DCMT CUTTING DATA

KENNEDY®



55º DIAMOND 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
KEN1206554E	DCMT070202-FM C15P TURNING INSERT	0.05 - 0.15	0.1 - 1.5	v_C (m/min)	180 - 500	170 - 450	60 - 300	-	-	120 - 300	120 - 280	250 - 800	-	40 - 80
KEN1206554F	DCMT070204-FM C25PM TURNING INSERT	0.05 - 0.20	0.5 - 1.5		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	250 - 800	-	-
KEN1206554G	DCMT070204-R C25PM TURNING INSERT	0.10 - 0.25	0.5 - 1.5		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1206554H	DCMT070208-R C25PM TURNING INSERT	0.10 - 0.25	0.8 - 1.5		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1206554J	DCMT11T302-FM C15P TURNING INSERT	0.04 - 0.15	0.08 - 2.0		180 - 500	170 - 450	60 - 300	-	-	120 - 300	120 - 280	-	-	40 - 80
KEN1206554K	DCMT11T304-FM C25PM TURNING INSERT	0.05 - 0.25	0.5 - 2.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1206554L	DCMT11T304-R C25PM TURNING INSERT	0.15 - 0.30	0.5 - 2.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1206554M	DCMT11T308-R C25PM TURNING INSERT	0.15 - 0.30	0.8 - 2.5		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1206554N	DCMT11T308-M C25M TURNING INSERT	0.08 - 0.25	0.5 - 3.0		-	-	-	170 - 220	150 - 200	-	-	-	-	-
KEN1206554P	DCMT11T308-F C15PK TURNING INSERT	0.15 - 0.30	0.8 - 2.5		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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