

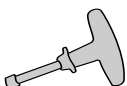

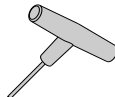



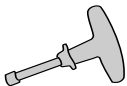

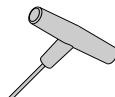



# Spare Parts and Accessories – Recommended Tightening Torque



drive size	screw catalog number	torque settings in./lbs. (Nm)	torque wrench catalog number	replaceable drive bits (1/4" drive shank)	T-handle wrenches	screwdriver style
 Torx drive						
T7	191.958 192.416 MS1017 MS1153 MS1882	10 (1,0)	—	—	—	DT7
T8	192.432 MS1186 MS1369 MS1405 SSN2T	10 (1,0)	—	—	—	DT8
T8	MS1861 MS1966 MS1969	15 (1,7)	—	—	—	DT8
T9	191.924 MS1027 S1011	20 (2,2)	KTW25	69709927454	—	DT9
T15	191.725 191.848 MS1129 MS1155 MS1156 MS1158 MS1168 MS1184 MS1273 MS1280 MS1281 MS1282 MS1283 MS1284 MS1285 MS1374 MS1492 MS1589 MS1872 MS1986 MS1987	35 (4,0)	KTW35	69709927469 or 6909928144 (3 1/2 O.A.L.)	TT15	DT15/BT15
T15	STCM35T15	45 (5,1)	KTW45	69709927469	TT15	DT15/BT15
T20	191.726 CFSS5125 S1012	45 (5,1)	KTW45	69709927482	TT20	—
T25	MS1221 MS1308 MS1309 MS1363 MS1891 S1934	45 (5,1)	KTW45	69709927489	TT25	—
T30	MS1493	60 (6,8)	—	69709927498	TT30	—
 hex drive		torque settings in./lbs. (Nm)				
5/64	STC-24 STC-27	20 (2,2)	KTW25	69709922172	KW078	—
3/32	S-995 STC-9 STC-34 STC-36	35 (4,0)	KTW35	69709922136	KW093	—
1/8	STC-11 STC-20 STC-32 STC-35	75 (8,5)	KTW75	69709922146	KW125	—
5/32	STC-8	75 (8,5)	KTW75	697099158	KW156	—
3/16	S-422 S-424	105 (11,9)	—	—	KW187	—
3,0 mm	STCM-35	75 (8,5)	KTW75	69709922164	KW3M	—

