

# Beyond™ Evolution™

## Grooving and Cut-Off

### Materials (CF Geometry)



### Applications



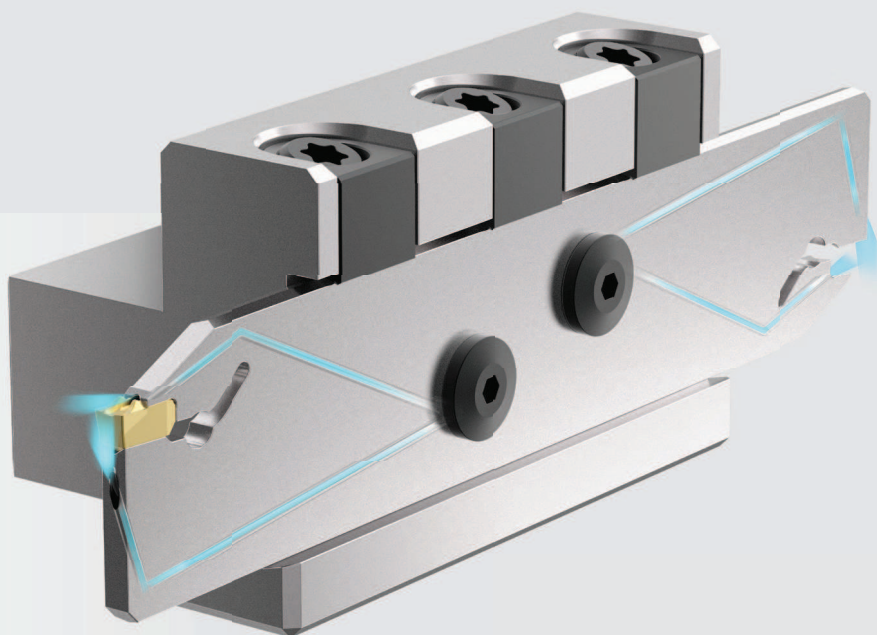
Cut-Off



O.D. Deep Grooving



Grooving

[kennametal.com/BeyondEvolution](http://kennametal.com/BeyondEvolution)

Beyond Evolution is the new single-sided grooving and cut-off tool that also performs multi-directional turning.

Whether you are using a high- or low-pressure coolant supply, Beyond Evolution, featuring active coolant control, delivers longer tool life and higher Metal Removal Rates (MRR).

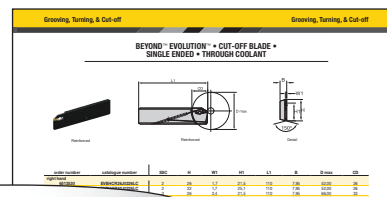
Available now: cut-off blades and supporting blocks with active coolant control. For even higher productivity in cut-off and deep-grooving applications.



The CF (cut-off fine) geometry is now also available with sharp corners and increased lead angles. A performance booster for applications in stainless steels, or in applications when thin walls are present.

## BEYOND™ EVOLUTION™ • CATALOGUE NUMBERING SYSTEM • CUT-OFF BLADES

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



EVBSCL32J0320LC

| EV                    | BS                                                                                  | C                     | L                                                                         | 32                | J                                                                                                    | 03                                                                                                                | 20                 | L                                                   | C                                        |
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| Family Name           | Tool Style                                                                          | Support Type          | Hand of Pocket                                                            | Blade Height      | Overall Length                                                                                       | Seat Size (SSC)                                                                                                   | Max. Cutting Depth | Hand of Blade                                       | Coolant                                  |
| Beyond™<br>Evolution™ | <b>BS</b> = Blade<br>Standard<br>2 Pocket<br><b>BH</b> = Blade<br>Heavy<br>1 Pocket | <b>C</b> = Reinforced | <b>N</b> = Neutral<br><b>L</b> = Left<br>Hand<br><b>R</b> = Right<br>Hand | in<br>millimetres | According<br>to ISO<br><b>G</b> = 90mm<br><b>J</b> = 110mm<br><b>M</b> = 150mm<br><b>X</b> = Special | <b>1B</b><br><b>1F</b><br><b>02</b><br><b>03</b><br><b>04</b><br><b>05</b><br><b>06</b><br><b>08</b><br><b>10</b> | in<br>millimetres  | <b>L</b> = Left<br>Hand<br><b>R</b> = Right<br>Hand | <b>C</b> = Through<br>Coolant<br>Capable |
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BEYOND™ EVOLUTION™ • CATALOGUE NUMBERING SYSTEM • BLOCKS

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.

Grooving, Turning, & Cut-off

Grooving, Turning, & Cut-off

BEYOND™ EVOLUTION™ • BLOCK FOR CUT-OFF BLADES WITH THROUGH COOLANT

A side-view cross-section diagram of a grooving tool. The tool is shown with a cutting edge on the left and a coolant passage on the right. The coolant passage is labeled 'COOLANT' and 'THROUGH COOLANT'.

