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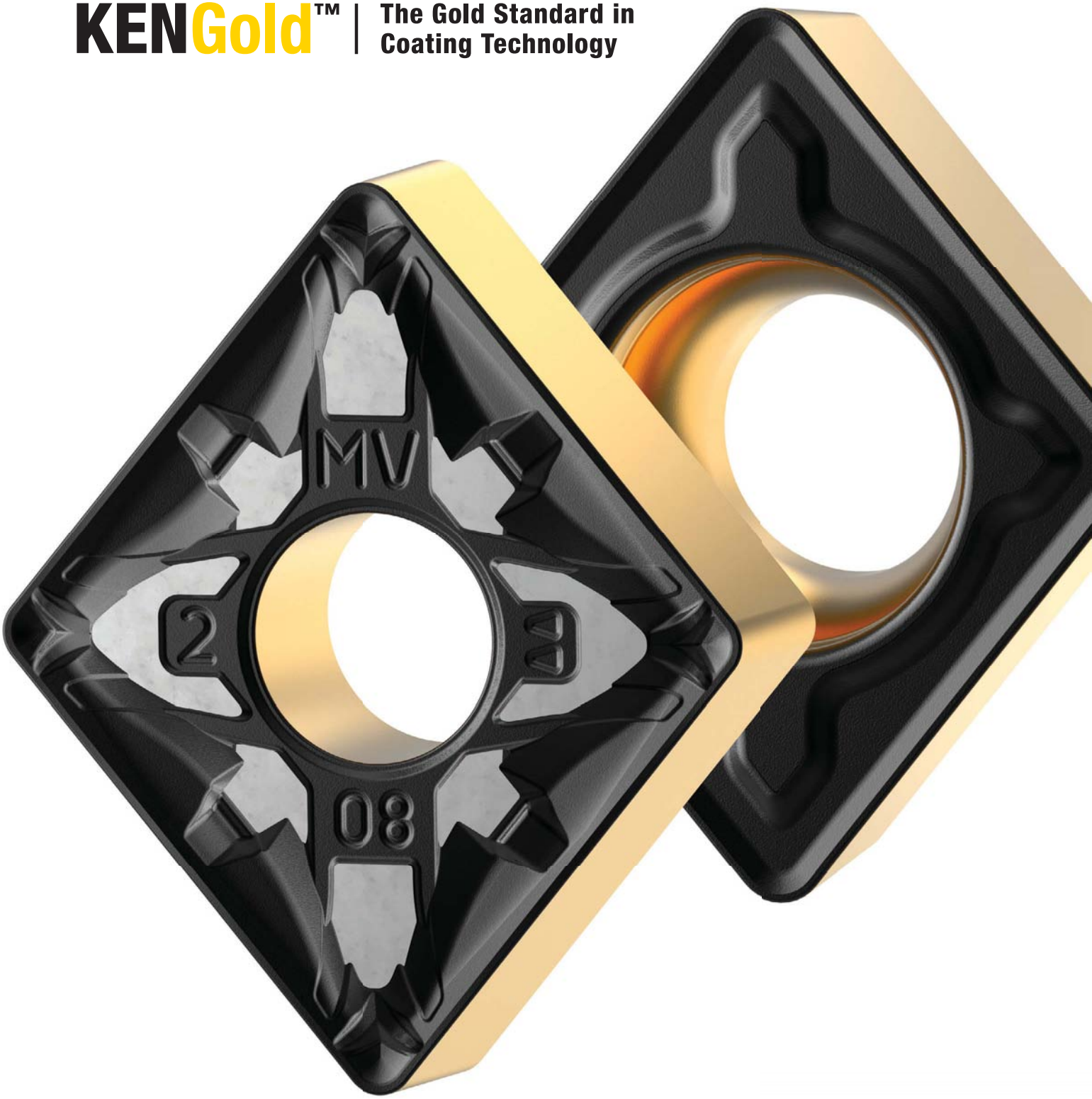
KENNAMETAL®

KENGold™ | The Gold Standard in Coating Technology



INNOVATIONS 2024 | METRIC

NEW COATING TECHNOLOGY FOR TURNING APPLICATIONS

KENGold™

ISO Turning

KENGold KCP25C Grade protects against flank wear.

KENGold KCP25C Grade offers easy identification of worn and/or unused edges.

KENGold KCP25C Grade resists wear and provides a strong thermal barrier.

KENGold KCP25C Grade increases output rate reliability and has consistent tool life.

INNOVATIONS

CAS — Customer Application Support

Get Fast and Reliable Answers to Your Toughest Problems

Our CAS Team is the metalworking industry's leading help desk resource for tooling application solutions and problem resolution.

Easy Access to Proven Metalworking Expertise!

Kennametal Application Engineers assist customers and engineering groups throughout the world with expert tool selection and application recommendations for the entire range of Kennametal tooling.

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Africa	**South Africa**	English	+27117489300	na.techsupport@kennametal.com
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	Korea (South)	English	+82 2 2100 6100	ap-kmt.techsupport@kennametal.com
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Service & Sales Centers Around the World

Region	Country	Sales Hotline	Email
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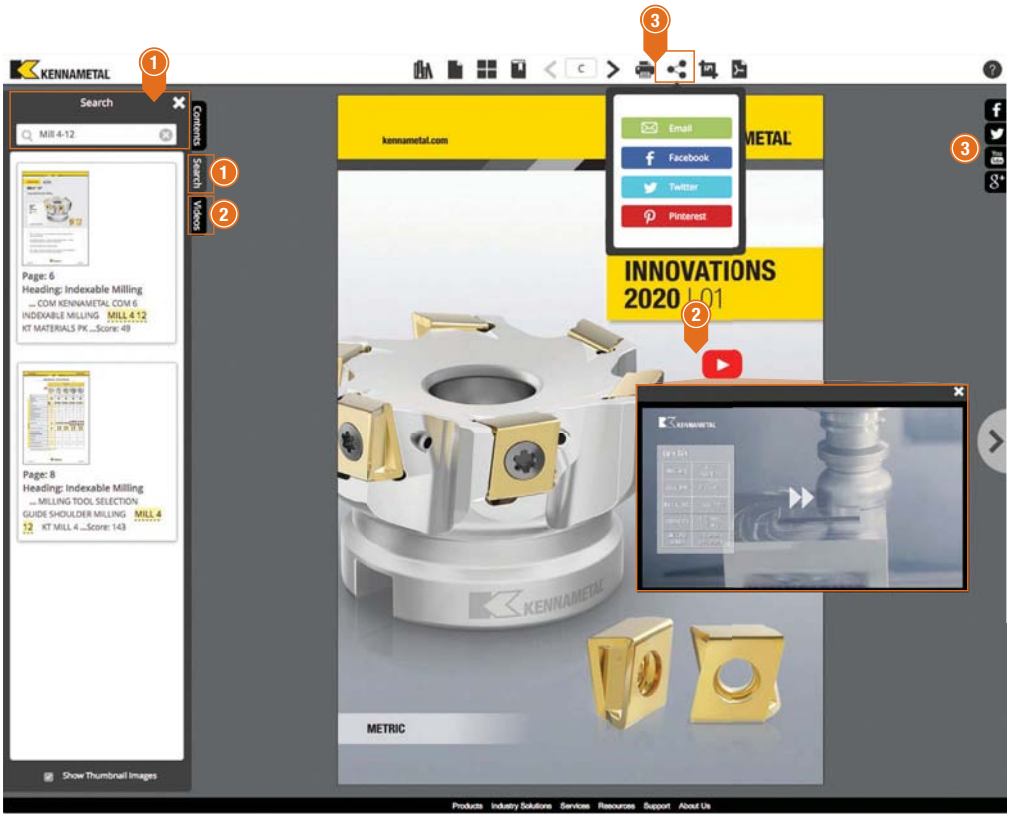
3. Share with others



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KENGold™

CVD Coating Technology for ISO Turning Applications

Materials

P

Applications

- Turning
- Boring
- Back Boring
- Profiling
- Facing
- I.D. Facing
- Chamfer Turning

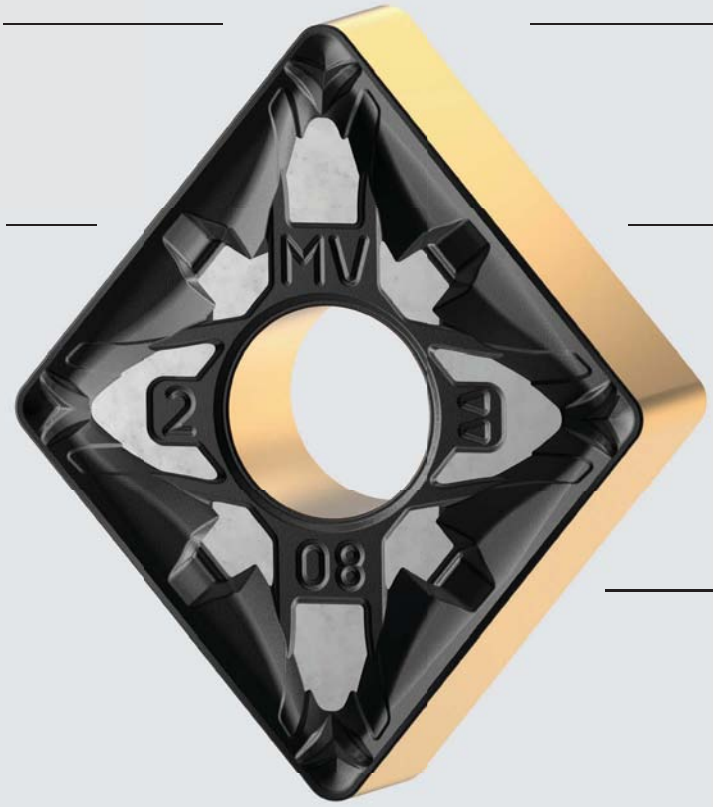
KENGold is a multilayer coating technology featuring uniform layers that resist abrasion, provide a strong thermal barrier, improve edge toughness, and allow for easy detection of wear due to its gold flank.

