

THE NEW VALUE FRONTIER



Milling

OTM-Milling Product Lineup



End Mills



Face Mills



Chamfer Mills





Custom Milling Cutters



ADVANCING PRODUCTIVITY

Product Lineup

	Description	Shape	Cutting Diameter	Applicable Insert	No. of Inserts
End Mills	EM - Small Diameter		0.438" - 0.875"	XPMT 0902	1~2
	EM - Large Diameter		0.625" - 1.500"	XPMT 0902 & XPMT 15T3	1~2
	EM - Extended Length		1.000"	XPMT 15T3	2
	EM - Long Edge		1.250" - 2.000"	XPMT 15308 & XPMT 15T3	6~10
	EM - Aluminum Cutting		0.750" - 2.000"	APET 0803 & APET 1604	2
	EM - Extended Length Aluminum Cutting		1.000" - 1.250"	APET 1604	2
Face Mills	FM Integral Shank Facemill		1.500"	XPMT 15T3	2
	FM Fixed Pocket Facemill		2.000" ~ 3.000"	XPMT 15T3	3~4
	FM-AL Aluminum Cutting Facemill		2.500" - 5.000"	APET	3~8

	Description	Shape	Lead Angle	Applicable Insert	No. of Inserts
Chamfer Mills	CM Chamfer Mill		3°-75°	XPMT	2
	CM-AL Aluminum Cutting Chamfer Mill		15°-75°	APET	2

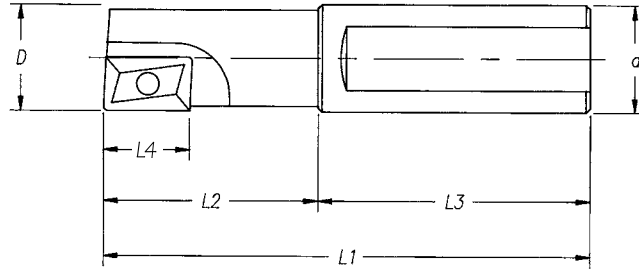
EM

Small Diameter End Mills

Reference page 12 for Insert Selection
Reference page 5 for Machining Recommendations



Single Flute



Description	Stock	Dimension (Inch)						Spare Parts		Inserts	
		D	d	L1	L2	L3	L4	Screw	Head	Applicable Insert	Insert Qty.
EM 0437-09*	●	0.438	0.500	2.78	1	1.78	0.37	SCR-04	T7	XPMT 0902	1
EM 0500-09*	●	0.500	0.500	2.78	1	1.78	0.37				
EM 0562-09**	●	0.563	0.500	2.78	1	1.78	0.37				

* Capable of ramping at 3° max
** Capable of ramping at 8° max

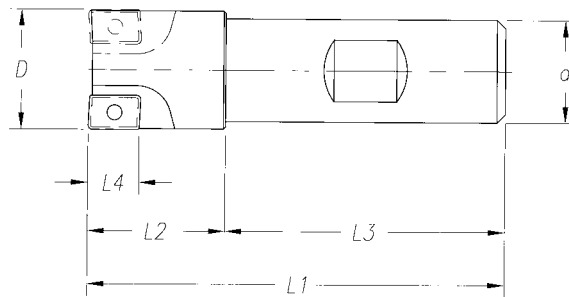
●:Stock Standard

Small Diameter End Mills

Reference page 12 for Insert Selection
Reference page 5 for Machining Recommendations



Two Flute



Description	Stock	Dimension (Inch)						Spare Parts		Inserts	
		D	d	L1	L2	L3	L4	Screw	Head	Applicable Insert	Insert Qty.
EM 0625-09*	●	0.625	0.625	2.90	1	1.90	0.37	SCR-04	T7	XPMT 0902	2
EM 0688-09*	●	0.688	0.625	2.90	1	1.90	0.37				
EM 0750-09*	●	0.750	0.625	3.03	1	2.03	0.37				
EM 0875-09*	●	0.875	0.625	3.03	1	2.03	0.37				

* Capable of ramping at 8° max

●:Stock Standard



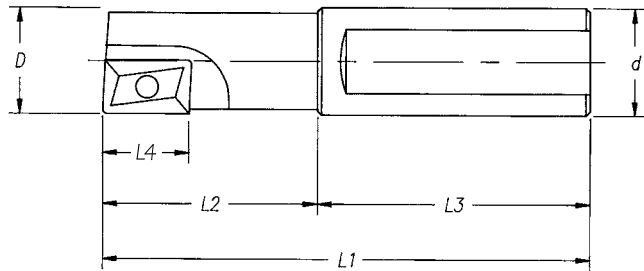
EM

Large Diameter End Mills

Reference page 12 for Insert Selection
Reference page 5 for Machining Recommendations



