



Keep-nut CNC Drilling Specifications

CNC Bit recommendations Natural Stone and Quartz:

CCH-KNBITCNC-11.8MM

Diameter: 11.8 mm +/- .2mm

RPM: 4500-5000 suggested RPM's

Feed-rate: Between 1.25" -1.5" /min (approx - 32-38mm/min)

Cooling: Both Spindle and Halo cooling advised

Depth: Depth should match height of insert so that Keep-nuts are flush with the surface when installed. (E.G. H6=6.5mm, H8.5 = 8.5mm, H15 = 15mm depth, etc.)



CNC Bit recommendations Sintered Stone and Porcelain:

CCH-KNBITCNC-11.8-D

Diameter: 11.8 mm +/- .2mm

RPM: 4500-5000 suggested RPM's

Feed-rate: Between 3/8" - 3/4" max (or Manufacturers recommendations if available)

Cooling: Both Spindle and Halo cooling advised

Depth: Depth should match height of insert so that Keep-nuts are flush with the surface when installed. (E.G. H6=6.5mm, H8.5 = 8.5mm, H15 = 15mm depth, etc.)



Flush Mount Series	With Flange Series	Thickness of Material	Insert Length	Number of Crowns	Standard Threads
		8 mm	5	1	METRIC M4 - M5 - M6 INCHES P10-24 P1/4-20
		8.5 mm	6	2	
		11 mm	8	4	
	X	14 mm	11.5	4	
	X	20 mm	15	4	