



1st Step – Select the Insert Geometry

Negative Inserts

▼ Roughing



▼▼ Medium Machining



▼▼▼ Finishing



▼▼▼ Finishing



Positive Inserts

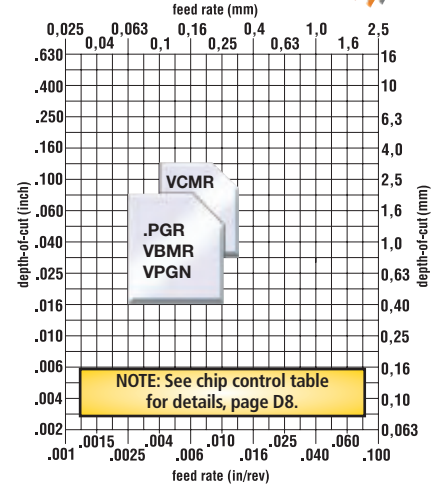
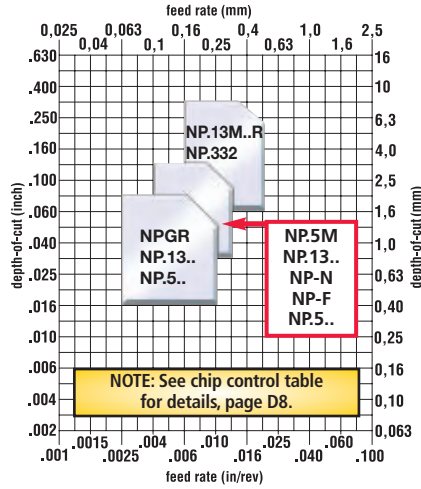
▼▼ Medium Machining



▼▼▼ Finishing



▼▼▼ Finishing



2nd Step – Select the Grade

Cutting Condition	Steel			Stainless Steel		
	▼▼▼	▼▼	▼	▼▼▼	▼▼	▼
heavily interrupted cut	KC9125	KC8050	KC8050	KC9225	KC8050	KC8050
lightly interrupted cut	KC9110	KC9125	KC8050	KC5010	KC5025	KC5025
varying depth of cut, casting or forging skin	KT315	KC9125	KC9125	KT315	KC9225	KC9225
smooth cut, pre-turned surface	KT315	KC9110	KC9110	KT315	KC5010	KC9225

Cutting Condition	Cast Iron			Non-Ferrous		
	▼▼▼	▼▼	▼	▼▼▼	▼▼	▼
heavily interrupted cut	KC9315	KC8050	KC8050	KC5010	KC5010	KC5010
lightly interrupted cut	KC9315	KC9315	KC8050	KC5410/KD100	KC5010	KC5010
varying depth of cut, casting or forging skin	KC5010	KC9315	KC9315	KD100/KD1405	KC5410	KC5410
smooth cut, pre-turned surface	KT315	KC5010	KC5010	KD1405	KC5410	KC5410

Cutting Condition	High-Temperature Alloys			Hardened Materials		
	▼▼▼	▼▼	▼	▼▼▼	▼▼	▼
heavily interrupted cut	KC5025	K68	K68	-	-	-
lightly interrupted cut	KC5010/KD120	KC5010	KC8050	KC5010/KB9610	KC5010	KC5010
varying depth of cut, casting or forging skin	KD120	KC5010	KC5010	KB9610	KC5010	KC5010
smooth cut, pre-turned surface	KB9610	KC5010	KC5010	KB9610	KB9610	KC5010



3rd Step – Select the Cutting Speed

Steel

KENNA PERFECT Material Group	grade	Speed - sfm (m/min)								Starting Conditions	
		170 (50)	330 (100)	490 (150)	655 (200)	820 (250)	980 (300)	1150 (350)	1300 (400)	sfm	m/min
P	KT315									850	260
	KC9110									800	240
	KC9125									600	180
	KC8050									550	165

Stainless Steel

KENNA PERFECT Material Group	grade	Speed - sfm (m/min)								Starting Conditions	
		170 (50)	330 (100)	490 (150)	655 (200)	820 (250)	980 (300)	1150 (350)	1300 (400)	sfm	m/min
M	KT315									750	230
	KC5010									600	180
	KC5025									400	120
	KC9225									550	170
	KC8050									500	150

Cast Iron

KENNA PERFECT Material Group	grade	Speed - sfm (m/min)								Starting Conditions	
		170 (50)	330 (100)	490 (150)	655 (200)	820 (250)	980 (300)	1150 (350)	1300 (400)	sfm	m/min
K	KT315									900	275
	KC5010									800	245
	KC9315									800	245
	KC8050									750	230

Non-Ferrous

KENNA PERFECT Material Group	grade	Speed - sfm (m/min)								Starting Conditions	
		800 (250)	1600 (500)	2400 (750)	3200 (1000)	4000 (1250)	4800 (1500)	5600 (1750)	6400 (2000)	sfm	m/min
N	KD100/KD1405									2500	765
	KC5410									1800	550
	KC5010									1500	460
	K68									500	150

High-Temperature Alloys

KENNA PERFECT Material Group	grade	Speed - sfm (m/min)								Starting Conditions	
		50 (15)	120 (40)	180 (55)	250 (80)	330 (100)	550 (170)	655 (200)	750 (230)	sfm	m/min
S	KB9610									700	215
	KD120									400	120
	KC5010									200	60
	KC5025									170	50
	KC8050									230	70
	K68									100	30

Hardened Materials

KENNA PERFECT Material Group	grade	Speed - sfm (m/min)								Starting Conditions	
		50 (15)	120 (40)	180 (55)	250 (80)	330 (100)	550 (170)	655 (200)	750 (230)	sfm	m/min
H	KB9610									500	150
	KC5010									130	40

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

TOP NOTCH PROFILING

K-LOCK

KENDEX MINI

APPLICATION-SPECIFIC TOOLS