A side-view cross-section diagram of a turning tool. The tool is shown with a cutting edge on the left and a coolant passage on the right. The coolant passage is labeled 'COOLANT' and 'THROUGH COOLANT'.

A side-view cross-section diagram of a cut-off tool. The tool is shown with a cutting edge on the left and a coolant passage on the right. The coolant passage is labeled 'COOLANT' and 'THROUGH COOLANT'.

A side-view cross-section diagram of a tool with a coolant passage. The tool is shown with a cutting edge on the left and a coolant passage on the right. The coolant passage is labeled 'COOLANT' and 'THROUGH COOLANT'.

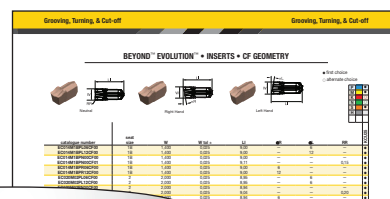
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EVTZN2525G32C

| EV                 | T          | Z                                         | N                                    | 2525                                                                        | G                                     | 32             | C                           |
|--------------------|------------|-------------------------------------------|--------------------------------------|-----------------------------------------------------------------------------|---------------------------------------|----------------|-----------------------------|
| Family Name        | Tool Block | Clamping Style                            | Hand of Tool                         | Shank Size                                                                  | Tool Length in (mm)                   | Blade Size     | Coolant                     |
| Beyond™ Evolution™ |            | E = Integral Clamp<br>Z = Removable Clamp | R = Right<br>L = Left<br>N = Neutral | Metric = Height x width in mm letter indicates tool length according to ISO | G = 80<br>J = 110<br>X = Other Length | in millimetres | C = Through Coolant Capable |

## BEYOND™ EVOLUTION™ • CATALOGUE NUMBERING SYSTEM • INSERTS

Each character in our catalogue number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.



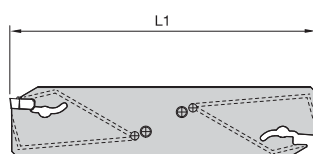
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| E                  | C           | 030                                                                                                                                                                                                                                                                                                                                    | M                  | 03              | P                    | N                                              | 00                                  | CF                                                                                      | 02            |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
|--------------------|-------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|-----------------|----------------------|------------------------------------------------|-------------------------------------|-----------------------------------------------------------------------------------------|---------------|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|--|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|----|----|-----|----|-----|----|-----|----|-----|----|-----|----|-----|----|-----|----|-----|--|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|----|----|-----|----|-----|----|-----|----|-----|--|
| Family Name        | Insert Type | Cutting Edge Width                                                                                                                                                                                                                                                                                                                     | Unit               | Seat Size (SSC) | Tolerance            | Hand of Insert                                 | Approach Angle                      | Chip-breaker                                                                            | Corner Radius |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| Beyond™ Evolution™ | C = Cut-Off |                                                                                                                                                                                                                                                                                                                                        | M = Metric         |                 | P = Periphery Ground | N = Neutral<br>L = Left Hand<br>R = Right Hand | 00 = Neutral<br>06 = 6°<br>12 = 12° | CL = Cut-Off Low Feed<br>CF = Cut-Off Fine<br>CM = Cut-Off Medium<br>CR = Cut-Off Rough |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
|                    |             | <table><tr><th>Cutting Edge Width</th><th>mm</th></tr><tr><td>014</td><td>1,4</td></tr><tr><td>020</td><td>2,0</td></tr><tr><td>030</td><td>3,0</td></tr><tr><td>040</td><td>4,0</td></tr><tr><td>050</td><td>5,0</td></tr><tr><td>060</td><td>6,0</td></tr><tr><td>070</td><td>7,0</td></tr><tr><td>080</td><td>8,0</td></tr></table> | Cutting Edge Width | mm              | 014                  | 1,4                                            | 020                                 | 2,0                                                                                     | 030           | 3,0 | 040 | 4,0 | 050 | 5,0 | 060 | 6,0 | 070 | 7,0 | 080 | 8,0 |  | <table><tr><th>Seat Size (SSC)</th><th>mm</th></tr><tr><td>1B</td><td>1,4</td></tr><tr><td>1F</td><td>2,0</td></tr><tr><td>02</td><td>3,0</td></tr><tr><td>03</td><td>4,0</td></tr><tr><td>04</td><td>5,0</td></tr><tr><td>05</td><td>6,0</td></tr><tr><td>06</td><td>7,0</td></tr><tr><td>08</td><td>8,0</td></tr></table> | Seat Size (SSC) | mm | 1B | 1,4 | 1F | 2,0 | 02 | 3,0 | 03 | 4,0 | 04 | 5,0 | 05 | 6,0 | 06 | 7,0 | 08 | 8,0 |  | <table><tr><th>Corner Radius</th><th>mm</th></tr><tr><td>00</td><td>0,0</td></tr><tr><td>01</td><td>0,1</td></tr><tr><td>02</td><td>0,2</td></tr><tr><td>04</td><td>0,4</td></tr></table> | Corner Radius | mm | 00 | 0,0 | 01 | 0,1 | 02 | 0,2 | 04 | 0,4 |  |
| Cutting Edge Width | mm          |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 014                | 1,4         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 020                | 2,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 030                | 3,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 040                | 4,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 050                | 5,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 060                | 6,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 070                | 7,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 080                | 8,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| Seat Size (SSC)    | mm          |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 1B                 | 1,4         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 1F                 | 2,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 02                 | 3,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 03                 | 4,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 04                 | 5,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 05                 | 6,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 06                 | 7,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 08                 | 8,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| Corner Radius      | mm          |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 00                 | 0,0         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 01                 | 0,1         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 02                 | 0,2         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |
| 04                 | 0,4         |                                                                                                                                                                                                                                                                                                                                        |                    |                 |                      |                                                |                                     |                                                                                         |               |     |     |     |     |     |     |     |     |     |     |     |  |                                                                                                                                                                                                                                                                                                                             |                 |    |    |     |    |     |    |     |    |     |    |     |    |     |    |     |    |     |  |                                                                                                                                                                                           |               |    |    |     |    |     |    |     |    |     |  |