Applied to the KCP25C turning insert grade, in combination with enhanced edge preparation features, customers will experience more reliable and consistent tool life.

This medium-temperature coating technology is comprised of TiCN-Al_2O_3. The composition can be broken down into four layers, each with unique protection properties:

Protects against flank wear

Offers easy identification of worn and/or unused edges (reducing waste)



Resists wear (abrasion, chipping) and provides a strong thermal barrier

Increases output rate reliability and has consistent tool life

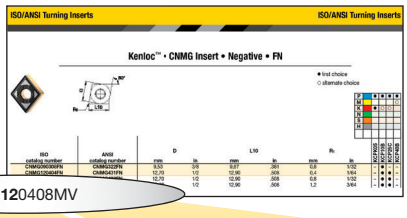
NEW!
MV geometry for medium versatile applications

- The outermost layer protects against flank wear and enables wear identification with its gold color TiCN top layer. This improves abrasion resistance within the KCP25C grade.
- The second layer is comprised of a black Al_2O_3 coating with a recently developed uniform nanostructure to act as a strong thermal barrier that resists wear.
- The third layer is a transition layer that bonds the tough and wear-resistant layers.
- The fourth layer resists chipping with its highly uniform crystal structure within the medium-temperature TiCN coating layer. This also enables improved toughness and greater wear resistance.

ISO/ANSI Turning Inserts

ISO Inserts • Catalog Numbering System

Each character in our catalog number signifies a specific trait of that product. Use the following key columns and corresponding images to easily identify which attributes apply.

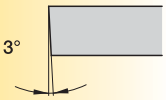
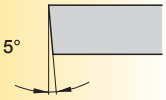
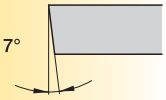
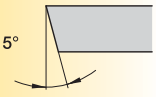
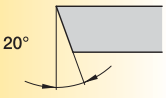
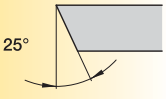
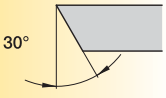
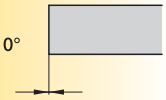
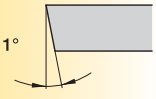


CNMG120408MV

C — Insert Shape

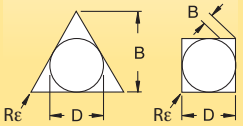
H	Hexagon 120°	
O	Octagon 135°	
P	Pentagon 108°	
R	Round —	
S	Square 90°	
T	Triangular 60°	
C **D** **E** **M** **V**	Rhomboid 80° 55° 75° 86° 35°	
W	Trigon 80° with enlarged corner angles	
L	Rectangular 90°	
A **B** **N/K**	Parallelogram 85° 82° 55°	

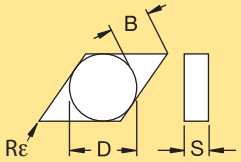
N — Insert Clearance Angle

A	3°	
B	5°	
C	7°	
D	15°	
E	20°	
F	25°	
G	30°	
N	0°	
P	11°	
O	Indicated for other clearance angles requiring descriptions.	

M — Tolerance Class

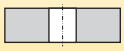
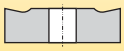
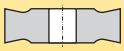
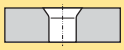
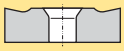
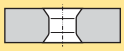
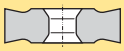
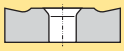
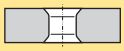
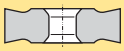
Tolerances apply prior to edge prep and coating.





D = Theoretical diameter of the insert inscribed circle
S = Thickness
B = See figures below

G — Insert Features

N	
R	
F	
A	
M	
G	
W	
T	
Q	
U	
B	
H	
C	
J	
X	Special Design

12 — Size

Code for metric cutting edge length "L10"

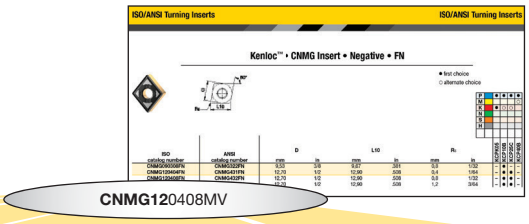
"D" mm	C	D	R	S	T	V	W
3,97	S4	04	03	03	06	—	—
4,76	04	05	04	04	08	08	S3
5,56	05	06	05	05	09	09	03
6,00	—	—	06	—	—	—	—
6,35	06	07	06	06	11	11	04
7,94	08	09	07	07	13	13	05
8,00	—	—	08	—	—	—	—
9,52	09	11	09	09	16	16	06
10,00	—	—	10	—	—	—	—
11,11	11	13	11	11	19	19	07
12,00	—	—	12	—	—	—	—
12,70	12	15	12	12	22	22	08
14,29	14	17	14	14	24	24	09
15,88	16	19	15	15	27	27	10
16,00	—	—	16	—	—	—	—
17,46	17	21	17	17	30	30	11
19,05	19	23	19	19	33	33	13
20,00	—	—	20	—	—	—	—
22,22	22	27	22	22	38	38	15
25,00	—	—	25	—	—	—	—
25,40	25	31	25	25	44	44	17
31,75	32	38	31	31	54	54	21
32,00	—	—	32	—	—	—	—

tolerance class	tolerance on "D"	tolerance on "B"	tolerance on "S"
C	±0,025	±0,013	±0,025
H	±0,013	±0,013	±0,025
E	±0,025	±0,025	±0,025
G	±0,025	±0,025	±0,013
M	See tables on next page		±0,013
U	See tables on next page		±0,013

ISO/ANSI Turning Inserts

ISO Inserts • Catalog Numbering System

(continued)



04	08			MV
Thickness S	Corner Radius "Rε"	Hand of Insert *(optional)*	Cutting Edge *(optional)*	Chipbreaker *(optional)*

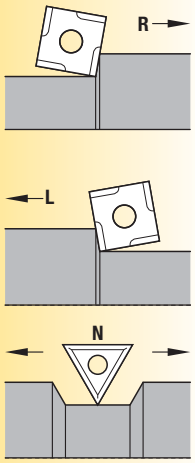
symbol	thickness
mm	mm
—	0,79
T0	1,00
01	1,59
T1	1,98
02	2,38
03	3,18
T3	3,97
04	4,76
05	5,56
06	6,35
07	7,94
9	9,52
11	11,11
12	12,70

symbol	corner radius
mm	mm
X0	0,04
01	0,1
02	0,2
04	0,4
08	0,8
12	1,2
16	1,6
20	2,0
24	2,4
28	2,8
32	3,2
00	round insert
M0	
—	

R = Right hand

L = Left hand

N = Neutral



F Sharp

E Rounded

T Chamfered

S Chamfered and Rounded

K Double-Chamfered

P Double-Chamfered and Rounded

F = Sharp

FF = Fine Finishing

FN = Finishing Negative

MV = Medium Versatile

MN = Medium Negative

MR = Medium Roughing

RN = Roughing Negative

UN = Universal Medium

FP = Finishing Positive

MP = Medium Positive

RP = Roughing Positive

RM = Roughing Medium

RH = Roughing Heavy

FW = Finishing Wiper

MW = Medium Wiper

FS = Finishing Sharp

MS = Medium Sharp

RW = Roughing Wiper

HP = High Positive

UP = Universal Positive

K = Light-Feed Chip Control

UF = Ultra-Fine Finishing

LF = Light Finishing

MF = Medium Finishing

E = Hone Only

T = Negative Land

S = Negative Land Plus Hone

MP-K = Medium Positive

MG-P = Medium Positive

	± Tolerance on "D"			
	Class M Tolerance			Class U Tolerance
"D"	Shapes S, T, C, R, & W	Shape D	Shape V	Shapes S, T, & C
mm	mm	mm	mm	mm
3,97	0,05	–	–	–
4,76	0,05	–	–	0,08
5,56	0,05	0,05	0,05	0,08
6,35	0,05	0,05	0,05	0,08
7,94	0,05	0,05	0,05	0,08
9,52	0,05	0,05	0,05	0,08
11,11	0,08	0,08	0,08	0,13
12,70	0,08	0,08	0,08	0,13
14,29	0,08	0,08	0,08	0,13
15,88	0,10	0,10	0,10	0,18
17,46	0,10	0,10	0,10	0,18
19,05	0,10	0,10	0,10	0,18
22,22	0,13	–	–	0,25
25,40	0,13	–	–	0,25
31,75	0,15	–	–	0,25

