KENNA PERFECT – LT Threading

5 Easy Steps to Improve Productivity

What you need to know:

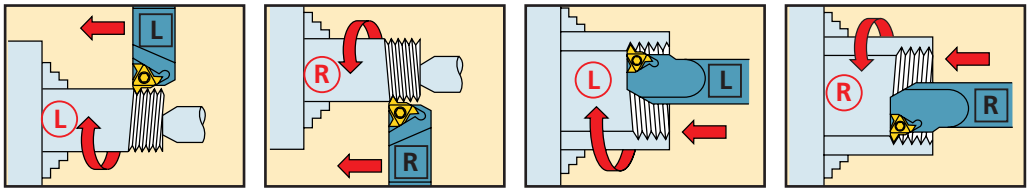
- external/internal operation
- spindle rotation/hand of thread
- feed direction

1st Step – Select Threading Method and Hand of Tooling

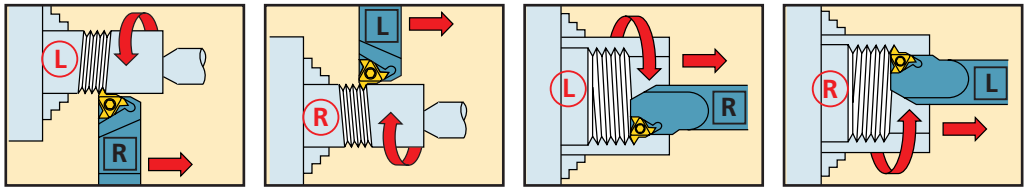
(L) or (R) – hand of thread

[L] or [R] – hand of holder/insert

• Feed direction toward the chuck – standard helix



• Feed direction away from the chuck – reverse helix



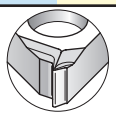
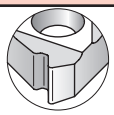
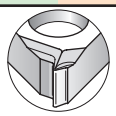
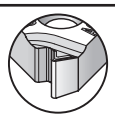
2nd Step – Choose Insert for Application

- See threading insert overview on page C9.
- Select cresting inserts for fully controlled thread form including diameter. Cresting inserts eliminate the need for deburring and are optimized for the best tool life at that pitch.
- Non-cresting partial profile inserts offer the flexibility to cut a variety of thread pitches with one insert.
- Note insert size for toolholder selection.

Insert Size	catalog number	KC5025	KC5010
11	LT11NRA60	●	●
16	LT16NRAG60	●	●

3rd Step – Select Grade and Speed

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

	Workpiece Material	Steel	Stainless Steel	Cast Iron	Non-Ferrous Metals	High-Temp Alloys
KENNA PERFECT	Insert Style	CB Chipbreaker 		Flat Top 	CB Chipbreaker 	
	Optimum Cutting Conditions	KC5010 160 - 750 (50 - 230)	KC5010 160 - 600 (50 - 185)	KC5010 230 - 700 (70 - 210)	KC5010 230 - 1300 (70 - 390)	KC5010 65 - 400 (20 - 120)
	First Choice	KC5025 130 - 650 (40 - 200)	KC5025 130 - 450 (40 - 135)	KC5025 200 - 475 (60 - 145)	KC5025 160 - 1150 (50 - 360)	KC5025 35 - 330 (10 - 100)
KENNA UNIVERSAL	Insert Style	-K Chipbreaker 				
	Selection	KU25T 80 - 450 (25 - 140)	KU25T 80 - 350 (25 - 100)	KU25T 100 - 360 (30 - 110)	KU25T 100 - 1000 (30 - 300)	KU25T 35 - 280 (10 - 85)

CB-style chip control inserts are not available with some thread forms.
In those cases, flat top inserts can be substituted.