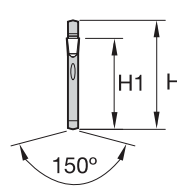
## BEYOND™ EVOLUTION™ • CUT-OFF BLADE • DOUBLE ENDED • THROUGH COOLANT



Straight



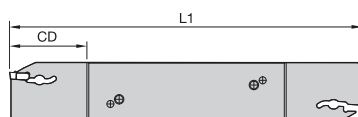
Straight



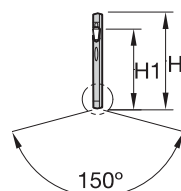
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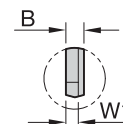
Reinforced



Reinforced



Detail



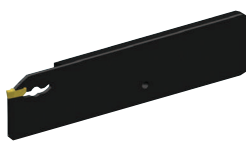
Detail

| order number        | catalogue number | SSC | H  | W1  | H1   | L1  | B    | CD |
|---------------------|------------------|-----|----|-----|------|-----|------|----|
| <b>neutral hand</b> |                  |     |    |     |      |     |      |    |
| 6513449             | EVBSN26M0233C    | 2   | 26 | 1,7 | 21,5 | 150 | 2,40 | 33 |
| 6513450             | EVBSN32M0233C    | 2   | 32 | 1,7 | 25,1 | 150 | 2,40 | 33 |
| 6513521             | EVBSN26J0340C    | 3   | 26 | —   | 21,5 | 110 | 2,40 | 40 |
| 6513522             | EVBSN26M0340C    | 3   | 26 | —   | 21,5 | 150 | 2,40 | 40 |
| 6513523             | EVBSN32M0350C    | 3   | 32 | —   | 25,1 | 150 | 2,40 | 50 |
| 6513524             | EVBSN26J0440C    | 4   | 26 | —   | 21,5 | 110 | 3,40 | 40 |
| 6513525             | EVBSN26M0440C    | 4   | 26 | —   | 21,5 | 150 | 3,40 | 40 |
| 6513526             | EVBSN32M0450C    | 4   | 32 | —   | 25,1 | 150 | 3,40 | 50 |
| 6513527             | EVBSN32M0560C    | 5   | 32 | —   | 25,1 | 150 | 4,40 | 60 |
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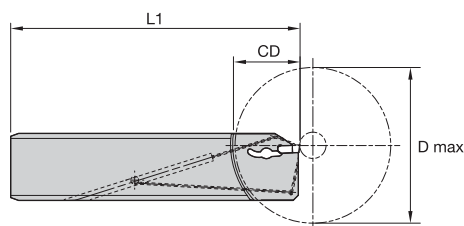
SSC = To correspond with the SSC on the insert.