	± Tolerance on "B"			
	Class M Tolerance			Class U Tolerance
"D"	Shapes S, T, C, R, & W	Shape D	Shape V	Shapes S, T, & C
mm	mm	mm	mm	mm
3,97	0,08	–	–	–
4,76	0,08	–	–	0,13
5,56	0,08	0,11	–	0,13
6,35	0,08	0,11	–	0,13
7,94	0,08	0,11	–	0,13
9,52	0,08	0,11	0,18	0,13
11,11	0,13	0,15	–	–
12,70	0,13	0,15	0,25	0,20
14,29	0,13	0,15	–	–
15,88	0,15	0,18	–	0,27
17,46	0,15	0,18	–	0,27
19,05	0,15	0,18	–	0,27
22,22	0,15	–	–	0,38
25,40	0,18	–	–	0,38
31,75	0,20	–	–	0,38

ISO/ANSI Turning Inserts

Turning Grades • Catalog Numbering System

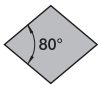
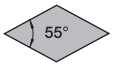
A system of grades, geometries, and application guidelines to provide optimal solutions for your metalcutting needs. It's easy to determine which Kennametal chip-control cutting tool will work best in your specific workpiece materials and applications!

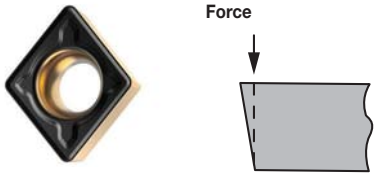
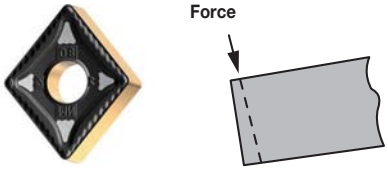
K	C	P	M	25	B
Brand	Insert Material	Primary Workpiece Material *(ISO 513)*	Secondary Workpiece Material *(optional)*	Application Range	Coating Generation
K = Kennametal		P Steel M Stainless Steel K Cast Iron N Non-Ferrous S High-Temp Alloys H Hardened Materials U Universal Machining		Hardest 5 fine finishing 10 finishing 15 20 medium to roughing 25 30 roughing 35 40 45 heaviest roughing 50 Toughest	**B** = Beyond™ Drive™ **C** = KENGold™ etc.
	Blank = Carbide, uncoated **C** = Carbide, coated **T** = Cermet **Y** = Ceramic **D** = PCD **B** = PcBN				

NOTE: Application range does not apply to PcBN grades.

ISO/ANSI Turning Inserts

Turning Technical Tips

	High ← Stability → Low						
Insert Shape	**R** **Round**	**S** **Square**	**C** **Rhombic**	**W** **Trigon**	**T** **Triangular**	**D** **Rhombic**	**V** **Rhombic**
							
Clamping Stability	++	++++	+++	++	++	+	+
Application	• Length, Face, and Profile Turning • High-Feed Capability	• Length and Face Turning	• Length, Face, and 90º Shoulder Turning	• Length, Face, and 90º Shoulder Turning	• Length, Face, Undercut, and 90º Shoulder Turning	• Length, Face, Undercut, and 90º Shoulder Turning	• Length, Face, Undercut, and 90º Shoulder Turning

	Positive Style Screw-On Inserts	**Negative Style Kenloc™ Inserts**
		
Advantages	• Shears metal, free cutting action. • Directs chip away from workpiece, generates less heat. • Less horsepower consumption, ideal for smaller and medium lathes.	• Strong cutting edge withstands higher cutting forces. • More mass to dissipate heat. • Double-sided design, more cutting edges. • Higher metal removal rate capability, ideal for medium to large lathes.
Disadvantages	• Smaller cross section at point of contact, less cutting edge stability. • Single-sided design, fewer cutting edges. • Transverse rupture strength versus compressive strength.	• Compresses metal and directs chip towards workpiece. • High pressure required. • Higher horsepower consumption. • Generates more heat.
Application Recommendation	• Medium to fine finishing. • Smooth cuts. • Instable cutting conditions. • OD of small parts and shallow grooves. • First choice for ID applications.	• Roughing to semi finishing. • Interrupted cuts. • Stable workpiece clamping. • OD and ID of diameter larger than 1.26"/32mm.

ISO/ANSI Turning Inserts

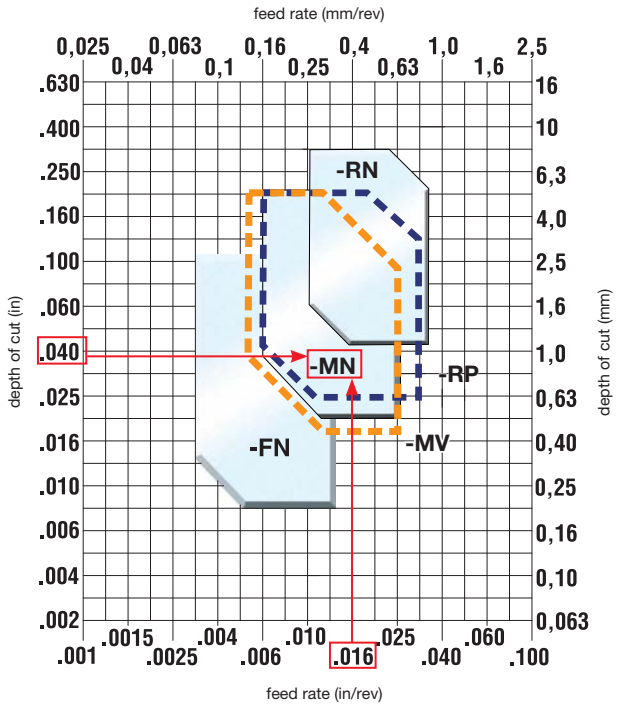
Selection Guide

1 Select the insert geometry

Given: depth of cut = .040" (1mm)
feed rate = .016 IPR (0,4mm)

Unknown: **insert geometry**
Solution: -MN

= *Example*



Negative Inserts

Roughing

RN – Roughing Negative

RP – Roughing Positive

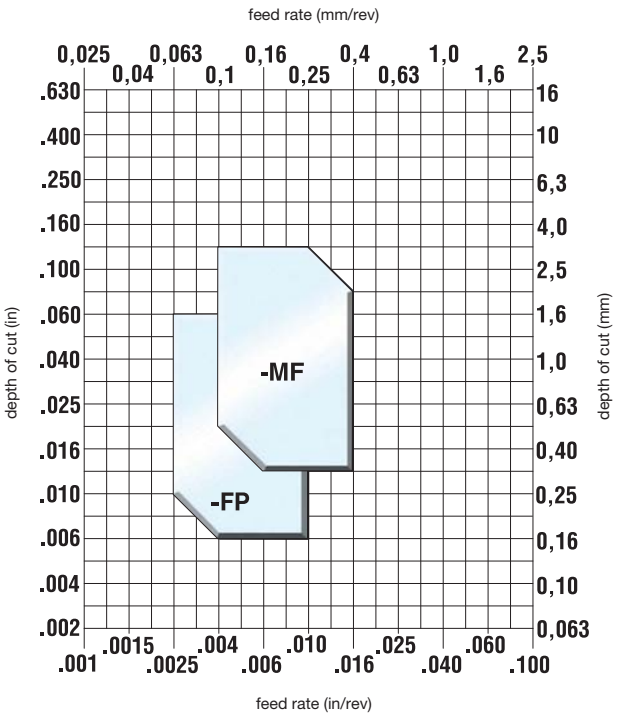
Medium Machining

MV – Medium Versatile

MN – Medium Negative

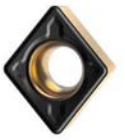
Finishing

FN – Finishing Negative



Positive Inserts

Medium Machining



MF – Medium Finishing

Finishing

FP – Finishing Positive

ISO/ANSI Turning Inserts

Selection Guide

(continued)

