

Application recommendations

Inserts precision ground

Grade matrix

Grade selection

Chipbreaker recommendation

Carbide / carbide coated / PCD / PCBN

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Chipbreaker →

for boring bars starting from 5 mm working diameter

Cutting material	Grade composition		Workpiece material					
			Steel	Stainless steel	Cast iron	Nonferrous materials	Heavy machinable materials	Hardened steel
Grade code	Substrat	Coating						
P10	P10	uncoated	● n	—	—	—	—	—
Chipbreaker			→ -1000 -1020					
P40	P40	uncoated	● n	—	—	—	—	—
Chipbreaker			→ -1000 -1020	-1011				
K10	K10	uncoated	—	—	● n	▲ n	● n	—
Chipbreaker					→ -1000 -1020	-1620 -2420	-1620* -2420	
H02	K10	TiAlN PVD	—	● n	t ▲ n	t ● n	—	—
Chipbreaker				→ -1620 -2420	-1000 -1020	-1620 -2420		
H06	P40	TiAlN PVD	▲ n	▲ n	t ▲ n	—	● n	—
Chipbreaker			→ -1000 -1020		-1000 -1020		-1000 -1020	
H25	P40	TiN CVD	▲ n	—	—	—	●	—
Chipbreaker			→ -1000 -1020				-1000 -1020	
H26	P40	TiN PVD	t ● n	●	—	—	▲ n	—
Chipbreaker			→ -1000 -1020	-1620 -2420				
PCD	Grainsize 10µm		—	—	—	▲	—	—
Chipbreaker						→ -0000		
PCBN			—	—	t ● n	—	—	t ▲ n
Chipbreaker					→ -0000			-0000

▲ = very good applicable

● = applicable

— = not applicable

* = for Titanium

t = dry

n = wet

Further cutting material, coatings and geometries on request.