

SUMMARY OF INSERT GRADES

INSERT SELECTION TABLE

Applications	Cutting Range	P	M	K	N	S		H	Powdered Metal
		Steel	Stainless Steel	Cast Iron	Non-ferrous Metals	Heat-Resistant Alloys	Titanium Alloys	Hard Materials	
Back Turning	Large ↑ Cutting Dia. ↓ Small	TC60M	PR1025		KPD001	PR1025	KPD001		PR1425 PR930
		PR1025	PR1225	KW10	KW10	PR1225	KW10	-	
		PR1225	PR930						
		PR1425							
		PR930							
External and Internal Turning	Large ↑ Cutting Dia. ↓ Small	TN6010	TN620						TN6010 TN60 KBN65M KBN70M PR930
		TN6020	TN60						
		TN60	PV720			CA6515			
		PV7010	PV7025	KBN60M	KPD001	CA6525	KPD001	KBN05M	
		PV720	CA6515	CA4505	KPD010	PR1125	KPD010	KBN10M	
		PV7025	CA6525	CA4515	KW10	PR1305	KW10	KBN25M	
		CA5515	PR1025	KW10		PR1310	SW05	KBN30M	
		CA5525	PR1225			PR1325	SW10	KBN35M	
		PR1005	PR1125				SW25		
		PR1025	PR930						
		PR1425							
		PR1225	PR930						
Cut-Off	Depends on workpiece material	PR1025	PR1025	KW10	KW10	KW10	KW10		
		PR1225	PR1225			PR1025			
Grooving	Glossy Finish ↑ Stable Cutting ↓	TC40N	TC40N						TC40N PR930
		TN90	TN90	PR905	KPD001	PR915		KBN510	
		PR930	PR915	PR1215	KW10	KW10	KPD001	KBN525	
		CR9025	CR9025	KW10	GW15	PR1115	KW10		
		PR1115	PR1115	KW10	GW15	PR1225			
Threading	Glossy Finish ↑ Stable Cutting ↓	TC60M	TC60M						PR1425 PR930
		PR930	PR930			KW10			
		PR1115	PR1025	KW10	KW10	GW15	KW10		
Drilling	Wear Resistance ↑ Toughness ↓	PR1025	PR1025			PR1025			
		PR1225	PR1225	PR905	KW10	PR1225	KW10		
		PR1230	PR660	PR1210	GW15	PR660	GW15		
		PR660							
Milling	Finishing ↑ Roughing ↓	TN100M	CA6535		KPD230	CA6535	KPD230		
		PR830	PR830	PR1210	KPD001	PR830	KPD001		
		PR1225	PR1225	PR1510	KPD010	PR660	KW10		
		PR1230	PR1525	KW10	KW10	PR1225	PR905		
		PR1525	PR1535		GW25	PR1525	PR1210		
					PR1535				

Highlighted items are recommended choice

GRADES	A
INSERTS	B
CBN & PCD	C
TURNING	E
BORING	F
GROOVING	G
CUT-OFF	H
THREADING	J
SOLID END MILLS	L
MILLING	M
SPARE PARTS	P
TECHNICAL	R
INDEX	T