

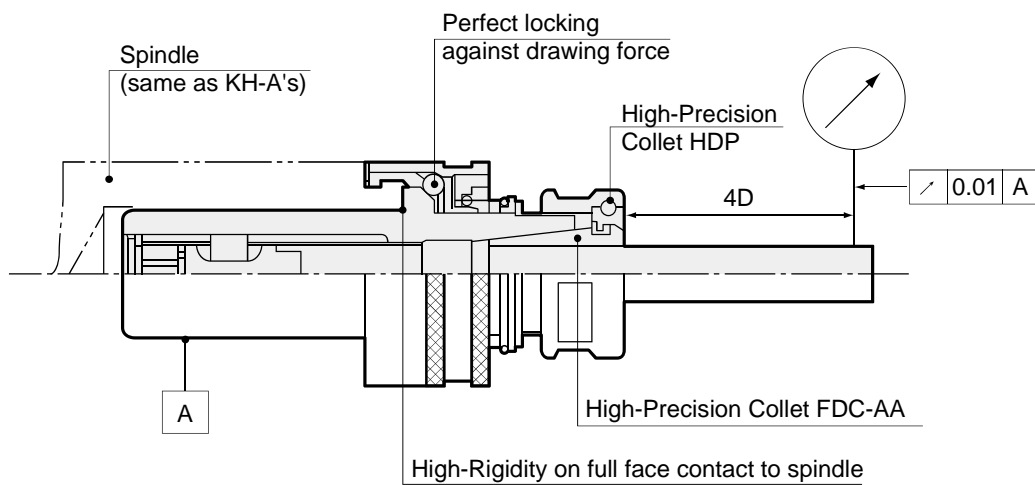
Quick Change Stub Holder KH-E

Application Endmilling

Feature

High Rigidity Special locking function assures rigid connection to the machine spindle.

High Precision High precision collet, runout is within 10 microns at 4xD (4 x tool shank dia. distance from nose of the holder).

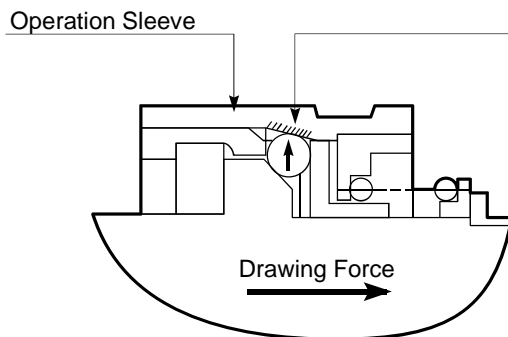


Significant Difference between KH-E and other stub holders

Eliminates axial tension.



Diffuses the pulling force caused by climb milling.



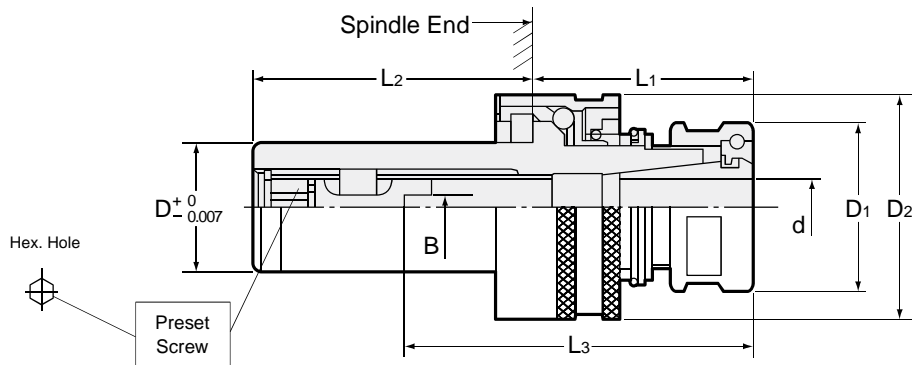
Enlarged Locking Function

The low-pitched taper on the operation sleeve secures the holder by the use of steel ball bearings which move readily and are locked into place by the drawing force.