Single Flute



Description	Stock	Dimension (Inch)						Spare Parts		Inserts	
		D	d	L1	L2	L3	L4	Screw	Head	Applicable Insert	Insert Qty.
EM 0625★*	●	0.625	0.750	2.90	1	1.90	0.60	SCR-16	T10	XPMT 15T3	1
EM 0688*	●	0.688	0.750	3.40	1.50	1.90	0.60				
EM 0750*	●	0.750	0.750	3.40	1.50	1.90	0.60				
EM 0813**	●	0.813	0.750	3.40	1.50	1.90	0.60				
EM 0875**	●	0.875	0.750	3.40	1.50	1.90	0.60				

★ The EM 0625 is designed for light cuts only because it has a large insert in a small diameter mill.

●:Stock Standard

* Capable of ramping at 3° max

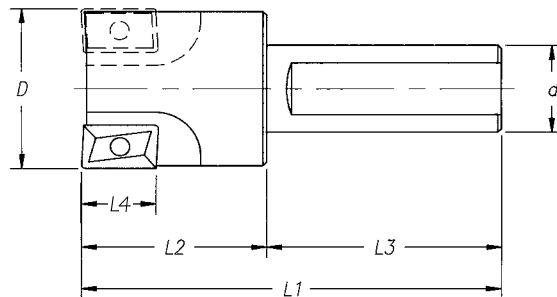
* Capable of ramping at 8° max

Large Diameter End Mills

Reference page 12 for Insert Selection
Reference page 5 for Machining Recommendations



Two and Three Flute



Description	Stock	Dimension (Inch)						Spare Parts		Inserts	
		D	d	L1	L2	L3	L4	Screw	Head	Applicable Insert	Insert Qty.
EM 0938*	●	0.938	0.750	3.40	1.50	1.90	0.60	SCR-16	T10	XPMT 15T3	2
EM 1000-09-3F*	●	1.000	0.750	3.03	1.00	2.03	0.37	SCR-01	T7	XPMT 0902	3
EM 1000*	●	1.000	0.750	3.40	1.50	1.90	0.60	SCR-16	T10	XPMT 15T3	2
EM 1000-1005*	●	1.000	1.000	3.78	1.50	2.28	0.60	SCR-16	T10		2
EM 1125*	●	1.125	0.750	3.40	1.50	1.90	0.60	SCR-30	T10		2
EM 1250	●	1.250	0.750	3.40	1.50	1.90	0.60	SCR-30	T10		2
EM 1250-3F*	●	1.250	1.000	3.78	1.50	2.28	0.60	SCR-30	T10		3
EM 1375*	●	1.375	0.750	3.40	1.50	1.90	0.60	SCR-30	T10		2
EM 1500*	●	1.500	0.750	3.40	1.50	1.90	0.60	SCR-30	T10		2
EM 1500-3F*	●	1.500	1.000	3.78	1.50	2.28	0.60	SCR-30	T10		3

* Capable of ramping at 8° max

●:Stock Standard

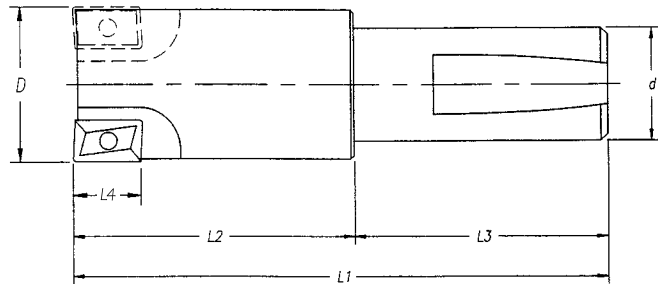
EM

Extended Length End Mills

Reference page 12 for Insert Selection



Two Flute



Description	Stock	Dimension (Inch)						Spare Parts		Inserts	
		D	d	L1	L2	L3	L4	Screw	Head	Applicable Insert	Insert Qty.
EM 100-2.5*	●	1.000	0.750	4.40	2.50	1.90	0.60	SCR-16	T10	XPMT 15T3	2
EM 100-3.5*	●	1.000	1.000	5.78	3.50	2.28	0.60				
EM 1250-2.5*	●	1.000	1.000	4.78	2.50	2.28	0.60				

* Capable of ramping at 8° max

●: Stock Standard

EM Recommended Cutting Conditions (Small Diameter, Large Diameter, Extended Length)

