

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

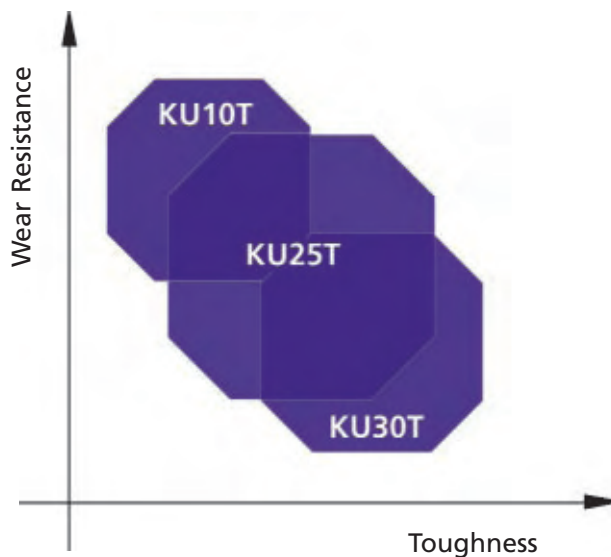


... engineered to meet the specific needs of job shops!



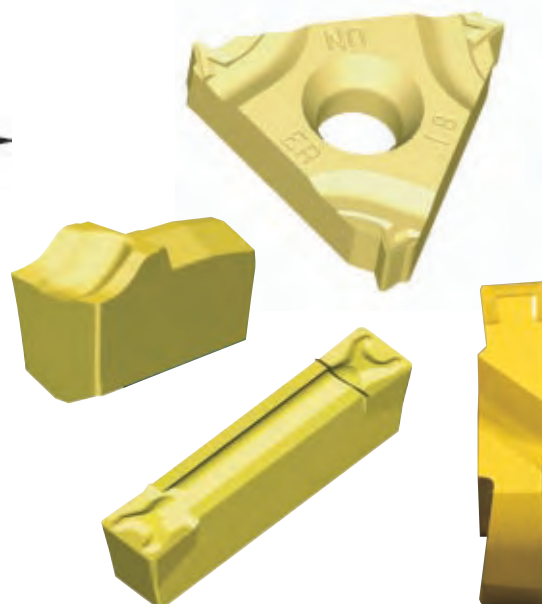
Universal Turning Grades

- 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



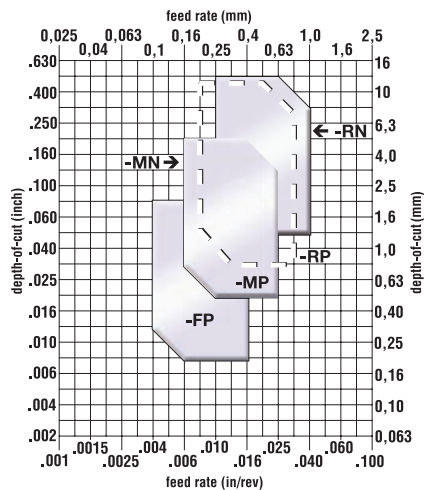
-MN

-MP

▼▼▼ Finishing



-FP



Positive Inserts

▼▼ Medium Machining



-MF

▼▼▼ Finishing

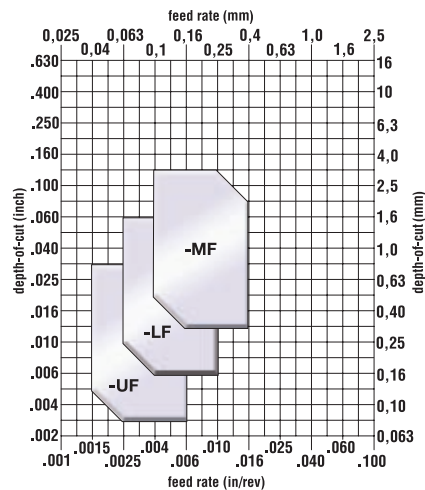


-LF

▼▼▼ Fine Finishing



-UF



2nd Step – Select the Grade

Negative Insert Geometry

Positive Insert Geometry

Cutting Condition		-FP ▼▼▼	-MP ▼▼	-MN ▼▼	-RN ▼	-RP ▼	-UF ▼▼▼▼	-LF ▼▼▼	-MF ▼▼
heavily interrupted cut		—	KU30T	KU30T	KU30T	KU30T	—	KU30T	KU30T
lightly interrupted cut		KU10T	KU30T	KU30T	KU30T	KU30T	KU10T	KU30T	KU30T
varying depth of cut, casting or forging skin		KU10T	KU10T	KU30T	KU30T	KU30T	KU10T	KU10T	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.