

KENLOC INSERTS
SCREW-ON INSERTS
TOOLHOLDERS
BORING BARS
TOP NOTCH GROOVING
TURNING PRODUCTS
A4
A2
IT THREADING
TOP NOTCH THREADING

KENNA UNIVERSAL Chip Control Geometries



Kennametal Clamping System

Chip Control Geometry Designation
example: MG-MP = CNMG-432MP

Feed Rate Range
(for best results, use the center 60% of the range)

operation	insert style application	insert geometry	profile	feed rate – inches										
				.0015	.0025	.004	.006	.010	.016	.025	.040	.060	.100	.200
medium machining	MG-MP			depth of cut – inches										
				.004	.006	.010	.016	.025	.040	.060	.100	.160	.250	.500
				feed rate – (mm)										
				0,04	0,063	0,10	0,16	0,25	0,4	0,63	1,0	1,6	2,5	5,0
				depth of cut – (mm)										
				0,1	0,16	0,25	0,4	0,63	1,0	1,6	2,5	4,0	6,3	10,0

Depth of Cut Range
(for all inserts in the program, select smaller inserts for lighter cuts and larger inserts for heavy cuts)

Chipbreaker Geometry
(section is through nose radius of insert)

Pictorial View of Insert

Primary Workpiece Material Group

- steel
- non-ferrous
- stainless steel
- high-temp alloys
- cast iron
- hardened materials

Machining Operation

(what the insert geometry is designed for)

- ▼▼▼▼ – fine finishing
- ▼▼▼ – finishing
- ▼▼ – medium machining
- ▼ – roughing



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					.0015	.0025	.004	.006	.010	.016	.025	.040	.060	.100	.200	
					depth of cut – inches											
					.004	.006	.010	.016	.025	.040	.060	.100	.160	.250	.500	
Kenloc Inserts	finishing	MG-FP			.004 - .012 (0,1 - 0,3)											
	medium machining	MG-MP			.006 - .020 (0,2 - 0,5)											
	medium machining	MG-MN			.006 - .020 (0,2 - 0,5)											
	roughing	MG-RP			.008 - .025 (0,2 - 0,6)											
	roughing	MG-RN			.010 - .025 (0,3 - 0,6)											
Screw-On Inserts	fine finishing	MT-UF			.002 - .010 (0,1 - 0,3)											
	finishing	MT-LF			.007 - .015 (0,2 - 0,4)											
	medium machining	MT-MF			.009 - .017 (0,2 - 0,4)											
					feed rate – (mm)											
					0,04	0,063	0,1	0,16	0,25	0,4	0,63	1,0	1,6	2,5	5,0	
					depth of cut – (mm)											
					0,1	0,16	0,25	0,4	0,63	1,0	1,6	2,5	4,0	6,3	10,0	

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