Work Material	Feed Rate (ipt)	Recommended Grade (Cutting Speed: SFM)					
		Cermet	PVD Coated Carbide			CVD Coated Carbide	Uncoated Carbide
		TC60	PR660	PR830	PR905	CA2335	KW10
Stainless Steel	Carbide: .003~.011 Cermet: .002~.007		☆ 150~300	★ 150~600			
Carbon Steel	Carbide: .004~.010 Cermet: .002~.007	☆ 300~1000	★ 250~550	☆ 200~650		★ 300~600	
Alloy Steel	Carbide: .004~.008 Cermet: .002~.005	☆ 300~750	★ 250~550	☆ 150~600		★ 300~600	
Metal Mold Steel	Carbide: .003~.011 Cermet: .002~.007	★ 225~550		★ 200~550		☆ 180~540	
Cast Iron	.002~.012				☆ 100~800		★ 100~500
Non-ferrous Metal	.002~.012	★ 1500~1800					☆ 500~1200

☆: 1st Recommendation

★: 2nd Recommendation



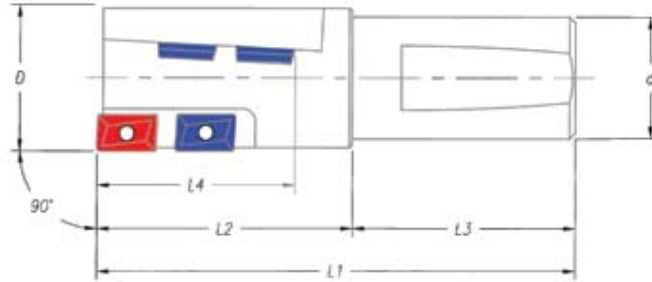
EM

Long Edge End Mills

Reference page 12 for Insert Selection



Two Flute



Description	Stock	Dimension (Inch)						Spare Parts		Inserts	
		D	d	L1	L2	L3	L4	Screw	Head	Applicable Insert	Insert Qty.
EM 1250-1500-LE	●	1.250	1.000	4.41	2.13	2.28	1.50	SCR-16	T10	XPMT 15T3*	6
EM 1500-2000-LE	●	1.500	1.250	4.91	2.63	2.28	2.00	SCR-30			8
EM 2000-2775-LE	●	2.000	1.500	6.25	3.50	2.75	2.77	SCR-30			10

* XPMT 15T3__ to be chosen for RED insert pockets based on shoulder wall radius requirement.
XPMT 15T308 to be used in all BLUE insert pockets.

●:Stock Standard

EM Recommended Cutting Conditions (Small Diameter, Large Diameter, Extended Length)

Work Material	Feed Rate (ipt)	Recommended Grade (Cutting Speed: SFM)					
		Cermet	PVD Coated Carbide			CVD Coated Carbide	Uncoated Carbide
		TC60	PR660	PR830	PR905	CA2335	KW10
Stainless Steel	Carbide: .003~.011 Cermet: .002~.007		☆ 150~300	★ 150~600			
Carbon Steel	Carbide: .004~.010 Cermet: .002~.007	☆ 300~1000	★ 250~550	☆ 200~650		★ 300~600	
Alloy Steel	Carbide: .004~.008 Cermet: .002~.005	☆ 300~750	★ 250~550	☆ 150~600		★ 300~600	
Metal Mold Steel	Carbide: .003~.011 Cermet: .002~.007	★ 225~550		★ 200~550		☆ 180~540	
Cast Iron	.002~.012				☆ 100~800		★ 100~500
Non-ferrous Metal	.002~.012	★ 1500~1800					☆ 500~1200

☆: 1st Recommendation
★: 2nd Recommendation

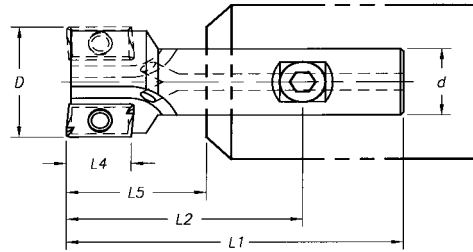
EM--AL

Aluminum Cutting End Mills

Reference page 12 for Insert Selection



Two and Three Flute



Description	Stock	Dimension (Inch)						Spare Parts		Inserts	
		D	d	L1	L2	L4	L5	Screw	Head	Applicable Insert	Insert Qty.
EM 0750-AL	●	0.750	0.750	3.360	2.351	0.300	1.350	SCR-01	T7	APET 0803	2
EM 0875-AL	●	0.875	0.750	3.360	2.351	0.300	1.350				2
EM 1000-AL	●	1.000	0.750	3.380	2.365	0.640	1.360	SCR-02	T15	APET 1604	2
EM 1250-AL	●	1.250	0.750	3.380	2.365	0.640	1.360				2
EM 1500-AL	●	1.500	1.000	4.000	2.864	0.640	1.740				2
EM 2000-AL	●	2.000	1.000	4.250	3.110	0.640	1.990				3