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|     |     |    |   |     |
| 120 | 122 | 33 | 4 | 124 |

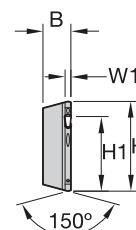
## BEYOND™ EVOLUTION™ • CUT-OFF BLADE • SINGLE ENDED • THROUGH COOLANT



Reinforced



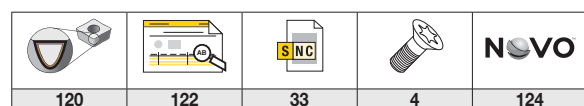
Reinforced



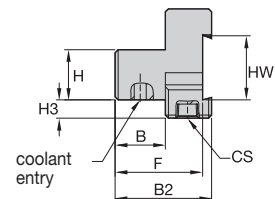
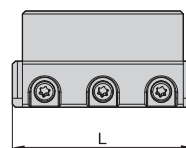
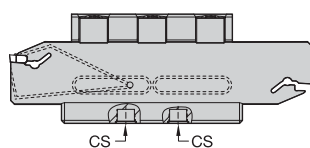
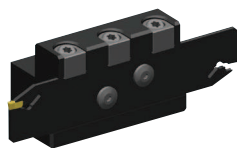
Detail

| order number      | catalogue number | SSC | H  | W1  | H1   | L1  | B    | D max | CD |
|-------------------|------------------|-----|----|-----|------|-----|------|-------|----|
| <b>right hand</b> |                  |     |    |     |      |     |      |       |    |
| 6513530           | EVBHCR26J0226LC  | 2   | 26 | 1,7 | 21,5 | 110 | 7,95 | 52,00 | 26 |
| 6513552           | EVBHCR32J0226LC  | 2   | 32 | 1,7 | 25,1 | 110 | 7,95 | 52,00 | 26 |
| 6513554           | EVBHCR26J0333LC  | 3   | 26 | 2,4 | 21,5 | 110 | 7,95 | 66,00 | 33 |
| 6513558           | EVBHCR32J0333LC  | 3   | 32 | 2,4 | 25,1 | 110 | 7,95 | 66,00 | 33 |
| 6513556           | EVBHCR32K0340LC  | 3   | 32 | 2,4 | 25,1 | 125 | 7,95 | 80,00 | 40 |
| 6513560           | EVBHCR26J0433LC  | 4   | 26 | 3,4 | 21,5 | 110 | 7,95 | 66,00 | 33 |
| 6513574           | EVBHCR32J0433LC  | 4   | 32 | 3,4 | 25,1 | 110 | 7,95 | 66,00 | 33 |
| 6513572           | EVBHCR32K0440LC  | 4   | 32 | 3,4 | 25,1 | 125 | 7,95 | 80,00 | 40 |
| <b>left hand</b>  |                  |     |    |     |      |     |      |       |    |
| 6513551           | EVBHCL26J0226RC  | 2   | 26 | 1,7 | 21,5 | 110 | 7,95 | 52,00 | 26 |
| 6513553           | EVBHCL32J0226RC  | 2   | 32 | 1,7 | 25,1 | 110 | 7,95 | 52,00 | 26 |
| 6513555           | EVBHCL26J0333RC  | 3   | 26 | 2,4 | 21,5 | 110 | 7,95 | 66,00 | 33 |
| 6513559           | EVBHCL32J0333RC  | 3   | 32 | 2,4 | 25,1 | 110 | 7,95 | 66,00 | 33 |
| 6513557           | EVBHCL32K0340RC  | 3   | 32 | 2,4 | 25,1 | 125 | 7,95 | 80,00 | 40 |
| 6513571           | EVBHCL26J0433RC  | 4   | 26 | 3,4 | 21,5 | 110 | 7,95 | 66,00 | 33 |
| 6513575           | EVBHCL32J0433RC  | 4   | 32 | 3,4 | 25,1 | 110 | 7,95 | 66,00 | 33 |
| 6513573           | EVBHCL32K0440RC  | 4   | 32 | 3,4 | 25,1 | 125 | 7,95 | 80,00 | 40 |

SSC = To correspond with the SSC on the insert.



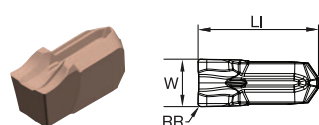
## BEYOND™ EVOLUTION™ • BLOCK FOR CUT-OFF BLADES WITH THROUGH COOLANT



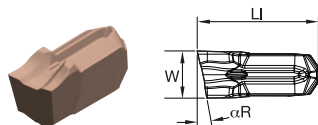
| order number | catalogue number | B2    | B     | F     | HW    | H     | H3    | L     | CS   |
|--------------|------------------|-------|-------|-------|-------|-------|-------|-------|------|
| 6543722      | EVTZN2020X26C    | 43,00 | 20,00 | 38,50 | 26,00 | 20,00 | 11,00 | 78,00 | G1/8 |
| 6543723      | EVTZN2020X32C    | 43,00 | 20,00 | 38,50 | 32,00 | 20,00 | 14,10 | 78,00 | G1/8 |
| 6543724      | EVTZN2525G26C    | 48,00 | 25,00 | 43,50 | 26,00 | 25,00 | 6,00  | 90,00 | G1/8 |
| 6543725      | EVTZN2525G32C    | 48,00 | 25,00 | 43,50 | 32,00 | 25,00 | 9,10  | 90,00 | G1/8 |

|     |     |    |   |     |
|-----|-----|----|---|-----|
|     |     |    |   |     |
| 120 | 122 | 34 | 4 | 124 |