2 Select the grade

Given: cutting conditions: lightly interrupted cut
Geometry: -MN

Unknown: grade
Solution: KCP25C

= Example

Cutting Condition	Negative Insert					Positive Insert	
	FN	MV	MN	RP	RN	FP	MF
Heavily Interrupted Cut	KCP25C	KCP40B	KCP40B	KCP40B	KCP40B	KCP25C	KCP25C
Lightly Interrupted Cut	KCP25C	KCP25C	KCP25C	KCP25C	KCP25C	KCP25C	KCP25C
Varying Depth of Cut, Casting, or Forging Skin	KCP10B	KCP10B	KCP10B	KCP10B	KCP10B	KCP10B	KCP10B
Smooth Cut, Pre-Turned Surface	KCP10B	KCPK05	KCP10B	KCPK05	KCPK05	KCP10B	KCP10B

3 Select the cutting speed

Given: grade KCP25C
cutting conditions
material CK15

Unknown: cutting speed
Solution: 1080 SFM (330 m/min)

= Example

Low-Carbon (<0.3% C) and Free-Machining Steel — speed — m/min (SFM) — Starting Conditions

material group	grade	135 (450)	180 (600)	225 (750)	275 (900)	320 (1050)	360 (1200)	410 (1350)	455 (1500)	495 (1650)	m/min	SFM
P0/P1	KCPK05										405	1330
	KCP10B										395	1300
	KCP25C										330	1080
	KCP40B										210	700

Medium- and High-Carbon Steels (>0.3% C) — speed — m/min (SFM) — Starting Conditions

material group	grade	135 (450)	180 (600)	225 (750)	275 (900)	320 (1050)	360 (1200)	410 (1350)	455 (1500)	495 (1650)	m/min	SFM
P2	KCPK05										280	920
	KCP10B										265	870
	KCP25C										235	770
	KCP40B										150	500

Alloy Steels and Tool Steels (≤330 HB) (≤35 HRC) — speed — m/min (SFM) — Starting Conditions

material group	grade	135 (450)	180 (600)	225 (750)	275 (900)	320 (1050)	360 (1200)	410 (1350)	455 (1500)	495 (1650)	m/min	SFM
P3	KCPK05										195	640
	KCP10B										190	620
	KCP25C										185	610
	KCP40B										120	400

Alloy Steels and Tool Steels (340–450 HB) (36–48 HRC) — speed — m/min (SFM) — Starting Conditions

material group	grade	60 (200)	90 (300)	120 (400)	150 (500)	180 (600)	210 (700)	240 (800)	270 (900)	300 (1000)	m/min	SFM
P4	KCPK05										155	510
	KCP10B										145	480
	KCP25C										125	410
	KCP40B										95	310

Ferritic, Martensitic, and PH Stainless Steels (≤330 HB) (≤35 HRC) — speed — m/min (SFM) — Starting Conditions

material group	grade	120 (400)	150 (500)	180 (600)	210 (700)	240 (800)	270 (900)	300 (1000)	330 (1100)	360 (1200)	m/min	SFM
P5	KCPK05										230	750
	KCP10B										215	710
	KCP25C										235	770
	KCP40B										135	440

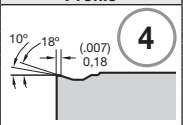
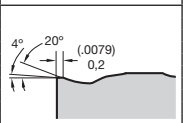
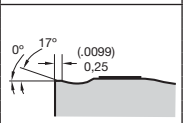
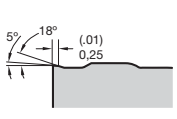
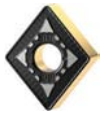
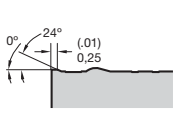
Ferritic, Martensitic, and PH Stainless Steels (340–450 HB) (36–48 HRC) — speed — m/min (SFM) — Starting Conditions

material group	grade	105 (350)	135 (450)	165 (550)	195 (650)	225 (750)	255 (850)	285 (950)	315 (1050)	345 (1150)	m/min	SFM
P6	KCPK05										190	620
	KCP10B										180	590
	KCP25C										180	590
	KCP40B										105	340

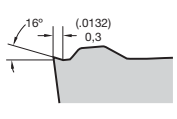
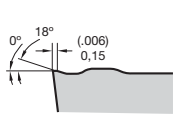
ISO/ANSI Turning Inserts

Chip Control Geometries

Kenloc™ Inserts

Type of Operation	Insert Geometry (3)			Profile	feed rate — in (mm)											
					.0015 (0,04)	.0025 (0,063)	.004 (0,1)	.006 (0,16)	.010 (0,25)	.016 (0,4)	.025 (0,63)	.040 (1,0)	.060 (1,6)	.100 (2,5)	.200 (5,0)	
					.004 (0,1)	.006 (0,16)	.010 (0,25)	.016 (0,4)	.025 (0,63)	.040 (1,0)	.060 (1,6)	.100 (2,5)	.160 (4,0)	.250 (6,3)	.500 (10,0)	
					depth of cut — in (mm)											
(1) Finishing	(2) MG-FN	P M K N S H		 (4)	(5) .003–.012 (0,08–0,3)											
					(6) .008–.125 (0,2–3,0)											
Medium Machining	MG-MV	P K						.006–.02 (0,15–0,50)								
									.02–.22 (0,50–5,5)							
Medium Machining	MG-MN	P							.008–.0125 (0,12–0,6)							
										.012–.200 (0,3–5,0)						
Roughing	MG-RP	P K								.007–.028 (0,18–0,7)						
											.024–.200 (0,6–5,0)					
Roughing	MG-RN	P K									.010–.030 (0,25–0,8)					
												.045–.275 (1,1–7,0)				

Screw-On Inserts

Finishing	MT-FP	P M K S					.0025–.010 (0,063–0,25)									
								.006–.060 (0,16–1,6)								
Medium Machining	MT-MF	P M K S						.004–.016 (0,1–0,4)								
									.012–.125 (0,32–3,2)							

(1) **Machining Operation —** for what the insert geometry is designed

(2) **Chip Control Geometry Designation —** example: MG-MV = CNMG-432MV

(3) **Primary Workpiece** Material Group

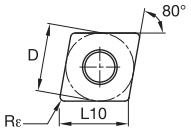
(4) **Chipbreaker Geometry —** section is through nose radius of insert

(5) **Feed Rate Range —** for best results, use the center 60% of the range

(6) **Depth-of-Cut Range —** for all inserts in the program, select smaller inserts for lighter cuts and larger inserts for heavy cuts

ISO/ANSI Turning Inserts

Kenloc™ • CNMG Insert • Negative • FN

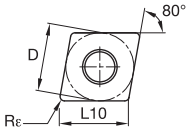


● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
CNMG090308FN	9,53	9,67	0,8	–	●	–	–
CNMG120404FN	12,70	12,90	0,4	–	●	●	–
CNMG120408FN	12,70	12,90	0,8	–	●	●	–
CNMG120412FN	12,70	12,90	1,2	–	●	●	–

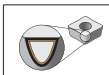
Kenloc • CNMG Insert • Negative • MV



● first choice
○ alternate choice

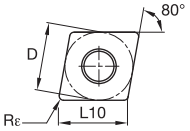
P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
CNMG090304MV	9,53	9,67	0,4	–	●	●	–
CNMG090308MV	9,53	9,67	0,8	–	●	●	●
CNMG120404MV	12,70	12,90	0,4	–	●	●	●
CNMG120408MV	12,70	12,90	0,8	●	●	●	●
CNMG120412MV	12,70	12,90	1,2	●	●	●	●
CNMG120416MV	12,70	12,90	1,6	–	●	●	●
CNMG160608MV	15,88	16,12	0,8	●	●	●	●
CNMG160612MV	15,88	16,12	1,2	●	●	●	●
CNMG160616MV	15,88	16,12	1,6	–	●	●	●
CNMG190608MV	19,05	19,34	0,8	●	●	●	●
CNMG190612MV	19,05	19,34	1,2	●	●	●	●
CNMG190616MV	19,05	19,34	1,6	–	●	●	●
CNMG190624MV	19,05	19,34	2,4	–	●	●	●

			NOVO
29	30	8–10	5

ISO/ANSI Turning Inserts

Kenloc™ • CNMG Insert • Negative • MN

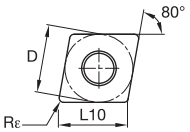


● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
CNMG090304MN	9,53	9,67	0,4	–	–	●	–
CNMG090308MN	9,53	9,67	0,8	–	●	●	–
CNMG120404MN	12,70	12,90	0,4	–	●	●	●
CNMG120408MN	12,70	12,90	0,8	●	●	●	●
CNMG120412MN	12,70	12,90	1,2	–	●	●	●
CNMU120612MN	12,70	12,90	1,2	–	●	–	–
CNMG120416MN	12,70	12,90	1,6	–	●	●	–
CNMG160608MN	15,88	16,12	0,8	–	●	●	–
CNMG160612MN	15,88	16,12	1,2	–	●	●	–
CNMG160616MN	15,88	16,12	1,6	–	●	●	–
CNMG190608MN	19,05	19,34	0,8	–	–	●	–
CNMG190612MN	19,05	19,34	1,2	–	–	●	–
CNMG190616MN	19,05	19,34	1,6	–	●	●	–
CNMG190624MN	19,05	19,34	2,4	–	–	●	–