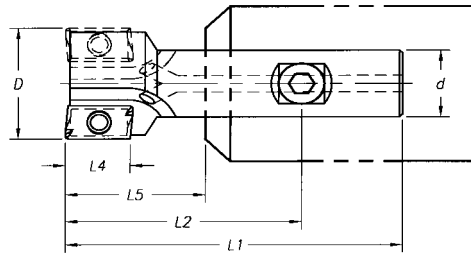
●:Stock Standard

Extended Length Aluminum Cutting End Mills

Reference page 12 for Insert Selection



Two Flute



Description	Stock	Dimension (Inch)						Spare Parts		Inserts	
		D	d	L1	L2	L4	L5	Screw	Head	Applicable Insert	Insert Qty.
EM 1000-2.75-AL	●	1.000	0.750	4.780	3.780	0.640	2.750	SCR-02	T15	APET 1604	2
EM 1000-3.75-AL	●	1.000	1.000	6.015	4.875	0.640	3.750				2
EM 1250-2.125-AL	●	1.250	1.000	4.433	3.293	0.640	2.125				2

●:Stock Standard

EM-AL Recommended Cutting Conditions

Work Material	Feed Rate (ipt)	Recommended Grade (Cutting Speed: SFM)	
		Uncoated Carbide	
		CW12	
Non-ferrous Metal	0.004~0.012	990~1650	



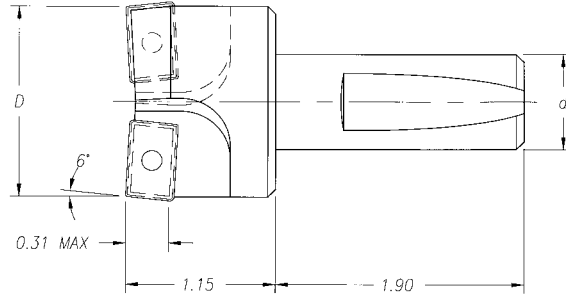
FM

Integral Shank Face Mills

Reference page 12 for Insert Selection
Reference page 9 for Machining Recommendations



Two Flute



Description	Stock	Unit	D	d	Lead Angle	Screw	Head	Applicable Insert	Insert Qty.
FM 1500-6 RH	●	Inch	1.500	0.750	6°	SCR-30	T10	XPMT 15T3	2

●:Stock Standard

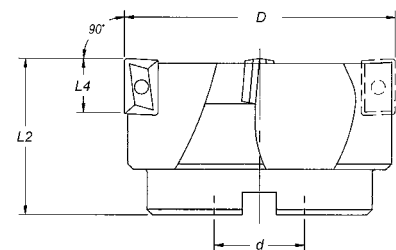
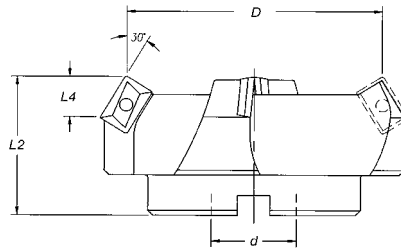
FM

Fixed Pocket Face Mills

Reference page 12 for Insert Selection
Reference page 9 for Machining Recommendations



Three and Four Flute



Description	Stock	Unit	D	Lead Angle	L2	L4	d	K'way	Screw	Head	Applicable Insert	Insert Qty.
FM 2000-30 RH/LH	●	Inch	2.000	30°	1.344	0.50	1.000	0.375	SCR-30	T10	XPMT 15T3	3
FM 2000-90 RH	●		2.000	0°	1.406	0.60	0.750	0.313	SCR-30	T10		3
FM 3000-30 RH/LH	●		3.000	30°	1.719	0.50	1.000	0.375	SCR-30	T10		4
FM 3000-90 RH	●		3.000	0°	1.781	0.60	1.000	0.375	SCR-30	T10		4

