



## Chipbreaker and Feed Rates – in/rev (mm/rev)

Workpiece Material and Application		Steel	Stainless Steel	Cast Iron	Non-Ferrous Metals	High-Temp Alloys	Hardened Materials	
	First Choice	Style	NG-K	NG-K	NG	NG-K	NG	
		Range	.003 - .011 (0,08 - 0,28)	.0025 - .008 (0,07 - 0,20)	.004 - .012 (0,01 - 0,30)	.003 - .012 (0,08 - 0,30)	.0025 - .008 (0,07 - 0,20)	.002 - .004 (0,05 - 0,10)
		Starting Conditions	.006 (0,15)	.005 (0,13)	.008 (0,20)	.008 (0,20)	.005 (0,13)	.003 (0,08)
	Alternative Choice	Style	NG	NG	NG-K	NG	NG	—
		Range	.004 - .012 (0,10 - 0,30)	.004 - .009 (0,10 - 0,23)	.003 - .011 (0,08 - 0,28)	.004 - .012 (0,01 - 0,30)	.004 - .008 (0,10 - 0,20)	
		Starting Conditions	.007 (0,18)	.006 (0,15)	.007 (0,18)	.008 (0,20)	.006 (0,15)	

## Recommendations for Grade and Speed Selection – sfm (m/min)

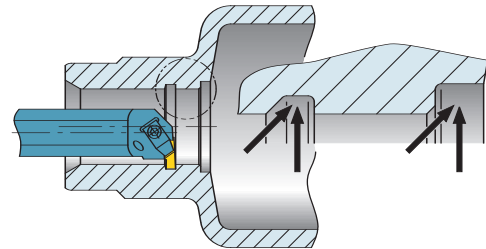
Machining Condition		Workpiece Material					
		Steel	Stainless Steel	Cast Iron	Non-Ferrous Metals	High-Temp Alloys	Hardened Materials
KENNA UNIVERSAL	Grade	KU30T	KU10T	KU30T	KU10T	KU10T	KU10T
	Range	200 - 650 (60 - 200)	150 - 550 (50 - 170)	200 - 650 (60 - 200)	500 - 2400 (150 - 730)	50 - 360 (20 - 110)	50 - 100 (20 - 40)
	Starting Conditions	500 (150)	400 (120)	500 (150)	1500 (450)	200 (60)	70 (20)

### Example for TOP NOTCH – Grooving:

material: low-alloyed steel  
 groove depth: .079 in. (2 mm)  
 groove width: .118 in. (3 mm)  
 operation: I.D. cut, limited speed capability, plunge groove and chamfer

### Recommendation:

insert: NG2M300RK  
 grade: KU30T  
 insert width: .118 in. (3 mm)  
 insert size: 2  
 toolholder: A12NEL2 (inch)  
 A20QNTOL2 (metric)  
 gage insert: N.2R



speed: 500 sfm (150 m/min)  
 feed: .006 ipr (0,15 mm)

Note: The insert size must match the gage insert size of your toolholder selection.

See page A4 for KU10T, KU25T, and KU30T grade descriptions.

To place an order, contact your authorized Kennametal distributor or visit [www.kennametal.com](http://www.kennametal.com).