Kenloc • CNMG Insert • Negative • RP



● first choice
○ alternate choice

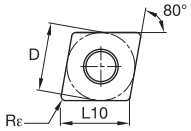
P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
CNMG120404RP	12,70	12,90	0,4	–	–	●	–
CNMG120408RP	12,70	12,90	0,8	●	●	●	–
CNMG120412RP	12,70	12,90	1,2	●	●	●	●
CNMG120416RP	12,70	12,90	1,6	–	●	●	–
CNMG160608RP	15,88	16,12	0,8	–	–	●	–
CNMG160612RP	15,88	16,12	1,2	●	●	●	●
CNMG160616RP	15,88	16,12	1,6	●	●	●	–
CNMG190612RP	19,05	19,34	1,2	–	●	●	●
CNMG190616RP	19,05	19,34	1,6	–	–	●	–

29	30	8–10	5

ISO/ANSI Turning Inserts

Kenloc™ • CNMG Insert • Negative • RN

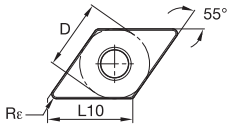


● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
CNMG120408RN	12,70	12,90	0,8	●	●	●	●
CNMG120412RN	12,70	12,90	1,2	●	●	●	●
CNMG120416RN	12,70	12,90	1,6	–	●	●	●
CNMG160608RN	15,88	16,12	0,8	–	●	●	–
CNMG160612RN	15,88	16,12	1,2	●	●	●	●
CNMG160616RN	15,88	16,12	1,6	●	●	●	●
CNMG190608RN	19,05	19,34	0,8	–	●	–	–
CNMG190612RN	19,05	19,34	1,2	–	●	●	●
CNMG190616RN	19,05	19,34	1,6	●	●	●	●
CNMG190624RN	19,05	19,34	2,4	–	–	●	–

Kenloc • DNMG Insert • Negative • FN

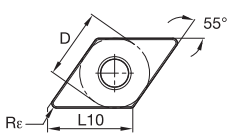


● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
DNMG110404FN	9,53	11,63	0,4	–	●	●	–
DNMG110408FN	9,53	11,63	0,8	–	●	●	–
DNMG110412FN	9,53	11,63	1,2	–	●	–	–
DNMG150404FN	12,70	15,50	0,4	–	●	●	–
DNMG150604FN	12,70	15,50	0,4	–	●	●	–
DNMG150408FN	12,70	15,50	0,8	●	●	●	–
DNMG150608FN	12,70	15,50	0,8	–	●	●	–
DNMG150412FN	12,70	15,50	1,2	–	●	–	–
DNMG150612FN	12,70	15,50	1,2	–	●	–	–

Kenloc • DNMG Insert • Negative • MV



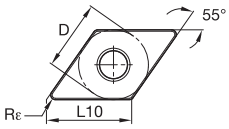
● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
DNMG110404MV	9,53	11,63	0,4	–	●	●	–
DNMG110408MV	9,53	11,63	0,8	●	●	●	–
DNMG110412MV	9,53	11,63	1,2	–	●	●	–
DNMG150404MV	12,70	15,50	0,4	–	●	●	–
DNMG150604MV	12,70	15,50	0,4	–	●	●	–
DNMG150408MV	12,70	15,50	0,8	●	●	●	●
DNMG150608MV	12,70	15,50	0,8	●	●	●	●
DNMG150412MV	12,70	15,50	1,2	–	●	●	●
DNMG150612MV	12,70	15,50	1,2	–	●	●	●

ISO/ANSI Turning Inserts

Kenloc™ • DNMG Insert • Negative • MN

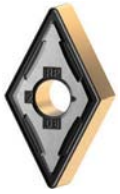


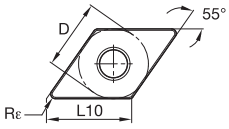
● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
DNMG110404MN	9,53	11,63	0,4	–	●	●	–
DNMG110408MN	9,53	11,63	0,8	–	●	●	–
DNMG110412MN	9,53	11,63	1,2	–	–	●	–
DNMG150404MN	12,70	15,50	0,4	–	●	●	–
DNMG150604MN	12,70	15,50	0,4	–	●	●	–
DNMG150408MN	12,70	15,50	0,8	●	●	●	–
DNMG150608MN	12,70	15,50	0,8	–	●	●	–
DNMG150412MN	12,70	15,50	1,2	–	●	●	●
DNMG150612MN	12,70	15,50	1,2	–	●	●	●

Kenloc • DNMG Insert • Negative • RP





● first choice
○ alternate choice

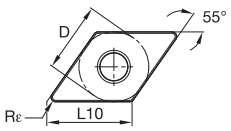
P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
DNMG110408RP	9,53	11,63	0,8	–	–	●	–
DNMG110412RP	9,53	11,63	1,2	–	–	●	–
DNMG150408RP	12,70	15,50	0,8	–	●	●	–
DNMG150608RP	12,70	15,50	0,8	–	●	●	–
DNMG150412RP	12,70	15,50	1,2	–	●	●	–
DNMG150612RP	12,70	15,50	1,2	–	●	●	–
DNMG150616RP	12,70	15,50	1,6	–	●	–	–

29	30	8–10	5

ISO/ANSI Turning Inserts

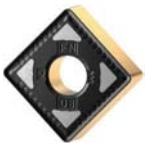
Kenloc™ • DNMG Insert • Negative • RN

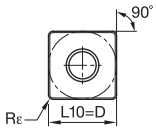


● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
DNMG150408RN	12,70	15,50	0,8	–	●	●	–
DNMG150608RN	12,70	15,50	0,8	●	●	●	●
DNMG150412RN	12,70	15,50	1,2	●	●	●	●
DNMG150612RN	12,70	15,50	1,2	●	●	●	●
DNMG150416RN	12,70	15,50	1,6	–	–	●	–
DNMG150616RN	12,70	15,50	1,6	–	–	●	●
DNMG190608RN	15,88	19,38	0,8	–	●	–	–
DNMG190612RN	15,88	19,38	1,2	–	●	–	–

Kenloc • SNMG Insert • Negative • FN

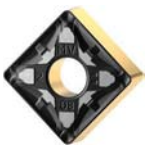


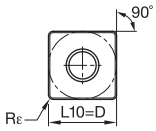


● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
SNMG120404FN	12,70	12,70	0,4	–	●	●	–
SNMG120408FN	12,70	12,70	0,8	–	●	●	–
SNMG120412FN	12,70	12,70	1,2	–	–	●	–

Kenloc • SNMG Insert • Negative • MV





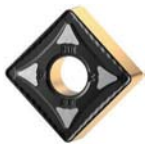
● first choice
○ alternate choice

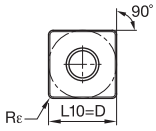
ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
SNMG090308MV	9,53	9,53	0,8	–	●	●	–
SNMG120404MV	12,70	12,70	0,4	–	●	●	–
SNMG120408MV	12,70	12,70	0,8	–	●	●	●
SNMG120412MV	12,70	12,70	1,2	–	●	●	●
SNMG120416MV	12,70	12,70	1,6	–	●	●	–
SNMG150612MV	15,88	15,88	1,2	–	●	●	–
SNMG150616MV	15,88	15,88	1,6	–	●	●	–
SNMG190612MV	19,05	19,05	1,2	–	●	●	–
SNMG190616MV	19,05	19,05	1,6	–	●	●	–

			
29	30	8–10	5

ISO/ANSI Turning Inserts

Kenloc™ • SNMG Insert • Negative • MN

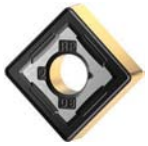


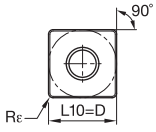


● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
				P ●	P ●	P ●	P ●
				M	M	M	M ○
				K ●	K ○	K ○	K
				N	N	N	N
				S	S	S	S
				H	H	H	H
SNMG090308MN	9,53	9,53	0,8	–	●	●	–
SNMG120404MN	12,70	12,70	0,4	–	●	●	–
SNMG120408MN	12,70	12,70	0,8	–	●	●	●
SNMG120412MN	12,70	12,70	1,2	–	●	●	–
SNMG120416MN	12,70	12,70	1,6	–	–	●	–
SNMG150612MN	15,88	15,88	1,2	–	●	●	–
SNMG150616MN	15,88	15,88	1,6	–	–	●	–
SNMG190612MN	19,05	19,05	1,2	–	–	●	–

