WNMG CUTTING DATA

KENNEDY®



80º TRIGON 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
KEN1203505U	WNMG080404-F C25PM TURNING INSERT	0.02 - 0.25	0.5 - 2.0	v_C (m/min)	150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1203505V	WNMG080408-F C25PM TURNING INSERT	0.05 - 0.25	1.0 - 2.5		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1203505W	WNMG080404-M C25PM TURNING INSERT	0.20 - 0.40	0.5 - 2.5		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1203505X	WNMG080408-M C25PM TURNING INSERT	0.20 - 0.40	1.0 - 3.5		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1203505Y	WNMG080412-M C25PM TURNING INSERT	0.20 - 0.40	1.5 - 3.5		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1203505Z	WNMG080408-R C25PM TURNING INSERT	0.30 - 0.50	1.0 - 5.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1203506A	WNMG080412-R C25PM TURNING INSERT	0.30 - 0.50	1.5 - 5.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-
KEN1203506B	WNMG060404-M C25M TURNING INSERT	0.07 - 0.30	0.2 - 1.5		-	-	-	170 - 220	150 - 200	-	-	-	-	-
KEN1203506C	WNMG060408-M C25M TURNING INSERT	0.20 - 0.40	1.0 - 3.0		-	-	-	170 - 220	150 - 200	-	-	-	-	-
KEN1203506D	WNMG080404-M C25M TURNING INSERT	0.07 - 0.30	0.2 - 1.5		-	-	-	170 - 220	150 - 200	-	-	-	-	-
KEN1203506E	WNMG060404-F C15PK TURNING INSERT	0.05 - 0.20	0.5 - 2.0		180 - 500	170 - 450	60 - 300	-	-	120 - 300	120 - 280	-	-	40 - 80
KEN1203506F	WNMG060408-M C15PK TURNING INSERT	0.20 - 0.40	1.0 - 2.5		170 - 410	130 - 360	80 - 310	-	-	-	-	-	-	-
KEN1203506G	WNMG080404-F C15PK TURNING INSERT	0.05 - 0.25	0.5 - 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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