



KENNA PERFECT TOP NOTCH Profiling

3rd Step – Select the Cutting Speed

Steel

KENNA PERFECT Material Group	grade	Speed - sfm (m/min)								Starting Conditions	
		170 (50)	330 (100)	490 (150)	655 (200)	820 (250)	980 (300)	1150 (350)	1300 (400)	sfm	m/min
P	KT315									850	260
	KC9110									800	240
	KC9125									600	180
	KC8050									550	165

Stainless Steel

KENNA PERFECT Material Group	grade	Speed - sfm (m/min)								Starting Conditions	
		170 (50)	330 (100)	490 (150)	655 (200)	820 (250)	980 (300)	1150 (350)	1300 (400)	sfm	m/min
M	KT315									750	230
	KC5010									600	180
	KC5025									400	120
	KC9225									550	170
	KC8050									500	150

Cast Iron

KENNA PERFECT Material Group	grade	Speed - sfm (m/min)								Starting Conditions	
		170 (50)	330 (100)	490 (150)	655 (200)	820 (250)	980 (300)	1150 (350)	1300 (400)	sfm	m/min
K	KT315									900	275
	KC5010									800	245
	KC9315									800	245
	KC8050									750	230

Non-Ferrous

KENNA PERFECT Material Group	grade	Speed - sfm (m/min)								Starting Conditions	
		800 (250)	1600 (500)	2400 (750)	3200 (1000)	4000 (1250)	4800 (1500)	5600 (1750)	6400 (2000)	sfm	m/min
N	KD100/KD1405									2500	765
	KC5410									1800	550
	KC5010									1500	460
	K68									500	150

High-Temperature Alloys

KENNA PERFECT Material Group	grade	Speed - sfm (m/min)								Starting Conditions	
		50 (15)	120 (40)	180 (55)	250 (80)	330 (100)	550 (170)	655 (200)	750 (230)	sfm	m/min
S	KB9610									700	215
	KD120									400	120
	KC5010									200	60
	KC5025									170	50
	KC8050									230	70
	K68									100	30

Hardened Materials

KENNA PERFECT Material Group	grade	Speed - sfm (m/min)								Starting Conditions	
		50 (15)	120 (40)	180 (55)	250 (80)	330 (100)	550 (170)	655 (200)	750 (230)	sfm	m/min
H	KB9610									500	150
	KC5010									130	40

Represents the recommended starting conditions. Optimize for your specific application.

TOP NOTCH PROFILING

K-LOCK

KENDEX MINI

APPLICATION-SPECIFIC TOOLS