

Application recommendations

Inserts

Grade matrix

Grade selection

Chipbreaker recommendation

Carbide / carbide coated / PCD / PCBN

● ▲ ▬
Chipbreaker →

| Cutting material | Grade composition | | Workpiece material | | | | | | |
|------------------|-------------------|----------------------|--------------------|-----------------|----------------|----------------------|----------------------------|----------------|---|
| | | | Steel | Stainless steel | Cast iron | Nonferrous materials | Heavy machinable materials | Hardened steel | |
| Grade code | Substrat | Coating | | | | | | | |
| K10 | K10 | uncoated | ▬ | ▬ | ● n | ▲ n | ● n | ▬ | ▬ |
| Chipbreaker | | | | | -1000 -1045 | -1620 -1645 | -1620* -1645 | | |
| G12 | K10 | TiAlN Multilayer PVD | ▬ | ● n | t ▲ n | t ● n | ▬ | ▬ | |
| Chipbreaker | | | | -1000 -1045 | -1000 -1045 | -1620 -1645 | | | |
| G16 | P40 | TiAlN Multilayer PVD | ▲ n | ▲ n | ● | ▬ | ● n | ▬ | |
| Chipbreaker | | | -1045 -1000 | | -1045 -1000 | | -1045 -1000 | | |
| G26 | P40 | TiN CVD | ● n | ● n | ▬ | ▬ | ▲ n | ▬ | |
| Chipbreaker | | | -1045 -1000 | -1045 -1000 | | | | | |
| PCD | Grain size 10 µm | | ▬ | ▬ | ▬ | t ▲ n | ▬ | ▬ | |
| Chipbreaker | | | | | | -0045 -1045 | | | |
| PCD 1 | Grain size 1 µm | | ▬ | ▬ | ▬ | t ▲ n | ▬ | ▬ | |
| Chipbreaker | | | | | | -0045 -1045 | | | |
| PCD C | Grain size 25 µm | | ▬ | ▬ | ▬ | t ▲ n | ▬ | ▬ | |
| Chipbreaker | | | | | | -0045 -1045 | | | |
| PCD 3 | Mixed grain | | ● n | ▬ | ▬ | t ▲ n | ▬ | ▬ | |
| Spanleitstufe | | | -0045 | | | -0045 -1045 | | | |
| CBN | | | ▬ | ▬ | t ● | ▬ | ▬ | t ▲ | |
| Chipbreaker | | | | | -0000 | | | -0000 | |
| CBN 8 | high CBN-content | | ● n | ▬ | t ● | ▬ | ▬ | t ▲ | |
| Chipbreaker | | | -0000 | | -0000 | | | -0000 | |

▲ = very good applicable ● = applicable ▬ = not applicable * = for Titanium t = dry n = wet
Further cutting materials, coatings and geometries on request.