●:Stock Standard



FM Recommended Cutting Conditions

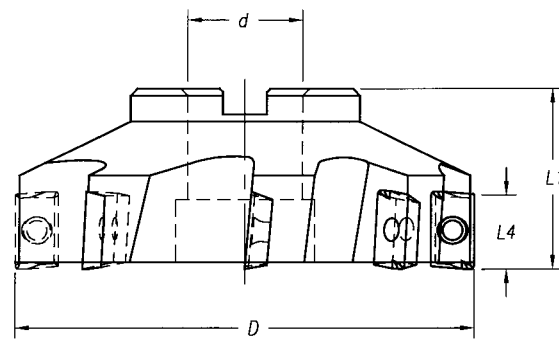
Work Material	Feed Rate (ipt)	Recommended Grade (Cutting Speed: SFM)					
		Cermet	PVD Coated Carbide			CVD Coated Carbide	Uncoated Carbide
		TC60	PR660	PR830	PR905	CA2335	KW10
Stainless Steel	Carbide: .003~.011 Cermet: .002~.007		☆ 150~300	★ 150~600			
Carbon Steel	Carbide: .004~.010 Cermet: .002~.007	☆ 300~1000	★ 250~550	☆ 200~650		★ 300~600	
Alloy Steel	Carbide: .004~.008 Cermet: .002~.005	☆ 300~750	★ 250~550	☆ 150~600		★ 300~600	
Metal Mold Steel	Carbide: .003~.011 Cermet: .002~.007	★ 225~550		★ 200~550		☆ 180~540	
Cast Iron	.002~.012				☆ 100~800		★ 100~500
Non-ferrous Metal	.002~.012	★ 1500~1800					☆ 500~1200

☆: 1st Recommendation
★: 2nd Recommendation

FM--AL

Aluminum Cutting Face Mills

Reference page 12 for Insert Selection



Description	Stock	Unit	Cutting Diameter	Lead Angle	L1	L4	D	Keyway	Screw	Head	Applicable Insert	Insert Qty.
FM-AL-2500-90-3	●	Inch	2.500	0°	1.570	0.640	0.750	0.375	SCR-02	T15	APET 1604	3
FM 3000-90-AL	●		3.000	0°	1.570	0.640	1.000	0.375				6
FM 4000-90-AL	●		4.000	0°	1.570	0.640	1.000	0.375				8
FM 4000-90-AL-125	●		4.000	0°	1.570	0.640	1.250	0.500				8
FM-AL-4000-90-5	●		4.000	0°	1.570	0.640	1.000	0.375				5
FM 5000-90-AL	●		5.000	0°	1.570	0.640	1.250	0.500				8

FM-AL Recommended Cutting Conditions

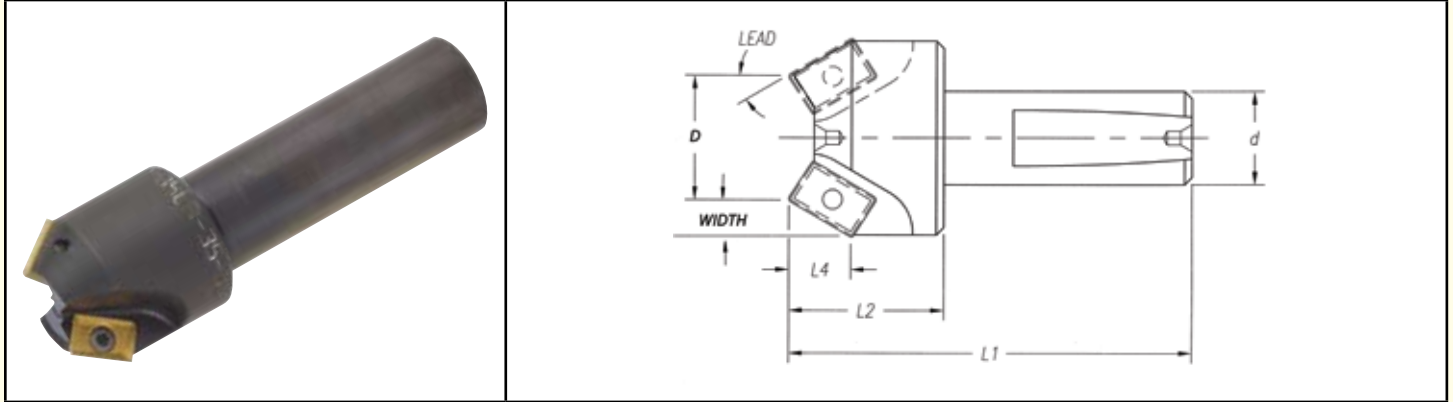
Work Material	Feed Rate (ipt)	Recommended Grade (Cutting Speed: SFM)	
		Uncoated Carbide	
		CW12	
Non-ferrous Metal	.002~.012	500~1200	



CM

Chamfer Mills

Reference page 12 for Insert Selection
Reference page 11 for Machining Recommendations



