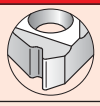
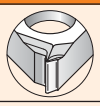
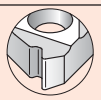
Step 4 • Select grade and speed

Recommendations for Grade and Speed Selection • SFM (m/min)

	workpiece material	P	M	K	N	S
Kenna Perfect™	insert style	CB chipbreaker		Flat Top 	CB Chipbreaker	
	optimum cutting conditions	**KC5010** 160–750	**KC5010** 160–600	**KC5010** 230–700	**KC5010** 230–1300	**KC5010** 65–400
	first choice	**KC5025** 130–650	**KC5025** 130–450	**KC5025** 200–475	**KC5025** 160–1150	**KC5025** 35–330
Kenna Universal™	insert style	-K chipbreaker				
	selection	**KU25T** 80–450	**KU25T** 80–350	**KU25T** 100–360	**KU25T** 100–1000	**KU25T** 35–280

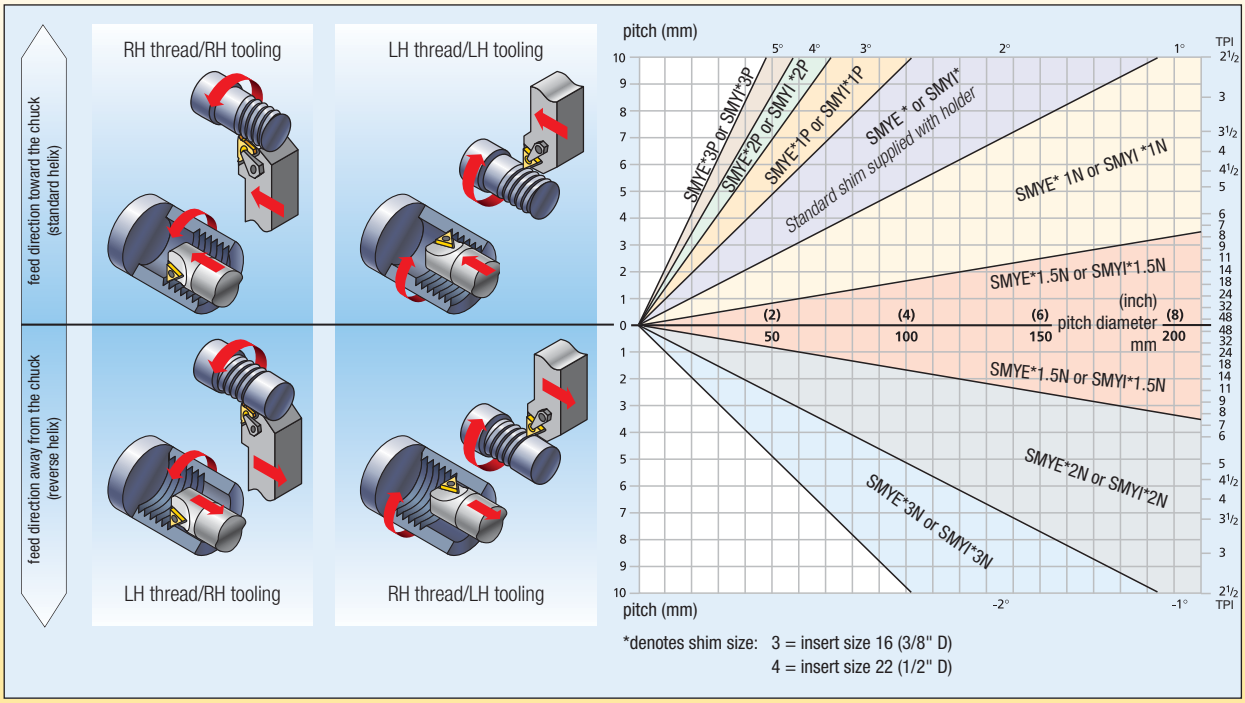
NOTE: CB-style chip control inserts are not available with some thread forms.
In those cases, flat top inserts can be substituted.

Step 5 • 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



*denotes shim size: 3 = insert size 16 (3/8" D)
4 = insert size 22 (1/2" D)

NOTE: If recommended shim is different from shim supplied with toolholder, order shim separately.
Optimise your threading operation by using the proper infeed angle and the recommended infeed values.
See the Technical Section on page E81–E83.
Also see detailed shim selection information on pages E101–E103.