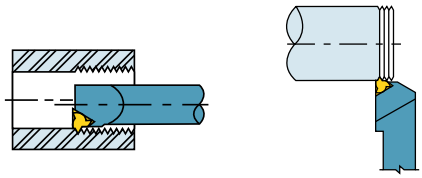
4th Step – Select Holder from Catalog Page

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

Required information:

- external/internal operation
- minimum bore diameter (for internal operations)
- hand of tool
- insert size (gage insert)

Select the appropriate holder for the insert size and hand



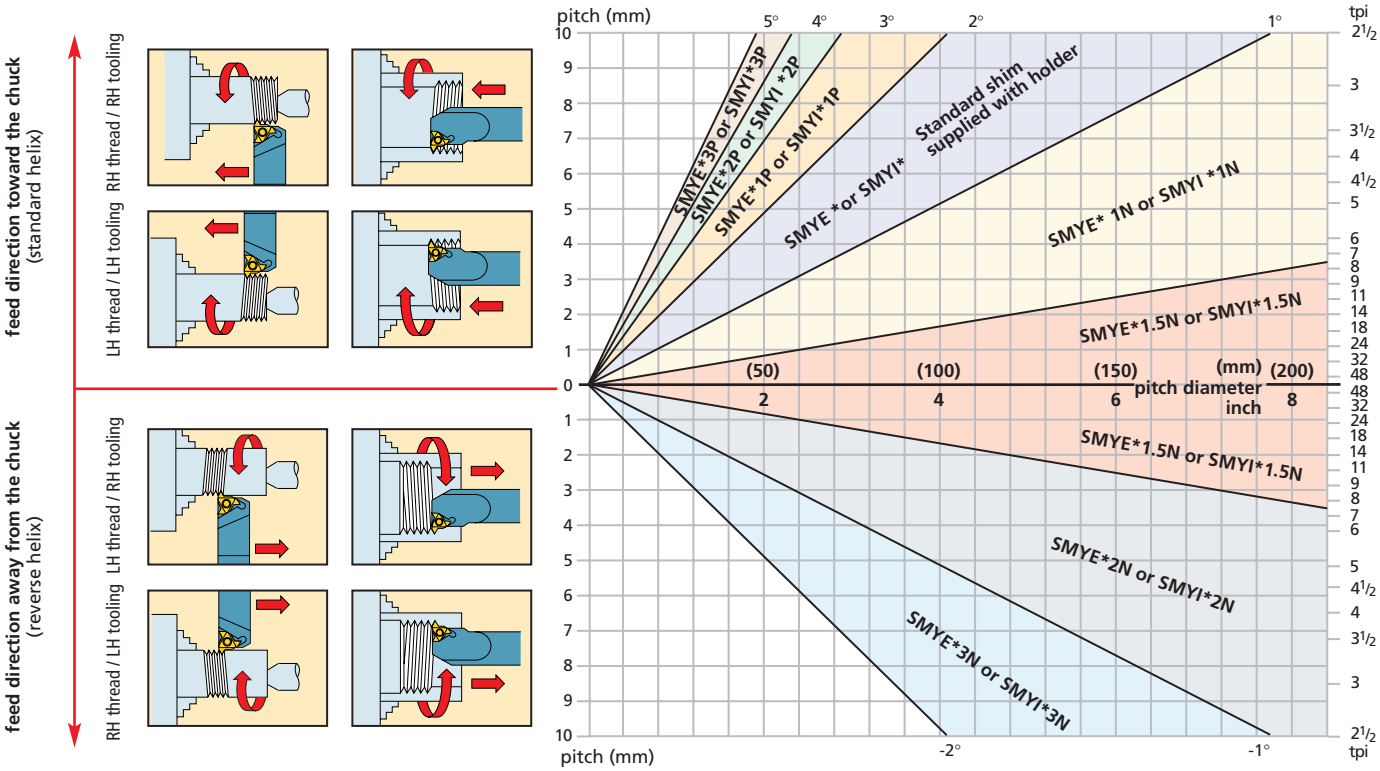
catalog number	gage insert	min. bore diameter	shim
S1212LSER3	LT16NR	.90 in	SM-YI3
A2020LSER16	LT16NR	16 mm	SM-YI3

5th Step – Select Appropriate Shim

Required information:

- thread form (tpi or pitch)
- pitch diameter
- helix method (hand of tool, feed direction, hand of thread)

Select the proper shim SMYE... for external RH or internal LH
SMYI... for internal RH or external LH



*denotes shim size: 3 = insert size 16 (3/8 in. D)
4 = insert size 22 (1/2 in. D)

If recommended shim is different from shim supplied with toolholder, order shim separately.

NOTE: Optimize your threading operation by using the proper infeed angle and the recommended infeed values. See the Technical Section on pages C58-C60 of this catalog. Also see detailed shim selection information on page, C61-C63.