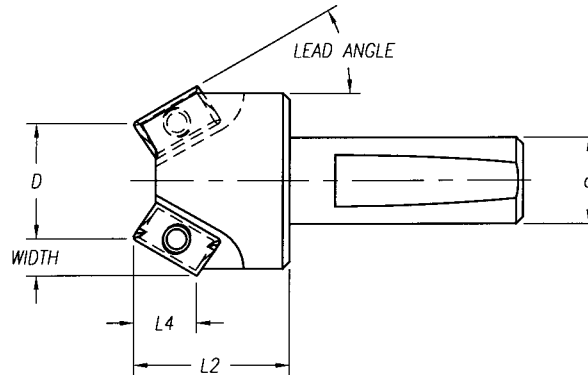
Description	Stock	Lead Angle (°)	D	d	Width	L4	L1	L2	Screw	Wrench	Applicable Insert	Insert Qty.
CM 0563-15-09	●	15	0.563	0.500	0.089	0.340	2.78	1.00	SCR-04	T7	XPMT 0902	
CM 0563-20-09	●	20	0.563	0.500	0.116	0.330	2.78	1.00				
CM 0563-25-09	●	25	0.563	0.500	0.143	0.310	2.78	1.00				
CM 0563-30-09	●	30	0.563	0.625	0.169	0.300	2.91	1.00				
CM 0563-35-09	●	35	0.563	0.625	0.194	0.280	2.91	1.00				
CM 0563-45-09	●	45	0.563	0.625	0.239	0.240	2.91	1.00				
CM 0563-60-09	●	60	0.563	0.625	0.301	0.160	2.91	1.00				
CM 0563-75-09	●	75	0.563	0.625	0.327	0.080	2.91	1.00				
CM 1000-03	●	3	1.000	0.750	0.031	0.589	3.15	1.25				
CM 1000-05	●	5	1.000	0.750	0.052	0.586	3.15	1.25				
CM 1000-10	●	10	1.000	0.750	0.103	0.577	3.15	1.25				
CM 1000-15	●	15	1.000	0.750	0.154	0.564	3.15	1.25				
CM 1000-20	●	20	1.000	0.750	0.204	0.547	3.15	1.25				
CM 1000-25	●	25	1.000	0.750	0.252	0.526	3.15	1.25				
CM 1000-30	●	30	1.000	0.750	0.298	0.501	3.15	1.25	SCR-30	T10	XPMT 15T3	
CM 1000-35	●	35	1.000	0.750	0.343	0.472	3.15	1.25				
CM 1000-37.5	●	37.5	1.000	0.750	0.372	0.456	3.15	1.25	SCR-30	T10	XPMT 15T3	
CM 1000-41	●	41	1.000	0.750	0.393	0.433	3.15	1.25				
CM 1000-45	●	45	1.000	0.750	0.400	0.400	3.15	1.25				
CM 1000-50	●	50	1.000	0.750	0.454	0.376	3.15	1.25				
CM 1000-55	●	55	1.000	0.750	0.507	0.327	3.15	1.25				
CM 1000-60	●	60	1.000	0.750	0.521	0.284	3.15	1.25				
CM 1000-70	●	70	1.000	0.750	0.547	0.193	3.15	1.25				
CM 1000-75	●	75	1.000	0.750	0.584	0.146	3.15	1.25				

●: Stock Standard

CM-AL

Chamfer Mills

Reference page 12 for Insert Selection



Description	Stock	Lead Angle (°)	D	d	Width	L4	L2	Screw	Wrench	Applicable Insert	Insert Qty.
CM 1000-15-AL	●	15	1.000	0.750	0.158	0.613	1.350	SCR-02	T15	APET 1604	2
CM 1000-20-AL	●	20	1.000	0.750	0.208	0.595	1.350				
CM 1000-30-AL	●	30	1.000	0.750	0.304	0.544	1.350				
CM 0800-45-AL	●	45	0.800	0.750	0.430	0.440	1.350				
CM 0800-60-AL	●	60	0.800	0.750	0.528	0.308	1.350				
CM 0690-75-AL	●	75	0.690	0.750	0.591	0.158	1.350				

●: Stock Standard

■ CM Recommended Cutting Conditions

Work Material	Feed Rate (ipt)	Recommended Grade (Cutting Speed: SFM)					
		Cermet	PVD Coated Carbide			CVD Coated Carbide	Uncoated Carbide
		TC60	PR660	PR830	PR905	CA2335	KW10
Stainless Steel	Carbide: .003~.011 Cermet: .002~.007		☆ 150~300	★ 150~600			
Carbon Steel	Carbide: .004~.010 Cermet: .002~.007	☆ 300~1000	★ 250~550	☆ 200~650		★ 300~600	
Alloy Steel	Carbide: .004~.008 Cermet: .002~.005	☆ 300~750	★ 250~550	☆ 150~600		★ 300~600	
Metal Mold Steel	Carbide: .003~.011 Cermet: .002~.007	★ 225~550		★ 200~550		☆ 180~540	
Cast Iron	.002~.012				☆ 100~800		★ 100~500
Non-ferrous Metal	.002~.012	★ 1500~1800					☆ 500~1200

