

INSERT GRADES

Insert Material Selection Table

Applications	Cutting Range	P	M	K		N	S		H	Powdered Metal	
		Steel	Stainless Steel	Gray Cast Iron	Nodular Cast Iron	Non-Ferrous Metals	Heat-Resistant Alloys	Titanium Alloys	Hardened Materials		
Milling	Finishing ↕ Roughing	TN100M	CA6535			KPD230	CA6535	KPD230			
		PR1225	PR1225	PR1210	PR1210	KPD001	PR1225	KPD001			
Turning	Finishing ↕ Roughing	PR1230	PR1525	PR1510	PR1510	KPD010	PR1535	KW10			
		PR1525	PR830	KW10	KW10	PDL025		PR905			
		PR830	PR1535			KW10		PR1210			
						GW25		PR1535			
		TN610		KBN475							
		TN6010		KBN60M							
		TN620	TN620	KA30	TN60		CF1		KT66		
		TN60	TN60				KS6040		A66N	TN6010	TN60
		PV710	PV720	PV7005	PV7005	KPD001	KW10		PT600M		
		PV7010	CA6515	CA5505	CA5505	KPD010	CA6515	KPD001	KBN05M		
Small Tools	Finishing ↕ Roughing	PV720	CA6525	CA4505	CA4505	PDL025	CA6525	KPD010	KBN10M	KBN570	
		CA510	PR1125	CA4515	CA4515	KW10	PR1305	SW05	KBN25M	KBN70M	
		CA515	PR1535				PR1310	SW10	KBN30M		
		CA525					PR1325	SW25	KBN35M		
		CA530					PR1535		KBN900		
		TN610									
		TN6010									
		TN620									
		PV710	TN620								TN610
		PV7010	PV720	CA4505	CA4505	KPD001	CA6515	KPD001	KBN05M		TN60
Boring	Large Bore Dia. ↕ Small	PV720	CA6525	PV7005	PV7005	KPD001	CA6515	KPD001	KBN05M	TN610	
		CA515	PR1025	CA4505	CA4505	KPD010	CA6525	KPD010	KBN10M	TN60	
		CA525	PR1125	CA4515	CA4515	PDL025	PR1125	KW10	KBN25M	KBN570	
		CA530	PR1225	KW10	KW10	KW10	PR1225	SW05	KBN30M	KBN70M	
		PR1025	PR930								
		PR1425	PR1535								
		PR930									
		PR1535									
		TN610									
		TN6010									
General Cut-Off	Large Cutting Dia. ↕ Small	CR9025	CR9025								
		PR930	PR930								
		PR915	PR915	KW10	KW10	PDL025	KW10	KW10			
		PR1215	PR1215	PR1215	PR1215	KW10	PR1225				
		PR1225	PR1225				PR660				
		PR1535	PR1535								
Small Dia. Cut-Off	Depends on Workpiece Material	PR1025	PR1025	KW10	KW10	PDL025	KW10	KW10			
		PR1225	PR1225			KW10	PR1025				
		PR1535	PR1535				PR1225				
		TC40	TC40								
Grooving	Glossy Finish ↕ Stable	TN620	TN620								
		TN90	TN90	PR905	PR905	KPD001	PR915	KPD001	KBN510	TC40	
		PV7040	PV7040	PR1215	PR1215	PDL025	KW10	KW10	KBN525		
		PR930	PR930	KW10	KW10	KW10	PR1215		PT600M	KBN570	
		PR1115	PR1115	GW15	GW15	GW15	PR1225				
		PR1215	PR1215								
Threading	Glossy Finish ↕ Stable	TC60M	TC60M	KW10	KW10	KW10	KW10	KW10			
		PR1115	PR1115	GW15	GW15	GW15	GW15	GW15		PR1115	
		PR930	PR930								
Drilling	Wear Resistance ↕ Toughness	PR1225	PR1225	PR1210	PR1210	KW10	PR1225	KW10			
		PR1230	PR830	KW10	KW10	GW15	KW10				
		PR830	PR660				GW15				
		PR660									

- Highlighted Items are Recommended Choice.