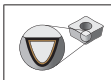
Kenloc • SNMG Insert • Negative • RP





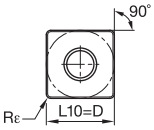
● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
				P ●	P ●	P ●	P ●
				M	M	M	M ○
				K ●	K ○	K ○	K
				N	N	N	N
				S	S	S	S
				H	H	H	H
SNMG120408RP	12,70	12,70	0,8	–	–	●	–
SNMG120412RP	12,70	12,70	1,2	–	●	●	–
SNMG150612RP	15,88	15,88	1,2	–	●	●	–
SNMG150616RP	15,88	15,88	1,6	–	●	●	–
SNMG190612RP	19,05	19,05	1,2	–	–	●	●
SNMG190616RP	19,05	19,05	1,6	–	–	●	–

			
29	30	8–10	5

ISO/ANSI Turning Inserts

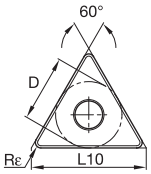
Kenloc™ • SNMG Insert • Negative • RN



● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
SNMG120408RN	12,70	12,70	0,8	–	–	●	●
SNMG120412RN	12,70	12,70	1,2	●	●	●	●
SNMG120416RN	12,70	12,70	1,6	–	●	●	●
SNMG150612RN	15,88	15,88	1,2	●	●	●	●
SNMG150616RN	15,88	15,88	1,6	●	–	●	–
SNMG190612RN	19,05	19,05	1,2	–	●	●	–
SNMG190616RN	19,05	19,05	1,6	●	–	●	●
SNMG250924	25,40	25,40	2,4	–	–	–	●

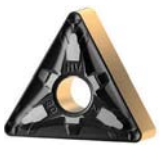
Kenloc • TNMG Insert • Negative • FN

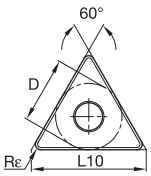


● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
TNMG160404FN	9,53	16,50	0,4	–	●	●	–
TNMG160408FN	9,53	16,50	0,8	–	●	●	–
TNMG160412FN	9,53	16,50	1,2	–	●	–	–
TNMG220408FN	12,70	22,00	0,8	–	●	–	–
TNMG220412FN	12,70	22,00	1,2	–	●	–	–

Kenloc • TNMG Insert • Negative • MV





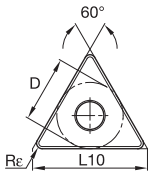
● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
TNMG160404MV	9,53	16,50	0,4	–	●	●	●
TNMG160408MV	9,53	16,50	0,8	●	●	●	●
TNMG160412MV	9,53	16,50	1,2	–	●	●	–
TNMG220404MV	12,70	22,00	0,4	–	●	●	–
TNMG220408MV	12,70	22,00	0,8	–	●	●	●
TNMG220412MV	12,70	22,00	1,2	–	●	●	–

29	30	8–10	5

ISO/ANSI Turning Inserts

Kenloc™ • TNMG Insert • Negative • MN

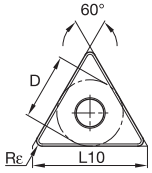


● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
TNMG160404MN	9,53	16,50	0,4	–	●	●	–
TNMG160408MN	9,53	16,50	0,8	–	●	●	–
TNMG160412MN	9,53	16,50	1,2	–	●	●	–
TNMG220404MN	12,70	22,00	0,4	–	–	●	–
TNMG220408MN	12,70	22,00	0,8	–	●	●	–
TNMG220412MN	12,70	22,00	1,2	–	●	●	●

Kenloc • TNMG Insert • Negative • RP

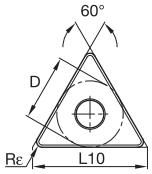


● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
TNMG160408RP	9,53	16,50	0,8	–	●	●	–
TNMG160412RP	9,53	16,50	1,2	–	●	●	–
TNMG220408RP	12,70	22,00	0,8	–	●	●	●
TNMG220412RP	12,70	22,00	1,2	–	–	●	–
TNMG220416RP	12,70	22,00	1,6	–	–	●	–
TNMG220432RP	12,70	22,00	3,2	–	●	–	–
TNMG330924RP	19,05	33,00	2,4	–	–	–	●

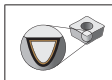
Kenloc • TNMG Insert • Negative • RN

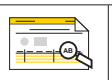


● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
TNMG160408RN	9,53	16,50	0,8	–	●	●	–
TNMG160412RN	9,53	16,50	1,2	–	●	●	–
TNMG220408RN	12,70	22,00	0,8	–	●	●	●
TNMG220412RN	12,70	22,00	1,2	–	●	●	●
TNMG220416RN	12,70	22,00	1,6	–	–	●	–
TNMG270612RN	15,88	27,50	1,2	–	–	–	●
TNMG270616RN	15,88	27,50	1,6	–	–	–	●
TNMG330924RN	19,05	33,00	2,4	–	●	–	●


29

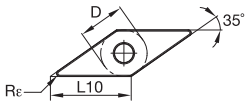

30

8–10

5

ISO/ANSI Turning Inserts

Kenloc™ • VNMG Insert • Negative • FN

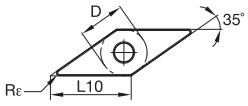


● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
VNMG160404FN	9,53	16,61	0,4	–	●	●	–
VNMG160408FN	9,53	16,61	0,8	–	●	●	–

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

Kenloc • VNMG Insert • Negative • MV

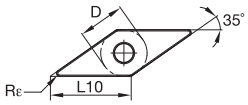


● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
VNMG160404MV	9,53	16,61	0,4	–	●	●	–
VNMG160408MV	9,53	16,61	0,8	●	●	●	●
VNMG160412MV	9,53	16,61	1,2	–	●	●	–

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

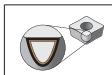
Kenloc • VNMG Insert • Negative • MN



● first choice
○ alternate choice

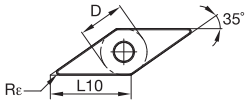
ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
VNMG160404MN	9,53	16,61	0,4	–	●	●	–
VNMG160408MN	9,53	16,61	0,8	–	●	●	–
VNMG160412MN	9,53	16,61	1,2	–	–	●	–

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

			
29	30	8–10	5

ISO/ANSI Turning Inserts

Kenloc™ • VNMG Insert • Negative • RP

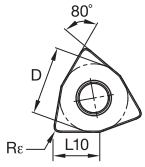


● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
VNMG160408RP	9,53	16,61	0,8	–	–	●	–
VNMG160412RP	9,53	16,61	1,2	–	–	●	–

Kenloc • WNMG Insert • Negative • FN

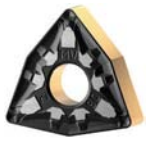


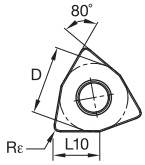
● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
WNMG060408FN	9,53	6,52	0,8	–	–	●	–
WNMG080404FN	12,70	8,69	0,4	–	●	●	–
WNMG080408FN	12,70	8,69	0,8	–	●	●	–

Kenloc • WNMG Insert • Negative • MV





● first choice
○ alternate choice

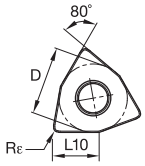
P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
WNMG060408MV	9,52	6,52	0,8	–	●	●	–
WNMG060412MV	9,53	6,52	1,2	–	●	●	–
WNMG080408MV	12,70	8,69	0,8	–	●	●	●
WNMG080412MV	12,70	8,69	1,2	–	●	●	●
WNMG080416MV	12,70	8,69	1,6	–	●	●	–

			
29	30	8–10	5

ISO/ANSI Turning Inserts

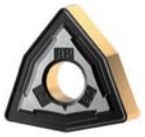
Kenloc™ • WNMG Insert • Negative • MN

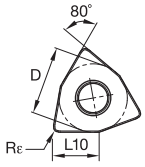


● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
WNMG060408MN	9,53	6,52	0,8	–	●	●	–
WNMG080408MN	12,70	8,69	0,8	–	●	●	–
WNMG080412MN	12,70	8,69	1,2	–	●	●	●
WNMG080416MN	12,70	8,69	1,6	–	–	●	–

Kenloc • WNMG Insert • Negative • RP

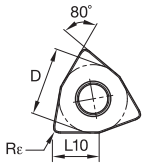




● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
WNMG060408RP	9,53	6,52	0,8	–	●	●	–
WNMG060412RP	9,53	6,52	1,2	–	–	●	–
WNMG080408RP	12,70	8,69	0,8	●	●	●	●
WNMG080412RP	12,70	8,69	1,2	●	●	●	–
WNMG080416RP	12,70	8,69	1,6	–	–	●	–