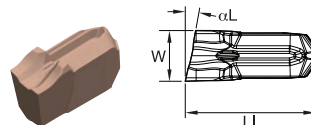
## BEYOND™ EVOLUTION™ • INSERTS • CF GEOMETRY



Neutral



Right Hand



Left Hand

● first choice

○ alternate choice

|   |   |
|---|---|
| P | ● |
| M | ● |
| K | ○ |
| N | ○ |
| S | ● |
| H | ○ |

| catalogue number | SSC | W     | W tol ± | LI    | αR | αL | RR   | KCU25 |
|------------------|-----|-------|---------|-------|----|----|------|-------|
| EC014M1BPL06CF00 | 1B  | 1,400 | 0,025   | 9,00  | —  | 6  | —    | ●     |
| EC014M1BPL12CF00 | 1B  | 1,400 | 0,025   | 9,00  | —  | 12 | —    | ●     |
| EC014M1BPN00CF00 | 1B  | 1,400 | 0,025   | 9,00  | —  | —  | —    | ●     |
| EC014M1BPN00CF01 | 1B  | 1,400 | 0,025   | 9,11  | —  | —  | 0,15 | ●     |
| EC014M1BPR06CF00 | 1B  | 1,400 | 0,025   | 9,00  | 6  | —  | —    | ●     |
| EC014M1BPR12CF00 | 1B  | 1,400 | 0,025   | 9,00  | 12 | —  | —    | ●     |
| EC020M02PL06CF00 | 2   | 2,000 | 0,025   | 8,95  | —  | 6  | —    | ●     |
| EC020M02PL12CF00 | 2   | 2,000 | 0,025   | 8,95  | —  | 6  | —    | ●     |
| EC020M02PN00CF00 | 2   | 2,000 | 0,025   | 8,94  | —  | —  | —    | ●     |
| EC020M02PN00CF02 | 2   | 2,000 | 0,025   | 9,04  | —  | —  | 0,20 | ●     |
| EC020M02PR06CF00 | 2   | 2,000 | 0,025   | 8,94  | 6  | —  | —    | ●     |
| EC020M02PR12CF00 | 2   | 2,000 | 0,025   | 8,95  | 6  | —  | —    | ●     |
| EC030M03PL06CF00 | 3   | 3,000 | 0,025   | 9,48  | —  | 6  | —    | ●     |
| EC030M03PL12CF00 | 3   | 3,000 | 0,025   | 9,48  | —  | 12 | —    | ●     |
| EC030M03PN00CF00 | 3   | 3,000 | 0,025   | 9,48  | —  | —  | —    | ●     |
| EC030M03PN00CF02 | 3   | 3,000 | 0,025   | 9,63  | —  | —  | 0,20 | ●     |
| EC030M03PR06CF00 | 3   | 3,000 | 0,025   | 9,48  | 6  | —  | —    | ●     |
| EC030M03PR12CF00 | 3   | 3,000 | 0,025   | 9,48  | 12 | —  | —    | ●     |
| EC040M04PL06CF00 | 4   | 4,000 | 0,025   | 10,01 | —  | 6  | —    | ●     |
| EC040M04PL12CF00 | 4   | 4,000 | 0,025   | 10,28 | —  | 12 | —    | ●     |
| EC040M04PN00CF00 | 4   | 4,000 | 0,025   | 10,01 | —  | —  | —    | ●     |
| EC040M04PN00CF02 | 4   | 4,000 | 0,025   | 10,16 | —  | —  | 0,20 | ●     |
| EC040M04PR06CF00 | 4   | 4,000 | 0,025   | 10,01 | 6  | —  | —    | ●     |
| EC040M04PR12CF00 | 4   | 4,000 | 0,025   | 10,28 | 12 | —  | —    | ●     |
| EC050M05PN00CF00 | 5   | 5,000 | 0,025   | 12,07 | —  | —  | —    | ●     |
| EC050M05PN00CF03 | 5   | 5,000 | 0,020   | 12,22 | —  | —  | 0,30 | ●     |

SSC = To correspond with the SSC on the toolholder.

|     |     |    |   |     |
|-----|-----|----|---|-----|
|     |     |    |   |     |
| 120 | 122 | 35 | 4 | 124 |



