

KENNA UNIVERSAL – TOP NOTCH Threading



4 Easy Steps to Improve Productivity

What you need to know:

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

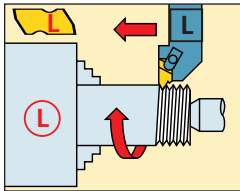
1st Step – Select Threading Method and Hand of Tooling

Ⓛ or Ⓜ – hand of thread

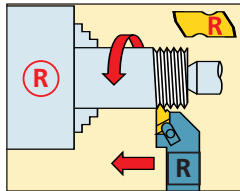
Ⓛ or Ⓜ – hand of toolholder

Ⓛ or Ⓜ – hand of insert

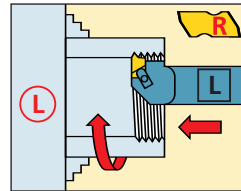
• Feed direction toward the chuck – standard helix



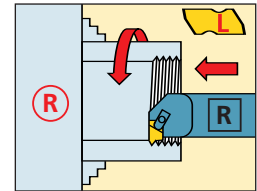
external left-hand thread



external right-hand thread

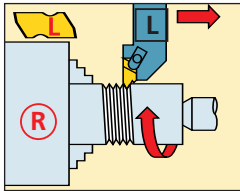


internal left-hand thread

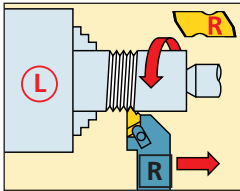


internal right-hand thread

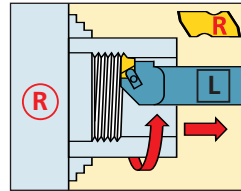
• Feed direction away from the chuck – reverse helix



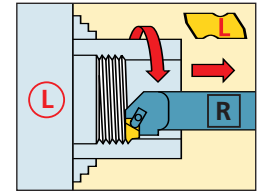
external right-hand thread



external left-hand thread



internal right-hand thread



internal left-hand thread

2nd Step – Choose Insert for Application

- Non-cresting partial profile inserts can cut a variety of thread pitches. Chip control is only available with partial profile inserts.
- Note insert size for toolholder selection.

	Insert Size	Catalog Number
	2	NT-2RK
	3	NT-3RK
	4	NT-4RK

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 UNIVERSAL	Insert Style	chip control or neutral				
	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)



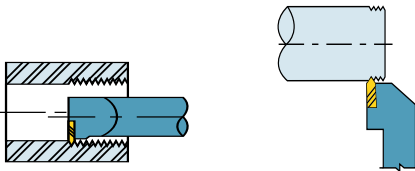
4th Step – Select Holder from Catalog Page

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
NSR-163D	N.3R
NSR-164D	N.4R

NOTE: TOP NOTCH toolholders and boring bars are listed with a gage insert to indicate the size and hand required. They are compatible with both grooving and threading inserts of the

TOP NOTCH Threading Example:

application: 8 TPI UN internal right-hand thread
 material: alloy steel
 workpiece dia.: 4.5 inch (114,3 mm)
 good cutting conditions
 feed toward the chuck

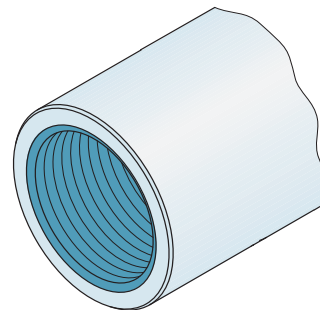
Recommendation:

insert: NT3LK
 grade: KU25T
 insert size:: 3

boring bar: A40NER3 (metric: A50UNNTOR4)
 gage insert: N.3L

speed: 250 sfm (75 m/min)
 infeed passes: 12 passes

See pages A68 for internal threading diameter limit chart.



For TOP NOTCH Threading Toolholders and Boring Bars, see pages A57-A66.