



KENLOC
KENDEX TURNING INSERTS
SCREW-ON
TOOLHOLDERS
BORING BARS
TURNING HOLDERS
BORING HEADS
CARTRIDGES

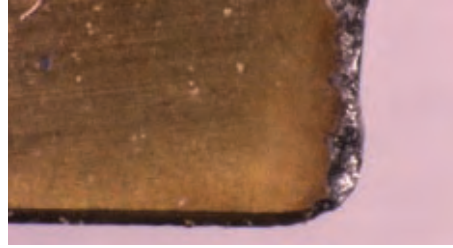
Edge Wear*



Corrective Action

- Increase feed rate.
- Reduce speed (sfm).
- Use more wear resistant grade.
- Apply coated grade.

Chipping



Corrective Action

- Utilize stronger grade.
- Consider edge preparation.
- Check rigidity of system.
- Increase lead angle.

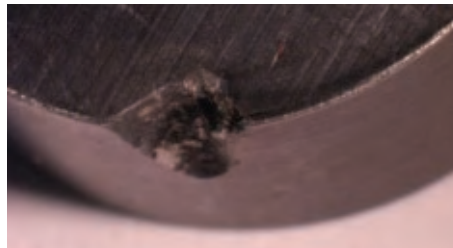
Heat Deformation



Corrective Action

- Reduce speed.
- Reduce feed.
- Reduce depth-of-cut (doc).
- Use grade with higher hot hardness.

Depth-of-Cut Notching



Corrective Action

- Change lead angle.
- Consider edge preparation.
- Apply different grade.

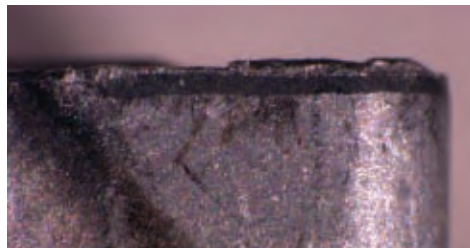
Thermal Cracking



Corrective Action

- Properly apply coolant.
- Reduce speed.
- Reduce feed.
- Apply coated grades.

Built-Up Edge



Corrective Action

- Increase speed (sfm).
- Increase feed rate.
- Apply coated grades or cermets.
- Utilize coolant.
- Edge prep (smaller hone).

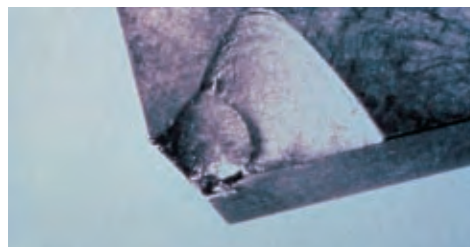
Crater



Corrective Action

- Reduce feed rate.
- Reduce speed (sfm).
- Apply coated grades or cermets.
- Utilize coolant.

Catastrophic Breakage



Corrective Action

- Utilize stronger insert geometry or grade.
- Reduce feed rate.
- Reduce depth-of-cut (doc).
- Check rigidity of system.

*NOTE: Generally, inserts should be indexed when .030" (0,7 mm) flank wear is reached. For finishing operations, index at .015" (0,4 mm) flank wear or sooner.