## BEYOND™ EVOLUTION™ • RECOMMENDED FEED RATES

- first choice
- alternate choice

|   |                    |
|---|--------------------|
| P | Steel              |
| M | Stainless Steel    |
| K | Cast Iron          |
| N | Non-Ferrous        |
| S | High-Temp Alloys   |
| H | Hardened Materials |

| Geometry | Description                                                                                                                                                                                                                  | Insert Geometry                                                                   | Seat Size (SSC) | Corner Radius | Starting Conditions | Cut-Off Feed Rates<br>mm/rev |      |      |      |      |      |      |      |
|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------|---------------|---------------------|------------------------------|------|------|------|------|------|------|------|
|          |                                                                                                                                                                                                                              |                                                                                   |                 | mm            | mm                  | 0,05                         | 0,10 | 0,15 | 0,20 | 0,25 | 0,30 | 0,35 | 0,40 |
| CF       | First choice in stainless steel, non-ferrous, and high-temperature materials.<br><br>Apply also press-to-size inserts in steel where smooth cutting is present or precision-ground inserts for applications with thin walls. |  | 1B              | 0,0           | 0,05                | ◀                            |      |      |      |      |      |      |      |
|          |                                                                                                                                                                                                                              |                                                                                   |                 | 0,1           | 0,06                | ◀                            |      |      |      |      |      |      |      |
|          |                                                                                                                                                                                                                              |                                                                                   | 2               | 0,0           | 0,06                | ◀                            |      |      |      |      |      |      |      |
|          |                                                                                                                                                                                                                              |                                                                                   |                 | 0,2           | 0,07                | ◀                            |      |      |      |      |      |      |      |
|          |                                                                                                                                                                                                                              |                                                                                   | 3               | 0,0           | 0,08                | ◀                            |      |      |      |      |      |      |      |
|          |                                                                                                                                                                                                                              |                                                                                   |                 | 0,2           | 0,09                | ◀                            |      |      |      |      |      |      |      |
|          |                                                                                                                                                                                                                              |                                                                                   | 4               | 0,0           | 0,08                | ◀                            |      |      |      |      |      |      |      |
|          |                                                                                                                                                                                                                              |                                                                                   |                 | 0,2           | 0,11                | ◀                            |      |      |      |      |      |      |      |
|          |                                                                                                                                                                                                                              |                                                                                   | 5               | 0,0           | 0,09                | ◀                            |      |      |      |      |      |      |      |
|          |                                                                                                                                                                                                                              |                                                                                   |                 | 0,3           | 0,13                | ◀                            |      |      |      |      |      |      |      |

NOTE: For cut-off inserts with a lead angle, maximum feed rate should be reduced by up to 40%.  
For more information on how to select a geometry reference, see the Kennametal Master Catalogue 2018, Volume I, page C12.

## Maximum Feed Rate Values

Data above is for P and K material groups. **Maximum** feed rates should be adjusted by multiplying max feed rate values by following factors for shown material groups.

| Material Group | Feed Factor |
|----------------|-------------|
| M              | .8          |
| N              | 1.2         |
| S              | .8          |
| H              | .5          |

# Coolant Accessories



[kennametal.com/CoolantAccessories](http://kennametal.com/CoolantAccessories)

Connecting Kennametal tooling to your machine is easy. Whether requiring heavy duty hoses capable of 350 bar (5,000 psi) or more flexible braided hoses capable of 210 bar (3,000 psi), we have you covered.

## Pre-assembled coolant kits

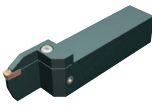
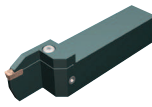
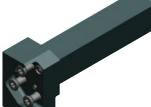
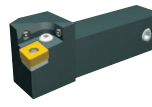
These kits connect Kennametal turning tooling to the industry's most common machines. The Kennametal universal coolant kits are ideal! Each kit contains the most common thread sizes with a variety of fitting styles for maximum flexibility.

## Know exactly what you need?

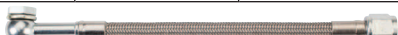
Knowing the precise components required will allow you to choose only the fittings you need! Each component is individually available, including less common fittings for your convenience.

## KITS • SELECTION GUIDE

## 1 STEP 1: Look for your application, holder style, and size.

| Application     | Cut-Off                                                                           |                                                                                   | Grooving                                                                          |                                                                                    |                                                                                     | Turning                                                                             |
|-----------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
| Holder Style    | Front clamp                                                                       | Top clamp                                                                         | Top clamp                                                                         | Top clamp                                                                          | Modular holder                                                                      | ISO turning holder                                                                  |
| Shank Size — mm | 12–20                                                                             | 12–20                                                                             | 12–20                                                                             | 25–40                                                                              | all                                                                                 | all                                                                                 |
|                 |  |  |  |  |  |  |

