CNMG 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
KEN1201844B	CNMG120404-F C25PM TURNING INSERT	0.02 - 0.25	0.5 - 1.5	v_c (m/min)	150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1201844C	CNMG120408-F C25PM TURNING INSERT	0.05 - 0.25	1.0 - 2.5		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1201844D	CNMG120404-M C25PM TURNING INSERT	0.20 - 0.40	0.5 - 2.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1201844E	CNMG120408-M C25PM TURNING INSERT	0.20 - 0.40	1.0 - 3.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1201844F	CNMG120412-M C25PM TURNING INSERT	0.20 - 0.40	1.0 - 3.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1201844H	CNMG120412-R C25PM TURNING INSERT	0.30 - 0.50	1.5 - 5.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1201844J	CNMG120416-R C25PM TURNING INSERT	0.30 - 0.50	2.0 - 5.0		130 - 350	130 - 280	70 - 110	150 - 200	50 - 180	-	-	-	-	-
KEN1201844K	CNMG160612-R C25PM TURNING INSERT	0.30 - 0.50	1.5 - 5.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1201844L	CNMG120404-M C25M TURNING INSERT	0.07 - 0.30	0.2 - 1.5		-	-	-	160 - 220	100 - 200	-	-	-	-	-
KEN1201844M	CNMG120408-M C25M TURNING INSERT	0.20 - 0.40	1.0 - 4.0		-	-	-	160 - 220	100 - 200	-	-	-	-	-
KEN1201844N	CNMG120404-F C15PK TURNING INSERT	0.05 - 0.25	0.5 - 1.5		180 - 500	170 - 450	60 - 180	-	-	-	-	-	-	-
KEN1201844P	CNMG120408-M C15PK TURNING INSERT	0.20 - 0.40	1.0 - 3.0		180 - 500	170 - 450	60 - 180	-	-	-	-	-	-	-
KEN1203538Y	CNMG120408-R C25PM TURNING INSERT	0.30 - 0.50	1.0 - 5.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-

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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