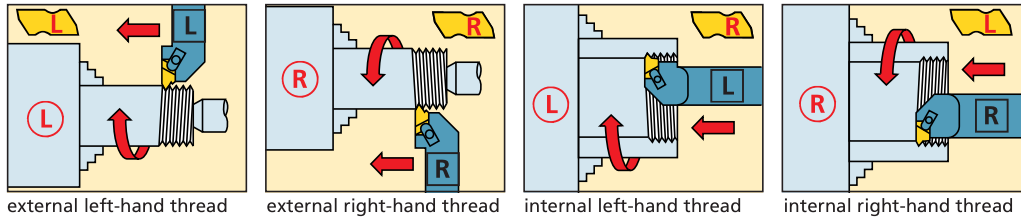## 4 Easy Steps to Improve Productivity

What you need to know:

- external/internal operation
- spindle rotation/hand of thread
- feed direction
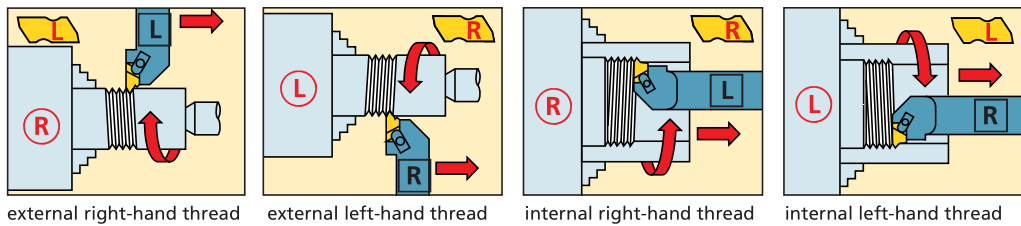
1st Step – Select Threading Method and Hand of Tooling

Ⓛ or Ⓡ – hand of thread

☐L or ☐R – hand of toolholder

▱ or ▱ – hand of insert

• **Feed direction toward the chuck – standard helix**

| external left-hand thread | external right-hand thread | internal left-hand thread | internal right-hand thread |

• **Feed direction away from the chuck – reverse helix**

| external right-hand thread | external left-hand thread | internal right-hand thread | internal left-hand thread |

2nd Step – Choose Insert for Application

- See threading insert overview on page C35.
- Select cresting inserts for fully controlled thread form including diameter control. Cresting inserts eliminate the need for deburring.
- Non-cresting partial profile inserts can cut a variety of thread pitches. Chip control is only available with partial profile inserts.
- Note insert size for toolholder selection.

Insert Size	catalog number	KC5025	KC5010
2	NT-2RK	●	●
3	NT-3RK	●	●
4	NT-4RK	●	●

3rd Step – Select Grade and Speed

Recommendations for Grade and Speed Selection – sfm (m/min)

	Workpiece Material	Steel	Stainless Steel	Cast Iron	Non-Ferrous Metals	High-Temp Alloys
KENNA PERFECT	Insert Style	chip control or neutral	chip control or positive	neutral	positive	positive
	Optimum Cutting Conditions	KC5010* 160 - 750 (50 - 230)	KC5010* 160 - 600 (50 - 185)	KC5010 230 - 700 (70 - 210)	KC5410 230 - 1300 (70 - 390)	KC5010 65 - 400 (20 - 120)
	First Choice	KC5025 130 - 650 (40 - 200)	KC5025 130 - 450 (40 - 135)	KC5025 200 - 475 (60 - 145)	KC5025 160 - 1150 (50 - 360)	KC5025 35 - 330 (10 - 100)
KENNA UNIVERSAL	Insert Style	chip control or neutral				
	Selection	KU25T 80 - 450 (25 - 140)	KU25T 80 - 350 (25 - 100)	KU25T 100 - 360 (30 - 110)	KU25T 100 - 1000 (30 - 300)	KU25T 35 - 280 (10 - 85)

* Note: KT315 is also available as an optimum cutting tool for steel and stainless steel for partial profile threading. Increase speed by 15% over the recommendations above.

Examples: Chip Control: NT-K or NT-CK (partial profile only)
Neutral: NT, NT-C, NTF, NTC, NJ, NJF, NDC-V, NA, NDC, NTB-A/B
Positive: NTP, NTK, NJP, NJK