☆: 1st Recommendation

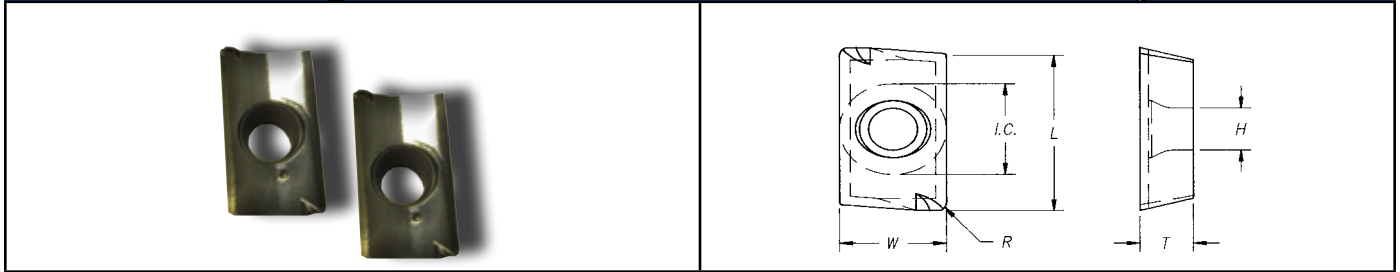
★: 2nd Recommendation

■ CM-AL Recommended Cutting Conditions

Work Material	Feed Rate (ipt)	Recommended Grade (Cutting Speed: SFM)	
		Uncoated Carbide	
		CW12	
Non-ferrous Metal	.002~.012	500~1200	

APET

Aluminum Cutting Inserts for the EM--AL, CM--AL, & FM--AL Style Cutters

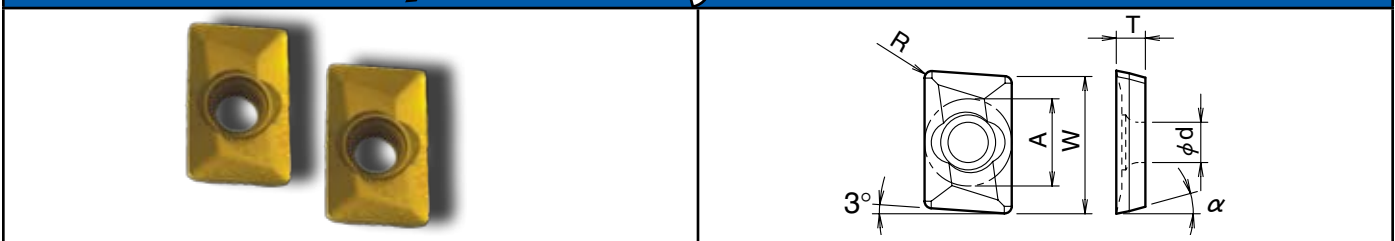


Insert	Dimension (Inch)					Available Grades
	I.C.	L	W	T	R	Uncoated Carbide
APET 0803PDR	0.250	0.300	0.250	0.125	0.028	● CW12
APET 1604PDR	0.375	0.630	0.375	0.188	0.039	●
APET 160416	0.375	0.630	0.375	0.188	0.060	●
APET 160431	0.375	0.630	0.375	0.188	0.125	●

●: Stock Standard

XPMT*

Inserts for the EM, FM & CM Style Cutters



*Formerly known as ADMM inserts

Insert	Dimension (Inch)						Angle	Available Grades					
	A	T	φd	W	R	α		Cermet	Uncoated Carbide	CVD Coated Carbide	PVD Coated Carbide		
								TC60	KW10	CA2335	PR660	PR830	PR905
XPMT 090208	0.250	0.094	0.110	0.325	0.031	15°	●	●	●	●	●	●	
XPMT 15T304	0.375	0.156	0.157	0.607	0.016	15°	●	●	●	●	●	●	
XPMT 15T308					0.031		●	●	●	●	●		
XPMT 15T316					0.063		●	●	●	●	●		
XPMT 15T324					0.093		●	●	●	●	●		
XPMT 15T331					0.122		●	●	●	●	●		
XPMT 15T364					0.250		●	●	●	●	●		

●: Stock Standard

Insert Grades for Milling

Grades		Color	Coating Layer	Application Recommendations
CVD Coated Carbides	CA2335	gold	TiN+TiC+TiN	CVD coated carbide for applications in steel , stainless steel , and steel castings .
	CW12	gray	n/a	Uncoated C3 carbide primarily for milling aluminum .
Uncoated Carbides	KW10	gray	n/a	Micrograin uncoated carbide recommended as first choice in most aluminum and non-ferrous materials , and as an alternate choice for high nickel/high temp alloy materials.
	PR660	gold	TiN	PVD coated grade as a first choice in milling tough to machine stainless steels and other tough materials.
PVD Coated Carbides	PR830	gold	TiAN + TiN	PVD coated carbide with fine surface coating for stable milling of die steel and steel .
	PR905	violet	TiAlN	PVD coated carbide with smooth fine surface coating on special carbide substrate for efficient and stable machining of gray cast iron and nodular cast iron .
Cermet	TC60	gray	n/a	Toughest cermet with good shock resistance for rough milling in a wide range of materials. Primarily recommended for tool steel applications .