Kenloc • WNMG Insert • Negative • RN



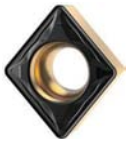
● first choice
○ alternate choice

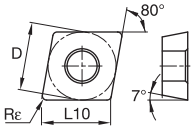
ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
WNMG060408RN	9,53	6,52	0,8	–	●	●	–
WNMG060412RN	9,53	6,52	1,2	–	–	●	–
WNMG080408RN	12,70	8,69	0,8	–	●	●	–
WNMG080412RN	12,70	8,69	1,2	●	●	●	●
WNMG080416RN	12,70	8,69	1,6	–	●	●	–

29	30	8–10	5

ISO/ANSI Turning Inserts

Screw-On • CCMT Insert • Positive • FP

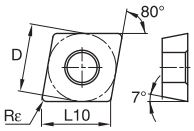




● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
CCMT060204FP	6,35	6,45	0,4	–	●	●	–
CCMT060208FP	6,35	6,45	0,8	–	–	●	–
CCMT09T302FP	9,53	9,67	0,2	–	–	●	–
CCMT09T304FP	9,53	9,67	0,4	–	●	●	–
CCMT09T308FP	9,53	9,67	0,8	–	●	●	–
CCMT120404FP	12,70	12,90	0,4	–	●	●	–
CCMT120408FP	12,70	12,90	0,8	–	–	●	–

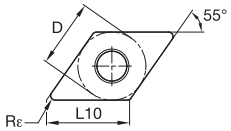
Screw-On • CCMT Insert • Positive • MF



● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
CCMT060204MF	6,35	6,45	0,4	–	●	●	–
CCMT060208MF	6,35	6,45	0,8	–	–	●	–
CCMT09T304MF	9,53	9,67	0,4	–	●	●	–
CCMT09T308MF	9,53	9,67	0,8	–	●	●	–
CCMT09T312MF	9,53	9,67	1,2	–	–	●	–
CCMT120408MF	12,70	12,90	0,8	–	●	●	–
CCMT120412MF	12,70	12,90	1,2	–	–	●	–

Screw-On • DCMT Insert • Positive • FP



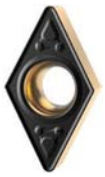
● first choice
○ alternate choice

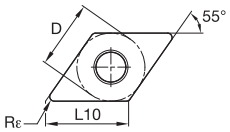
ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
DCMT070202FP	6,35	7,75	0,2	–	–	●	–
DCMT070204FP	6,35	7,75	0,4	–	–	●	–
DCMT070208FP	6,35	7,75	0,8	–	–	●	–
DCMT11T302FP	9,53	11,63	0,2	–	●	●	–
DCMT11T304FP	9,53	11,63	0,4	–	●	●	–
DCMT11T308FP	9,53	11,63	0,8	–	●	●	–

29	30	8–10	5

ISO/ANSI Turning Inserts

Screw-On • DCMT Insert • Positive • MF



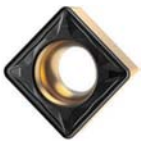


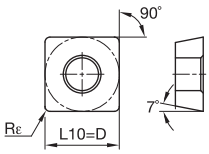
● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
DCMT11T304MF	9,53	11,63	0,4	–	●	●	–
DCMT11T308MF	9,53	11,63	0,8	–	●	●	–
DCMT11T312MF	9,53	11,63	1,2	–	●	●	–

Screw-On • SCMT Insert • Positive • FP



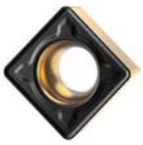


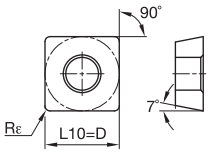
● first choice
○ alternate choice

P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
SCMT09T304FP	9,53	9,53	0,4	–	–	●	–
SCMT09T308FP	9,53	9,53	0,8	–	–	●	–
SCMT120404FP	12,70	12,70	0,4	–	–	●	–
SCMT120408FP	12,70	12,70	0,8	–	–	●	–

Screw-On • SCMT Insert • Positive • MF





● first choice
○ alternate choice

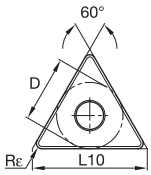
P	●	●	●	●
M				○
K	●	○	○	
N				
S				
H				

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
SCMT09T308MF	9,53	9,53	0,8	–	●	●	–
SCMT09T312MF	9,53	9,53	1,2	–	–	●	–
SCMT120404MF	12,70	12,70	0,4	–	–	●	–
SCMT120408MF	12,70	12,70	0,8	–	–	●	–
SCMT120412MF	12,70	12,70	1,2	–	–	●	–

29	30	8–10	5

ISO/ANSI Turning Inserts

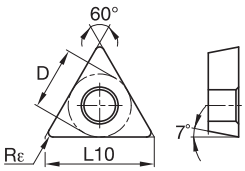
Screw-On • TCMT Insert • Positive • FP



● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
TCMT090204FP	5,56	9,62	0,4	–	–	●	–
TCMT110204FP	6,35	11,00	0,4	–	–	●	–
TCMT110304FP	6,35	11,00	0,4	–	●	–	–
TCMT110208FP	6,35	11,00	0,8	–	–	●	–
TCMT16T304FP	9,53	16,50	0,4	–	–	●	–
TCMT16T308FP	9,53	16,50	0,8	–	–	●	–

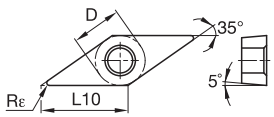
Screw-On • TCMT Insert • Positive • MF



● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
TCMT110204MF	6,35	11,00	0,4	–	–	●	–
TCMT110208MF	6,35	11,00	0,8	–	–	●	–
TCMT16T308MF	9,53	16,50	0,8	–	–	●	–
TCMT16T312MF	9,53	16,50	1,2	–	–	●	–

Screw-On • VBMT Insert • Positive • FP



● first choice
○ alternate choice

ISO catalogue number	D	L10	Rε	KCPK05	KCP10B	KCP25C	KCP40B
VBMT160404FP	9,53	16,61	0,4	–	●	●	–
VBMT160408FP	9,53	16,61	0,8	–	●	●	–
VBMT160412FP	9,53	16,61	1,2	–	●	●	–

			
29	30	8–10	5

Grades and Grade Descriptions

Turning

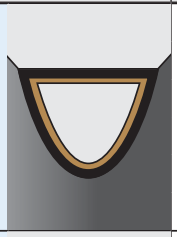
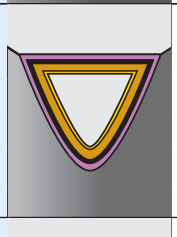
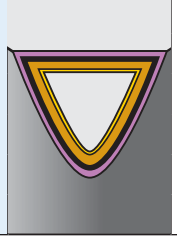
NEW!

KENGold™ | The Gold Standard in Coating Technology

wear resistance ⟷ toughness

Coating	Grade Description		05	10	15	20	25	30	35	40	45
KCP25C 	Composition: A tough cobalt-enriched carbide grade with a newly designed advanced multilayer MTCVD TiCN-Al_2O_3 coating with a gold TiN outer layer on the flank. Application: Primarily the best general-purpose turning grade for steels and ferritic/martensitic stainless steels with alternate capability in heavy cast iron roughing. The substrate design provides an excellent combination of deformation resistance and insert edge strength. Coating layers offer superior wear resistance, enabling increased speeds and productivity. A targeted post-coat treatment minimizes microchipping and enables improved part finishes while retaining the bright gold color on the flank so that used/unused cutting edges can clearly be identified.	P				■	■	■			
		K							■	■	

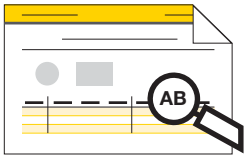
wear resistance ⟷ toughness

Coating	Grade Description		05	10	15	20	25	30	35	40	45
KCPK05 	Composition: A deformation-resistant, cobalt-enriched substrate combined with a thick MTCVD TiCN-Al_2O_3 coating. Application: Primarily for high-productivity turning of steels in continuous to lightly interrupted cuts. Its unique combination of substrate and coating also makes it an alternate choice as a roughing grade for cast iron where chipping resistance is required. This grade provides an excellent combination of deformation resistance and high-speed capability, allowing the fastest steel part production.	P	■	■	■						
		K					■	■	■		
KCP10B 	Composition: A specially engineered wear-resistant cobalt-enriched carbide grade with a multilayer MTCVD TiCN-Al_2O_3-TiOCN coating with superior interlayer adhesion. Application: Primarily an excellent finishing to medium machining grade for steels, ferritic, and martensitic steels. Alternatively it can also be used for heavy roughing of cast irons. The cobalt-enriched substrate offers a balanced combination of deformation resistance and edge toughness, while the smooth thick coating adds outstanding abrasion and crater wear resistance for high-speed machining with excellent surface finishes.	P		■	■	■					
		K						■	■		
KCP40B 	Composition: A very tough cobalt-enriched carbide grade with a thin multilayer MTCVD TiCN-Al_2O_3-TiOCN coating. Application: Primarily for heavy roughing of carbon steels, alloy steels, and ferritic/martensitic stainless steels. It is also an alternative choice for roughing of austenitic and duplex stainless steels. The strong substrate and thin coating combination provides superior toughness and operational security, allowing high feeds and depths of cut for increased metal removal rates even in demanding interrupted cuts.	P							■	■	■
		M				■	■	■			

Grades

General Information

Key to Product Table Column Headings



You may notice a slight change in the appearance of our product tables and specification charts. In this catalog, Kennametal introduces a set of short-name codes to improve the readability of tables and drawings. These codes replace full-text descriptions. The full list of codes and their definitions can be found below.