Note • For center-thru coolant feed, please select KH-EC1 or KH-EC2 models.

Quick Change Stub Holder KH-E

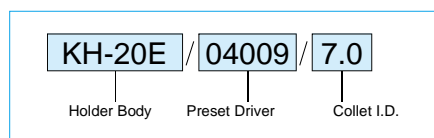
Holder Set — including nut, preset driver and collet



Part Number	D	Chucking Range	B	Preset Driver	L3	D1	D2	L1	L2	Collet	Nut
KH -12E	12	0.5 - 6.0	0	KHS -00006	23 - 43	23	24.3	34	35	FDC-d 07AA	HDP-07A
		3.1 - 5.0	2.4	KHS -02406							
		5.1 - 6.0	3.0	KHS -03006							
KH -14E	14	0.5 - 7.0	0	KHS -00007	23 - 43	23	26.3	34	35	FDC-d 07AA	HDP-07A
		3.1 - 5.0	2.4	KHS -02407							
		5.1 - 6.0	3.0	KHS -03007							
		6.1 - 7.0	4.0	KHS -04007							
KH -16E	16	2.6 - 9.0	0	KHS -00009	29 - 45	26	32	35	40	FDC-d 09AA	HDP-09
		3.1 - 5.0	2.4	KHS -02409							
		5.1 - 6.0	3.0	KHS -03009							
		6.1 - 9.0	4.0	KHS -04009							
KH -19E	19	2.6 - 9.0	0	KHS -00009	29 - 50	26	35	35	45	FDC-d 09AA	HDP-09
		3.1 - 5.0	2.4	KHS -02409							
		5.1 - 6.0	3.0	KHS -03009							
KH -20E	20	6.1 - 9.0	4.0	KHS -04009	34 - 56						
KH -22E	22	2.6 - 12	0	KHS -00012	35 - 57	32	38	35	55	FDC-d 12AA	HDP-12
		3.1 - 5.0	2.4	KHS -02412							
		5.1 - 6.0	3.0	KHS -03012							
		6.1 - 9.0	4.0	KHS -04012							
KH -24E	24	9.1 - 12	5.0	KHS -05012	37 - 64		40				
		3.6 - 16	0	KHS -00016	38 - 60 (65)	36	44	35	60	FDC-d 16AA	HDP-16
		3.6 - 5.0	2.4	KHS -02416							
		5.1 - 6.0	3.0	KHS -03016							
6.1 - 9.0	4.0	KHS -04016									
KH -25E	25	9.1 - 12	5.0	KHS -05016	42 - 64 (69)						
		12.1 - 16	6.0	KHS -06016	47 - 69 (74)		47		65		
		3.6 - 22	0	KHS -00022	38 - 74		51				
		3.6 - 5.0	2.4	KHS -02422	39 - 75						
KH -30E	30	5.1 - 6.0	3.0	KHS -03022	42 - 78	46		40	80	FDC-d 22AA	HDP-22
		6.1 - 9.0	4.0	KHS -04022							
		9.1 - 12	5.0	KHS -05022							
		12.1 - 16	6.0	KHS -06022							
KH -32E	32	16.1 - 22	8.0	KHS -08022	54 - 87		55				
		20.1 - 32	0	KHS -00032	45 - 85	66	75	50	100	FDC-d 32A	HDP-32
		20.1 - 32	8.0	KHS -08032							
		22.1 - 32	12.0	KHS -12032							
			67 - 107								

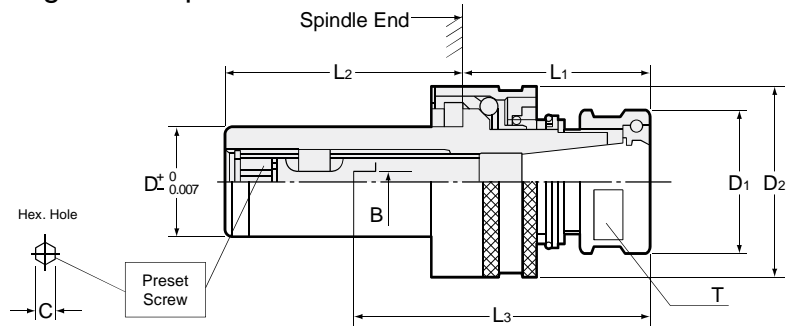
- All dimensions shown in millimeters.
- Spanner wrench is sold separately. (Page 60)