## 2 STEP 2: Find the matching coolant kits.

| Kit Description                          | Hose Type:    |               |               |               |               |               |
|------------------------------------------|-------------------------------------------------------------------------------------------------|---------------|---------------|---------------|---------------|---------------|
| Universal 200mm flex hose coolant kit    | •                                                                                               | •             | •             | •             | •             | •             |
| Universal 300mm flex hose coolant kit    | •                                                                                               | •             | •             | •             | •             | •             |
| Maximum Coolant Pressure Bar/psi         | 200 / 2901                                                                                      | 200 / 2901    | 200 / 2901    | 200 / 2901    | 200 / 2901    | 200 / 2901    |
| Kit Description                          | Hose Type:  |               |               |               |               |               |
| M8x1.0 banjo 200mm flex hose coolant kit | •                                                                                               | •             | •             |               |               |               |
| M8x1.0 banjo 300mm flex hose coolant kit | •                                                                                               | •             | •             |               |               |               |
| G 1/8 banjo 200mm flex hose coolant kit  |                                                                                                 |               |               | •             | •             | •             |
| G 1/8 banjo 300mm flex hose coolant kit  |                                                                                                 |               |               | •             | •             | •             |
| Maximum Coolant Pressure Bar/psi         | 200 / 2901                                                                                      | 200 / 2901    | 200 / 2901    | 200 / 2901    | 200 / 2901    | 200 / 2901    |
| Kit Description                          | Hose Type:  |               |               |               |               |               |
| Universal 200mm heavy-duty coolant kit   |                                                                                                 |               |               | •             | •             | •             |
| Universal 300mm heavy-duty coolant kit   |                                                                                                 |               |               | •             | •             | •             |
| Maximum Coolant Pressure Bar/psi         | 200 / 2901                                                                                      | * 350 / 5,076 | * 350 / 5,076 | * 350 / 5,076 | * 350 / 5,076 | * 350 / 5,076 |

\* Max pressure for seat size (SSC) 02 holders is 200 bar/2901 psi.

## KIT COMPONENTS

|                                          |                             |              | COMPONENT DESCRIPTION                                                             |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                     |                                                                                     |                                                                                     |                                                                                     |                                                                                     |                                                                                     |                                                                                     |
|------------------------------------------|-----------------------------|--------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
|                                          |                             |              | 1/16 NPTF MALE TO JIC MALE                                                        | 1/8 NPTF MALE TO JIC MALE                                                         | M8 X 1.25 MALE TO JIC MALE                                                        | M8 X 1.0 MALE TO JIC MALE                                                         | G1/8 MALE TO JIC MALE                                                             | M10 MALE TO JIC MALE                                                              | MALE JIC TO FEMALE JIC ELBOW                                                      | HEAVY DUTY 200MM COOLANT HOSE                                                     | HEAVY DUTY 300MM COOLANT HOSE                                                       | UNIV 200MM FLEX COOLANT HOSE                                                        | UNIV 300MM FLEX COOLANT HOSE                                                        | M8X1.0 BANJO 200MM FLEX HOSE                                                        | G1/8 BANJO 200MM FLEX HOSE                                                          | M8X1.0 BANJO 300MM FLEX HOSE                                                        | G1/8 BANJO 300MM FLEX HOSE                                                          |
|                                          |                             |              |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Kit Description                          | Catalogue Number            | Order Number |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                     |                                                                                     |                                                                                     |                                                                                     |                                                                                     |                                                                                     |                                                                                     |
| Universal 200mm flex hose coolant kit    | COOL-KIT-UNIVERSAL-FLEX-101 | 6475019      | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 |                                                                                   |                                                                                     | ●                                                                                   |                                                                                     |                                                                                     |                                                                                     |                                                                                     |                                                                                     |
| Universal 300mm flex hose coolant kit    | COOL-KIT-UNIVERSAL-FLEX-201 | 6475021      | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                 |                                                                                   |                                                                                     |                                                                                     | ●                                                                                   |                                                                                     |                                                                                     |                                                                                     |                                                                                     |
| M8x1.0 banjo 200mm flex hose coolant kit | COOL-KIT-FLEX-301B          | 6475023      |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 |                                                                                     |                                                                                     |                                                                                     | ●                                                                                   |                                                                                     |                                                                                     |                                                                                     |
| M8x1.0 banjo 300mm flex hose coolant kit | COOL-KIT-FLEX-401B          | 6475025      |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 |                                                                                     |                                                                                     |                                                                                     |                                                                                     |                                                                                     | ●                                                                                   |                                                                                     |
| G 1/8 banjo 200mm flex hose coolant kit  | COOL-KIT-FLEX-501B          | 6475027      |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 |                                                                                     |                                                                                     |                                                                                     |                                                                                     | ●                                                                                   |                                                                                     |                                                                                     |
| G 1/8 banjo 300mm flex hose coolant kit  | COOL-KIT-FLEX-601B          | 6475029      |                                                                                   |                                                                                   |                                                                                   |                                                                                   |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 |                                                                                     |                                                                                     |                                                                                     |                                                                                     |                                                                                     | ●                                                                                   |                                                                                     |
| Universal 200mm heavy-duty coolant kit   | COOL-KIT-101-HD             | 6145372      | ●                                                                                 | ●                                                                                 |                                                                                   |                                                                                   |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 | ●                                                                                   |                                                                                     |                                                                                     |                                                                                     |                                                                                     |                                                                                     |                                                                                     |
| Universal 300mm heavy-duty coolant kit   | COOL-KIT-201-HD             | 6145373      | ●                                                                                 | ●                                                                                 |                                                                                   |                                                                                   |                                                                                   | ●                                                                                 | ●                                                                                 | ●                                                                                 |                                                                                     | ●                                                                                   |                                                                                     |                                                                                     |                                                                                     |                                                                                     |                                                                                     |