Short-Name Code	Full Text Description
D	Insert: Insert IC Size
L10	Insert Cutting Edge Length
Rε	Corner Radius

Material Cross Reference • DIN

P Steel
M Stainless Steel
K Cast Iron

N Non-Ferrous
S High-Temp Alloys

H Hardened Materials
C CFRP Materials

material group	description	content	tensile strength RM (MPa)*	hardness (HB)	hardness (HRC)	material number
P0	Low-Carbon Steels, Long Chipping	C <0,25%	<530	<125	–	–
P1	Low-Carbon Steels, Short Chipping, Free Machining	C <0,25%	<530	<125	–	C15, Ck22, ST37-2, S235JR, 9SMnPb28, GS38
P2	Medium- and High-Carbon Steels	C >0,25%	>530	<220	<25	ST52, S355JR, C35, GS60, Cf53
P3	Alloy Steels and Tool Steels	C >0,25%	600–850	<330	<35	16MnCr5, Ck45, 21CrMoV5-7, 38SMn28
P4	Alloy Steels and Tool Steels	C >0,25%	850–1400	340–450	35–48	100Cr6, 30CrNiMo8, 42CrMo4, C70W2, S6525, X120Mn12
P5	Ferritic, Martensitic, and PH Stainless Steels	–	600–900	<330	<35	100Cr6, 30CrNiMo8, 42CrMo4, C70W2, S6525, X120Mn12
P6	High-Strength Ferritic, Martensitic, and PH Stainless Steels	–	900–1350	350–450	35–48	X102CrMo17, G-X120Cr29
M1	Austenitic Stainless Steel	–	<600	130–200	–	X5CrNi 18 10, X2CrNiMo 17 13 2, G-X25CrNiSi18 9, X15CrNiSi 20 12
M2	High-Strength Austenitic Stainless and Cast Stainless Steels	–	600–800	150–230	<25	X2CrNiMo 13 4, X5NiCr 32 21, X5CrNiNb 18 10, G-X15CrNi 25-20
M3	Duplex Stainless Steel	–	<800	135–275	<30	X8CrNiMo27 5, X2CrNiMoN22 5 3, X20CrNiSi25 4, G-X40CrNiSi27 4
K1	Grey Cast Iron	–	125–500	120–290	<32	GG15, GG25, GG30, GG40, GTW40
K2	Low- and Medium-Strength Ductile Irons (Nodular Irons) and Compacted Graphite Irons (CGI)	–	<600	130–260	<28	GGG40, GTS35
K3	High-Strength Ductile Irons and Austempered Ductile Iron (ADI)	–	>600	180–350	<43	GGG60, GTW55, GTS65
N1	Wrought Aluminum	–	–	–	–	AlMg1, Al99.5, AlCuMg1, AlCuBiPb, AlMgSi1, ALMgSiPb
N2	Low-Silicon Aluminum Alloys and Magnesium Alloys	Si <12,2%	–	–	–	GAlSiCu4, GDAlSi10Mg
N3	High-Silicon Aluminum Alloys and Magnesium Alloys	Si >12,2%	–	–	–	G-ALSi12, G-AlSi17Cu4, G-AlSi21CuNiMg
N4	Copper-, Brass-, Zinc-Based on Machinability Index Range of 70–100	–	–	–	–	CuZn40, Ms60, G-CuSn5ZnPb, CuZn37, CuSi3Mn
N5	Nylon, Plastics, Rubbers, Phenolics, Resins, Fiberglass	–	–	–	–	LEXAN®, HOSTALEN™, POLYSTYROL®, MAKROLON®
N6	Carbon, Graphite Composites, CFRP	–	–	–	–	CFK, GFK
N7	Metal Matrix Composites (MMC)	–	–	–	–	–
S1	Iron-Based, Heat-Resistant Alloys	–	500–1200	160–260	25–48	X1NiCrMoCu32 28 7, X12NiCrSi36 16, X5NiCrAlTi31 20, X40CoCrNi20 20
S2	Cobalt-Based, Heat-Resistant Alloys	–	1000–1450	250–450	25–48	Haynes® 188, Stellite™ 6,21,31
S3	Nickel-Based, Heat-Resistant Alloys	–	600–1700	160–450	<48	INCONEL® 690, INCONEL 625, Hastelloy®, NIMONIC® 75
S4	Titanium and Titanium Alloys	–	900–1600	300–400	33–48	Ti1, TiAl5Sn2, TiAl6V4, TiAl4Mo4Sn2
H1	Hardened Materials	–	–	–	44–48	GX260NiCr42, GX330NiCr42, GX300CrNiSi952, GX300CrMo153, Hardox® 400
H2	Hardened Materials	–	–	–	48–55	–
H3	Hardened Materials	–	–	–	56–60	–
H4	Hardened Materials	–	–	–	>60	–
C1	CFRP, CFRP/CFRP	–	–	–	–	–
C2	CFRP/Non-Ferrous	–	–	–	–	–
C3	CFRP/High-Temp	–	–	–	–	–
C4	CFRP/Stainless Steel	–	–	–	–	–
C5	CFRP/Non-Ferrous/High-Temp	–	–	–	–	–

Notes

METALCUTTING SAFETY

IMPORTANT SAFETY INSTRUCTIONS

Read before using the tools in this catalog!

Projectile and Fragmentation Hazards:

Modern metalcutting operations involve high spindle and cutter speeds and high temperatures and cutting forces. Hot metal chips may fly off the workpiece during metalcutting. Although cutting tools are designed and manufactured to withstand high cutting forces and temperatures, they can sometimes fragment, particularly if they are subjected to over-stress, severe impact, or other abuse.

To avoid injury:

- Always wear appropriate personal protective equipment, including safety goggles, when operating metalcutting machines or working nearby.
- Always make sure all machine guards are in place.

Breathing and Skin Contact Hazards:

Grinding carbide or other advanced cutting tool materials produces dust or mist containing metallic particles. Breathing this dust or mist — especially over an extended period — can cause temporary or permanent lung disease or make existing medical conditions worse. Contact with this dust or mist can irritate eyes, skin, and mucous membranes and may make existing skin conditions worse.

To avoid injury:

- Always wear breathing protection and safety goggles when grinding.
- Provide ventilation control and collect and properly dispose of dust, mist, or sludge from grinding.
- Avoid skin contact with dust or mist.

For more information, read the applicable Material Safety Data Sheet provided by Kennametal and consult General Industry Safety and Health Regulations, Part 1910, Title 29 of the Code of Federal Regulations.

These safety instructions are general guidelines. Many variables affect machining operations. It is impossible to cover every specific situation. The technical information included in this catalog and recommendations on machining practices may not apply to your particular operation. For more information, consult the Kennametal Metalcutting Safety booklet, available free from Kennametal at 724 539 5747 or fax 724 539 5439. For specific product safety and environmental questions, contact our Corporate Environmental Health and Safety Office at 724 539 5066 or fax 724 539 5372.

INNOVATIONS

WORLD HEADQUARTERS
Kennametal Inc.
525 William Penn Place I Suite 3300
Pittsburgh, PA 15219 USA
Tel: 1 800 446 7738
ftmill.service@kennametal.com

EUROPEAN HEADQUARTERS
Kennametal Europe GmbH
Rheingoldstrasse 50
CH 8212 Neuhausen am Rheinfall
Switzerland
Tel: +41 52 6750 100
neuhausen.info@kennametal.com

ASIA-PACIFIC HEADQUARTERS
Kennametal Singapore Pte. Ltd.
3A International Business Park
Unit #01-02/03/05, ICON@IBP
Singapore 609935
Tel: +65 6265 9222
k-sg.sales@kennametal.com

INDIA HEADQUARTERS
Kennametal India Limited
CIN: L27109KA1964PLC001546
8/9th Mile, Tumkur Road
Bangalore - 560073
Tel: +91 080 22198444 or +91 080 43281444
bangalore.information@kennametal.com

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kennametal.com