Ordering Example



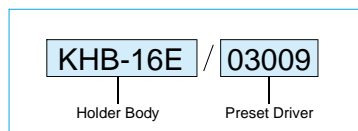
Quick Change Stub Holder KH-E

Holder Body — including nut and preset driver.



Part Number	D 0 -0.007	D1	D2	B	L1	L2	L3	T	C
KHB- 12E /	00006		-	-			23 - 43		
	02406	12	23	2.4			25 - 46		3
	03006			3					
KHB- 14E /	00007			-	34	35	23 - 43	-	
	02407	14	23	2.4			25 - 46		4
	03007			3					
	04007			4					
KHB- 16E /	00009			-			29 - 45		
	02409	16	26	2.4		40	32 - 49	24	4
	03009			3			34 - 51		
	04009			4					
KHB- 19E /	00009			-			29 - 45		
	02409	19	26	2.4		45	32 - 49	24	4
	03009			3			34 - 56		
	04009			4					
KHB- 22E /	00012			-			35 - 57		
	02412	22	32	2.4	35	55	33 - 60	30	5
	03012			3					
	04012			4			37 - 64		
	05012			5					
KHB- 25E /	00016	25		-			38 - 60 (65)		
	02416		36	2.4		60	36 - 58 (63)		
	03016	26		3			39 - 58 (63)	33	6
	04016	28		4			42 - 64 (69)		
	05016			5		65	47 - 69 (74)		
	06016	30		6			50 - 72 (77)		
KHB- 32E /	00022	32		-			38 - 74		
	02422		46	2.4			39 - 75		
	03022			3					
	04022	35		4	40	80	42 - 78	42	6
	05022			5			48 - 84		
KHB- 36E /	06022			6			54 - 87		
	08022	36		8					
KHB- 48E /	00032			-			45 - 85		
	08032	48	66	8	50	100	51 - 91	-	6
	12032			12			67 - 107		

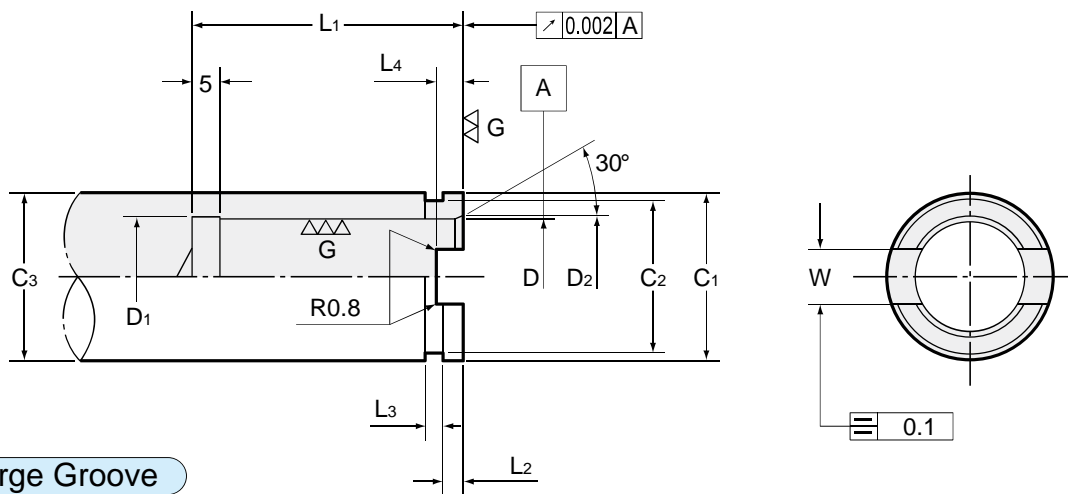
Ordering Example



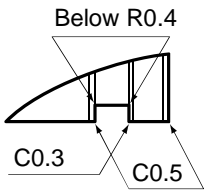
- All dimensions shown in millimeters.
- L₃ in brackets stands for max. dimensions for the KH-28E and KH-30E only.
- Collet and spanner wrench are sold separately. (Page 60)

