DNMG 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
KEN1208122J	DNMG150604-F C15PK TURNING INSERT	0.05 - 0.25	0.5 - 2.0	v_c (m/min)	180 - 500	170 - 450	60 - 300	-	-	120 - 300	120 - 280	-	-	40 - 80
KEN1208122B	DNMG150604-F C25PM TURNING INSERT	0.05 - 0.25	0.5 - 2.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1208122H	DNMG150604-M C25M TURNING INSERT	0.07 - 0.30	0.2 - 1.5		-	-	-	170 - 220	150 - 200	-	-	-	-	-
KEN1208122D	DNMG150604-M C25PM TURNING INSERT	0.20 - 0.40	0.5 - 2.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1208122C	DNMG150608-F C25PM TURNING INSERT	0.05 - 0.25	1.0 - 3.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1208122E	DNMG150608-M C25PM TURNING INSERT	0.20 - 0.40	1.0 - 3.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1203539B	DNMG150608-R C25PM TURNING INSERT	0.30 - 0.50	1.5 - 4.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1208122G	DNMG150612-R C25PM TURNING INSERT	0.30 - 0.50	1.5 - 4.0		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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