TCMT CUTTING DATA

KENNEDY®



60º TRIANGULAR 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
KEN1209961N	TCMT110204-M C25PM TURNING INSERT	0.10 - 0.25	0.5 - 2.0	v_c (m/min)	150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1209961Q	TCMT16T304-M C25P TURNING INSERT	0.15 - 0.30	0.5 - 2.5		180 - 500	170 - 450	60 - 300	-	-	120 - 300	120 - 280	-	-	40 - 80
KEN1209961P	TCMT16T308-M C25P 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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