

The only universal products ...

KENNA UNIVERSAL

Program Content

- KENLOC Inserts
- SCREW-ON Inserts
- TOP NOTCH Grooving with Chip Control
- LT Threading Inserts with Chip Control
- A4 Groove & Turn Inserts
- A2 Cut-Off Inserts

by Grade...



KU10T

1 2 3

1 KU – KENNA UNIVERSAL Grade

2 WEAR/TOUGHNESS

ISO RANGE:

10 = Highly Wear Resistant
to

50 = Extremely Tough

3 T - Turning

M - Milling

D - Drilling

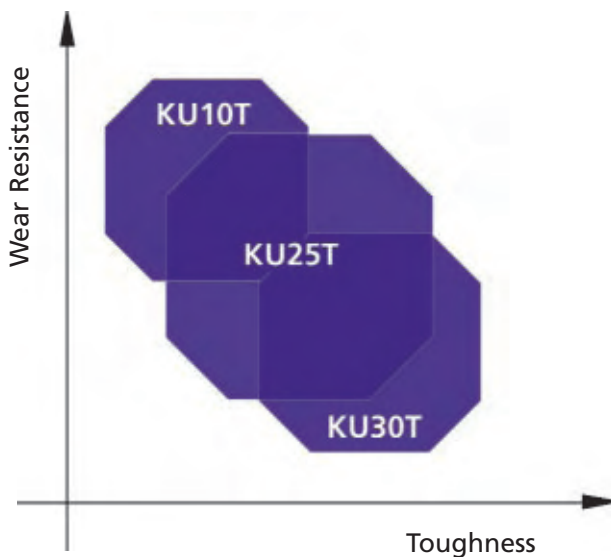


... engineered to meet the specific needs of job shops!



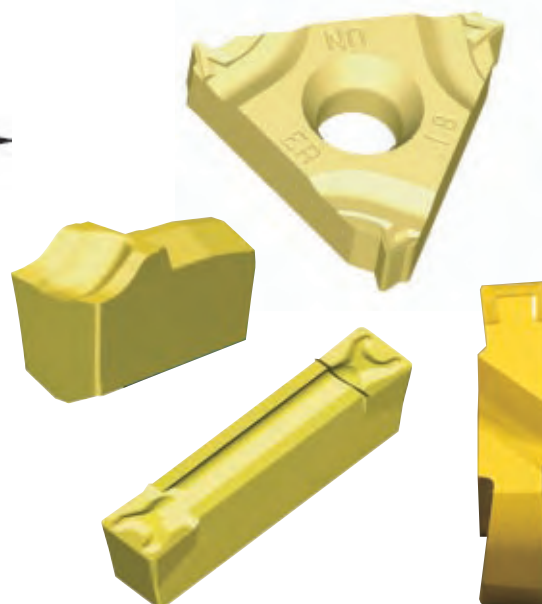
Universal Turning Grades

- KU10T** – PVD-coated grade for finishing and medium machining operations
- KU25T** – Tough PVD-coated grade for finishing and medium machining in threading and cut-off operations
- KU30T** – CVD-coated grade for roughing and medium machining operations



Apply on:

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



1st Step – Select the Insert Geometry

Negative Inserts

▼ Roughing



-RN -RP

▼▼ Medium Machining

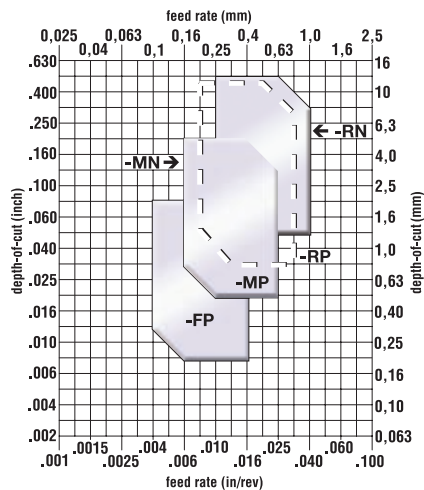


-MN -MP

▼▼▼ Finishing



-FP



Positive Inserts

▼▼ Medium Machining



-MF

▼▼▼ Finishing

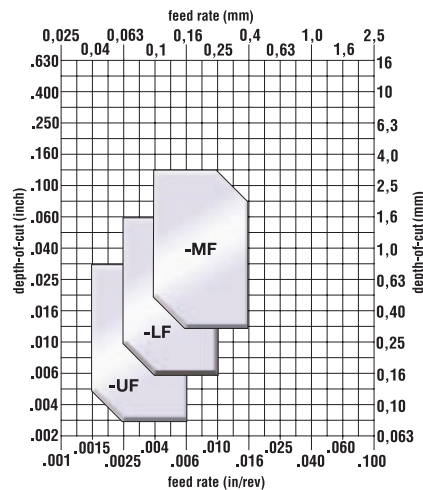


-LF

▼▼▼▼ Fine Finishing



-UF



2nd Step – Select the Grade

Negative Insert Geometry

Positive Insert Geometry

Cutting Condition	Symbol	Negative Insert Geometry				Positive Insert Geometry			
		-FP	-MP	-MN	-RN	-RP	-UF	-LF	-MF
heavily interrupted cut		▼▼▼	▼▼	▼▼	▼	▼	▼▼▼▼	▼▼▼	▼▼
lightly interrupted cut		–	KU30T	KU30T	KU30T	KU30T	–	KU30T	KU30T
varying depth of cut, casting or forging skin		KU10T	KU10T	KU30T	KU30T	KU30T	KU10T	KU30T	KU30T
smooth cut, pre-turned surface		KU10T	KU10T	KU30T	KU30T	KU30T	KU10T	KU10T	KU30T



3rd Step – Select the Cutting Speed

Plain Carbon and Alloy Steels, Ferritic and Martensitic and PH Stainless Steels

Material Group	grade	Speed - sfm (m/min)							Starting Conditions	
		170 (50)	330 (100)	490 (150)	655 (200)	820 (250)	980 (300)	1150 (350)	sfm	m/min
P	KU10T								650	200
	KU30T								500	150

Austenitic and Stainless Steels

Material Group	grade	Speed - sfm (m/min)							Starting Conditions	
		170 (50)	330 (100)	490 (150)	655 (200)	820 (250)	980 (300)	1150 (350)	sfm	m/min
M	KU10T								600	180
	KU30T								450	140

Gray and Ductile Cast Irons

Material Group	grade	Speed - sfm (m/min)							Starting Conditions	
		170 (50)	330 (100)	490 (150)	655 (200)	820 (250)	980 (300)	1150 (350)	sfm	m/min
K	KU10T								800	240
	KU30T								650	200

Non-Ferrous Metals: Low-silicon aluminum alloys (<12%) and magnesium alloys

Material Group	grade	Speed - sfm (m/min)							Starting Conditions	
		800 (240)	1200 (360)	1600 (490)	2000 (610)	2400 (730)	2800 (855)	3200 (975)	sfm	m/min
N	KU10T								1500	460

High-Temp Alloys

Material Group	grade	Speed - sfm (m/min)							Starting Conditions	
		170 (50)	330 (100)	490 (150)	655 (200)	820 (250)	980 (300)	1150 (350)	sfm	m/min
S	KU10T								220	65
	KU30T								150	45

Hardened Materials (>48 HRC)

Material Group	grade	Speed - sfm (m/min)							Starting Conditions	
		170 (50)	330 (100)	490 (150)	655 (200)	820 (250)	980 (300)	1150 (350)	sfm	m/min
H	KU10T								200	60

Represents the recommended starting conditions. Optimize for your specific application.

KENLOC
TURNING INSERTS
KINDEX
SCREW-ON
TOOLHOLDERS
BORING BARS
TURNING HOLDERS
BORING HEADS
CARTRIDGES