

What you need to know:

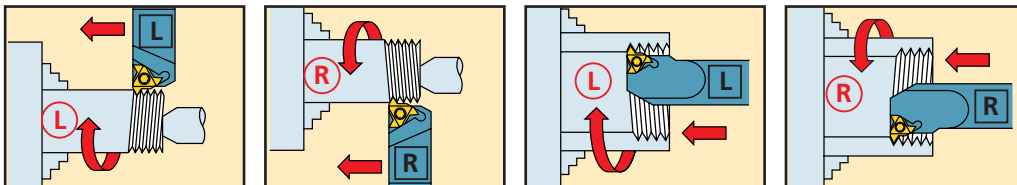
- external/internal operation
- spindle rotation/hand of thread
- feed direction

1st Step – Select Threading Method and Hand of Tooling

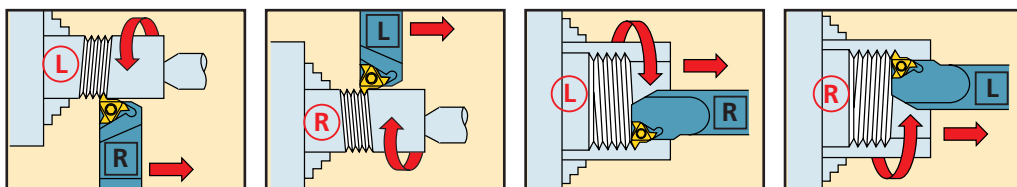
Ⓛ or Ⓜ – hand of thread

Ⓛ or Ⓜ – hand of holder/insert

• Feed direction toward the chuck – standard helix



• Feed direction away from the chuck – reverse helix



2nd Step – Choose Insert for Application

- See threading insert overview on page C9.
- Select cresting inserts for fully controlled thread form including diameter. Cresting inserts eliminate the need for deburring and are optimized for the best tool life at that pitch.
- Non-cresting partial profile inserts offer the flexibility to cut a variety of thread pitches with one insert.
- Note insert size for toolholder selection.

Insert Size	catalog number	KC5025	KC5010
11	LT11NRA60	●	●
16	LT16NRAG60	●	●

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	CB Chipbreaker		Flat Top	CB Chipbreaker	
	Optimum Cutting Conditions	KC5010 160 - 750 (50 - 230)	KC5010 160 - 600 (50 - 185)	KC5010 230 - 700 (70 - 210)	KC5010 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	-K Chipbreaker				
	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)

CB-style chip control inserts are not available with some thread forms. In those cases, flat top inserts can be substituted.



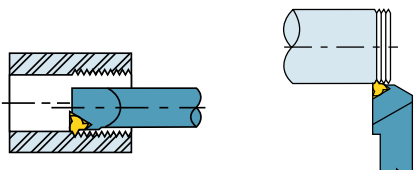
4th Step – Select Holder from Catalog Page

Note: The insert size must match the gage insert size of your toolholder selection:

Required information:

- external/internal operation
- minimum bore diameter (for internal operations)
- hand of tool
- insert size (gage insert)

Select the appropriate holder for the insert size and hand



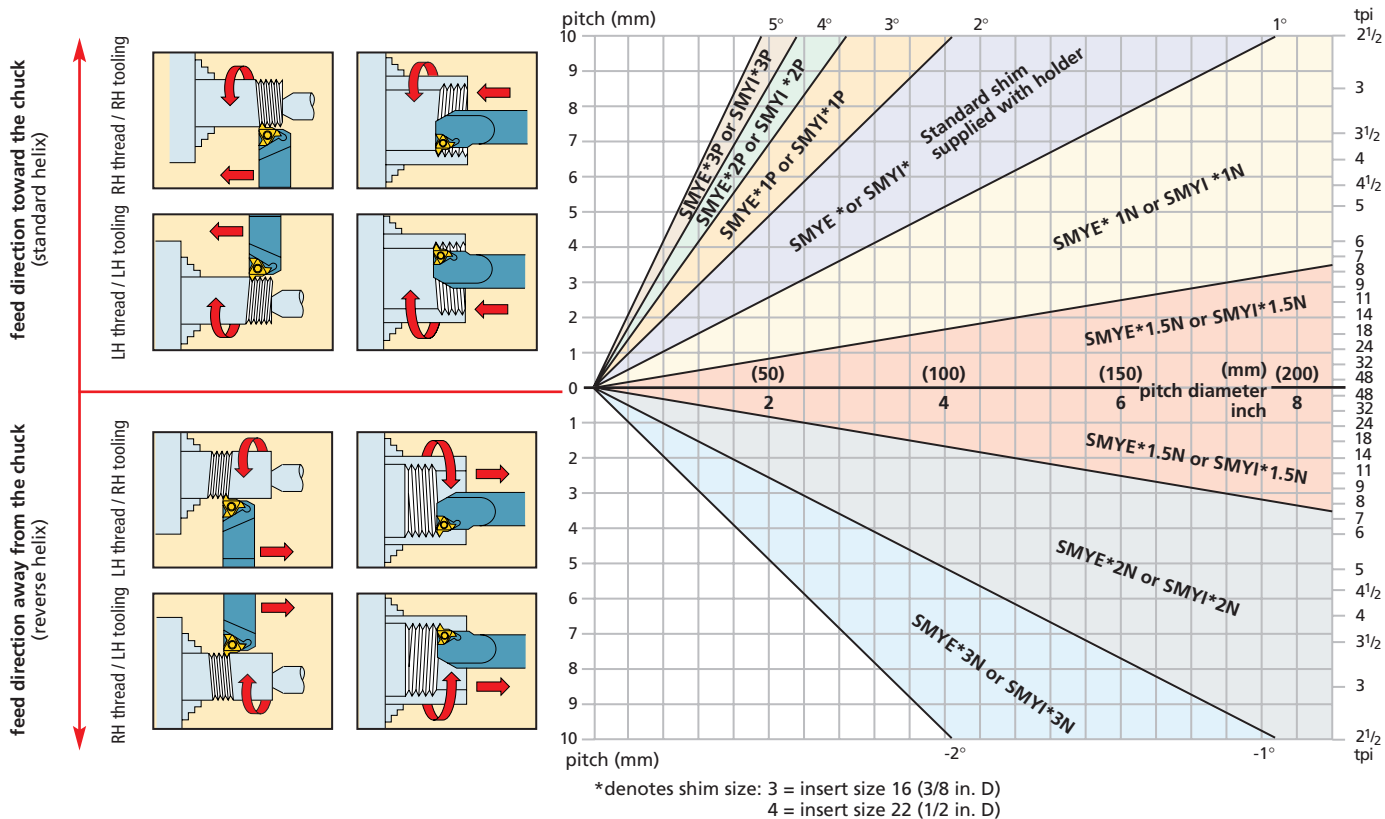
catalog number	gage insert	min. bore diameter	shim
S1212LSER3	LT16NR	.90 in	SM-YI3
A2020LSER16	LT16NR	16 mm	SM-YI3

5th Step – Select Appropriate Shim

Required information:

- thread form (tpi or pitch)
- pitch diameter
- helix method (hand of tool, feed direction, hand of thread)

Select the proper shim SMYE... for external RH or internal LH
SMYI... for internal RH or external LH



If recommended shim is different from shim supplied with toolholder, order shim separately.

NOTE: Optimize your threading operation by using the proper infeed angle and the recommended infeed values. See the Technical Section on pages C58-C60 of this catalog. Also see detailed shim selection information on page, C61-C63.