## INDIVIDUAL KIT COMPONENT LIST



| order number | catalogue number      | description                                                                                                                                 |
|--------------|-----------------------|---------------------------------------------------------------------------------------------------------------------------------------------|
| 6145374      | 1-16NPTF-JIC          | Straight fitting, 1/16 NPTF male thread to JIC male thread                                                                                  |
| 6145375      | 1-8NPTF-JIC           | Straight fitting, 1/8 NPTF male thread to JIC male thread                                                                                   |
| 6145378      | M8X1.25-JIC           | Straight fitting, M8 x 1.25 male thread to JIC male thread                                                                                  |
| 6475041      | M8X1-JIC              | Straight fitting, M8 x 1.0 male thread to JIC male thread                                                                                   |
| 6145376      | G18-JIC               | Straight fitting, G 1/8 male thread to JIC male thread                                                                                      |
| 6145377      | M10X1.5-JIC           | Straight fitting, M10 x 1.5 male thread to JIC male thread                                                                                  |
| 6145379      | JICM-JICF-ELB         | Elbow fitting, male JIC thread to female JIC thread                                                                                         |
| 6145380      | COOL-HOSE-200-HD      | Heavy Duty 200mm Coolant hose with JIC female fitting both ends                                                                             |
| 6145381      | COOL-HOSE-300-HD      | Heavy Duty 300mm Coolant hose with JIC female fitting both ends                                                                             |
| 6432549      | COOL-HOSE-200-FLEX    | Flexible braided 200mm Coolant hose with JIC female fitting both ends                                                                       |
| 6432550      | COOL-HOSE-300-FLEX    | Flexible braided 300mm Coolant hose with JIC female fitting both ends                                                                       |
| 6475043      | M8X1-BAN-JIC-HOSE-200 | Flexible braided 200mm Coolant hose, M8 x 1.0 male thread to JIC female thread.<br>Contains (1) M8x1.0 banjo bolt and (2) M8 bonded washers |
| 6475045      | G18-BAN-JIC-HOSE-200  | Flexible braided 200mm Coolant hose, G 1/8 male thread to JIC female thread.<br>Contains (1) G 1/8 banjo bolt and (2) G 1/8 bonded washers  |
| 6475047      | M8X1-BAN-JIC-HOSE-300 | Flexible braided 300mm Coolant hose, M8 x 1.0 male thread to JIC female thread.<br>Contains (1) M8x1.0 banjo bolt and (2) M8 bonded washers |
| 6475049      | G18-BAN-JIC-HOSE-300  | Flexible braided 300mm Coolant hose, G 1/8 male thread to JIC female thread.<br>Contains (1) G 1/8 banjo bolt and (2) G 1/8 bonded washers  |

## COOLANT ACCESSORIES

The items shown below are not part of any coolant kits shown on previous pages.



| order number | catalogue number | description                                                |
|--------------|------------------|------------------------------------------------------------|
| 6145382      | M6X1-JIC         | Straight fitting, M6 x 1.0 male thread to JIC male thread  |
| 6145383      | JICM-JICM-STR    | Straight fitting, JIC male thread to JIC male thread       |
| 6145386      | G14-G18-RED      | Straight fitting, G 1/4 male thread to G 1/8th male thread |
| 6475058      | R18-JIC          | Straight fitting, 1/8 BSPT male thread to JIC male thread  |
| 6475059      | R14-JIC          | Straight fitting, 1/4 BSPT male thread to JIC male thread  |

## COOLANT SPARE PARTS

Included in kits; part of components.

| order number | catalogue number | description                      |
|--------------|------------------|----------------------------------|
| 6475051      | M8X1-BAN-BOLT    | Banjo bolt, M8 x 1.0 male thread |
| 6475053      | G18-BAN-BOLT     | Banjo bolt, G1/8 male thread     |
| 6475060      | M6-BON-WASHER    | M6 bonded washer                 |
| 6475055      | M8-BON-WASHER    | M8 bonded washer                 |
| 6475061      | M10-BON-WASHER   | M10 bonded washer                |
| 6475056      | G18-BON-WASHER   | G 1/8 bonded washer              |