

Introduction

Change to New Label

1 Indication of Cutting Conditions

To improve usability, cutting conditions are indicated in the label.

* This will apply to only new insert grades temporarily.

Indication of Cutting Conditions

P For Carbon Steel / Alloy Steel

M For Stainless Steel / Cast Iron

K For Gray Cast Iron / Nodular Cast Iron

N For Aluminum / Non-ferrous Metal / Non-Metal

S For Titanium Alloy / Ni Alloy

H For Heat Treated Steel / Chilled Cast Iron

For 2nd recommendation materials, only round mark is shown

Usage Classification by Materials

Cutting Speed

Depth of Cut

Feed

* Upper is Metric (meter)
Lower is Inch

Rough=For Heavy Cutting
Middle=For Medium Cutting
Finish=For Light Cutting

For 1st Recommendation materials, round mark and down-arrow are shown and recommended cutting conditions are indicated

For Continuous Machining= ○ Cont.
For Light Interruption= ◐ Light Int.
For Interruption= ◑ Heavy Int.

Center Values of Recommended Cutting Conditions

Upper and Lower limits of Recommended Cutting Conditions

2 Dual labeling for the grade PR1025 (PR925)

TiCN PR925 grade changed to PR1025 and it is now classified correctly within the new PVD coated PR1000 series (TiCN) separate from the PR1100 series (TiAlN). For identification purposes, label indicates both previous and new names, as shown on right.

Dual grade indication

Dual label indicates new grade PR1025 and previous grade PR925