
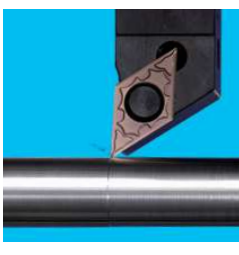









INSERT GRADES

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	
Turning 	Finishing ↑ ↓	TN610								
		TN6010								
		TN620	TN620						KT66	
		TN60	TN60						A66N	TN6010
		PV710	PV720	PV7005	PV7005	KPD001	KW10		PT600M	TN60
		PV7010	CA6515	CA5505	CA5505	KPD010	CA6515	KPD001	KBN05M	
		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	
	Roughing	CA530				PR1535		KBN900		
Small Tools 	Finishing ↑ ↓	TN610								
		TN6010								
		TN620								
		PV710	TN620							TN610
		PV7010	PV720	CA4505	CA4505	KPD001	CA6515	KPD001	KBN05M	TN60
		PV720	PR930	CA4515	CA4515	KPD010	PR1125	KPD010	KBN10M	
		PR930	PR1025	KW10	KW10	KW10	PR1225	KW10	KBN25M	KBN570
		PR1005	PR1225						KBN30M	KBN70M
		PR1025	PR1535							
		PR1425								
	Roughing	PR1535								
Boring 	Large ↑ ↓ Small	TN610								
		TN6010								
		TN620								
		PV710	TN60							
		PV7010	CA6515	KBN475						PT600M
		PV720	CA6525	KBN60M						TN610
		CA515	PR1025	PV7005	PV7005	KPD001	CA6515	KPD001	KBN05M	TN60
		CA525	PR1125	CA4505	CA4505	KPD010	CA6525	KPD010	KBN10M	
		CA530	PR1225	CA4515	CA4515	PDL025	PR1125	KW10	KBN25M	KBN570
		PR1025	PR930	KW10	KW10	KW10	PR1225	SW05	KBN30M	KBN70M
	Small	PR1425	PR1535							
General Cut-Off 	Large ↑ ↓ Small	CR9025	CR9025							
		PR930	PR930							
		PR915	PR915	KW10	KW10	PDL025	KW10	KW10		
		PR1215	PR1215	PR1215	PR1215	KW10	PR1225			
		PR1225	PR1225				PR660			
		PR1535	PR1535							
	Small	PR660	PR660							
Small Dia. Cut-Off 	Depends on Workpiece Material	PR1025	PR1025	KW10	KW10	PDL025	KW10	KW10		
		PR1225	PR1225			KW10	PR1025			
		PR1535	PR1535				PR1225			
Grooving 	Glossy Finish ↑ ↓ Stable	TC40	TC40							
		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							
PR1225	PR1225									
Threading 	Glossy Finish ↑ ↓ Stable	TC60M	TC60M	KW10	KW10	KW10	KW10	KW10		
		PR1115	PR1115	GW15	GW15	GW15	GW15	GW15		PR1115
		PR930	PR930							
Drilling 	Wear Resistance ↑ ↓	PR1225	PR1225	PR1210	PR1210	KW10	PR1225	KW10		
		PR1230	PR830	KW10	KW10	GW15	KW10			
		PR830	PR660				GW15			
		PR660								
Milling 	Finishing ↑ ↓ Roughing	TN100M	CA6535			KPD230	CA6535	KPD230		
		PR1225	PR1225	PR1210	PR1210	KPD001	PR830	KPD001		
		PR1230	PR1525	PR1510	PR1510	KPD010	PR660	KW10		
		PR1525	PR830	KW10	KW10	PDL025	PR1225	PR905		
		PR830	PR1535			KW10	PR1525	PR1210		
						GW25		PR1535		

· Highlighted Items are Recommended Choice.

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