Insert Grades Application Summary

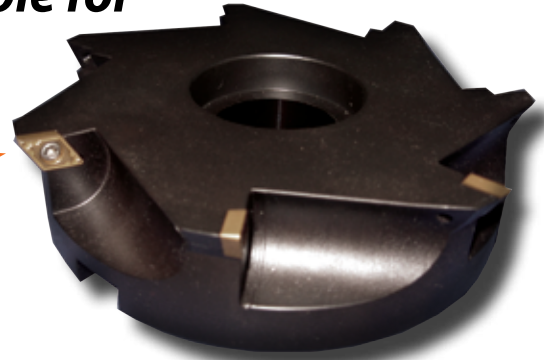
WORK MATERIAL	CVD Coated Carbide	Uncoated Carbide		PVD Coated Carbide			Cermet
	CA2335	CW12	KW10	PR660	PR830	PR905	TC60
Stainless Steel				☆	★		
Carbon Steel	★			★	☆		☆
Alloy Steel	★			★	☆		☆
Metal Mold Steel	☆				★		★
Cast Iron			★			☆	
Titanium			★			☆	
High Temp Alloy					★	☆	
Non-ferrous Metal		☆	☆				★

☆: 1st Recommendation ★: 2nd Recommendation

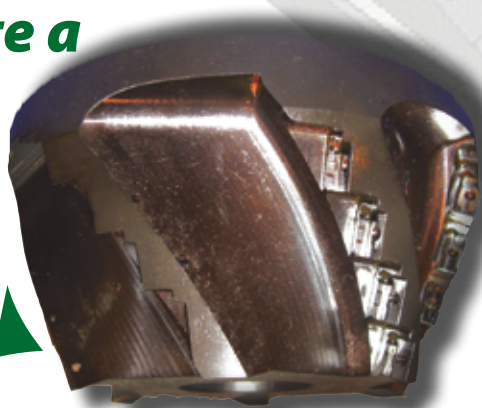
Customized Milling Cutters

Several customization options available for your specific milling applications

**Custom
Dovetail Cutters
or Back Facing Cutters**



**Combination Milling Cutters
that Create a
Profile**



**Variations of
Diameters and
Lead Angles**



Customized Tool Ordering Procedure

To request a quote for a custom tool, please follow the steps below:

1. Photocopy and fill out the Special Tool Design Worksheet on page 15 of this brochure.
2. Fax the completed form along with any necessary prints and drawings to the Kyocera Quotations Department at 828-692-1344.
3. Contact the Kyocera Quotations Department at 800-823-7284 with any questions regarding the custom drill quotation procedure.



Kyocera Industrial Ceramics Corp.
 Cutting Tool Division
 Ph: 800-823-7284
 Fax: 828-692-1344
 Email: kyoceracuttingtools@kyocera.com
 www.kyocera.com/cuttingtools

SPECIAL TOOL DESIGN WORKSHEET

DATE: _____

Page _____ of _____

CUSTOMER INFORMATION

Company Name: _____

Phone: _____

Contact: _____

Fax: _____

Address: _____

Email: _____

City, State, Zip: _____

Kyocera Distributor Name: _____

PART INFORMATION

Part Number or Description: _____

Material: _____ Hardness (Rc): _____

Current problem or objective: _____

MACHINE INFORMATION

Machine being tooled: _____ Machine condition, age: _____

Spindle Hp: _____ Max RPM: _____ Max IPM: _____

Circle one of each: Horizontal or vertical spindle? Stationary or rotating tooling?

TOOL INFORMATION

Describe the tool (drill, mill, combo tool?) _____

Quantity to quote: _____ Shank size/description: _____

Right or left hand cutting: _____ Thru coolant? (and inlet type/location): _____

Size or weight restrictions (if applicable): _____

- Prints and Drawings
 Finished part
 Raw stock or casting
 Fixturing
 Special inserts, hardware, etc.
 Process sheet
 Existing tooling

- Supplied information should include:
 Tolerance requirements, raw stock tolerances
 Surface finish requirements (witness lines ok?)
 Depth(s) of cut
 Fillets, inside corner radii (insert nose radii)
 Allowable overtravel on thru cuts
 Amount of finish stock to leave

THE NEW VALUE FRONTIER



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ADVANCING PRODUCTIVITY