CCMT CUTTING DATA

KENNEDY®



80º RHOMBIC TYPE

				Material	P			M		K		N	S	H
					Non-alloy steel <25 HRc	Low alloy steel 25-35 HRc	High alloy steel, Tool steel 35-45 HRc	Ferritic / Martensitic Stainless steel	Austenitic Stainless steel	Grey Cast iron	Nodular Cast iron	Aluminium & Non-ferrous material	Heat Resistant and Super Alloys	Hard materials <55 HRc
Order Code	Insert	f_n (mm/rev)	a_p (mm)	VDI	1-5	6-9	10-11	12-13	14	15-16	17-20	21-30	31-37	38-41
KEN1201538Q	CCMT060204-FM C25PM TURNING INSERT	0.05 - 0.20	0.5 - 2.0	v_c (m/min)	150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1201538R	CCMT060204-R C25PM TURNING INSERT	0.10 - 0.25	0.5 - 2.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1201714U	CCMT09T304-F C15PK TURNING INSERT	0.05 - 0.20	0.5 - 2.0		180 - 500	170 - 450	60 - 180	-	-	-	-	-	-	-
KEN1206371M	CCMT060204-M C15PK TURNING INSERT	0.10 - 0.25	0.5 - 2.0		180 - 500	170 - 450	60 - 180	-	-	-	-	-	-	-
KEN1206371N	CCMT060204-M C25M TURNING INSERT	0.08 - 0.25	0.25 - 2.5		-	-	-	-	-	-	-	-	-	-
KEN1206371P	CCMT09T304-M C25M TURNING INSERT	0.06 - 0.25	0.1 - 2.0		-	-	-	160 - 220	100 - 200	-	-	-	-	-
KEN1206371Q	CCMT060208-R C25PM TURNING INSERT	0.10 - 0.25	0.8 - 2.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1206371R	CCMT09T302-FM C15P TURNING INSERT	0.04 - 0.15	0.08 - 2.0		180 - 500	170 - 450	60 - 300	-	-	120 - 300	120 - 280	-	-	40 - 80
KEN1206371T	CCMT09T304-FM C25PM TURNING INSERT	0.05 - 0.20	0.5 - 2.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1206371U	CCMT09T304-R C25PM TURNING INSERT	0.15 - 0.30	0.5 - 2.5		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1206371V	CCMT09T308-R C25PM TURNING INSERT	0.15 - 0.30	0.8 - 2.5		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1206742Y	CCMT060204-F C25M TURNING INSERT	0.05 - 0.20	0.1 - 2.0		-	-	-	170 - 220	150 - 200	-	-	-	-	-
KEN1207121R	CCMT060204-F C15PK TURNING INSERT	0.05 - 0.20	0.5 - 2.0		180 - 500	170 - 450	60 - 180	-	-	-	-	-	-	-
KEN1209951B	CCMT060202-FM C15P TURNING INSERT	0.04 - 0.15	0.08 - 2.0		180 - 500	170 - 450	60 - 300	-	-	120 - 300	120 - 280	-	-	40 - 80

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up.
The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

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