# Milling Screw Torque Value



Inserts  
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 End Mills  
 Die and Mold  
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milling cutter	screw number	torque in./lb.	torque (Nm)	thread	driver	insert catalog number
4.00...R311U	121.610	25	2.8	M6,0 x 1,00	170.003	4.21103R...
4.00...R313U	121.612	45	5	M6,0 x 1,00	KTW45	4.21503R...
Fix-Perfect 12 mm Cast Iron	121.612	45	5	M6,0 x 1,00	KTW45	SPHX1205....
Fix-Perfect 15 mm Cast Iron	121.616	45	5	M6,0 x 1,00	KTW45	SPHX15T6....
KGOR1.30T3-0-4	191.725	35	4.0	M4,0 x 0,70	T15	TPXW32.5NGL...
KGOR2.36T4-0-3	191.726	40	4.5	M5,0 x 0,80	T20	TPXW43.5NGL...
KGOR.078T7-0-2.5	191.958	10	1	M2,2 x 0,45	T7	TPXW71.5NGL...
Fix-Perfect 312 series cutters	192.134	45	5	M6,0 x 1,00	KTW45	4.21501R...
KFSR Face Mills	193.409	73	8.2	M5,0 x 0,80	TTP20	OF.64
Fix-Perfect 10 mm Cast Iron	420.060	45	5	M6,0 x 1,00	KTW45	MDHX1004....
Fix-Perfect 15 mm Aluminum	420.060	45	5	M6,0 x 1,00	KTW45	BGHX15L5....
KDNR200RN...	554.202	65	7.3	M6,0 x 1,00	4,0	RNG45T
KG50-15SS	CFS5125	40	4.5	M5,0 x 0,80	T20	GD2004R
KSSZR400GD2004L-90-5	CFS5125	40	4.5	M5,0 x 0,80	T20	GD2004L
MCF 0° & 45°	MS1017	10	1	M2,3 x 0,45	T7	SEKN42A6
	MS1026	15	1.7	M2,2 x 0,45	T8	SDEB2.61.52
Mini End Mills	MS1027	20	2.3	M3,0 x 0,50	T9	RPGB32.5
KISR__SE4453	MS1129	35	4.0	M4,5 x 0,75	T15	SEHW43A6T
KISR_00LF3.5_	MS1129	35	4.0	M4,5 x 0,75	T15	LFEW3.53_RLN
KISZR200XP2.53L-90-5	MS1129	35	4.0	M4,5 x 0,75	T15	XPCWL / XPMTL
KSPR...XD2.322	MS1168	35	4.0	M4,0 x 0,70	T15	XDMT2.32...
NGE-B End Mills	MS1168	35	4.0	M4,0 x 0,70	T15	ADKT2.32.8PDER5GB
	MS1169	40	4.5	M5,0 x 0,80	T20	
K90T16B Cartridge	MS1184	35	4.0	M4,0 x 0,70	T15	TPCW16T3PDR
KSSR...AP2.63...	MS1184	35	4.0	M4,0 x 0,70	T15	APKT1604PD...
NGE-B Face & End Mills	MS1184	35	4.0	M4,0 x 0,70	T15	ADKT2.32.8PDER5GB
	MS1185	10	1	M2,5 x 0,45	T7	TPCW1102PDR
	MS1186	10	1	M2,5 x 0,45	T8	XDCW150308
KAS - CNH1000 / 1200	MS1273	35	4.0	M4,0 x 0,70	T15	CNHQ1005R08
NGE-B ( HARVI )	MS1273	35	4.0	M4,0 x 0,70	T15	ADKT2.32.8PDER5GB
	MS1280	35	4.0	M4,0 x 0,70	T15	LNE1235
KS..LNE1240	MS1281	35	4.0	M4,0 x 0,70	T15	LNE1240
KS..LNE1245	MS1282	35	4.0	M4,0 x 0,70	T15	LNE1245
KS..LNE1250	MS1283	35	4.0	M4,0 x 0,70	T15	LNE1250
KS..LNE1255	MS1284	35	4.0	M4,0 x 0,70	T15	LNE1255
KS..LNE1255	MS1285	35	4.0	M4,0 x 0,70	T15	LNE1260
KAS-CNH1000	MS1308	40	4.5	M5,0 x 0,80	T25	CNHQ1005R08
KAS-CNH1200	MS1309	40	4.5	M5,0 x 0,80	T25	CNHQ1205R08
KMCR4S	MS1363	45	5	M6,0 x 1,00	T25	Steel Cartridge
Mini End Mills	MS1369	10	1	M2,5 x 0,45	T8	SDEB2.61.50
K90X15HB	MS1374	35	4.0	M4,5 x 0,75	T15	XDCW2.533R
KSSR---SE4-45-.	MS1374	35	4.0	M4,5 x 0,75	T15	SEHW43A6T
Index. End Mills - Center Cut.	MS1405	10	1	M2,5 x 0,45	T8	SDEB2.61.52D
KAS-CNH1600	MS1492	35	4.0	M5,0 x 0,80	T15	CNHQ1606R08
KAS-CNH1600	MS1493	60	6.8	M6,0 x 1,00	T30	CNHQ1606R08

