

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 Resistant Steel / Chilled Cast Iron

The diagram shows a KYOCERA label for CNMG120408PS CA5505. Callouts include: 'Corner R' pointing to the 'r ε 0.8' value; 'Usage Classification according to Materials' pointing to the material selection circles (P, M, K, N, S, H); 'Cutting Speed' pointing to the Vc values; 'Depth of Cut' pointing to the ap values; 'Feed' pointing to the f values; 'Center Values of Recommended Cutting Conditions' pointing to the 'Cont' (Continuous) and 'Middle' (Medium) labels; 'Upper and Lower limits of Recommended Cutting Conditions' pointing to the ranges in parentheses; and 'Rough=For Heavy Cutting, Middle=For Medium Cutting, Finish=For Light Cutting' pointing to the 'Rough', 'Middle', and 'Finish' labels.

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

The diagram shows a KYOCERA label for BDMT110308ER-JS PR1025. A callout box points to the 'PR1025 (PR925)' label, stating: 'Dual label indicates new grade PR1025 and previous grade PR925'.