425</b>	310
M	1	-	-	-	805	<b>720</b>	605	770	<b>675</b>	605	820	<b>675</b>	560
	2	-	-	-	720	<b>625</b>	560	690	<b>590</b>	490	705	<b>575</b>	475
	3	-	-	-	575	<b>510</b>	460	510	<b>460</b>	360	575	<b>425</b>	330
K	1	-	-	-	1165	<b>1050</b>	950	-	-	-	-	-	-
	2	-	-	-	920	<b>820</b>	755	-	-	-	-	-	-
	3	-	-	-	770	<b>690</b>	625	-	-	-	-	-	-
N	1	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-
	4	-	-	-	-	-	-	-	-	-	-	-	-
H	1	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-

\*Recommended for wet machining only.

NOTE: FIRST choice starting speeds are in **bold** type. As the average chip thickness increases, the speed should be decreased.

## ■ Recommended Starting Speeds for Wet Machining • Inch

Material Group		KC410M			KCPK30			KCPM40			KCSM40		
P	1	-	-	-	1430	<b>1250</b>	1170	930	<b>810</b>	775	-	-	-
	2	-	-	-	880	<b>800</b>	720	790	<b>685</b>	565	-	-	-
	3	-	-	-	800	<b>720</b>	645	720	<b>615</b>	500	-	-	-
	4	-	-	-	605	<b>550</b>	500	645	<b>540</b>	420	-	-	-
	5	-	-	-	810	<b>720</b>	655	540	<b>485</b>	420	540	<b>460</b>	380
	6	-	-	-	500	<b>420</b>	382	470	<b>370</b>	290	470	<b>340</b>	250
M	1	-	-	-	645	<b>575</b>	485	615	<b>540</b>	485	655	<b>540</b>	450
	2	-	-	-	575	<b>500</b>	450	550	<b>470</b>	390	565	<b>460</b>	380
	3	-	-	-	460	<b>410</b>	370	410	<b>370</b>	290	460	<b>340</b>	265
K	1	-	-	-	930	<b>840</b>	760	-	-	-	-	-	-
	2	-	-	-	735	<b>655</b>	605	-	-	-	-	-	-
	3	-	-	-	615	<b>550</b>	500	-	-	-	-	-	-
N	1	3830	<b>3400</b>	3135	-	-	-	-	-	-	-	-	-
	2	3400	<b>3135</b>	2890	-	-	-	-	-	-	-	-	-
	3	3400	<b>3135</b>	2890	-	-	-	-	-	-	-	-	-
S	1	-	-	-	-	-	-	130	<b>105</b>	90	130	<b>105</b>	80
	2	-	-	-	-	-	-	130	<b>105</b>	90	130	<b>105</b>	80
	3	-	-	-	-	-	-	155	<b>130</b>	90	155	<b>130</b>	80
	4	-	-	-	210	<b>155</b>	105	210	<b>155</b>	105	185	<b>155</b>	90
H	1	-	-	-	-	-	-	-	-	-	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-

NOTE: FIRST choice starting speeds are in **bold** type. As the average chip thickness increases, the speed should be decreased.

**“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





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