# Milling Screw Torque Value (cont.)



milling cutter	screw number	toque. in./lb.	torque (Nm)	thread	driver	insert catalog number
	<b>MS1589</b>	20	2.3	M3,5 x 0,60	T15	
NGE-A Face & End Mills	<b>MS1861</b>	15	1.7	M2,5 x 0,45	T8	ADKT1035....
KSSR338RF5Z5	<b>MS1891</b>	45	5	M4,5 x 0,75	T25	RFCW53Z
NGE-II Face Mills	<b>MS1986</b>	35	4.0	M4,0 x 0,70	TT15	ANGT2.54....
NGE-II Face Mills	<b>MS1987</b>	35	4.0	M4,0 x 0,70	TT15	ANGT2.54....
KSSISR 0°, 15°, 45°	<b>MS2078</b>	35	4.0	M3,5 x 0,60	TTP15	SDET43, SEKT443, SDKT43
KSSP Helical End Mills	<b>MS2078</b>	35	4.0	M3,5 x 0,60	TTP15	SDET43...
KSSS Slotting Cutters	<b>MS2078</b>	35	4.0	M3,5 x 0,60	TTP15	SDET43...
KSSISR 0°	<b>MS2079</b>	35	4.0	M4,0 x 0,50	TTP15	SDET53PD...
Mill 1 Face & End Mills	<b>MS2126</b>	35	4.0	M3,5 x 0,60	TTP15	EDPT1805.....
KICR112SP30	<b>S1011</b>	20	2.3	#4 - 40	T9	SPEB322
KICR138SP40	<b>S1012</b>	40	4.5	#8 - 32	T20	SPEB422
KSSR239RF5Z4	<b>S1934</b>	40	4.5	#10 - 32	T25	RFCW53...
KSSR200RP...	<b>S1997</b>	55	6.2	#10 - 24	5/16	RPG43
KHDR6SN630	<b>S219</b>	105	11.9	1/4 - 28	3/16	GNEC65J2.5R10
KIPR0.8AE24-0	<b>S244</b>	75	8.5	#10 - 32	1/8	AEC2422
KIPR1AE24-0	<b>S245</b>	75	8.5	1/4 - 28	5/32	AEC2422
KIPR1.12AE24-0	<b>S246</b>	75	8.5	1/4 - 28	5/32	AEC2422
KACR_K90BPD100R	<b>S422</b>	105	11.9	1/4 - 28	KW-187	K90BPD100R
KIPR1.25AE24-0	<b>S994</b>	40	4.5	#10 - 32	3/32	AEC2422
KIPR1.25AE24-0	<b>S995</b>	40	4.5	#10 - 24	3/32	AEC2422
K045TM1RW050-STN11N	<b>SN2T</b>	10	1	M2,6 x 0,45	T8	STN11N
K079TM1RW075-STN16N	<b>SN3T</b>	30	3.4	#5 - 40	T10	STN16N
K067TM1RW062-STN16N	<b>SN3TM</b>	30	3.4	#5 - 40	T10	STN16N
K118TM1RW199-STN27N	<b>SN5TM</b>	40	4.5	M5,0 x 0,80	T25	STN27N
K035TM1RW050-STN10M	<b>SN7T</b>	10	1	M2,2 x 0,45	T7	STN10
KSSISR 0°, 15°, 45°	<b>SRS3</b>	40	4.5	M5,0 x 0,50	THW35M	SM455, SM451, SM449
KSSISR 0°	<b>SRS4</b>	40	4.5	M6,0 x 0,75	THW4M	SM450
KDNR4SN4-15CB	<b>STC11</b>	75	8.5	1/4 - 28	1/8	SNG433
KDSR-SP4-1MB	<b>STC11</b>	75	8.5	1/4 - 28	1/8	SPG433
KDNR6SN6-15CB	<b>STC20</b>	75	8.5	1/4 - 28	1/8	SNG633
KS64-OS4	<b>STC24</b>	20	2.3	#6 - 40	5/64	OSP4R / OSP4L
KCIR2RN408C	<b>STC25</b>	40	4.5	#10 - 32	3/32	RNMA43
KCIR1.2RN306C	<b>STC27</b>	20	2.3	#8 - 36	5/64	RNMA32
KHVR_TE3-OC	<b>STC32</b>	75	8.5	1/4 - 28	1/8	TEEN322J
KGOR-NG2 / NG3	<b>STC34</b>	40	4.5	#10 - 32	3/32	NG2062L
KFWPR4SP405C	<b>STC35</b>	75	8.5	1/4 - 28	1/8	SPG433
KL2IR_CN40	<b>STC36</b>	35	4.0	1/4 - 28	3/32	CNMA432
KL2SR_CN40	<b>STC36</b>	35	4.0	1/4 - 28	3/32	CNMA432
KS616-TP4	<b>STC4</b>	100	11.3	5/16 - 24	5/32	TPC432T
KS612-TP3	<b>STC5</b>	40	4.5	#10 - 32	3/32	TPC322T
KSSR_TP40.	<b>STC8</b>	75	8.5	5/16 - 24	5/32	TPG432
KISR/KSSR_TP30.	<b>STC9</b>	40	4.5	#10 - 32	3/32	TPG322
KFSR Face Mills	<b>STCM1115IP</b>	44	5.0	M6,0 x 1,00	TTP15	OF..64
MCF 0° & 45° wedge screw	<b>STCM35</b>	75	8.5	M6,0 x 1,00	3,0	SEKN42A6
	<b>STCM35T15</b>	55	6.2	1/4 - 28	T15	SEKN42A6

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