


Drilling Insert Grades

Summary of Insert Grades

Workpiece Material		Steel (Carbon steel / Alloy steel)				Stainless steel / Cast steel				Cast Iron (Gray cast iron / Nodular cast iron)					
Cutting Range		← Finishing		→ Roughing		← Finishing		→ Roughing		← Finishing		→ Roughing			
Classification		P01	P10	P20	P30	P40	M01	M10	M20	M30	M40	K01	K10	K20	K30
Coated Carbide	PR Series		PR660						PR660				PR905		
	MEGACOAT (PR Series)		PR730	PR830				PR730	PR830						
Carbide			PR915					PR915							
			PR930					PR930							
			PR1025					PR1025							
			PR1225					PR1225				PR1210			
			PR1230									KW10			
												GW15			
Workpiece Material		Non-ferrous Metals (Aluminum / Non-ferrous metals / Non-metals)				Titanium / Titanium alloys				Hardened materials (Hardened steel / Chilled cast iron)					
Cutting Range		← Finishing		→ Roughing		← Finishing		→ Roughing		← Finishing		→ Roughing			
Classification		N01	N10	N20	N30	S01	S10	S20	S30	H01	H10	H20	H30		
Coated Carbide	MEGACOAT (PR Series)										PR1230				
	Carbide		KW10				KW10								
			GW15				GW15								

Insert Material Selection Guide

Application	Cutting Range	P	M	K		N	S		H	Sintered steel	
		Steel	Stainless Steel	Gray Cast Iron	Nodular Cast Iron	Non-ferrous Metals	Heat-Resistant Alloys	Titanium Alloys	Hardened materials		
	Wear Resistance ↑ ↓ Toughness	PR930					PR660				
		PR730	PR730				PR1025				
		PR830	PR830	PR905	PR905	KW10	PR1225	KW10			
		PR915	PR915	PR1210	PR1210	GW15	PR1230				
		PR1025	PR1025	KW10	KW10		KW10				
		PR1225	PR1225				GW15				
		PR1230	PR660								
		PR660									

• Highlighted materials are recommended choice.