Quick Change Stub Holder

Spindle Standard for KH - E



Enlarge Groove



Note

- All corners not specified should be chamfered to C0.5.
- The material of the spindle face is SCM415. Heat treatment HV613-697. Carburized depth 0.4 - 0.6mm.

Nominal Size	D +0.010 +0.005	D ₁	D ₂	C ₁ 0 -0.1	C ₂ 0 -0.1	C ₃	L ₁	L ₂ +0.1 0	L ₃	W C10	L ₄
12E	12	12.4	13.5	18	16.5	18or more	38	2.5	2.5	6	3.5
14E	14	14.4	15.5	22	20	20or more				8	
16E	16	16.4	17.5	26.4	24	25or more	43	3.5	3.0	10	4.5
19E	19	19.4	20.5	29.4	27	28or more	48				
20E	20	20.4	21.5			32or more	30				
22E	22	22.4	23.5	32	35						
24E	24	24.4	25.5	34.4		38	40or more				
25E	25	25.4	26.5	37.4	41						
26E	26	26.4	27.5	47.8		45	65or more	103			
28E	28	28.4	29.5		40.4			38	40or more	68	
30E	30	30.4	31.5	47.8	45	65or more	103				
32E	32	32.4	33.5				43.8	41	45or more	83	
35E	35	35.4	36.5	47.8	45	65or more	103				
36E	36	36.4	37.5				43.8	41	45or more	83	
48E	48	48.4	49.5	65.4	62	65or more	103	4.5	4.0	11	5.5

• All dimensions shown in millimeters.

Quick Change Stub Holder KH-E

End-milling Cutting Parameters

Shape	Material	Cutter's dia	Rotation (min ⁻¹)	Feed (mm/min)	L Max. Cutting Length L			
					KH16E	KH22E	KH26E	KH35E
	Aluminum (AC4C)	φ 6	4,000	387	1D	1D	—	—
		φ 12	3,150	400	—	1D	1D	—
		φ 16	2,000	345	—	—	0.75D	0.75D
		φ 20	1,000	315	—	—	—	0.5D
	Cast Iron (FC25)	φ 6	2,240	150	0.75D	1D	—	—
		φ 12	1,000	190	—	0.75D	0.75D	—
		φ 16	800	170	—	—	1D	0.75D
		φ 20	630	160	—	—	—	0.5D
	Steel (S45C)	φ 6	1,000	48	1D	1D	—	—
		φ 12	450	60	—	0.75D	1D	—
		φ 16	355	60	—	—	0.5D	0.5D
		φ 20	280	56	—	—	—	0.5D
	Aluminum (AC4C)	φ 6	9,000	1,000	0.3D	0.3D	—	—
		φ 12	4,000	1,180	—	0.3D	0.3D	—
		φ 16	3,150	1,060	—	—	0.3D	0.2D
		φ 20	2,500	1,000	—	—	—	0.1D
	Cast Iron (FC25)	φ 6	2,650	355	0.1D	0.1D	—	—
		φ 12	1,180	450	—	0.2D	0.2D	—
		φ 16	950	400	—	—	0.2D	0.1D
		φ 20	750	375	—	—	—	0.1D
	Steel (S45C)	φ 6	1,320	125	0.2D	0.2D	—	—
		φ 12	600	160	—	0.2D	0.2D	—
		φ 16	470	160	—	—	0.2D	0.1D
		φ 20	375	150	—	—	—	0.1D

• All dimensions shown in millimeters.